






















TTD2090220





















Type: Lange Hochleistungs-Spiralbohrer mit Kühlmittelloch

d1	d2	l1	l2
2,20	4,00	55	24,75

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
Yes	Right	140°	30°	2

Coated	Coating type	Material	Material type	Norm
Yes	TiAlN	MD	SMG SP	TUSA

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed Vc	Advancement per revolution fn
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm2		45 : 75	0.205
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		40 : 70	0.2
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		35 : 70	0.17
M01	Ferritic stainless steels		30 : 50	0.07
M02	Martensitic stainless steels		30 : 50	0.11
M03	Martensitic stainless steels - PH		30 : 50	0.055
M04	Austenitic stainless steels		20 : 40	0.055
K01	Gray/lamellar cast iron		20 : 60	0.315
K02	Nodular/nodular cast iron		15 : 40	0.315
N01	Drawn aluminum alloys		100 : 300	0.115
N02	Die-cast aluminum alloys		80 : 250	0.135
N03	Copper		60 : 120	0.115
N04	Brass - Bronze		80 : 140	0.135
N05	Lead-free brass		80 : 140	0.155
S01	Super alloys (Inconel - Hastelloy - Nimonic)		15 : 25	0.02
S02	Pure titanium (Grade 2 - Grade 4)		15 : 25	0.08
S03	Titanium alloys (Grade 5)		15 : 30	0.08
S04	Cobalt Chrome Alloys		15 : 30	0.03
H01	Hardened steels up to 55 HRC		20 : 40	0.02

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H01	Hardened steels up to 55 HRC		20 : 40	0.02
H02	Hardened steels from 55 HRC		15 : 30	-



SWISS HIGH PRECISION TOOLS
