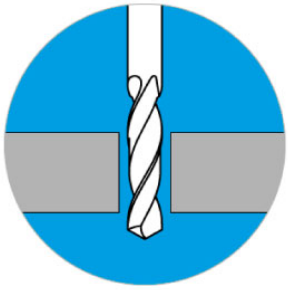

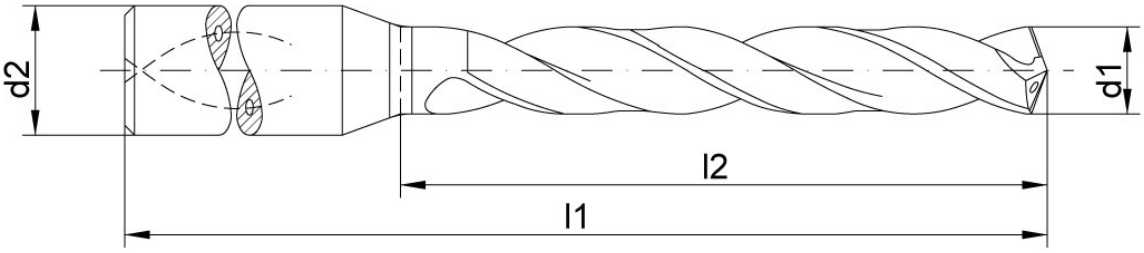

TTD2090365

Type: Lange Hochleistungs-Spiralbohrer mit Kühlmittelloch

d1	d2	l1	l2
3,65	6,00	85	41,10

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	0.26
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2	🟢	40 : 70	0.25
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2	🟢	35 : 70	0.2
M01	Ferritic stainless steels	🟢	30 : 50	0.09
M02	Martensitic stainless steels	🟢	30 : 50	0.125
M03	Martensitic stainless steels - PH	🟢	30 : 50	0.08
M04	Austenitic stainless steels	🟢	20 : 40	0.08
K01	Gray/lamellar cast iron	🟢	20 : 60	0.35
K02	Nodular/nodular cast iron	🟢	15 : 40	0.35
N01	Drawn aluminum alloys	🟡	100 : 300	0.135
N02	Die-cast aluminum alloys	🟡	80 : 250	0.155
N03	Copper	🟡	60 : 120	0.135
N04	Brass - Bronze	🟡	80 : 140	0.155
N05	Lead-free brass	🟡	80 : 140	0.17
S01	Super alloys (Inconel - Hastelloy - Nimonic)	🟢	15 : 25	0.025
S02	Pure titanium (Grade 2 - Grade 4)	🟢	15 : 25	0.1
S03	Titanium alloys (Grade 5)	🟢	15 : 30	0.1
S04	Cobalt Chrome Alloys	🟢	15 : 30	0.035
H01	Hardened steels up to 55 HRC	🟡	20 : 40	0.025

Machinable Materials				
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S03	Titanium alloys (Grade 5)		15 : 30	0.1
S04	Cobalt Chrome Alloys		15 : 30	0.035
H01	Hardened steels up to 55 HRC		20 : 40	0.025
H02	Hardened steels from 55 HRC		15 : 30	-