





















TTD2120320E

Type: High-performance long short twist drill with coolant holes

| d1 | d2 | l1 | l2 | l3 |
|------|------|----|-------|-------|
| 3,20 | 6,00 | 92 | 14,10 | 49,00 |

| Coolant holes | Cut | Point angle | Spiral angle | Cutting edges Z |
|---------------|-------|-------------|--------------|-----------------|
| Yes | Right | 130° | - | 2 |

| Coated | Coating type | Material | Material type | Norm |
|--------|--------------|----------|---------------|------|
| Yes | ALCRONOS | MD | SMG 10 | 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 |  | 50 : 80 | 0.14-0.16 |
| P02 | Low alloy steels from 800 N/mm2 to 1100 N/mm2 |  | 45 : 65 | 0.13-0.15 |
| P03 | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |  | 40 - 60 | 0.12-0.14 |
| M01 | Ferritic stainless steels |  | 35 - 50 | 0.095-0.105 |
| M02 | Martensitic stainless steels |  | 30 - 45 | 0.095-0.105 |
| M03 | Martensitic stainless steels - PH |  | 30 - 45 | 0.095-0.105 |
| M04 | Austenitic stainless steels |  | 30 - 45 | 0.085-0.095 |
| K01 | Gray/lamellar cast iron |  | 80 - 100 | 0.14-0.16 |
| K02 | Nodular/nodular cast iron |  | 80 - 100 | 0.14-0.16 |
| N01 | Drawn aluminum alloys |  | 100 : 160 | 0.11-0.125 |
| N02 | Die-cast aluminum alloys |  | 80 : 140 | 0.12-0.135 |
| N03 | Copper |  | 60 : 100 | 0.10-0.115 |
| N04 | Brass - Bronze |  | 80 : 140 | 0.125-0.14 |
| N05 | Lead-free brass |  | 60 : 120 | 0.105-0.120 |
| S01 | Super alloys (Inconel - Hastelloy - Nimonic) |  | 20 : 40 | 0.05-0.06 |
| S02 | Pure titanium (Grade 2 - Grade 4) |  | 10 : 25 | 0.06-0.07 |
| S03 | Titanium alloys (Grade 5) |  | 15 - 30 | 0.08-0.09 |
| S04 | Cobalt Chrome Alloys |  | 35 - 50 | 0.08-0.09 |
| H01 | Hardened steels up to 55 HRC |  | 20 - 30 | 0.02-0.025 |
| H02 | Hardened steels from 55 HRC |  | - | - |