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















**Type:** Extra Long high-performance twist drill with coolant holes

$d1$	$d2$	$l1$	$l2$
2,25	4,00	75	38,85

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
		<b>Recommended</b> Part. recommended Not recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		45 : 75	0.185
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		40 : 70	0.18
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		35 : 70	0.155
<b>M01</b>	Ferritic stainless steels		30 : 50	0.065
<b>M02</b>	Martensitic stainless steels		30 : 50	0.1
<b>M03</b>	Martensitic stainless steels - PH		30 : 50	0.05
<b>M04</b>	Austenitic stainless steels		20 : 40	0.05
<b>K01</b>	Gray/lamellar cast iron		20 : 60	0.285
<b>K02</b>	Nodular/nodular cast iron		15 : 40	0.285
<b>N01</b>	Drawn aluminum alloys		100 : 300	0.105
<b>N02</b>	Die-cast aluminum alloys		80 : 250	0.12
<b>N03</b>	Copper		60 : 120	0.105
<b>N04</b>	Brass - Bronze		80 : 140	0.12
<b>N05</b>	Lead-free brass		80 : 140	0.14
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		15 : 25	0.02
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		15 : 25	0.07
<b>S03</b>	Titanium alloys (Grade 5)		15 : 30	0.07
<b>S04</b>	Cobalt Chrome Alloys		15 : 30	0.025
<b>H01</b>	Hardened steels up to 55 HRC		20 : 40	0.02

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<b>H02</b>	Hardened steels from 55 HRC		15 : 30	-



SWISS HIGH PRECISION TOOLS

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