






















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















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

| d1 | d2 | l1 | l2 |
|------|------|----|-------|
| 3,15 | 6,00 | 93 | 54,35 |

| 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 | 0.235 |
| P02 | Low alloy steels from 800 N/mm2 to 1100 N/mm2 |  | 40 : 70 | 0.225 |
| P03 | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |  | 35 : 70 | 0.18 |
| M01 | Ferritic stainless steels |  | 30 : 50 | 0.08 |
| M02 | Martensitic stainless steels |  | 30 : 50 | 0.115 |
| M03 | Martensitic stainless steels - PH |  | 30 : 50 | 0.07 |
| M04 | Austenitic stainless steels |  | 20 : 40 | 0.07 |
| K01 | Gray/lamellar cast iron |  | 20 : 60 | 0.315 |
| K02 | Nodular/nodular cast iron |  | 15 : 40 | 0.315 |
| N01 | Drawn aluminum alloys |  | 100 : 300 | 0.12 |
| N02 | Die-cast aluminum alloys |  | 80 : 250 | 0.14 |
| N03 | Copper |  | 60 : 120 | 0.12 |
| N04 | Brass - Bronze |  | 80 : 140 | 0.14 |
| N05 | Lead-free brass |  | 80 : 140 | 0.155 |
| S01 | Super alloys (Inconel - Hastelloy - Nimonic) |  | 15 : 25 | 0.025 |
| S02 | Pure titanium (Grade 2 - Grade 4) |  | 15 : 25 | 0.09 |
| S03 | Titanium alloys (Grade 5) |  | 15 : 30 | 0.09 |
| S04 | Cobalt Chrome Alloys |  | 15 : 30 | 0.03 |
| H01 | Hardened steels up to 55 HRC |  | 20 : 40 | 0.025 |

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| H02 | Hardened steels from 55 HRC |  | 15 : 30 | - |



SWISS HIGH PRECISION TOOLS
