























TTD2180220E

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

| d1 | d2 | l1 | l2 | l3 |
|------|------|----|------|-------|
| 2,20 | 4,00 | 94 | 9,70 | 46,90 |

| 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 | 0.10-0.12 |
| P02 | Low alloy steels from 800 N/mm2 to 1100 N/mm2 |  | 45 : 65 | 0.09-0.11 |
| P03 | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |  | 40 - 60 | 0.08-0.10 |
| M01 | Ferritic stainless steels |  | 35 - 50 | 0.065-0.075 |
| M02 | Martensitic stainless steels |  | 30 - 45 | 0.065-0.075 |
| M03 | Martensitic stainless steels - PH |  | 30 - 45 | 0.065-0.075 |
| M04 | Austenitic stainless steels |  | 30 - 45 | 0.055-0.065 |
| K01 | Gray/lamellar cast iron |  | 80 - 100 | 0.10-0.12 |
| K02 | Nodular/nodular cast iron |  | 80 - 100 | 0.10-0.12 |
| N01 | Drawn aluminum alloys |  | 100 : 160 | 0.08-0.95 |
| N02 | Die-cast aluminum alloys |  | 80 : 140 | 0.09-0.105 |
| N03 | Copper |  | 60 : 100 | 0.07-0.085 |
| N04 | Brass - Bronze |  | 80 : 140 | 0.095-0.11 |
| N05 | Lead-free brass |  | 60 : 120 | 0.075-0.09 |
| S01 | Super alloys (Inconel - Hastelloy - Nimonic) |  | 20 : 40 | 0.03-0.04 |
| S02 | Pure titanium (Grade 2 - Grade 4) |  | 10 : 25 | 0.04-0.05 |
| S03 | Titanium alloys (Grade 5) |  | 15 - 30 | 0.06-0.07 |
| S04 | Cobalt Chrome Alloys |  | 35 - 50 | 0.06-0.07 |
| H01 | Hardened steels up to 55 HRC |  | 20 - 30 | 0.012-0.016 |
| H02 | Hardened steels from 55 HRC |  | - | - |