























## TTD2180250E

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

d1	d2	l1	l2	l3
2,50	4,00	100	11,00	52,50

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
		<b>Recommended</b> Part. recommended <b>Not</b> recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		50 : 80	0.12-0.14
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		45 : 65	0.11-0.13
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 - 60	0.10-0.12
<b>M01</b>	Ferritic stainless steels		35 - 50	0.08-0.09
<b>M02</b>	Martensitic stainless steels		30 - 45	0.08-0.09
<b>M03</b>	Martensitic stainless steels - PH		30 - 45	0.08-0.09
<b>M04</b>	Austenitic stainless steels		30 - 45	0.07-0.08
<b>K01</b>	Gray/lamellar cast iron		80 - 100	0.12-0.14
<b>K02</b>	Nodular/nodular cast iron		80 - 100	0.12-0.14
<b>N01</b>	Drawn aluminum alloys		100 : 160	0.095-0.11
<b>N02</b>	Die-cast aluminum alloys		80 : 140	0.105-0.120
<b>N03</b>	Copper		60 : 100	0.085-0.10
<b>N04</b>	Brass - Bronze		80 : 140	0.11-0.125
<b>N05</b>	Lead-free brass		60 : 120	0.09-0.105
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0.04-0.05
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		10 : 25	0.05-0.06
<b>S03</b>	Titanium alloys (Grade 5)		15 - 30	0.07-0.08
<b>S04</b>	Cobalt Chrome Alloys		35 - 50	0.07-0.08
<b>H01</b>	Hardened steels up to 55 HRC		20 - 30	0.016-0.02
<b>H02</b>	Hardened steels from 55 HRC		-	-