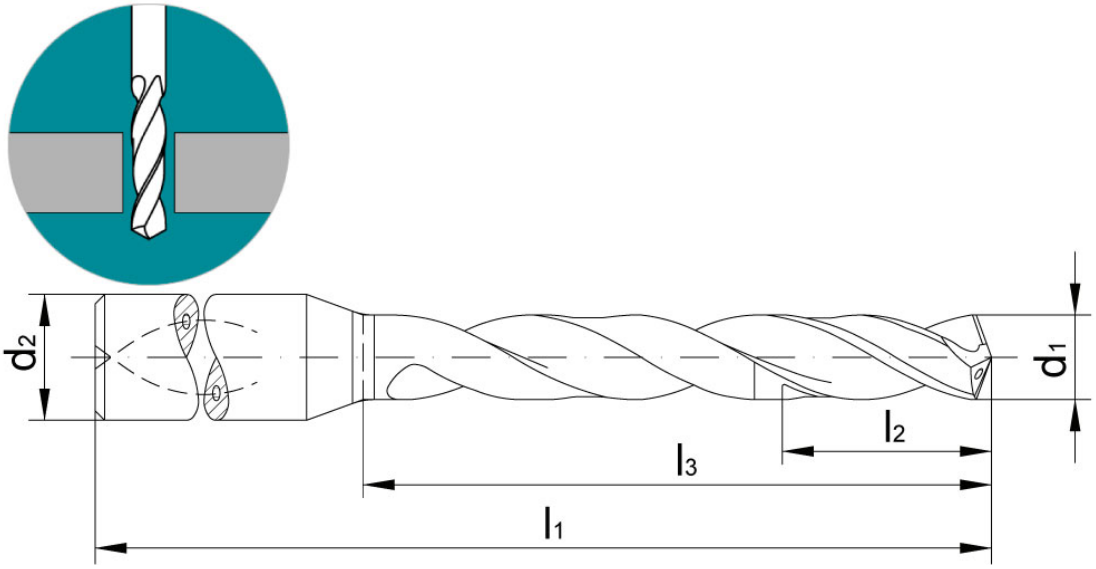

TTD2180380E

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

d1	d2	l1	l2	l3
3,80	6,00	126	16,75	79,80

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	0.16-0.20
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		45 : 65	0.15-0.18
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 - 60	0.14-0.17
M01	Ferritic stainless steels		35 - 50	0.11-0.12
M02	Martensitic stainless steels		30 - 45	0.11-0.12
M03	Martensitic stainless steels - PH		30 - 45	0.11-0.12
M04	Austenitic stainless steels		30 - 45	0.10-0.11
K01	Gray/lamellar cast iron		80 - 100	0.16-0.20
K02	Nodular/nodular cast iron		80 - 100	0.16-0.20
N01	Drawn aluminum alloys		100 : 160	0.125-0.14
N02	Die-cast aluminum alloys		80 : 140	0.135-0.15
N03	Copper		60 : 100	0.115-0.13
N04	Brass - Bronze		80 : 140	0.14-0.17
N05	Lead-free brass		60 : 120	0.12-0.135
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0.06-0.07
S02	Pure titanium (Grade 2 - Grade 4)		10 : 25	0.07-0.08
S03	Titanium alloys (Grade 5)		15 - 30	0.09-0.10
S04	Cobalt Chrome Alloys		35 - 50	0.09-0.10
H01	Hardened steels up to 55 HRC		20 - 30	0.025-0.03
H02	Hardened steels from 55 HRC		-	-