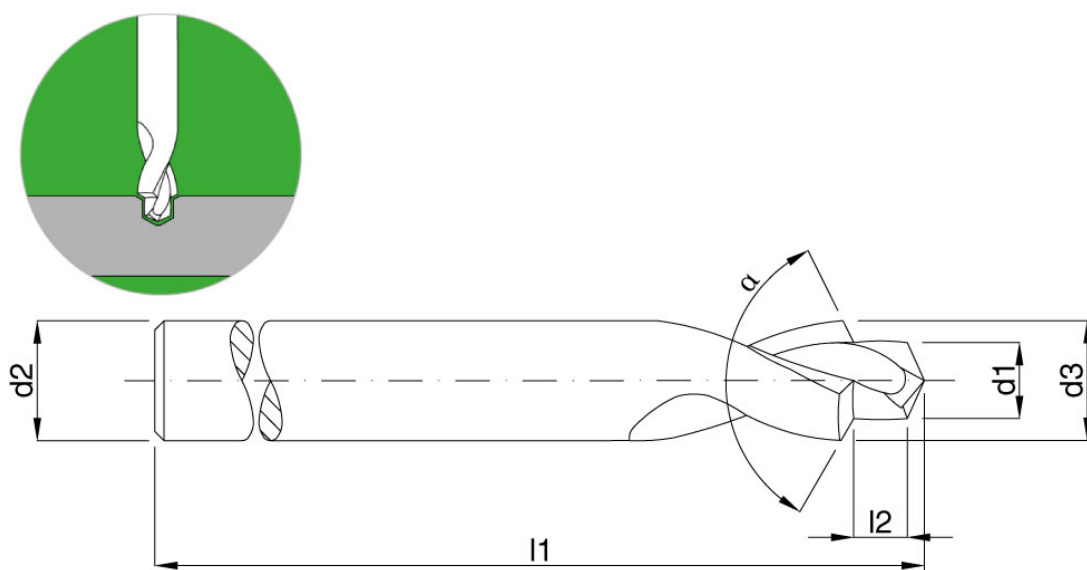




TWP0000190

Type: Torx pilot drill

d1	d2	d3	l1	l2
1,90	4,00	4,00	50	1,07

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	140°	20°	2

Coated	Coating type	Material	Material type	Norm
Yes	TISINOS	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		-	-
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		-	-
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
M01	Ferritic stainless steels		20 : 30	0.040 - 0.060
M02	Martensitic stainless steels		20 : 30	0.040 - 0.060
M03	Martensitic stainless steels - PH		20 : 30	0.040 - 0.060
M04	Austenitic stainless steels		-	-
K01	Gray/lamellar cast iron		-	-
K02	Nodular/nodular cast iron		-	-
N01	Drawn aluminum alloys		-	-
N02	Die-cast aluminum alloys		-	-
N03	Copper		-	-
N04	Brass - Bronze		-	-
N05	Lead-free brass		-	-
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 30	0.020 - 0.030
S02	Pure titanium (Grade 2 - Grade 4)		20 : 30	0.020 - 0.030
S03	Titanium alloys (Grade 5)		20 : 30	0.020 - 0.030
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		-	-

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		-	-
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N01	Drawn aluminum alloys		-	-
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S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 30	0.020 - 0.030
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S03	Titanium alloys (Grade 5)		20 : 30	0.020 - 0.030
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		-	-
H02	Hardened steels from 55 HRC		-	-