SANDVIK
Coromant

2020.1

New cutting tools

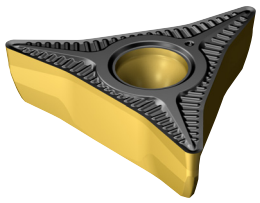
General turning

CoroTurn® Prime

L3WX wiper geometry for A-type inserts

For finishing of ductile materials high-strength steels, cold-forging steels and duplex stainless steels, with high demand on surface finish

See page 5



CoroTurn® TR and CoroTurn® 107

With over and under coolant capabilities

Under coolant for increased tool life and productivity, especially in applications generating a lot of heat into the insert. Over coolant for better chip control

See chapter A

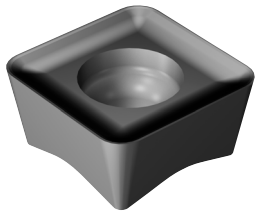
Milling

CoroMill® 415 insert for milling

New insert geometry

New M-M30 geometry for CoroMill® 415 in both iC05 and iC07 insert sizes, complementing the old M-M30 geometry assortment.

See page 14



CoroMill® 390 square shoulder milling cutter

Lightweight shoulder milling cutter

Inch version cutters to be used together with Silent Tools™ damped adaptors for long overhang machining in demanding applications

See page 15

CoroMill® Plura

Heavy duty milling

From 10–25 mm (.625–.750") First choice for heavy-duty operations in ISO P and ISO M.

See page 16

CoroMill® 316

Grade GC1730

Grade GC1730 replaces the existing GC1030 grade
First choice for ISO P and ISO M materials

See chapter B

Drilling

CoroDrill® DS20

Indexable insert drill

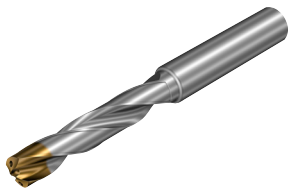
Extended assortment with new drill diameters and insert size

See page 39

CoroDrill® 860-GM

Solid carbide drill

A high-performance drilling solution for short holes in most materials.
The drill offers robust process security, high hole integrity and excellent tool life and is ideal for general engineering and automotive applications.



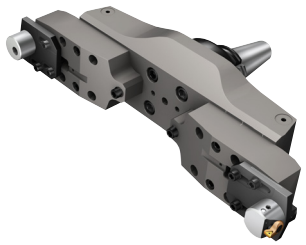
See page 42

Boring

CoroBore 826

CoroBore® XL

New CoroBore® 826 fine boring heads with high precision nozzles

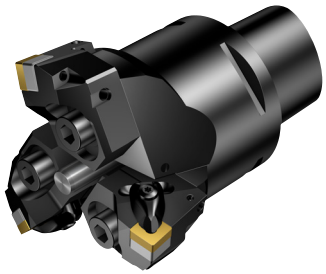


See page 76

CoroBore® BR30

Extended assortment

Larger diameters now available.



See page 75

Tooling systems

CoroChuck™ 930

Extended assortment with new slender and pencil dimensions

Designed for all applications and components where accessibility and high performance are required

See chapter E

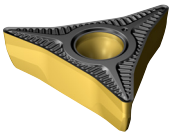
General turning

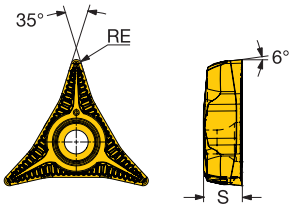
For complete assortment, see www.sandvik.coromant.com

ENG

CoroTurn® Prime insert for turning

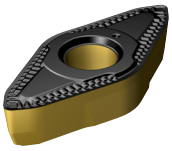
A-type insert

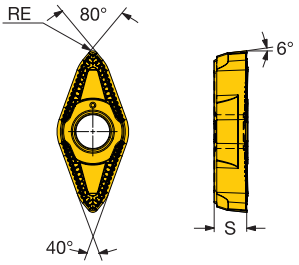




		SSC	S	RE	ISO CODE	P 4325
Finishing	L3WX	CP-A	6.00 *.236*	0.79 *.031*	CP-A1108-L3WX	★

B-type insert





		SSC	S	REEQ	RE	ISO CODE	M 2025
Medium	H3	CP-B	5.00 *.197*	0.8 *.031*	0.79 *.031*	CP-B1108-H3	★

SSC = To correspond with SSC on holder.

97

CoroTurn® TR cutting unit for turning

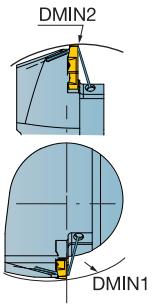
Screw clamp design

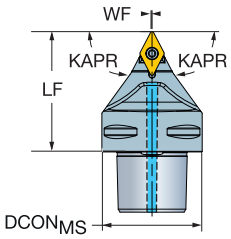
Coromant Capto® - Internal coolant supply

TR-DC

KAPR 62.5° Cx-TR-D13NCN..C

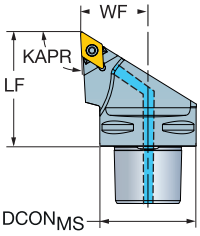
PSIR 27.5°

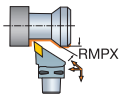
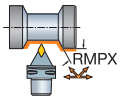




93.0° Cx-TR-D13JCR/L..C

-3.0°



								Dimensions, mm, inch						
		CZC_{MS}	$DMIN_1$	$DMIN_2$	RMPX	CNSC	Ordering code	$DCON_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
	13	C4	251.0	150.0	27°	3	C4-TR-D13JCR/L-27050C	40	50.0	27.0	150	3.0	0.37	TR-DC1308
			9.882	*5.906*				*1.575*	*1.969*	*1.063*	*2175*			
		C5	249.0	175.0	27°	3	C5-TR-D13JCR/L-35060C	50	60.0	35.0	150	3.0	0.69	TR-DC1308
			9.803	*6.890*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	253.0	240.0	27°	3	C6-TR-D13JCR/L-45065C	63	65.0	45.0	150	3.0	1.39	TR-DC1308
			9.961	*9.449*				*2.480*	*2.559*	*1.772*	*2175*			
		C8	253.0	250.0	27°	3	C8-TR-D13JCR/L-55080C	80	80.0	55.0	150	3.0	2.54	TR-DC1308
			9.961	*9.843*				*3.150*	*3.150*	*2.165*	*2175*			
	13	C4		140.0	57°	3	C4-TR-D13NCN-00050C	40	50.0	0.5	150	3.0	0.32	TR-DC1308
				5.512				*1.575*	*1.969*	*.020*	*2175*			
		C5		165.0	57°	3	C5-TR-D13NCN-00060C	50	60.0	0.5	150	3.0	0.62	TR-DC1308
				6.496				*1.969*	*2.362*	*.020*	*2175*			
		C6		190.0	57°	3	C6-TR-D13NCN-00065C	63	65.0	0.5	150	3.0	1.06	TR-DC1308
				7.480				*2.480*	*2.559*	*.020*	*2175*			

N = Neutral, R = Right hand, L = Left hand

Spare parts			
Insert screw	Bottom plug M4	Coolant nozzle	Bits insert screw
5513 020-01	3213 010-256	5691 026-03	5680 084-15

For complete list of spare parts, see www.sandvik.coromant.com

97 100

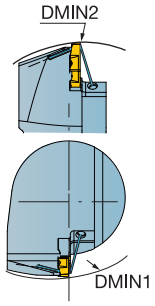
CoroTurn® TR cutting unit for turning

Screw clamp design

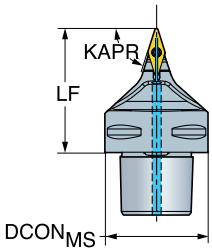
Coromant Capto® - Internal coolant supply

TR-VB

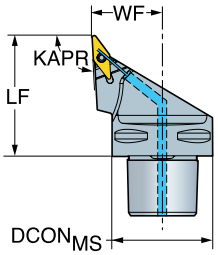
KAPR
PSIR

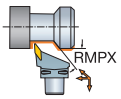


Cx-TR-V13VBN..C
72.5°
17.5°



Cx-TR-V13JBR/L..C
93.0°
-3.0°



								Dimensions, mm, inch						
		CZC$_{MS}$	DMIN$_1$	DMIN$_2$	RMPX	CNSC	Ordering code	DCON$_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
	13	C4	253.0	140.0	50°	3	C4-TR-V13JBR/L-27050C	40	50.0	27.0	150	2.0	0.34	TR-VB1308
			9.961	*5.512*				*1.575*	*1.969*	*1.063*	*2175*			
		C5	228.0	165.0	50°	3	C5-TR-V13JBR/L-35060C	50	60.0	35.0	150	2.0	0.68	TR-VB1308
			8.976	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	232.0	190.0	50°	3	C6-TR-V13JBR/L-45065C	63	65.0	45.0	150	2.0	1.13	TR-VB1308
			9.134	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			
		C8	233.0	250.0	50°	3	C8-TR-V13JBR/L-55080C	80	80.0	55.0	150	2.0	2.44	TR-VB1308
			9.173	*9.843*				*3.150*	*3.150*	*2.165*	*2175*			
	13	C4		140.0	70°	3	C4-TR-V13VBN-00050C	40	50.0	0.5	150	2.0	0.29	TR-VB1308
				5.512				*1.575*	*1.969*	*.020*	*2175*			
		C5		165.0	70°	3	C5-TR-V13VBN-00060C	50	60.0	0.5	150	2.0	0.58	TR-VB1308
				6.496				*1.969*	*2.362*	*.020*	*2175*			
		C6		190.0	70°	3	C6-TR-V13VBN-00065C	63	65.0	0.5	150	2.0	1.00	TR-VB1308
				7.480				*2.480*	*2.559*	*.020*	*2175*			

N = Neutral, R = Right hand, L = Left hand

Spare parts			
Insert screw	Bottom plug M4	Coolant nozzle	Bits insert screw
5513 020-64	3213 010-256	5691 026-03	5680 084-21

For complete list of spare parts, see www.sandvik.coromant.com

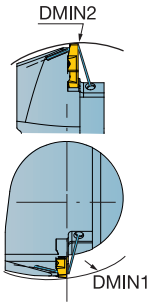
97 100

CoroTurn® TR cutting unit for turning

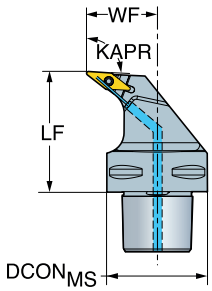
Screw clamp design

Coromant Capto® - Internal coolant supply

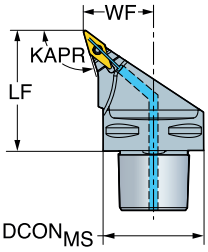
KAPR



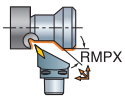
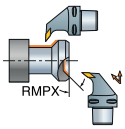
Cx-TR-V13UBR/L..C
93.0°



Cx-TR-V13HBR/L..C
107.5°



TR-VB

		CZC$_{MS}$	DMIN$_1$	DMIN$_2$	RMPX	CNSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
	13	C5	99.0	165.0	35°	3	C5-TR-V13HBR/L-35060C	50	60.0	35.0	150	2.0	0.64	TR-VB1308
			3.898	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	150.0	190.0	35°	3	C6-TR-V13HBR/L-45065C	63	65.0	45.0	150	2.0	1.15	TR-VB1308
			5.906	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			
		C8	133.0	250.0	35°	3	C8-TR-V13HBR/L-55080C	80	80.0	55.0	150	2.0	2.46	TR-VB1308
			5.236	*9.843*				*3.150*	*3.150*	*2.165*	*2175*			
		C4	95.0	140.0	35°	3	C4-TR-V13HBR/L-27050C	40	50.0	27.0	150	2.0	0.35	TR-VB1308
			3.740	*5.512*				*1.575*	*1.969*	*1.063*	*2175*			
	13	C5	67.0	165.0	50°	3	C5-TR-V13UBR/L-35060C	50	60.0	35.0	150	2.0	0.71	TR-VB1308
			2.638	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	118.0	190.0	50°	3	C6-TR-V13UBR/L-45065C	63	65.0	45.0	150	2.0	1.24	TR-VB1308
			4.646	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			
		C8	100.0	250.0	50°	3	C8-TR-V13UBR/L-55080C	80	80.0	55.0	150	2.0	2.61	TR-VB1308
			3.937	*9.843*				*3.150*	*3.150*	*2.165*	*2175*			
		C4	54.0	140.0	50°	3	C4-TR-V13UBR/L-27050C	40	50.0	27.0	150	2.0	0.38	TR-VB1308
			2.126	*5.512*				*1.575*	*1.969*	*1.063*	*2175*			

N = Neutral, R = Right hand, L = Left hand

Spare parts

Insert screw	Bottom plug M4	Coolant nozzle	Bits insert screw
5513 020-64	3213 010-256	5691 026-03	5680 084-21

For complete list of spare parts, see www.sandvik.coromant.com

97 100

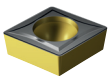
ENG

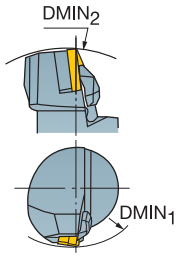
CoroTurn® 107 cutting unit for turning

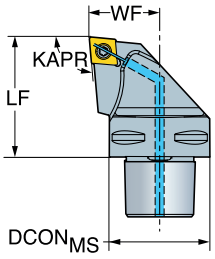
Screw clamp design

Coromant Capto® - Precision coolant supply

KAPR 95.0°
PSIR -5.0°

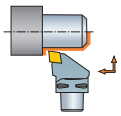






CCMT, CCGT
CCGX, CCET

CCMW

	IC		CZC$_{MS}$	DMIN$_1$	DMIN$_2$	CNSC	Ordering code	DCON$_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
				Dimensions, mm, inch										
	09	3/8	C3	265.0	700.0	3	C3-SCLCR/L-22040-09C	32	40.0	22.0	150	3.0	0.20	CCMT 09 T3 08
				10.433	*27.559*			*1.260*	*1.575*	*.866*	*2175*			
			C4	272.0	600.0	3	C4-SCLCR/L-27050-09C	40	50.0	27.0	150	3.0	0.43	CCMT 09 T3 08
				10.709	*23.622*			*1.575*	*1.969*	*1.063*	*2175*			
	12	1/2	C4	210.0	600.0	3	C4-SCLCR/L-27050-12C	40	50.0	27.0	150	3.0	0.44	CCMT 12 04 08
				8.268	*23.622*			*1.575*	*1.969*	*1.063*	*2175*			
			C5	204.0	550.0	3	C5-SCLCR/L-35060-12C	50	60.0	35.0	150	3.0	0.77	CCMT 12 04 08
				8.032	*21.654*			*1.969*	*2.362*	*1.378*	*2175*			
			C6	208.0	800.0	3	C6-SCLCR/L-45065-12C	63	65.0	45.0	150	3.0	1.34	CCMT 12 04 08
				8.189	*31.496*			*2.480*	*2.559*	*1.772*	*2175*			

R = Right hand, L = Left hand

			Spare parts	
		CZC$_{MS}$	Insert screw	Nozzle
09	3/8	C3-C5	5513 020-09	5691 026-13
12	1/2	C4-C5	5513 020-17	5691 026-13

For complete list of spare parts, see www.sandvik.coromant.com

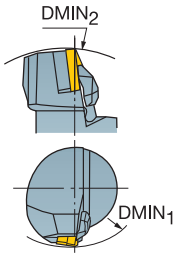
97 100

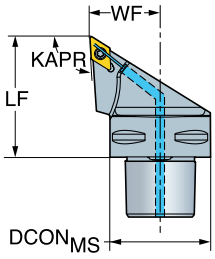
CoroTurn® 107 cutting unit for turning

Screw clamp design

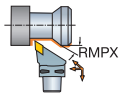
Coromant Capto® - Precision coolant supply

KAPR 93.0°
PSIR -3.0°





DCMT, DCMX
DCGT, DCGX, DCET
DCMW

									Dimensions, mm, inch						
		IC	CZC_{MS}	$DMIN_1$	$DMIN_2$	RMPX	CNSC	**Ordering code**	$DCON_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
	11	3/8	C3	244.0	135.0	27°	3	**C3-SDJCR/L-22040-11C**	32	40.0	22.0	150	3.0	0.19	DCMT 11 T3 08
				9.606	*5.315*				*1.260*	*1.575*	*.866*	*2175*			
			C4	246.0	140.0	27°	3	**C4-SDJCR/L-27050-11C**	40	50.0	27.0	150	3.0	0.38	DCMT 11 T3 08
				9.685	*5.512*				*1.575*	*1.969*	*1.063*	*2175*			
			C5	250.0	165.0	27°	3	**C5-SDJCR/L-35060-11C**	50	60.0	35.0	150	3.0	0.70	DCMT 11 T3 08
				9.843	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
			C6	250.0	190.0	27°	3	**C6-SDJCR/L-45065-11C**	63	65.0	45.0	150	3.0	1.19	DCMT 11 T3 08
				9.843	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			

R = Right hand, L = Left hand

Spare parts

Insert screw	Shim screw	Shim	Bottom plug M4	Coolant nozzle	Bits insert screw
5513 020-01	5512 090-01	5322 263-01	3213 010-256	5691 026-03	5680 084-15

For complete list of spare parts, see www.sandvik.coromant.com

97 100

CoroTurn® 107 cutting unit for turning

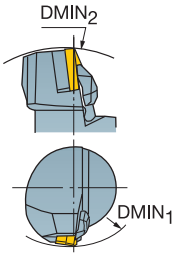
Screw clamp design

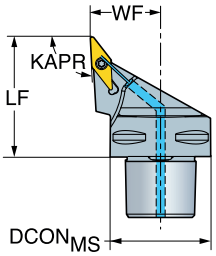
Coromant Capto® - Precision coolant supply

Cx-SVJBR/L..C

KAPR 93.0°

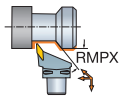
PSIR -3.0°





VBMT, VBGT
VCGX,
VCGT, VCET

VBMW, VCMW

									Dimensions, mm, inch						
			CZC_{MS}	$DMIN_1$	$DMIN_2$	RMPX	CNSC	Ordering code	$DCON_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
	11	1/4	C3	368.0	116.0	50°	3	C3-SVJBR/L-2204011B1C	32	40.0	22.0	150	0.9	0.18	VBMT 11 03 04
				14.488	*4.567*				*1.260*	*1.575*	*.866*	*2175*			
			C4	434.0	140.0	50°	3	C4-SVJBL-2705011B1C	40	50.0	27.0	150	0.9	0.36	VBMT 11 03 04
				17.087	*5.512*				*1.575*	*1.969*	*1.063*	*2175*			
			C4	434.0	140.0	50°	3	C4-SVJBR-2705011B1C	40	50.0	27.0	150	3.0	0.36	VBMT 11 03 04
				17.087	*5.512*				*1.575*	*1.969*	*1.063*	*2175*			
	16	3/8	C4	270.0	140.0	50°	3	C4-SVJBR/L-27050-16C	40	50.0	27.0	150	3.0	0.33	VBMT 16 04 08
				10.630	*5.512*				*1.575*	*1.969*	*1.063*	*2175*			
			C5	270.0	165.0	50°	3	C5-SVJBR/L-35060-16C	50	60.0	35.0	150	3.0	0.63	VBMT 16 04 08
				10.630	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
			C6	270.0	190.0	50°	3	C6-SVJBR/L-45065-16C	63	65.0	45.0	150	3.0	1.14	VBMT 16 04 08
				10.630	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			
			C8	272.0	248.0	50°	3	C8-SVJBR/L-55080-16C	80	80.0	55.0	150	3.0	2.40	VBMT 16 04 08
				10.709	*9.764*				*3.150*	*3.150*	*2.165*	*2175*			

R = Right hand, L = Left hand

	Spare parts					
MIID	Insert screw	Shim screw	Shim	Bottom plug M4	Coolant nozzle	Bits insert screw
VBMT 11	5513 020-03	-	-	3213 010-256	5691 026-03	5680 084-15
VBMT 16	5513 020-01	5512 090-01	5322 270-01	3213 010-256	5691 026-03	5680 084-15

For complete list of spare parts, see www.sandvik.coromant.com

97 100

CoroTurn® 107 cutting unit for turning

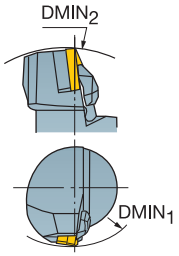
Screw clamp design

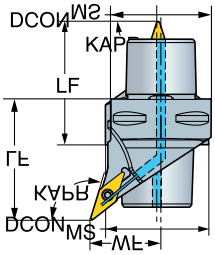
Coromant Capto® - Internal coolant supply

Cx-SVVBN..C

KAPR 72.5°

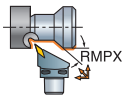
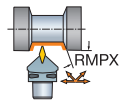
PSIR 17.5°





VBMT, VBGT
VCGX,
VCGT, VCET

VBMW, VCMW

									Ordering code	Dimensions, mm, inch						MIID
				CZC$_{MS}$	DMIN$_1$	DMIN$_2$	RMPX	CNSC		DCON$_{MS}$	LF	WF	BAR PSI	NM	KG	
	16	3/8	C4	124.0	140.0	35°	3		C4-SVHBR/L-27050-16C	40	50.0	27.0	150	3.0	0.35	VBMT 16 04 08
				4.882	*5.512*					*1.575*	*1.969*	*1.063*	*2175*			
			C5	124.0	165.0	35°	3		C5-SVHBR/L-35060-16C	50	60.0	35.0	150	3.0	0.63	VBMT 16 04 08
				4.882	*6.496*					*1.969*	*2.362*	*1.378*	*2175*			
			C6	134.0	190.0	35°	3		C6-SVHBR/L-45065-16C	63	65.0	45.0	150	3.0	1.14	VBMT 16 04 08
				5.276	*7.480*					*2.480*	*2.559*	*1.772*	*2175*			
	16	3/8	C5		165.0	70°	3		C4-SVVBN-00055-16C	50	60.0	0.6	150	3.0	0.31	VBMT 16 04 08
					6.496					*1.969*	*2.362*	*.024*	*2175*			
			C5		165.0	70°	3		C5-SVVBN-00060-16C	50	60.0	0.6	150	3.0	0.55	VBMT 16 04 08
					6.496					*1.969*	*2.362*	*.024*	*2175*			
			C6		190.0	70°	3		C6-SVVBN-00065-16C	63	65.0	0.6	150	3.0	0.97	VBMT 16 04 08
					7.480					*2.480*	*2.559*	*.024*	*2175*			

B1 = For insert with thickness 03 = 3.18 mm (2 =1/8").

N = Neutral, R = Right hand, L = Left hand

Spare parts					
Insert screw	Shim screw	Shim	Bottom plug M4	Coolant nozzle	Bits insert screw
5513 020-01	5512 090-01	5322 270-01	3213 010-256	5691 026-03	5680 084-15

For complete list of spare parts, see www.sandvik.coromant.com

97 100

ENG

Milling

High-feed milling tools

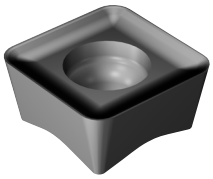
Shoulder milling tools

Optimized solid milling tools

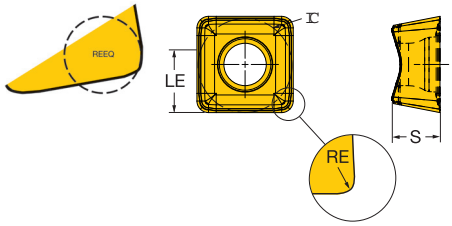
Cutting data

For complete assortment, see www.sandvik.coromant.com

CoroMill® 415 insert for milling



KRINS 15°



		RE	Ordering code	P	M				S			H		Dimensions, mm			
				1130	1040	1130	S30T	S40T	1130	S30T	S40T	1010	1130	IC	LE	S	REEQ
Medium	05	1.20	415N-05 02 12E-M30		★		☆	☆		★	☆			5.0	3.0	2.21	2.00
		.047												.197	.118	.087	.079
	05	1.20	415N-05 02 12M-M30	★	★	☆	☆	☆	☆	★	☆	★	☆	5.0	3.0	2.21	2.00
		.047												.197	.118	.087	.079
	07	2.00	415N-07 03 20E-M30		★		☆	☆		★	☆			7.0	3.0	3.07	2.20
		.079												.276	.118	.121	.087
	07	2.00	415N-07 03 20M-M30	★	★	☆	☆	☆	☆	★	☆	★	☆	7.0	3.0	3.07	2.80
		.079												.276	.118	.121	.110

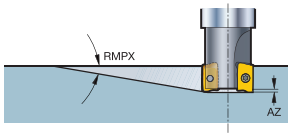
415N-05 02 12M-M30 increases DC by 1.0 mm and reduces DCX by 0.26 mm and LF by 0.13 mm
415N-07 03 20M-M30 increases DC by 1.7 mm and reduces DCX by 0.44 mm and LF by 0.22 mm
(In comparison to using the tool with MIID)

ENG

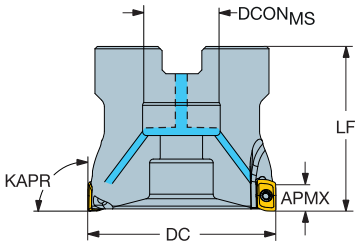
CoroMill® 390 square shoulder milling cutter

Arbor - Internal coolant supply

Lightweight shoulder milling cutter



KAPR 90°



Inch version

DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, inch DCON$_{MS}$	ISO	LF	FT/LBS	LBS	RPMX	CICT	MIID
2.000	11	3/4	.217	.394	1°	.039	1	3	**RA390-051R19LW-11L**	.750	A	1.181	.8	0.15	10000	3	R390-11..
	11	3/4	.217	.394	1°	.039	1	4	**RA390-051R19LW-11M**	.750	A	1.181	.8	0.15	10000	4	R390-11..

		Spare parts	
DC		Insert screw	Screw
2.000	11	5513 020-35	3213 030-606

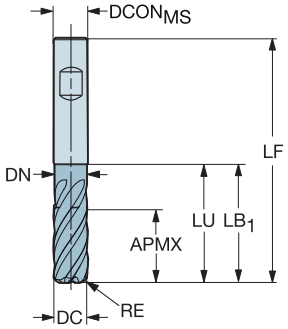
For complete list of spare parts, see www.sandvik.coromant.com

97 100

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	$DCON_{MS}$	LF	DN	LB_1
10.0	10	22.0	0.50	30.0	5	2F342-1000-050-PD	★	☆	10.0	72.0	9.5	30.0
	10	22.0	1.00	30.0	5	2F342-1000-100-PD	★	☆	10.0	72.0	9.5	30.0
	10	22.0	2.00	30.0	5	2F342-1000-200-PD	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.50	36.0	5	2F342-1200-050-PD	★	☆	12.0	83.0	11.4	36.0
	12	26.0	1.00	36.0	5	2F342-1200-100-PD	★	☆	12.0	83.0	11.4	36.0
	12	26.0	2.00	36.0	5	2F342-1200-200-PD	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.50	42.0	5	2F342-1600-050-PD	★	☆	16.0	92.0	15.2	42.0
	16	34.0	1.00	42.0	5	2F342-1600-100-PD	★	☆	16.0	92.0	15.2	42.0
	16	34.0	2.00	42.0	5	2F342-1600-200-PD	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	1.00	52.0	5	2F342-2000-100-PD	★	☆	20.0	104.0	19.0	52.0
	20	42.0	2.00	52.0	5	2F342-2000-200-PD	★	☆	20.0	104.0	19.0	52.0

Dimensions, mm

Inch version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	$DCON_{MS}$	LF	DN	LB_1
.625	5/8	1.315	.030	1.625	5	2F342-1588-076-PD	★	☆	.625	3.500	.594	1.626
	5/8	1.315	.060	1.625	5	2F342-1588-152-PD	★	☆	.625	3.500	.594	1.626
.750	3/4	1.626	.030	1.937	5	2F342-1905-076-PD	★	☆	.750	4.000	.713	1.937
	3/4	1.626	.060	1.937	5	2F342-1905-152-PD	★	☆	.750	4.000	.713	1.937

Dimensions, inch

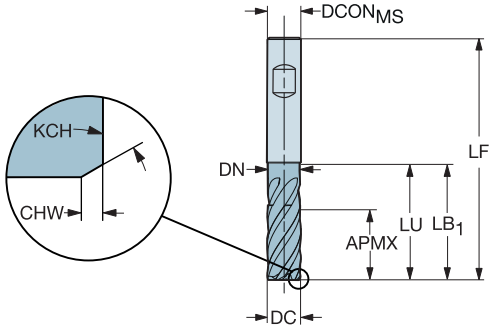
31 37 97 101

ENG

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	$DCON_{MS}$	LF	DN	LB_1
								Dimensions, mm					
10.0	10	22.0	0.15	45°	30.0	5	2N342-1000-PD	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.15	45°	36.0	5	2N342-1200-PD	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.25	45°	42.0	5	2N342-1600-PD	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	0.25	45°	52.0	5	2N342-2000-PD	★	☆	20.0	104.0	19.0	52.0
25.0	25	52.0	0.25	45°	63.0	5	2N342-2500-PD	★	☆	25.0	121.0	24.0	63.0

Inch version

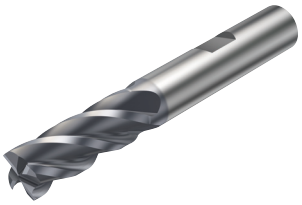
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	$DCON_{MS}$	LF	DN	LB_1
								Dimensions, inch					
.625	5/8	1.315	.010	45°	1.625	5	2N342-1588-PD	★	☆	.625	3.500	.594	1.625
.750	3/4	1.626	.010	45°	1.937	5	2N342-1905-PD	★	☆	.750	4.000	.713	1.937

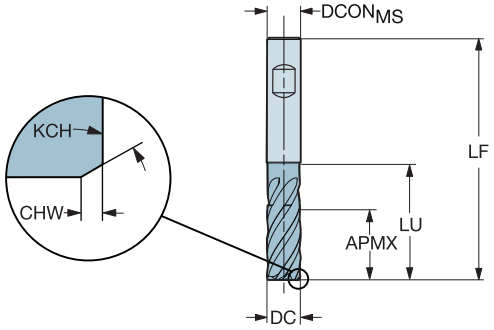
31 37 97 101

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	Dimensions, mm $DCON_{MS}$	LF
10.0	10	22.0	0.15	45°	22.0	4	2P342-1000-PB	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	4	2P342-1200-PB	★	☆	12.0	83.0
16.0	16	34.0	0.25	45°	34.0	4	2P342-1600-PB	★	☆	16.0	97.0
20.0	20	42.0	0.25	45°	42.0	4	2P342-2000-PB	★	☆	20.0	109.6
25.0	25	52.0	0.25	45°	52.0	4	2P342-2500-PB	★	☆	25.0	129.5

Inch version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	Dimensions, inch $DCON_{MS}$	LF
.625	5/8	1.313	.010	45°	1.313	4	2P342-1588-PB	★	☆	.625	3.500
.750	3/4	1.625	.010	45°	1.625	4	2P342-1905-PB	★	☆	.750	4.315

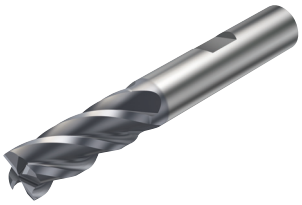
31 37 97 101

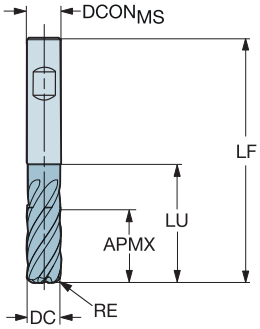
ENG

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	Dimensions, mm $DCON_{MS}$	LF
10.0	10	22.0	0.50	22.0	4	2S342-1000-050-PB	★	☆	10.0	72.0
	10	22.0	1.00	22.0	4	2S342-1000-100-PB	★	☆	10.0	72.0
	10	22.0	2.00	22.0	4	2S342-1000-200-PB	★	☆	10.0	72.0
12.0	12	26.0	0.50	26.0	4	2S342-1200-050-PB	★	☆	12.0	83.0
	12	26.0	1.00	26.0	4	2S342-1200-100-PB	★	☆	12.0	83.0
	12	26.0	2.00	26.0	4	2S342-1200-200-PB	★	☆	12.0	83.0
16.0	16	34.0	0.50	34.0	4	2S342-1600-050-PB	★	☆	16.0	97.0
	16	34.0	1.00	34.0	4	2S342-1600-100-PB	★	☆	16.0	97.0
	16	34.0	2.00	34.0	4	2S342-1600-200-PB	★	☆	16.0	97.0
20.0	20	42.0	1.00	42.0	4	2S342-2000-100-PB	★	☆	20.0	109.6
	20	42.0	2.00	42.0	4	2S342-2000-200-PB	★	☆	20.0	109.6

Inch version

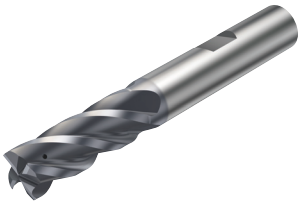
DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	Dimensions, inch $DCON_{MS}$	LF
.625	5/8	1.313	.030	1.313	4	2S342-1588-076-PB	★	☆	.625	3.500
	5/8	1.315	.060	1.315	4	2S342-1588-152-PB	★	☆	.625	3.500
.750	3/4	1.625	.030	1.625	4	2S342-1905-076-PB	★	☆	.750	4.315
	3/4	1.625	.060	1.625	4	2S342-1905-152-PB	★	☆	.750	4.315

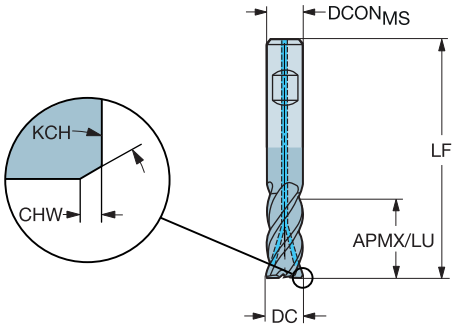
31 37 97 101

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

DC	CZC_{MS}	APMX	CHW	KCH	LU	CXSC	ZEFP	Ordering code	M 1740	S 1740	Dimensions, mm $DCON_{MS}$	LF
10.0	10	22.0	0.15	45°	22.0	3	4	2P342-1000-CMB	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	3	4	2P342-1200-CMB	★	☆	12.0	83.0
16.0	16	34.0	0.25	45°	34.0	3	4	2P342-1600-CMB	★	☆	16.0	97.0
20.0	20	42.0	0.25	45°	42.0	3	4	2P342-2000-CMB	★	☆	20.0	109.6
25.0	25	52.0	0.25	45°	52.0	3	4	2P342-2500-CMB	★	☆	25.0	129.5

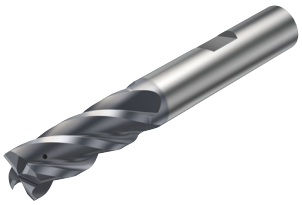
31 37 97 101

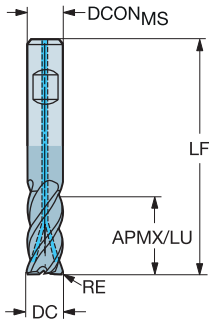
ENG

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

DC	CZCMS	APMX	RE	LU	CNSC	CXSC	ZEFP	FHA	Ordering code	M 1740	S 1740	DCONMS	LF
10.0	10	22.0	0.50	22.0	1	4	4	38°	2S342-1000-050CMB	★	☆	10.0	72.0
	10	22.0	1.00	22.0	1	4	4	38°	2S342-1000-100CMB	★	☆	10.0	72.0
	10	22.0	1.50	22.0	1	4	4	38°	2S342-1000-150CMB	★	☆	10.0	72.0
	10	22.0	2.00	22.0	1	4	4	38°	2S342-1000-200CMB	★	☆	10.0	72.0
	10	22.0	3.00	22.0	1	4	4	38°	2S342-1000-300CMB	★	☆	10.0	72.0
12.0	12	26.0	0.50	26.0	1	4	4	38°	2S342-1200-050CMB	★	☆	12.0	83.0
	12	26.0	1.00	26.0	1	4	4	38°	2S342-1200-100CMB	★	☆	12.0	83.0
	12	26.0	1.50	26.0	1	4	4	38°	2S342-1200-150CMB	★	☆	12.0	83.0
	12	26.0	2.00	26.0	1	4	4	38°	2S342-1200-200CMB	★	☆	12.0	83.0
	12	26.0	3.00	26.0	1	4	4	38°	2S342-1200-300CMB	★	☆	12.0	83.0
16.0	16	34.0	0.50	34.0	1	4	4	38°	2S342-1600-050CMB	★	☆	16.0	97.0
	16	34.0	1.00	34.0	1	4	4	38°	2S342-1600-100CMB	★	☆	16.0	97.0
	16	34.0	2.00	34.0	1	4	4	42°	2S342-1600-200CMB	★	☆	16.0	97.0
	16	34.0	3.00	34.0	1	4	4	38°	2S342-1600-300CMB	★	☆	16.0	97.0
	16	34.0	4.00	34.0	1	4	4	38°	2S342-1600-400CMB	★	☆	16.0	97.0
	16	34.0	5.00	34.0	1	4	4	38°	2S342-1600-500CMB	★	☆	16.0	97.0
20.0	20	42.0	1.00	42.0	1	4	4	38°	2S342-2000-100CMB	★	☆	20.0	109.6
	20	42.0	2.00	42.0	1	4	4	38°	2S342-2000-200CMB	★	☆	20.0	109.6
	20	42.0	3.00	42.0	1	4	4	38°	2S342-2000-300CMB	★	☆	20.0	109.6
	20	42.0	4.00	42.0	1	4	4	38°	2S342-2000-400CMB	★	☆	20.0	109.6
	20	42.0	5.00	42.0	1	4	4	38°	2S342-2000-500CMB	★	☆	20.0	109.6
	20	42.0	6.35	42.0	1	4	4	38°	2S342-2000-635CMB	★	☆	20.0	109.6

Dimensions, mm

Inch version

DC	CZCMS	APMX	RE	LU	CNSC	CXSC	ZEFP	FHA	Ordering code	M 1740	S 1740	DCONMS	LF
.625	5/8	1.313	.030	1.313	1	4	4	38°	2S342-1588-076CMB	★	☆	.625	3.780
	5/8	1.313	.060	1.313	1	4	4	38°	2S342-1588-152CMB	★	☆	.625	3.780
	5/8	1.313	.090	1.313	1	4	4	38°	2S342-1588-229CMB	★	☆	.625	3.780
	5/8	1.313	.120	1.313	1	4	4	38°	2S342-1588-305CMB	★	☆	.625	3.780
.750	3/4	1.625	.030	1.625	1	4	4	38°	2S342-1905-076CMB	★	☆	.750	4.315
	3/4	1.625	.060	1.625	1	4	4	38°	2S342-1905-152CMB	★	☆	.750	4.315
	3/4	1.625	.090	1.625	1	4	4	38°	2S342-1905-229CMB	★	☆	.750	4.315
	3/4	1.625	.120	1.625	1	4	4	38°	2S342-1905-305CMB	★	☆	.750	4.315
	3/4	1.625	.190	1.625	1	4	4	38°	2S342-1905-483CMB	★	☆	.750	4.315

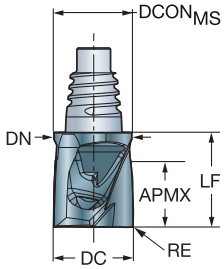
Dimensions, inch

31 37 97 101

CoroMill® 316 solid carbide head for high chip load milling

For multi-material with hardness ≤ 48 HRc

FHA	10°
BSG	COROMANT
TCDC	h10



Metric version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	$DCON_{MS}$	LF	DN
10.0	E10	8.0	0.50	2	316-10SM210-10005P	★	★	☆	☆	9.7	11.8	9.7
	E10	8.0	0.80	2	316-10SM210-10008P	★	★	☆	☆	9.7	11.8	9.7
	E10	8.0	1.00	2	316-10SM210-10010P	★	★	☆	☆	9.7	11.8	9.7
12.0	E12	10.0	0.50	2	316-12SM210-12005P	★	★	☆	☆	11.7	14.0	11.7
	E12	10.0	0.80	2	316-12SM210-12008P	★	★	☆	☆	11.7	14.0	11.7
16.0	E16	13.0	0.50	2	316-16SM210-16005P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	0.80	2	316-16SM210-16008P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	1.00	2	316-16SM210-16010P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	3.00	2	316-16SM210-16030P	★	★	☆	☆	15.5	18.1	15.5

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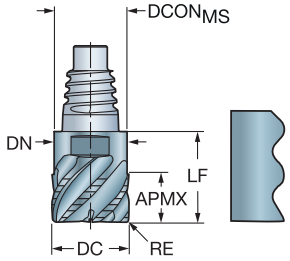
ENG

CoroMill® 316 solid carbide head for roughing with chip breaker

For multi-material with hardness ≤ 48 HRc

FHA	45°
BSG	COROMANT
TCDC	h12



Metric version

DC	CZC$_{MS}$	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	LF	DN
						Dimensions, mm						
10.0	E10	5.5	0.40	4	316-10SM440-10004K	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	0.40	5	316-10SM545-10004K	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	0.40	5	316-12SM545-12004K	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	0.40	4	316-12SM440-12004K	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	0.40	6	316-16SM645-16004K	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	0.40	4	316-16SM440-16004K	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	0.40	6	316-20SM645-20004K	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	0.40	8	316-25SM845-25004K	★	★	☆	☆	24.2	25.6	24.2

Inch version

DC	CZC$_{MS}$	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	LF	DN
						Dimensions, inch						
.375	E10	.209	.016	4	A316-10SM440-03704K	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.016	4	A316-12SM440-05004K	★	★	☆	☆	.484	.575	.484
	E12	.276	.062	4	A316-12SM440-05015K	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.062	4	A316-16SM440-06215K	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.015	4	A316-20SM440-07504K	★	★	☆	☆	.728	.839	.728
	E20	.413	.016	6	A316-20SM645-07504K	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.016	8	A316-25SM845-10004K	★	★	☆	☆	.965	1.008	.965

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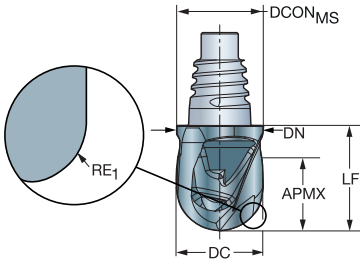
CoroMill® 316 solid carbide head for profiling

For multi-material with hardness ≤ 48 HRc

BSG	COROMANT
TCDC	h9
PSIR	0°



Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	E10	8.0	5.00	2	10°	316-10BM210-10050G	★	★	☆	☆	9.7	11.8	9.7
12.0	E12	10.0	6.00	2	10°	316-12BM210-12060G	★	★	☆	☆	11.7	14.0	11.7
16.0	E16	13.0	8.00	2	10°	316-16BM210-16080G	★	★	☆	☆	15.5	18.1	15.5

Inch version

DC	CZC$_{MS}$	APMX	RE$_1$	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCON$_{MS}$	LF	DN
.375	E10	.315	.188	2	10°	A316-10BM210-03750G	★	★	☆	☆	.364	.465	.382
.500	E12	.413	.250	2	10°	A316-12BM210-05060G	★	★	☆	☆	.484	.551	.461
.625	E16	.512	.313	2	10°	A316-16BM210-06280G	★	★	☆	☆	.610	.713	.610

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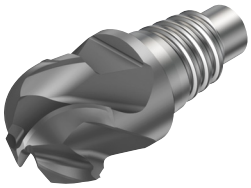
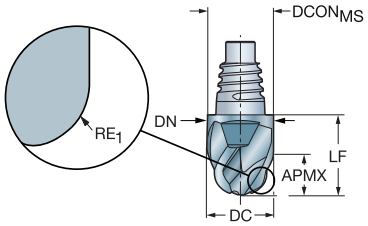
ENG

CoroMill® 316 solid carbide head for profiling

For multi-material with hardness ≤ 48 HRc

BSG	COROMANT
TCDC	h9
PSIR	0°





Metric version

DC	CZCMS	APMX	RE1	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCONMS	LF	DN
10.0	E10	5.5	5.00	4	40°	316-10BM440-10050G	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	6.00	4	40°	316-12BM440-12060G	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	8.00	4	40°	316-16BM440-16080G	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	10.00	2	40°	316-20BM240-200AG	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	10.00	4	40°	316-20BM440-200AG	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	12.50	4	40°	316-25BM440-250DG	★	★	☆	☆	24.2	25.6	24.2

Inch version

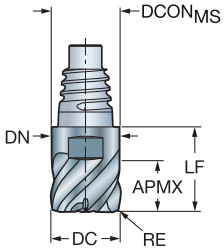
DC	CZCMS	APMX	RE1	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCONMS	LF	DN
.375	E10	.209	.188	4	40°	A316-10BM440-03750G	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.250	4	40°	A316-12BM440-05060G	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.313	4	40°	A316-16BM440-06280G	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.375	4	40°	A316-20BM440-075AG	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.500	4	40°	A316-25BM440-100CG	★	★	☆	☆	.965	1.008	.965

36 37 97

CoroMill® 316 solid carbide head for finishing

For multi-material with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9



Metric version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	$DCON_{MS}$	LF	DN
						Dimensions, mm						
10.0	E10	5.5	1.00	6	316-10FM650-10010L	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	1.00	6	316-12FM650-12010L	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	1.50	6	316-16FM650-16015L	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	1.50	8	316-20FM850-20015L	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	1.00	8	316-25FM850-25010L	★	★	☆	☆	24.2	25.6	24.2

Inch version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	$DCON_{MS}$	LF	DN
						Dimensions, inch						
.375	E10	.209	.015	6	A316-10FM650-03704L	★	★	☆	☆	.364	.488	.364
	E10	.209	.031	6	A316-10FM650-03708L	★	★	☆	☆	.364	.488	.364
	E10	.209	.062	6	A316-10FM650-03715L	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.015	6	A316-12FM650-05004L	★	★	☆	☆	.484	.575	.484
	E12	.276	.062	6	A316-12FM650-05015L	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.031	6	A316-16FM650-06208L	★	★	☆	☆	.610	.736	.610
	E16	.335	.031	8	A316-16FM850-06208L	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.031	8	A316-20FM850-07508L	★	★	☆	☆	.728	.839	.728
	E20	.413	.031	10	A316-20FMA50-07508L	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.062	10	A316-25FMA50-10015L	★	★	☆	☆	.965	1.008	.965
	E25	.551	.062	12	A316-25FMC50-10015L	★	★	☆	☆	.965	1.008	.965

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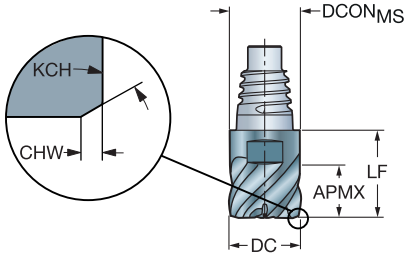
ENG

CoroMill® 316 solid carbide head for finishing

For multi-material with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h10



Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	E10	5.5	0.10	45°	6	**316-10FM650-10000L**	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	0.10	45°	6	**316-12FM650-12000L**	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	0.15	45°	6	**316-16FM650-16000L**	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	0.15	45°	8	**316-20FM850-20000L**	★	★	☆	☆	19.3	21.3	19.3

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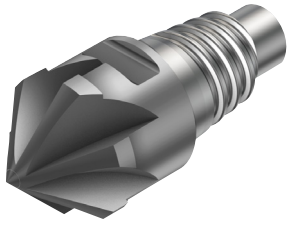
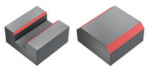
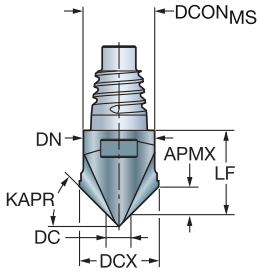
CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc

BSG COROMANT







Metric version

KAPR	CZCMS	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCONMS	DC	DCX	LF	DN
15°	E12	1.20	6	316-12CM600-12015G	★	★	☆	☆	11.70	3.00	12.0	14.50	11.7
30°		2.60	6	316-12CM600-12030G	★	★	☆	☆	11.70	3.00	12.0	13.60	11.7
45°	E10	4.25	4	316-10CM400-10045G	★	★	☆	☆	9.70	1.50	10.0	11.66	9.7
45°	E12	4.50	6	316-12CM600-12045G	★	★	☆	☆	11.70	3.00	12.0	13.00	11.7
45°	E16	6.00	8	316-16CM800-16045G	★	★	☆	☆	15.50	4.00	16.0	16.70	15.5
60°	E10	5.60	4	316-10CM400-10060G	★	★	☆	☆	9.70	3.50	10.0	12.40	9.7
60°	E12	6.50	6	316-12CM600-12060G	★	★	☆	☆	11.70	4.50	12.0	14.50	11.7

Inch version

KAPR	CZCMS	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCONMS	DC	DCX	LF	DN
30°	E10	.073	4	A316-10CM400-03730G	★	★	☆	☆	.364	.118	.375	.454	.364
30°	E12	.110	6	A316-12CM600-05030G	★	★	☆	☆	.484	.118	.500	.541	.484
30°	E16	.146	8	A316-16CM800-06230G	★	★	☆	☆	.610	.118	.625	.702	.610
45°	E10	.128	4	A316-10CM400-03745G	★	★	☆	☆	.364	.118	.375	.429	.364
45°	E12	.191	6	A316-12CM600-05045G	★	★	☆	☆	.484	.118	.500	.516	.484
45°	E16	.256	8	A316-16CM800-06245G	★	★	☆	☆	.610	.256	.625	.736	.610
49°	E12	.220	6	A316-12CM600-05049G	★	★	☆	☆	.484	.118	.500	.575	.484
49°	E16	.291	8	A316-16CM800-06249G	★	★	☆	☆	.610	.118	.625	.736	.610
60°	E10	.222	4	A316-10CM400-03760G	★	★	☆	☆	.364	.118	.375	.488	.364
60°	E12	.280	6	A316-12CM600-05060G	★	★	☆	☆	.484	.177	.500	.575	.484
60°	E16	.303	8	A316-16CM800-06260G	★	★	☆	☆	.610	.276	.625	.736	.610

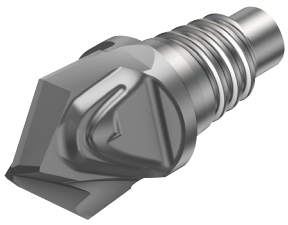
35 37 97

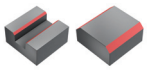
ENG

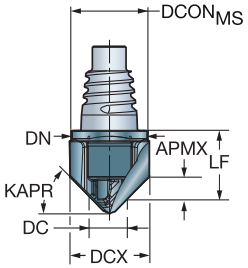
CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc

BSG COROMANT







Metric version

KAPR	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCON$_{MS}$	DC	DCX	LF	DN
15°	E12	1.33	2	316-12CM210-12015G	★	★	☆	☆	11.70	1.50	12.0	13.70	11.7
30°		3.03	2	316-12CM210-12030G	★	★	☆	☆	11.70	1.50	12.0	13.73	11.7
45°	E10	4.23	2	316-10CM210-10045G	★	★	☆	☆	9.70	1.50	10.0	11.53	9.7
45°	E12	5.23	2	316-12CM210-12045G	★	★	☆	☆	11.70	1.50	12.0	13.27	11.7
45°	E16	7.23	2	316-16CM210-16045G	★	★	☆	☆	15.50	1.50	16.0	17.83	15.5
60°	E10	7.50	2	316-10CM210-10060G	★	★	☆	☆	9.70	1.50	10.0	11.53	9.7
60°	E12	7.73	2	316-12CM210-12060G	★	★	☆	☆	11.70	1.50	12.0	13.27	11.7

Inch version

KAPR	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCON$_{MS}$	DC	DCX	LF	DN
45°	E10	4.29	2	A316-10CM210-03745G	★	★	☆	☆	9.25	1.50	9.5	11.53	9.3
45°	E12	5.85	2	A316-12CM210-05045G	★	★	☆	☆	12.30	1.50	12.7	13.80	12.3
45°	E16	7.45	2	A316-16CM210-06245G	★	★	☆	☆	15.50	1.50	15.9	17.83	15.5

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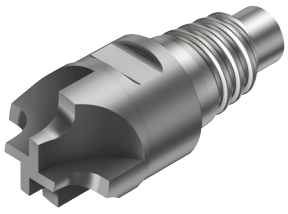
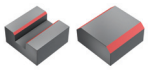
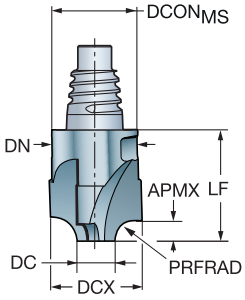
CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc

BSG COROMANT







Metric version

PRFRAD	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCON$_{MS}$	DC	DCX	LF	DN
1.5	E10	1.50	4	316-10UM400-10015G	★	★	☆	☆	9.70	5.00	10.0	12.40	9.7
3.0		3.00	4	316-10UM400-10030G	★	★	☆	☆	9.70	4.00	10.0	12.40	9.7
3.0	E12	3.00	4	316-12UM400-12030G	★	★	☆	☆	11.70	5.00	12.0	14.50	11.7
4.0		4.00	4	316-12UM400-12040G	★	★	☆	☆	11.70	4.00	12.0	14.50	11.7
4.0	E16	4.00	4	316-16UM400-16040G	★	★	☆	☆	15.50	6.00	16.0	18.70	15.5
5.0		5.00	4	316-16UM400-16050G	★	★	☆	☆	15.50	6.00	16.0	18.70	15.5
6.0	E20	6.00	4	316-20UM400-20060G	★	★	☆	☆	19.30	8.00	20.0	21.30	19.3
8.0	E25	8.00	4	316-25UM400-25080G	★	★	☆	☆	24.20	8.00	25.0	25.60	24.2

Inch version

PRFRAD	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCON$_{MS}$	DC	DCX	LF	DN
.062	E10	.062	4	A316-10UM400-03715G	★	★	☆	☆	.364	.236	.375	.488	.364
.125		.125	4	A316-10UM400-03732G	★	★	☆	☆	.364	.118	.375	.488	.364
.188	E16	.188	4	A316-16UM400-06247G	★	★	☆	☆	.610	.236	.625	.736	.610
.250	E20	.250	4	A316-20UM400-07563G	★	★	☆	☆	.728	.236	.750	.839	.728

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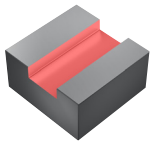
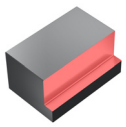
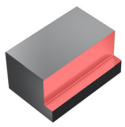
ENG

Cutting speed recommendations

Optimized - CoroMill® Plura solid carbide end mill for heavy duty milling







					a_e = 1.0 x DC a_p = 1.0 x DC			a_e = 0.5 x DC a_p = 1.0 x DC			a_e = 0.25 x DC a_p = 1.0 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	D01	150	492	D02	180	590	D03	250	820
	P2.2.Z.AN	02.2	Low-alloyed steel	240	D04	120	394	D02	145	475	D03	200	656
	P3.0.Z.HT	03.21	High alloyed steel	380	D04	80	262	D02	95	311	D03	135	442
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	D04	115	377	D02	140	459	D03	195	639
	M1.0.Z.AQ	05.21	Austenic stainless steel	200	D04	80	262	D05	100	328	D06	140	459
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	D04	80	262	D08	95	311	D09	135	442
K	K1.1.C.NS	07.2	Malleable cast iron	200	D01	150	492	D02	180	590	D03	250	820
	K2.1.C.UT	08.2	Grey cast iron	180	D01	150	492	D02	180	590	D03	250	820
	K3.2.C.UT	09.2	Nodular cast iron	215	D01	160	525	D02	190	623	D03	270	885
S	S2.0.Z.AG	20.22	Nickel based super alloys	350	D07	20	148	D08	25	180	D09	32	246
	S4.2.Z.AN	23.22	Titanium based alloys	320	D07	40	262	D08	50	311	D09	60	442

For optimized cutting data see CoroPlus® ToolGuide.

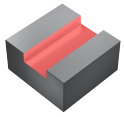
Feed recommendations

mm/tooth
inch/tooth

DC	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	19.050	20.000	25.000
f_z	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.750*	*0.787*	*0.984*
D01	0.020	0.024	0.028	0.035	0.036	0.042	0.043	0.048	0.050	0.057	0.059	0.063	0.070	0.070	0.080	0.083	0.100
	0.0008	*0.0009*	*0.0011*	*0.0014*	*0.0014*	*0.0017*	*0.0017*	*0.0019*	*0.0020*	*0.0022*	*0.0023*	*0.0025*	*0.0027*	*0.0028*	*0.0032*	*0.0033*	*0.0039*
D02	0.024	0.030	0.036	0.047	0.049	0.058	0.059	0.067	0.070	0.080	0.084	0.090	0.099	0.100	0.115	0.120	0.145
	0.0009	*0.0012*	*0.0014*	*0.0019*	*0.0019*	*0.0023*	*0.0023*	*0.0026*	*0.0028*	*0.0031*	*0.0033*	*0.0035*	*0.0039*	*0.0039*	*0.0045*	*0.0047*	*0.0057*
D03	0.028	0.035	0.041	0.054	0.056	0.067	0.067	0.077	0.080	0.093	0.098	0.107	0.119	0.120	0.140	0.147	0.180
	0.0011	*0.0014*	*0.0016*	*0.0021*	*0.0022*	*0.0026*	*0.0026*	*0.0030*	*0.0031*	*0.0037*	*0.0039*	*0.0042*	*0.0047*	*0.0047*	*0.0055*	*0.0058*	*0.0071*
D04	0.020	0.023	0.025	0.030	0.031	0.035	0.035	0.039	0.040	0.047	0.049	0.053	0.060	0.060	0.070	0.073	0.090
	0.0008	*0.0009*	*0.0010*	*0.0012*	*0.0012*	*0.0014*	*0.0014*	*0.0015*	*0.0016*	*0.0018*	*0.0019*	*0.0021*	*0.0023*	*0.0024*	*0.0028*	*0.0029*	*0.0035*
D05	0.020	0.023	0.025	0.037	0.040	0.051	0.052	0.063	0.067	0.076	0.079	0.084	0.093	0.093	0.107	0.111	0.133
	0.0008	*0.0009*	*0.0010*	*0.0015*	*0.0016*	*0.0020*	*0.0020*	*0.0025*	*0.0026*	*0.0030*	*0.0031*	*0.0033*	*0.0037*	*0.0037*	*0.0042*	*0.0044*	*0.0052*
D06	0.020	0.023	0.026	0.044	0.047	0.061	0.062	0.076	0.080	0.090	0.094	0.100	0.109	0.110	0.125	0.130	0.200
	0.0008	*0.0009*	*0.0010*	*0.0017*	*0.0019*	*0.0024*	*0.0024*	*0.0030*	*0.0031*	*0.0035*	*0.0037*	*0.0039*	*0.0043*	*0.0043*	*0.0049*	*0.0051*	*0.0079*
D07	0.020	0.020	0.020	0.020	0.021	0.027	0.028	0.033	0.035	0.038	0.040	0.042	0.045	0.045	0.050	0.052	0.060
	0.0008	*0.0008*	*0.0008*	*0.0008*	*0.0008*	*0.0011*	*0.0011*	*0.0013*	*0.0014*	*0.0015*	*0.0016*	*0.0016*	*0.0018*	*0.0018*	*0.0020*	*0.0020*	*0.0024*
D08	0.024	0.026	0.029	0.033	0.034	0.037	0.038	0.041	0.042	0.048	0.050	0.054	0.060	0.060	0.069	0.072	0.087
	0.0009	*0.0010*	*0.0011*	*0.0013*	*0.0013*	*0.0015*	*0.0015*	*0.0016*	*0.0017*	*0.0019*	*0.0020*	*0.0021*	*0.0023*	*0.0024*	*0.0027*	*0.0028*	*0.0034*
D09	0.030	0.033	0.035	0.040	0.041	0.045	0.045	0.049	0.050	0.070	0.077	0.091	0.110	0.111	0.142	0.152	0.203
	0.0012	*0.0013*	*0.0014*	*0.0016*	*0.0016*	*0.0018*	*0.0018*	*0.0019*	*0.0020*	*0.0028*	*0.0030*	*0.0036*	*0.0043*	*0.0044*	*0.0056*	*0.0060*	*0.0080*

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for high chip load milling



					a_e = 1.0 x DC a_p = 0.5 x DC			a_e = 0.5 x DC a_p = 0.5 x DC			a_e = 0.1 x DC a_p = 0.75 x DC		
ISO	**MC No.**	**CMC**	**Material**	**HB**	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	O01	145	476	O02	195	640	O03	290	951
	P2.2.Z.AN	02.2	Low-alloyed steel	240	O01	110	361	O02	150	492	O03	225	738
	P3.0.Z.HT	03.21	High alloyed steel	380	O01	55	180	O02	75	246	O03	115	377
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	O01	75	246	O02	100	328	O03	150	492
	M1.0.Z.AQ	05.21	Austenic stainless steel	200	O06	60	197	O05	85	279	O04	125	410
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	O06	75	246	O05	100	328	O04	150	492
K	K1.1.C.NS	07.2	Malleable cast iron	200	O01	140	459	O02	185	607	O03	280	919
	K2.1.C.UT	08.2	Grey cast iron	180	O01	75	246	O02	105	344	O03	155	509
	K3.2.C.UT	09.2	Nodular cast iron	215	O01	110	361	O02	150	492	O03	220	722
S	S1.0.U.AG	20.12	Iron based superalloys	280	O06	20	66	O05	25	82	O04	40	131
	S2.0.Z.AG	20.22	Nickel based super alloys	350	O06	15	49	O05	25	82	O04	35	115
	S4.2.Z.AN	23.22	Titanium based alloys	320	O06	25	82	O05	35	115	O04	50	164

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

DC	10.000	12.000	16.000
f_z	*0.394*	*0.472*	*0.630*
O01	0.070	0.080	0.110
	0.0028	*0.0031*	*0.0043*
O02	0.120	0.120	0.140
	0.0047	*0.0047*	*0.0055*
O03	0.140	0.140	0.140
	0.0055	*0.0055*	*0.0055*
O04	0.120	0.120	0.120
	0.0047	*0.0047*	*0.0047*
O05	0.075	0.090	0.120
	0.0030	*0.0035*	*0.0047*
O06	0.050	0.060	0.070
	0.0020	*0.0024*	*0.0028*

ENG

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for roughing with chip breaker

				a_e = 1.0 x DC			a_e = 0.5 x DC			a_e = 0.1 x DC		
				a_p = 0.5 x DC			a_p = 1.0 x DC			a_p = 1.5 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	L01	170	558	L02	220	722	L03	315	1033
	P2.2.Z.AN	02.2	Low-alloyed steel	240	L01	120	394	L02	160	525	L03	230	755
	P3.0.Z.HT	03.21	High alloyed steel	380	L01	80	262	L02	100	328	L03	140	459
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	L01	50	164	L02	65	213	L03	95	312
	M1.0.Z.AQ	05.21	Austenic stainless steel	200	L04	60	197	L05	75	246	L06	115	377
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	L04	50	164	L05	65	213	L06	95	312
K	K1.1.C.NS	07.2	Malleable cast iron	200	L01	130	427	L02	170	558	L03	245	804
	K2.1.C.UT	08.2	Grey cast iron	180	L01	130	427	L02	170	558	L03	245	804
	K3.2.C.UT	09.2	Nodular cast iron	215	L01	115	377	L02	155	509	L03	220	722
N	N1.2.Z.AG	30.12	Aluminium based alloys	100	L08	1270	4167	L09	1610	5282	L07	2150	7054
	N1.3.C.UT	30.21	Aluminium based alloys	75	L08	310	1017	L09	380	1247	L07	540	1772
	N1.4.C.NS	30.42	Aluminium based alloys	130	L08	110	361	L09	150	492	L07	220	722
	N3.2.C.UT	33.2	Copper and copper alloys	90	L08	170	558	L09	230	755	L07	320	1050
S	S1.0.U.AG	20.12	Iron based superalloys	280	L04	20	66	L05	30	98	L06	50	164
	S2.0.Z.AG	20.22	Nickel based superalloys	350	L04	20	66	L05	30	98	L06	50	164
	S4.2.Z.AN	23.22	Titanium based alloys	320	L04	50	164	L05	80	262	L06	130	427

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

DC	6	8	9.525	10	12	12.7	14	15.875	16	18	20	25	25.4
f_z	*0.236*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.787*	*0.984*	*1.000*
L01	0.030	0.050	0.060	0.060	0.070	0.070	0.080	0.090	0.090	0.100	0.100	0.100	0.100
	0.0012	*0.0020*	*0.0024*	*0.0024*	*0.0028*	*0.0028*	*0.0031*	*0.0035*	*0.0035*	*0.0039*	*0.0039*	*0.0039*	*0.0039*
L02	0.040	0.070	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.120	0.140	0.160	0.160
	0.0016	*0.0028*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0055*	*0.0063*	*0.0063*
L03	0.070	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.150	0.200	0.200	0.200
	0.0028	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0059*	*0.0079*	*0.0079*	*0.0079*
L04	0.020	0.040	0.050	0.050	0.060	0.060	0.060	0.070	0.070	0.080	0.080	0.080	0.080
	0.0008	*0.0016*	*0.0020*	*0.0020*	*0.0024*	*0.0024*	*0.0024*	*0.0028*	*0.0028*	*0.0031*	*0.0031*	*0.0031*	*0.0031*
L05	0.040	0.060	0.080	0.080	0.080	0.080	0.080	0.100	0.100	0.100	0.110	0.130	0.130
	0.0016	*0.0024*	*0.0031*	*0.0031*	*0.0031*	*0.0031*	*0.0031*	*0.0039*	*0.0039*	*0.0039*	*0.0043*	*0.0051*	*0.0051*
L06	0.060	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.160	0.160	0.160
	0.0024	*0.0031*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0063*	*0.0063*	*0.0063*
L07	0.150	0.200	0.260	0.260	0.260	0.260	0.260	0.260	0.260	0.330	0.440	0.440	0.440
	0.0059	*0.0079*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0130*	*0.0173*	*0.0173*	*0.0173*
L08	0.070	0.110	0.130	0.130	0.150	0.150	0.180	0.200	0.200	0.220	0.220	0.220	0.220
	0.0028	*0.0043*	*0.0051*	*0.0051*	*0.0059*	*0.0059*	*0.0071*	*0.0079*	*0.0079*	*0.0087*	*0.0087*	*0.0087*	*0.0087*
L09	0.100	0.160	0.220	0.220	0.220	0.220	0.220	0.260	0.260	0.260	0.310	0.350	0.350
	0.0039	*0.0063*	*0.0087*	*0.0087*	*0.0087*	*0.0087*	*0.0087*	*0.0102*	*0.0102*	*0.0102*	*0.0122*	*0.0138*	*0.0138*

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for finishing

						a_e = 0.1 x DC				a_e = 0.05 x DC								
						a_p = 1.0 x DC				a_p = 1.5 x DC								
ISO	MC No.	CMC	Material	HB		f_z	v_c m/min	v_c feet/min		f_z	v_c m/min	v_c feet/min						
P	P1.2.Z.AN	01.2	Unalloyed steel	190		J01	280	919		J02	330	1083						
	P2.2.Z.AN	02.2	Low-alloyed steel	240		J01	205	673		J02	240	787						
	P3.0.Z.HT	03.21	High alloyed steel	380		J01	120	394		J02	140	459						
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200		J01	80	262		J02	95	312						
	M1.0.Z.AQ	05.21	Austenic stainless steel	200		J03	100	328		J04	115	377						
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260		J03	80	262		J04	95	312						
K	K1.1.C.NS	07.2	Malleable cast iron	200		J01	220	722		J04	255	837						
	K2.1.C.UT	08.2	Grey cast iron	180		J01	220	722		J02	255	837						
	K3.2.C.UT	09.2	Nodular cast iron	215		J01	140	459		J02	165	541						
S	S1.0.U.AG	20.12	Iron based superalloys	280		J03	50	164		J04	60	197						
	S2.0.Z.AG	20.22	Nickel based super alloys	350		J03	50	164		J04	60	197						
	S4.2.Z.AN	23.22	Titanium based alloys	320		J03	80	262		J04	95	312						
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC		J03	120	394		J04	140	459						
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC		J03	120	394		J04	140	459						
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC		J03	70	230		J04	80	262						

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

DC	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.750*	*0.787*	*0.984*	*1.000*
J01	0.040	0.050	0.070	0.070	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.150	0.180	0.200	0.200	0.200
	0.0016	*0.0020*	*0.0028*	*0.0028*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0059*	*0.0071*	*0.0079*	*0.0079*	*0.0079*
J02	0.050	0.060	0.080	0.080	0.120	0.120	0.150	0.150	0.150	0.150	0.150	0.160	0.160	0.180	0.200	0.200	0.250	0.250
	0.0020	*0.0024*	*0.0031*	*0.0031*	*0.0047*	*0.0047*	*0.0059*	*0.0059*	*0.0059*	*0.0059*	*0.0059*	*0.0063*	*0.0063*	*0.0071*	*0.0079*	*0.0079*	*0.0098*	*0.0098*
J03	0.030	0.040	0.060	0.060	0.080	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.140	0.160	0.160	0.160
	0.0012	*0.0016*	*0.0024*	*0.0024*	*0.0031*	*0.0031*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0055*	*0.0063*	*0.0063*	*0.0063*
J04	0.040	0.050	0.060	0.060	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.140	0.140	0.150	0.160	0.160	0.200	0.200
	0.0016	*0.0020*	*0.0024*	*0.0024*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0055*	*0.0055*	*0.0059*	*0.0063*	*0.0063*	*0.0079*	*0.0079*

ENG

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for chamfer milling

								a_e = 0.1 x DC	a_p = 0.1 x DC
ISO	**MC No.**	**CMC**	**Material**	**HB**	f_z	v_c m/min	v_c feet/min		
P	P1.2.Z.AN	01.2	Unalloyed steel	190	C01	320	1050		
	P2.2.Z.AN	02.2	Low-alloyed steel	240	C01	220	722		
	P3.0.Z.HT	03.21	High alloyed steel	380	C01	130	427		
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	C01	90	295		
	M1.0.Z.AQ	05.21	Austenic stainless steel	200	C02	110	361		
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	C02	70	230		
K	K1.1.C.NS	07.2	Malleable cast iron	200	C01	240	787		
	K2.1.C.UT	08.2	Grey cast iron	180	C01	240	787		
	K3.2.C.UT	09.2	Nodular cast iron	215	C01	215	705		
N	N1.2.Z.AG	30.12	Aluminium based alloys	100	C03	2300	7546		
	N1.3.C.UT	30.21	Aluminium based alloys	75	C03	370	1214		
	N1.4.C.NS	30.42	Aluminium based alloys	130	C03	240	787		
	N3.2.C.UT	33.2	Copper and copper alloys	90	C03	680	2231		
S	S1.0.U.AG	20.12	Iron based superalloys	280	C02	50	164		
	S2.0.Z.AG	20.22	Nickel based super alloys	350	C02	50	164		
	S4.2.Z.AN	23.22	Titanium based alloys	320	C02	90	295		
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	C02	70	230		

For optimized cutting data see CoroPlus® ToolGuide.

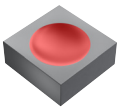
Feed recommendations

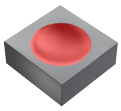
mm/tooth
inch/tooth

DC	1	2	3	4	6	6.35	8	9.525	10	12	12.7	14	15.875	16	20
f_z	*0.039*	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.787*
C01	0.020	0.030	0.040	0.050	0.070	0.070	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.200
	0.0008	*0.0012*	*0.0016*	*0.0020*	*0.0028*	*0.0028*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0079*
C02	0.020	0.020	0.030	0.040	0.060	0.060	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.160
	0.0008	*0.0008*	*0.0012*	*0.0016*	*0.0024*	*0.0024*	*0.0031*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0047*	*0.0063*
C03	0.040	0.070	0.070	0.110	0.150	0.150	0.200	0.260	0.260	0.260	0.260	0.260	0.260	0.260	0.440
	0.0016	*0.0028*	*0.0028*	*0.0043*	*0.0059*	*0.0059*	*0.0079*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0173*

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for profiling





					a_e = 0.05 x DC			a_e = 0.01 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	N01	300	984	N04	360	1181
	P2.2.Z.AN	02.2	Low-alloyed steel	240	N01	220	722	N04	265	869
	P3.0.Z.HT	03.21	High alloyed steel	380	N01	130	427	N04	150	492
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	N01	90	295	N05	100	328
	M1.0.Z.AQ	05.21	Austenic stainless steel	200	N02	110	361	N05	130	427
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	N02	90	295	N04	100	328
K	K1.1.C.NS	07.2	Malleable cast iron	200	N01	240	787	N04	290	951
	K2.1.C.UT	08.2	Grey cast iron	180	N01	240	787	N04	290	951
	K3.2.C.UT	09.2	Nodular cast iron	215	N01	215	705	N04	255	837
N	N1.2.Z.AG	30.12	Aluminium based alloys	100	N03	1765	5791	N06	1765	5791
	N1.3.C.UT	30.21	Aluminium based alloys	75	N03	755	2477	N06	910	2986
	N1.4.C.NS	30.42	Aluminium based alloys	130	N03	280	919	N06	335	1099
	N3.2.C.UT	33.2	Copper and copper alloys	90	N03	505	1657	N06	615	2018
S	S1.0.U.AG	20.12	Iron based superalloys	280	N02	50	164	N05	70	230
	S2.0.Z.AG	20.22	Nickel based superalloys	350	N02	50	164	N05	70	230
	S4.2.Z.AN	23.22	Titanium based alloys	320	N02	100	328	N05	130	427
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	N02	145	476	N05	175	574
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC	N02	145	476	N05	175	574
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC	N02	85	279	N05	100	328
O	O7.0.S.UT		Graphite		N03	800	2625	N06	850	2789

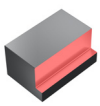
For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

DC	1.000	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	16.000	20.000	25.000	25.400
f_z	*0.039*	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.630*	*0.787*	*0.984*	*1.000*
N01	0.020	0.030	0.050	0.060	0.080	0.080	0.120	0.120	0.150	0.150	0.150	0.150	0.160	0.020	0.025	0.025
	0.0008	*0.0012*	*0.0020*	*0.0024*	*0.0031*	*0.0031*	*0.0047*	*0.0047*	*0.0059*	*0.0059*	*0.0059*	*0.0059*	*0.0063*	*0.0079*	*0.0098*	*0.0098*
N02	0.020	0.030	0.040	0.050	0.060	0.060	0.100	0.100	0.120	0.120	0.120	0.120	0.140	0.016	0.020	0.020
	0.0008	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0024*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0055*	*0.0630*	*0.0079*	*0.0790*
N03	0.060	0.080	0.100	0.130	0.180	0.180	0.260	0.260	0.330	0.330	0.330	0.330	0.380	0.440	0.500	0.500
	0.0024	*0.0031*	*0.0039*	*0.0051*	*0.0071*	*0.0071*	*0.0102*	*0.0102*	*0.0130*	*0.0130*	*0.0130*	*0.0130*	*0.0150*	*0.0173*	*0.0197*	*0.0197*
N04	0.030	0.050	0.080	0.100	0.120	0.120	0.150	0.150	0.200	0.200	0.200	0.200	0.200	0.250	0.250	0.250
	0.0012	*0.0020*	*0.0031*	*0.0039*	*0.0047*	*0.0047*	*0.0059*	*0.0059*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0098*	*0.0098*	*0.0098*
N05	0.020	0.040	0.065	0.080	0.100	0.100	0.120	0.120	0.160	0.160	0.160	0.160	0.160	0.200	0.200	0.200
	0.0008	*0.0016*	*0.0026*	*0.0031*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0079*	*0.0079*	*0.0079*
N06	0.070	0.110	0.175	0.220	0.260	0.260	0.330	0.330	0.440	0.440	0.440	0.440	0.440	0.500	0.500	0.500
	0.0028	*0.0043*	*0.0069*	*0.0087*	*0.0102*	*0.0102*	*0.0130*	*0.0130*	*0.0173*	*0.0173*	*0.0173*	*0.0173*	*0.0173*	*0.0197*	*0.0197*	*0.0197*

Optimized - CoroMill® Plura solid carbide end mill for edging applications
For composite materials



	a_p x a_e > DC		a_p x a_e > DC	
	f_z mm/tooth*	v_c m/min	f_z mm/tooth*	v_c m/min
2P460	0.03	100	0.08	200
2P350	0.03	130	0.03	280
2P050	0.06	100	0.05	200

Feed is same for all diameters.

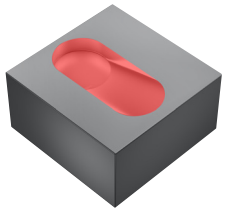
ENG

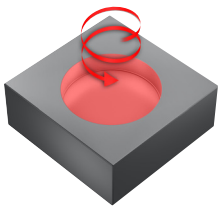
Maximum ramping angle

CoroMill® Plura - Optimized

CoroMill® Plura - Versatile

CoroMill® 316





ISO	Material	Number of teeth (ZEFP) ≤2	3	4	5	≥6
P	Steel (Hardness <300 HB)	9	7	5	5	≤4
	Steel (Hardness >300 HB)	7	5	4	3	≤3
M	Stainless steel	5	5	5	4	≤4
K	Cast iron	10	10	8	6	≤5
N	Non-ferrous metals	15	12	10	10	≤10
S	Super alloys and titanium	5	5	4	4	≤3
H	Hard materials	2	2	1.5	1.5	≤1.5
O	Non ISO	15	12	10	10	≤10

Grades for milling

	P	M	K	N	S	H	O	Wet	Dry	Description
1610	+					++		✗	✓	Ultra fine substrate and CIL coating. Suitable for finishing and semi-finishing in ISO H (and hard ISO P) materials. Not suitable for large a_e. For stable conditions.
1620	+	++	+		+	+		✓	✓	Versatile grade similar to 1630. Works in most materials. High wear resistance. Is stronger in ISO S and ISO M compared to 1630.
1630	++	+	++		+		+	✓	✓	Versatile grade similar to 1620. Works in most materials. Is stronger in ISO P and ISO K compared to 1620. Dry machining is preferred.
1640	+	++	+		++			✓	✓	Very tough grade for high chip loads (large a_e). Works in most materials. Works well in wet conditions. Suitable for unstable conditions.
H10F				++			+	✓	✗	Uncoated grade for machining ISO N and some ISO O (e.g. thermoplastics) materials.
N20C				+			++	✓	✓	Diamond coated grade for graphite and composites as well as ISO N with high (roughly >9%) silicon content.
1700						++		✗	✓	Very hard grade for working in ISO H materials.
1710					++			✓	✗	Hard, wear resistant fine-grained substrate. New coating with adhesion reducing properties. Specific grade for Nickel-based alloys.
1730	++	+	++		+			✓	✓	Next generation 1730 grade. Versatile grade that is tougher and more all-round compared to 1630. Dry machining is preferred.
1740	+	++	+		++			✓	✓	Next generation 1740 grade. New sub micron substrate and TiAlN coating for increased toughness and wider application area compared to 1640. Excellent in wet conditions.
1745					++			✓	✗	Tough sub-micron grain-sized substrate with new silicon coating. Grade dedicated to Titanium alloys.
P10	+	+	+		+	+		✓	✓	Only one Tool Style has this grade. Long ball nose cutter. Grade is very similar to 1620.

Drilling

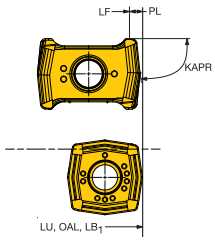
For complete assortment, see www.sandvik.coromant.com

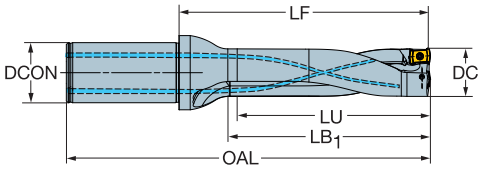
ENG

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





Metric design

							Dimensions, mm								
DC	LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
28.00	112.00	32	2.12	0.00	0.33	DS20-D2800L32-04	32.00	140.16	201.00	116.00	0.83	81°	10	0.743	13000
	140.00	32	2.12	0.00	0.33	DS20-D2800L32-05	32.00	168.16	229.00	144.00	0.83	81°	10	0.809	8000
	168.00	32	2.12	-0.10	0.40	DS20-D2800L32-06	32.00	196.16	257.00	172.00	0.83	81°	10	0.874	6000
	196.00	32	2.12	-0.10	0.40	DS20-D2800L32-07	32.00	224.16	285.00	200.00	0.83	81°	10	0.939	4000
29.00	116.00	32	1.84	0.00	0.33	DS20-D2900L32-04	32.00	144.16	205.00	120.00	0.83	81°	10	0.773	12000
	145.00	32	1.84	0.00	0.33	DS20-D2900L32-05	32.00	173.16	234.00	149.00	0.83	81°	10	0.846	8000
	174.00	32	1.84	-0.10	0.40	DS20-D2900L32-06	32.00	202.16	263.00	178.00	0.83	81°	10	0.918	5000
	203.00	32	1.84	-0.10	0.40	DS20-D2900L32-07	32.00	231.16	292.00	207.00	0.83	81°	10	0.991	4000
30.00	120.00	32	1.56	0.00	0.33	DS20-D3000L32-04	32.00	148.16	209.00	124.00	0.83	81°	10	0.805	12000
	150.00	32	1.56	0.00	0.33	DS20-D3000L32-05	32.00	178.16	239.00	154.00	0.83	81°	10	0.885	8000
	180.00	32	1.56	-0.10	0.40	DS20-D3000L32-06	32.00	208.16	269.00	184.00	0.83	81°	10	0.966	5000
	210.00	32	1.56	-0.10	0.40	DS20-D3000L32-07	32.00	238.16	299.00	214.00	0.83	81°	10	1.046	4000
31.00	124.00	40	1.28	0.00	0.35	DS20-D3100L40-04	40.00	158.16	229.00	128.00	0.83	81°	10	1.250	12000
	155.00	40	1.28	0.00	0.35	DS20-D3100L40-05	40.00	189.16	260.00	159.00	0.83	81°	10	1.339	7000
	186.00	40	1.28	-0.10	0.40	DS20-D3100L40-06	40.00	220.16	291.00	190.00	0.83	81°	10	1.428	5000
	217.00	40	1.28	-0.10	0.40	DS20-D3100L40-07	40.00	251.16	322.00	221.00	0.83	81°	10	1.516	4000
32.00	128.00	40	1.00	0.00	0.35	DS20-D3200L40-04	40.00	162.16	233.00	132.00	0.83	81°	10	1.286	11000
	160.00	40	1.00	0.00	0.35	DS20-D3200L40-05	40.00	194.16	265.00	164.00	0.83	81°	10	1.384	7000
	192.00	40	1.00	-0.10	0.40	DS20-D3200L40-06	40.00	226.16	297.00	196.00	0.83	81°	10	1.481	5000
	224.00	40	1.00	-0.10	0.40	DS20-D3200L40-07	40.00	258.16	329.00	228.00	0.83	81°	10	1.579	3000
33.00	132.00	40	0.72	0.00	0.35	DS20-D3300L40-04	40.00	165.16	236.00	136.00	0.83	81°	10	1.313	11000
	165.00	40	0.72	0.00	0.35	DS20-D3300L40-05	40.00	198.16	269.00	169.00	0.83	81°	10	1.420	7000
	198.00	40	0.72	-0.10	0.40	DS20-D3300L40-06	40.00	231.16	302.00	202.00	0.83	81°	10	1.527	5000
	231.00	40	0.72	-0.10	0.40	DS20-D3300L40-07	40.00	264.16	335.00	235.00	0.83	81°	10	1.634	3000

Inch design

							Dimensions, inch								
DC	LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	PSI	LBS	RPMX
1.125	4.500	1 1/4	.077	.000	.013	DS20-D2858LX31-04	1.250	5.587	7.982	4.642	.033	81°	145	1.660	13000
	5.625	1 1/4	.077	.000	.013	DS20-D2858LX31-05	1.250	6.712	9.107	5.767	.033	81°	145	1.814	8000
	6.750	1 1/4	.077	-.004	.016	DS20-D2858LX31-06	1.250	7.837	10.232	6.892	.033	81°	145	1.966	5000
	7.875	1 1/4	.077	-.004	.016	DS20-D2858LX31-07	1.250	8.962	11.357	8.017	.033	81°	145	2.120	4000
1.187	4.748	1 1/4	.059	.000	.013	DS20-D3015LX31-04	1.250	5.830	8.225	4.890	.033	81°	145	1.768	12000
	5.935	1 1/4	.059	.000	.013	DS20-D3015LX31-05	1.250	7.017	9.412	6.077	.033	81°	145	1.948	8000
	7.122	1 1/4	.059	-.004	.016	DS20-D3015LX31-06	1.250	8.204	10.599	7.264	.033	81°	145	2.127	5000
	8.309	1 1/4	.059	-.004	.016	DS20-D3015LX31-07	1.250	9.391	11.786	8.451	.033	81°	145	2.308	4000
1.250	5.000	1 1/2	.042	.000	.014	DS20-D3175LX38-04	1.500	6.292	9.081	5.142	.033	81°	145	2.680	11000
	6.250	1 1/2	.042	.000	.014	DS20-D3175LX38-05	1.500	7.542	10.331	6.392	.033	81°	145	2.890	7000
	7.500	1 1/2	.042	-.004	.016	DS20-D3175LX38-06	1.500	8.792	11.581	7.642	.033	81°	145	3.101	5000
	8.750	1 1/2	.042	-.004	.016	DS20-D3175LX38-07	1.500	10.042	12.831	8.892	.033	81°	145	3.311	3000

Spare parts
Insert screw
5513 020-57

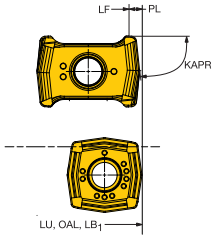
For complete list of spare parts, see www.sandvik.coromant.com

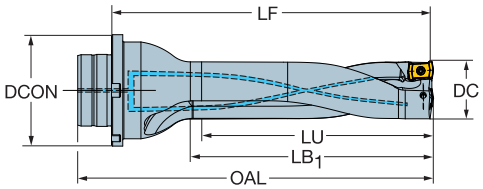
41 97 100

CoroDrill® DS20 indexable insert drill

Modular drill interface

Internal coolant supply





							Dimensions, mm								
DC	LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
28.00	112.00	MDI-32	2.12	0.00	0.33	DS20-D2800DM32-04	32.00	150.16	166.00	116.00	0.83	81°	10	0.705	13000
	196.00	MDI-32	2.12	-0.10	0.40	DS20-D2800DM32-07	32.00	234.16	250.00	200.00	0.83	81°	10	0.901	4000
28.57	114.30	MDI-32	1.95	0.00	0.33	DS20-D2858DM32-04	32.00	151.82	167.65	117.90	0.83	81°	10	0.718	13000
	200.02	MDI-32	1.95	-0.10	0.40	DS20-D2858DM32-07	32.00	237.54	253.37	203.63	0.83	81°	10	0.927	4000
29.00	116.00	MDI-32	1.84	0.00	0.33	DS20-D2900DM32-04	32.00	154.16	170.00	120.00	0.83	81°	10	0.734	12000
	203.00	MDI-32	1.84	-0.10	0.40	DS20-D2900DM32-07	32.00	241.16	257.00	207.00	0.83	81°	10	0.952	4000
30.00	120.00	MDI-32	1.56	0.00	0.33	DS20-D3000DM32-04	32.00	158.16	174.00	124.00	0.83	81°	10	0.766	12000
	210.00	MDI-32	1.56	-0.10	0.40	DS20-D3000DM32-07	32.00	248.16	264.00	214.00	0.83	81°	10	1.008	4000
30.14	120.59	MDI-32	1.51	0.00	0.33	DS20-D3015DM32-04	32.00	157.99	173.82	124.20	0.83	81°	10	0.767	12000
	211.04	MDI-32	1.51	-0.10	0.40	DS20-D3015DM32-07	32.00	248.44	264.27	214.65	0.83	81°	10	1.012	4000
31.00	124.00	MDI-32	1.28	0.00	0.35	DS20-D3100DM32-04	32.00	164.16	180.00	128.00	0.83	81°	10	0.818	12000
	217.00	MDI-32	1.28	-0.10	0.40	DS20-D3100DM32-07	32.00	256.16	272.00	221.00	0.83	81°	10	1.075	4000
31.75	127.00	MDI-32	1.07	0.00	0.35	DS20-D3175DM32-04	32.00	166.27	182.10	130.60	0.83	81°	10	0.839	11000
	222.25	MDI-32	1.07	-0.10	0.40	DS20-D3175DM32-07	32.00	261.49	277.33	225.85	0.83	81°	10	1.125	3000
32.00	128.00	MDI-40	1.00	0.00	0.35	DS20-D3200DM40-04	40.00	175.16	191.00	132.00	0.83	81°	10	1.260	11000
	224.00	MDI-40	1.00	-0.10	0.40	DS20-D3200DM40-07	40.00	271.16	287.00	228.00	0.83	81°	10	1.553	3000
33.00	132.00	MDI-40	0.72	0.00	0.35	DS20-D3300DM40-04	40.00	179.16	195.00	136.00	0.83	81°	10	1.299	11000
	231.00	MDI-40	0.72	-0.10	0.40	DS20-D3300DM40-07	40.00	278.16	294.00	235.00	0.83	81°	10	1.620	3000

Spare parts
Insert screw
5513 020-57

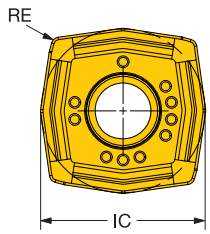
For complete list of spare parts, see www.sandvik.coromant.com

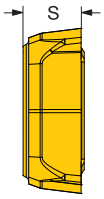
41 97 100

ENG

CoroDrill® DS20 insert for drilling

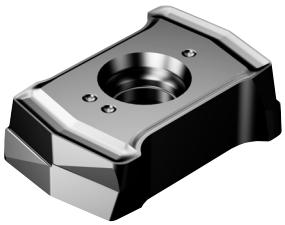
Central insert

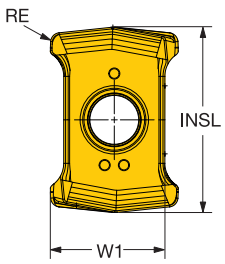


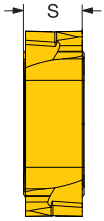


	INSUC	Ordering code	P 1344	P 1144	M 1344	K H13A	K 1344	N 1344	N H13A	S 1344	Dimensions, mm S	RE	IC
04C	C	DS20-0407-C-L5	★	★		★	☆	★	☆	★	3.20	0.35	11.1
											.126	*.014*	*.436*
	C	DS20-0407-C-M7	★		★					☆	3.20	0.35	11.1
											.126	*.014*	*.436*

Peripheral insert







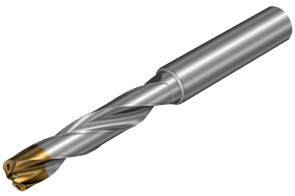
	INSUC	Ordering code	P 4324	P 4334	P 4344	M 2044	M 4334	M 4344	K 4324	K 4334	K 4344	N 4344	N H13A	S 2044	S 4344	S H13A	H 4334	H 4344	Dimensions, mm S	RE	W1
04P	P	DS20-0407-P-H5W		☆	☆	☆	☆	☆											4.25	0.70	9.2
																			.167	*.028*	*.366*
	P	DS20-0407-P-L5W	☆	★	☆	★	☆	☆				☆		☆	☆				4.25	0.70	9.2
																			.167	*.028*	*.366*
	P	DS20-0407-P-L6W			☆			☆			☆	☆			★			★	4.25	0.70	9.2
																			.167	*.028*	*.366*
	P	DS20-0407-P-M7W	☆	★	☆				☆	★	☆						☆	☆	4.25	0.70	9.2
																			.167	*.028*	*.366*
	P	DS20-0407-P-S5W						☆				☆	★		★	☆			4.25	0.70	9.2
																			.167	*.028*	*.366*

39 52 97

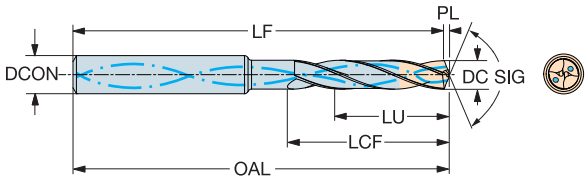
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P	M	K	N	S	H	Dimensions, mm, inch								
							X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.00	.118	24.5	.965	8	6	860.1-0300-024A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016
3.10	.122	9.9	.390	3	6	860.1-0310-009A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.10	.122	16.1	.634	5	6	860.1-0310-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.10	.122	25.4	1.000	8	6	860.1-0310-025A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016
3.17	.125	10.1	.398	3	6	860.1-0317-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.17	.125	16.4	.646	5	6	860.1-0317-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.18	.125	26.0	1.024	8	6	860.1-0318-026A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.20	.126	10.2	.402	3	6	860.1-0320-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.20	.126	16.6	.654	5	6	860.1-0320-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.20	.126	26.2	1.032	8	6	860.1-0320-026A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.30	.130	10.5	.413	3	6	860.1-0330-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	65.4	2.575	20	.787	0.6	.024
3.30	.130	17.1	.673	5	6	860.1-0330-017A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	61.4	2.417	28	1.102	0.6	.024
3.30	.130	27.0	1.063	8	6	860.1-0330-027A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.40	.134	10.8	.425	3	6	860.1-0340-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.40	.134	17.6	.693	5	6	860.1-0340-017A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.40	.134	27.8	1.094	8	6	860.1-0340-027A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.45	.136	11.0	.433	3	6	860.1-0345-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.45	.136	17.9	.705	5	6	860.1-0345-017A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	28.6	1.126	8	6	860.1-0350-028A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.57	.141	11.4	.449	3	6	860.1-0357-011A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	65.4	2.575	20	.787	0.6	.024
3.57	.141	18.5	.728	5	6	860.1-0357-018A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	61.4	2.417	28	1.102	0.6	.024
3.57	.141	28.9	1.138	8	6	860.1-0357-028A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.60	.142	11.5	.453	3	6	860.1-0360-011A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.60	.142	18.7	.736	5	6	860.1-0360-018A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	11.8	.465	3	6	860.1-0370-011A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.70	.146	19.2	.756	5	6	860.1-0370-019A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	28.8	1.134	8	6	860.1-0370-028A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.80	.150	12.1	.476	3	6	860.1-0380-012A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024
3.80	.150	19.7	.776	5	6	860.1-0380-019A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024
3.80	.150	31.1	1.224	8	6	860.1-0380-031A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.5	3.524	48	1.890	0.5	.020
3.90	.154	12.4	.488	3	6	860.1-0390-012A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	73.3	2.886	24	.945	0.7	.028
3.90	.154	20.2	.795	5	6	860.1-0390-020A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	65.3	2.571	36	1.417	0.7	.028
3.97	.156	20.6	.811	5	6	860.1-0397-020A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
3.97	.156	32.5	1.280	8	6	860.1-0397-032A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.00	.157	32.7	1.287	8	6	860.1-0400-032A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.10	.161	13.0	.512	3	6	860.1-0410-013A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	73.3	2.886	24	.945	0.7	.028
4.10	.161	21.2	.835	5	6	860.1-0410-021A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	65.3	2.571	36	1.417	0.7	.028
4.10	.161	33.5	1.319	8	6	860.1-0410-033A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.20	.165	13.4	.528	3	6	860.1-0420-013A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.20	.165	21.8	.858	5	6	860.1-0420-021A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.20	.165	34.4	1.354	8	6	860.1-0420-034A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.30	.169	13.7	.539	3	6	860.1-0430-013A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	73.3	2.886	24	.945	0.7	.028
4.30	.169	22.3	.878	5	6	860.1-0430-022A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	65.3	2.571	36	1.417	0.7	.028
4.30	.169	35.2	1.386	8	6	860.1-0430-035A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.36	.172	13.9	.547	3	6	860.1-0436-013A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.36	.172	22.6	.890	5	6	860.1-0436-022A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.37	.172	35.8	1.409	8	6	860.1-0437-035A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.40	.173	14.0	.551	3	6	860.1-0440-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.40	.173	22.8	.898	5	6	860.1-0440-022A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.50	.177	14.3	.563	3	6	860.1-0450-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.50	.177	23.3	.917	5	6	860.1-0450-023A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.50	.177	36.8	1.449	8	6	860.1-0450-036A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028

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CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply

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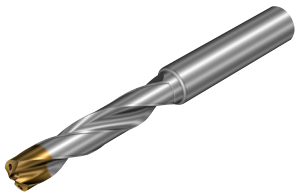

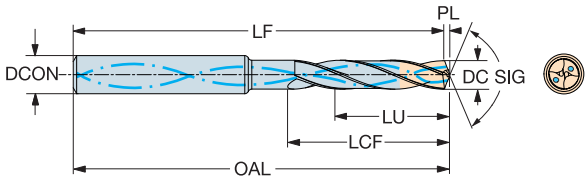

												Dimensions, mm, inch									
							P	M	K	N	S	H										
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
4.55	.179	14.5	.571	3	6	860.1-0455-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.60	.181	14.6	.575	3	6	860.1-0460-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	73.2	2.882	24	.945	0.8	.031
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	65.2	2.567	36	1.417	0.8	.031
4.60	.181	37.6	1.480	8	6	860.1-0460-037A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028
4.70	.185	14.6	.575	3	6	860.1-0470-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.70	.185	24.4	.961	5	6	860.1-0470-024A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.70	.185	38.5	1.516	8	6	860.1-0470-038A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028
4.76	.187	15.1	.594	3	6	860.1-0476-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.76	.187	24.7	.972	5	6	860.1-0476-024A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	81.2	3.197	44	1.732	0.8	.031
4.76	.187	38.9	1.532	8	6	860.1-0476-038A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	103.3	4.067	62	2.441	0.7	.028
4.80	.189	15.3	.602	3	6	860.1-0480-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.80	.189	24.9	.980	5	6	860.1-0480-024A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
4.80	.189	39.3	1.547	8	6	860.1-0480-039A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028
4.90	.193	15.6	.614	3	6	860.1-0490-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.90	.193	25.4	1.000	5	6	860.1-0490-025A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.00	.197	15.9	.626	3	6	860.1-0500-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	25.9	1.020	5	6	860.1-0500-025A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.00	.197	40.9	1.610	8	6	860.1-0500-040A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.2	3.630	62	2.441	0.8	.031
5.10	.201	16.2	.638	3	6	860.1-0510-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	81.1	3.193	28	1.102	0.9	.035
5.10	.201	26.4	1.039	5	6	860.1-0510-026A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	92.1	3.626	44	1.732	0.9	.035
5.10	.201	41.7	1.642	8	6	860.1-0510-041A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	65.1	2.563	62	2.441	0.9	.035
5.16	.203	16.4	.646	3	6	860.1-0516-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.16	.203	26.7	1.051	5	6	860.1-0516-026A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.20	.205	26.9	1.059	5	6	860.1-0520-026A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	42.5	1.673	8	6	860.1-0520-042A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	65.1	2.563	62	2.441	0.9	.035
5.30	.209	27.2	1.071	5	6	860.1-0525-027A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	16.6	.654	3	6	860.1-0530-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.30	.209	27.5	1.083	5	6	860.1-0530-027A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	43.4	1.709	8	6	860.1-0530-043A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.1	3.626	62	2.441	0.9	.035
5.40	.213	16.5	.650	3	6	860.1-0540-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	81.1	3.193	28	1.102	0.9	.035
5.40	.213	28.0	1.102	5	6	860.1-0540-027A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	65.1	2.563	44	1.732	0.9	.035
5.40	.213	44.2	1.740	8	6	860.1-0540-044A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	65.1	2.563	62	2.441	0.9	.035
5.50	.217	16.4	.646	3	6	860.1-0550-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	28.5	1.122	5	6	860.1-0550-028A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.55	.219	45.0	1.772	8	6	860.1-0550-045A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.1	3.626	62	2.441	0.9	.035
5.56	.219	28.8	1.134	5	6	860.1-0555-028A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.56	.219	16.4	.646	3	6	860.1-0556-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.56	.219	28.8	1.134	5	6	860.1-0556-028A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.56	.219	45.5	1.791	8	6	860.1-0556-045A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.1	3.626	62	2.441	0.9	.035
5.60	.220	16.3	.642	3	6	860.1-0560-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	81.0	3.189	28	1.102	1.0	.039
5.60	.220	29.0	1.142	5	6	860.1-0560-029A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	92.0	3.622	44	1.732	1.0	.039
5.60	.220	45.8	1.803	8	6	860.1-0560-045A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	65.0	2.559	62	2.441	1.0	.039
5.70	.224	16.2	.638	3	6	860.1-0570-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.70	.224	29.5	1.161	5	6	860.1-0570-029A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
5.70	.224	46.6	1.835	8	6	860.1-0570-046A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.0	3.622	62	2.441	1.0	.039
5.80	.228	16.2	.638	3	6	860.1-0580-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.80	.228	30.1	1.185	5	6	860.1-0580-030A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.1	.042
5.80	.228	47.5	1.870	8	6	860.1-0580-047A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.0	3.622	62	2.441	1.0	.039
5.90	.232	16.1	.634	3	6	860.1-0590-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.90	.232	48.3	1.902	8	6	860.1-0590-048A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.0	3.622	62	2.441	1.0	.039
5.95	.234	16.0	.630	3	6	860.1-0595-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.1	.043
6.00	.236	16.0	.630	3	6	860.1-0600-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.1	.043
6.00	.236	31.1	1.224	5	6	860.1-0600-031A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.1	.043
6.00	.236	49.1	1.933	8	6	860.1-0600-049A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	92.0	3.622	62	2.441	1.0	.039
6.10	.240	19.4	.764	3	8	860.1-0610-019A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.1	.044
6.10	.240	31.6	1.244	5	8	860.1-0610-031A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.1	.044
6.10	.240	49.9	1.965	8	8	860.1-0610-049A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	78.0	3.071	84	3.307	1.0	.039

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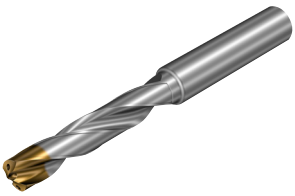
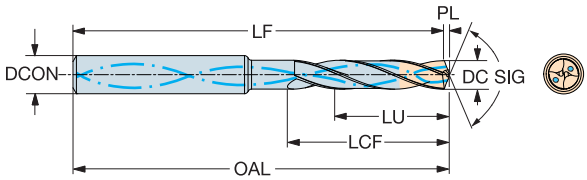
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P	M	K	N	S	H	Dimensions, mm, inch								
							X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
6.20	.244	19.7	.776	3	8	860.1-0620-019A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.044
6.20	.244	32.1	1.264	5	8	860.1-0620-032A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	103.9	4.091	53	2.087	1.1	.044
6.20	.244	50.7	1.996	8	8	860.1-0620-050A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	77.9	3.067	84	3.307	1.1	.043
6.30	.248	20.0	.787	3	8	860.1-0630-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.045
6.30	.248	32.6	1.283	5	8	860.1-0630-032A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	77.9	3.067	53	2.087	1.1	.045
6.30	.248	51.5	2.028	8	8	860.1-0630-051A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	89.9	3.539	84	3.307	1.1	.043
6.35	.250	20.2	.795	3	8	860.1-0635-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.045
6.35	.250	32.9	1.295	5	8	860.1-0635-032A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.2	.045
6.35	.250	52.0	2.047	8	8	860.1-0635-051A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.9	4.091	84	3.307	1.1	.043
6.40	.252	20.4	.803	3	8	860.1-0640-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.046
6.40	.252	33.2	1.307	5	8	860.1-0640-033A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.2	.046
6.40	.252	52.4	2.063	8	8	860.1-0640-052A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.9	4.091	84	3.307	1.1	.043
6.50	.256	20.7	.815	3	8	860.1-0650-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.047
6.50	.256	33.7	1.327	5	8	860.1-0650-033A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	77.9	3.067	53	2.087	1.2	.047
6.50	.256	53.2	2.094	8	8	860.1-0650-053A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	89.9	3.539	84	3.307	1.1	.043
6.60	.260	20.6	.811	3	8	860.1-0660-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.047
6.60	.260	34.2	1.346	5	8	860.1-0660-034A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.2	.047
6.60	.260	54.0	2.126	8	8	860.1-0660-054A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.9	4.091	84	3.307	1.1	.043
6.70	.264	20.5	.807	3	8	860.1-0670-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.048
6.70	.264	34.7	1.366	5	8	860.1-0670-034A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.2	.048
6.70	.264	54.8	2.157	8	8	860.1-0670-054A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	77.9	3.067	84	3.307	1.1	.043
6.75	.266	20.5	.807	3	8	860.1-0675-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.048
6.75	.266	35.0	1.378	5	8	860.1-0675-034A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.048
6.80	.268	20.4	.803	3	8	860.1-0680-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.049
6.80	.268	35.2	1.386	5	8	860.1-0680-035A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.049
6.80	.268	55.6	2.189	8	8	860.1-0680-055A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.8	4.087	84	3.307	1.2	.047
6.90	.272	20.3	.799	3	8	860.1-0690-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.3	.049
6.90	.272	35.8	1.409	5	8	860.1-0690-035A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.049
6.90	.272	56.5	2.224	8	8	860.1-0690-056A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.8	4.087	84	3.307	1.2	.047
7.00	.276	22.3	.878	3	8	860.1-0700-022A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.050
7.00	.276	36.3	1.429	5	8	860.1-0700-036A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	103.8	4.087	53	2.087	1.3	.050
7.00	.276	57.3	2.256	8	8	860.1-0700-057A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	77.8	3.063	84	3.307	1.2	.047
7.10	.280	22.6	.890	3	8	860.1-0710-022A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.051
7.10	.280	36.8	1.449	5	8	860.1-0710-036A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.051
7.10	.280	58.1	2.287	8	8	860.1-0710-058A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.8	4.087	84	3.307	1.2	.047
7.14	.281	22.7	.894	3	8	860.1-0714-022A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.051
7.14	.281	58.4	2.299	8	8	860.1-0714-058A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.8	4.087	84	3.307	1.2	.047
7.20	.283	22.9	.902	3	8	860.1-0720-022A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.052
7.20	.283	37.3	1.469	5	8	860.1-0720-037A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	77.8	3.063	53	2.087	1.3	.052
7.30	.287	23.2	.913	3	8	860.1-0730-023A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.052
7.30	.287	37.8	1.488	5	8	860.1-0730-037A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.052
7.40	.291	23.5	.925	3	8	860.1-0740-023A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.053
7.40	.291	38.3	1.508	5	8	860.1-0740-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.053
7.40	.291	60.5	2.382	8	8	860.1-0740-060A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.7	4.083	84	3.307	1.3	.051
7.50	.295	23.9	.941	3	8	860.1-0750-023A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.054
7.50	.295	38.8	1.528	5	8	860.1-0750-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.4	.054
7.50	.295	61.4	2.417	8	8	860.1-0750-061A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.7	4.083	84	3.307	1.3	.051
7.54	.297	24.0	.945	3	8	860.1-0754-023A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.054
7.60	.299	24.2	.953	3	8	860.1-0760-024A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.054
7.60	.299	38.7	1.524	5	10	860.1-0760-038A1-GM	★	★	★	☆	☆	★	10.0	.394	91	3.583	118.6	4.669	53	2.087	1.4	.054
7.70	.303	24.5	.965	3	8	860.1-0770-024A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.055
7.70	.303	63.0	2.480	8	8	860.1-0770-063A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.7	4.083	84	3.307	1.3	.051
7.80	.307	24.8	.976	3	8	860.1-0780-024A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.056
7.80	.307	38.6	1.520	5	8	860.1-0780-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	77.7	3.059	53	2.087	1.4	.056
7.80	.307	63.8	2.512	8	8	860.1-0780-063A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	89.7	3.532	84	3.307	1.3	.051
7.90	.311	25.1	.988	3	8	860.1-0790-025A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.6	3.055	41	1.614	1.4	.057
7.90	.311	64.6	2.543	8	8	860.1-0790-064A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	103.6	4.079	84	3.307	1.4	.055

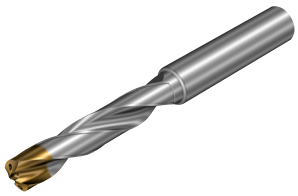
68 97 100 101

ENG

CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



TCHA H9
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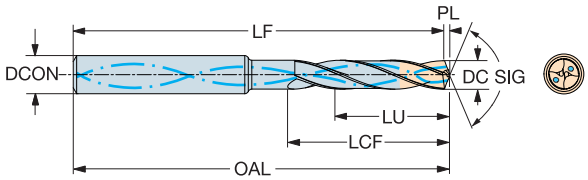

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	S X1BM	H X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
7.94	.313	25.3	.996	3	8	860.1-0794-025A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.6	3.055	41	1.614	1.4	.057
7.94	.313	38.4	1.512	5	8	860.1-0794-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	77.6	3.055	53	2.087	1.4	.057
7.94	.313	65.0	2.559	8	8	860.1-0794-064A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	89.6	3.528	84	3.307	1.4	.055
8.00	.315	25.5	1.004	3	8	860.1-0800-025A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.6	3.055	41	1.614	1.5	.057
8.00	.315	38.4	1.512	5	8	860.1-0800-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	103.6	4.079	53	2.087	1.5	.057
8.00	.315	65.5	2.579	8	8	860.1-0800-065A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	77.6	3.055	84	3.307	1.4	.055
8.10	.319	25.8	1.016	3	10	860.1-0810-025A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.058
8.10	.319	42.0	1.654	5	10	860.1-0810-041A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	87.6	3.449	61	2.402	1.5	.058
8.10	.319	66.3	2.610	8	10	860.1-0810-066A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	87.6	3.449	106	4.173	1.4	.055
8.20	.323	26.1	1.028	3	10	860.1-0820-026A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.059
8.20	.323	42.5	1.673	5	10	860.1-0820-042A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	87.6	3.449	61	2.402	1.5	.059
8.20	.323	67.1	2.642	8	10	860.1-0820-067A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	101.6	4.000	106	4.173	1.4	.055
8.30	.327	26.4	1.039	3	10	860.1-0830-026A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.059
8.30	.327	43.0	1.693	5	10	860.1-0830-043A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.5	.059
8.30	.327	67.9	2.673	8	10	860.1-0830-067A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	118.6	4.669	106	4.173	1.4	.055
8.40	.331	26.7	1.051	3	10	860.1-0840-026A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.060
8.40	.331	43.5	1.713	5	10	860.1-0840-043A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.5	.060
8.50	.335	27.0	1.063	3	10	860.1-0850-027A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.061
8.50	.335	44.0	1.732	5	10	860.1-0850-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.061
8.50	.335	69.5	2.736	8	10	860.1-0850-069A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	118.5	4.665	106	4.173	1.5	.059
8.60	.339	27.4	1.079	3	10	860.1-0860-027A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.6	.062
8.60	.339	44.6	1.756	5	10	860.1-0860-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	118.5	4.665	61	2.402	1.6	.062
8.60	.339	70.4	2.772	8	10	860.1-0860-070A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	87.5	3.445	106	4.173	1.5	.059
8.70	.343	27.7	1.091	3	10	860.1-0870-027A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.6	.062
8.70	.343	45.0	1.772	5	10	860.1-0870-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	87.5	3.445	61	2.402	1.6	.062
8.70	.343	71.2	2.803	8	10	860.1-0870-071A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	101.5	3.996	106	4.173	1.5	.059
8.73	.344	27.8	1.094	3	10	860.1-0873-027A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.6	.063
8.73	.344	71.4	2.811	8	10	860.1-0873-071A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	118.5	4.665	106	4.173	1.6	.063
8.80	.346	28.0	1.102	3	10	860.1-0880-028A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.6	.063
8.80	.346	44.9	1.768	5	10	860.1-0880-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	87.5	3.445	61	2.402	1.6	.063
8.90	.350	28.3	1.114	3	10	860.1-0890-028A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.6	.064
9.00	.354	28.6	1.126	3	10	860.1-0900-028A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.6	.064
9.00	.354	44.7	1.760	5	10	860.1-0900-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	87.5	3.445	61	2.402	1.6	.064
9.00	.354	73.6	2.898	8	10	860.1-0900-073A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	101.5	3.996	106	4.173	1.6	.064
9.13	.359	29.1	1.146	3	10	860.1-0913-029A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.065
9.20	.362	29.3	1.154	3	10	860.1-0920-029A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.066
9.30	.366	29.6	1.165	3	10	860.1-0930-029A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.067
9.30	.366	44.4	1.748	5	10	860.1-0930-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.7	.067
9.40	.370	44.4	1.748	5	10	860.1-0940-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.7	.067
9.40	.370	76.9	3.028	8	10	860.1-0940-076A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	131.4	5.173	106	4.173	1.7	.067
9.50	.374	30.2	1.189	3	10	860.1-0950-030A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068
9.50	.374	44.3	1.744	5	10	860.1-0950-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	131.4	5.173	61	2.402	1.7	.068
9.50	.374	77.7	3.059	8	10	860.1-0950-077A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	87.4	3.441	106	4.173	1.7	.068
9.52	.375	30.3	1.193	3	10	860.1-0952-030A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068
9.52	.375	44.3	1.744	5	10	860.1-0952-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.7	.068
9.52	.375	77.9	3.067	8	10	860.1-0952-077A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	131.4	5.173	106	4.173	1.7	.068
9.60	.378	30.2	1.189	3	10	860.1-0960-030A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.069
9.60	.378	44.2	1.740	5	10	860.1-0960-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	87.4	3.441	61	2.402	1.7	.069
9.70	.382	30.1	1.185	3	10	860.1-0970-030A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.8	.069
9.70	.382	44.1	1.736	5	10	860.1-0970-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	131.3	5.169	61	2.402	1.8	.069
9.70	.382	79.4	3.126	8	10	860.1-0970-079A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	87.3	3.437	106	4.173	1.8	.069
9.80	.386	30.0	1.181	3	10	860.1-0980-030A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.8	.070
9.80	.386	44.0	1.732	5	10	860.1-0980-044A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.3	3.988	61	2.402	1.8	.070
9.80	.386	80.2	3.157	8	10	860.1-0980-080A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	131.3	5.169	106	4.173	1.8	.070
9.90	.390	30.0	1.181	3	10	860.1-0990-029A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.8	.071
9.90	.390	44.0	1.732	5	10	860.1-0990-043A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.3	3.988	61	2.402	1.8	.071
9.92	.391	30.0	1.181	3	10	860.1-0992-029A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.8	.071
9.92	.391	81.2	3.197	8	10	860.1-0992-081A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	87.3	3.437	106	4.173	1.8	.071

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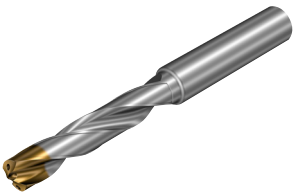
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



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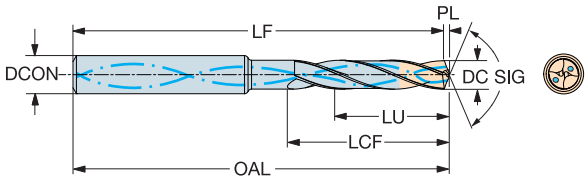

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	S X1BM	H X1BM	Dimensions, mm, inch $DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
10.00	.394	29.9	1.177	3	10	860.1-1000-029A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.8	.072
10.00	.394	43.9	1.728	5	10	860.1-1000-043A1-GM	★	☆	★	☆	☆	★	10.0	.394	103	4.055	101.3	3.988	61	2.402	1.8	.072
10.00	.394	81.8	3.220	8	10	860.1-1000-081A1-GM	★	☆	★	☆	☆	★	10.0	.394	152	5.984	131.3	5.169	106	4.173	1.8	.072
10.10	.398	32.1	1.264	3	12	860.1-1010-032A1-GM	★	☆	★	☆	☆	★	12.0	.472	89	3.504	100.3	3.949	55	2.165	1.8	.072
10.10	.398	52.3	2.059	5	12	860.1-1010-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	103	4.055	116.3	4.579	71	2.795	1.8	.072
10.10	.398	82.6	3.252	8	12	860.1-1010-082A1-GM	★	☆	★	☆	☆	★	12.0	.472	152	5.984	138.3	5.445	128	5.039	1.8	.072
10.20	.402	32.5	1.280	3	12	860.1-1020-032A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.9	.073
10.20	.402	52.9	2.083	5	12	860.1-1020-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	138.3	5.445	71	2.795	1.9	.073
10.20	.402	83.5	3.287	8	12	860.1-1020-083A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	100.3	3.949	128	5.039	1.9	.073
10.30	.406	32.8	1.291	3	12	860.1-1030-032A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.074
10.30	.406	52.9	2.083	5	12	860.1-1030-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	138.2	5.441	71	2.795	1.9	.074
10.30	.406	84.3	3.319	8	12	860.1-1030-084A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	116.2	4.575	128	5.039	1.9	.074
10.32	.406	32.8	1.291	3	12	860.1-1032-032A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.074
10.32	.406	52.9	2.083	5	12	860.1-1032-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.9	.074
10.40	.409	33.1	1.303	3	12	860.1-1040-033A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.075
10.40	.409	52.8	2.079	5	12	860.1-1040-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	100.2	3.945	71	2.795	1.9	.075
10.50	.413	33.4	1.315	3	12	860.1-1050-033A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.075
10.50	.413	52.7	2.075	5	12	860.1-1050-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.9	.075
10.50	.413	85.9	3.382	8	12	860.1-1050-085A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	138.2	5.441	128	5.039	1.9	.075
10.60	.417	33.7	1.327	3	12	860.1-1060-033A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.076
10.70	.421	34.0	1.339	3	12	860.1-1070-034A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.077
10.70	.421	52.5	2.067	5	12	860.1-1070-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.9	.077
10.71	.422	34.1	1.343	3	12	860.1-1071-034A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.077
10.71	.422	52.5	2.067	5	12	860.1-1071-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.9	.077
10.80	.425	34.4	1.354	3	12	860.1-1080-034A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	2.0	.077
10.80	.425	52.5	2.067	5	12	860.1-1080-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	100.1	3.941	71	2.795	2.0	.077
10.80	.425	88.4	3.480	8	12	860.1-1080-088A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	116.1	4.571	128	5.039	2.0	.077
11.00	.433	35.0	1.378	3	12	860.1-1100-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	2.0	.079
11.00	.433	52.3	2.059	5	12	860.1-1100-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	2.0	.079
11.00	.433	90.0	3.543	8	12	860.1-1100-090A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	100.1	3.941	128	5.039	2.0	.079
11.10	.437	35.3	1.390	3	12	860.1-1110-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	2.0	.080
11.10	.437	52.2	2.055	5	12	860.1-1110-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	149.1	5.870	71	2.795	2.0	.080
11.10	.437	90.8	3.575	8	12	860.1-1110-090A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	100.1	3.941	128	5.039	2.0	.080
11.11	.437	35.4	1.394	3	12	860.1-1111-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	2.0	.080
11.11	.437	52.2	2.055	5	12	860.1-1111-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	2.0	.080
11.20	.441	35.6	1.402	3	12	860.1-1120-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	2.0	.080
11.20	.441	52.1	2.051	5	12	860.1-1120-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	2.0	.080
11.30	.445	52.1	2.051	5	12	860.1-1130-052A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	2.1	.081
11.50	.453	35.9	1.413	3	12	860.1-1150-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.1	.082
11.50	.453	51.9	2.043	5	12	860.1-1150-051A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.1	.082
11.50	.453	94.1	3.705	8	12	860.1-1150-094A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	149.0	5.866	128	5.039	2.1	.082
11.60	.457	35.8	1.409	3	12	860.1-1160-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.1	.083
11.70	.461	35.8	1.409	3	12	860.1-1170-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.1	.084
11.80	.465	35.7	1.406	3	12	860.1-1180-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.1	.085
11.80	.465	51.7	2.035	5	12	860.1-1180-051A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	149.0	5.866	71	2.795	2.1	.085
11.80	.465	96.5	3.799	8	12	860.1-1180-096A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	100.0	3.937	128	5.039	2.1	.085
11.90	.469	51.6	2.032	5	12	860.1-1190-051A1-GM	★	☆	★	☆	☆	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.2	.085
11.90	.469	97.4	3.835	8	12	860.1-1190-097A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	149.0	5.866	128	5.039	2.2	.085
12.00	.472	35.6	1.402	3	12	860.1-1200-035A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	99.9	3.933	55	2.165	2.2	.086
12.00	.472	51.6	2.032	5	14	860.1-1200-051A1-GM	★	☆	★	☆	☆	★	14.0	.551	118	4.646	115.9	4.563	71	2.795	2.2	.086
12.00	.472	98.2	3.866	8	12	860.1-1200-098A1-GM	★	☆	★	☆	☆	★	12.0	.472	180	7.087	148.9	5.862	128	5.039	2.2	.086
12.10	.476	56.7	2.232	5	14	860.1-1210-056A1-GM	★	☆	★	☆	☆	★	14.0	.551	118	4.646	121.9	4.799	77	3.032	2.2	.087
12.20	.480	38.8	1.528	3	14	860.1-1220-038A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.2	.087
12.20	.480	56.6	2.228	5	14	860.1-1220-056A1-GM	★	☆	★	☆	☆	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.2	.087
12.30	.484	39.1	1.539	3	14	860.1-1230-039A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.2	.088
12.30	.484	100.6	3.961	8	14	860.1-1230-100A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	104.9	4.130	151	5.945	2.2	.088
12.40	.488	39.4	1.551	3	14	860.1-1240-039A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.3	.089

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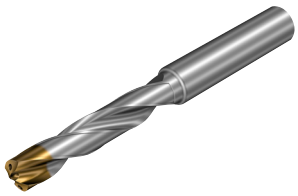
ENG

CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



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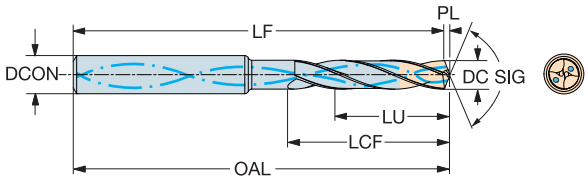

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	S X1BM	H X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
12.50	.492	39.4	1.551	3	14	860.1-1250-039A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.3	.090
12.50	.492	56.4	2.220	5	14	860.1-1250-056A1-GM	★	☆	★	☆	☆	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.3	.090
12.50	.492	102.3	4.028	8	14	860.1-1250-102A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	157.9	6.217	151	5.945	2.3	.090
12.70	.500	39.2	1.543	3	14	860.1-1270-039A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.3	.091
12.70	.500	56.2	2.213	5	14	860.1-1270-056A1-GM	★	☆	★	☆	☆	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.3	.091
12.70	.500	103.9	4.091	8	14	860.1-1270-103A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	157.8	6.213	151	5.945	2.3	.091
12.80	.504	104.7	4.122	8	14	860.1-1280-104A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	157.8	6.213	151	5.945	2.3	.092
13.00	.512	39.0	1.535	3	14	860.1-1300-038A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.4	.093
13.00	.512	56.0	2.205	5	14	860.1-1300-055A1-GM	★	☆	★	☆	☆	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.4	.093
13.00	.512	106.4	4.189	8	14	860.1-1300-106A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	157.8	6.213	151	5.945	2.4	.093
13.10	.516	55.9	2.201	5	14	860.1-1310-055A1-GM	★	☆	★	☆	☆	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.4	.094
13.25	.522	38.8	1.528	3	14	860.1-1325-038A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.4	.095
13.30	.524	38.8	1.528	3	14	860.1-1330-036A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.4	.095
13.50	.531	38.6	1.520	3	14	860.1-1350-038A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.5	.097
13.50	.531	55.6	2.189	5	14	860.1-1350-055A1-GM	★	☆	★	☆	☆	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.5	.097
13.50	.531	110.5	4.350	8	14	860.1-1350-110A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	157.7	6.209	151	5.945	2.5	.097
13.75	.541	38.4	1.512	3	14	860.1-1375-038A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.5	.099
13.80	.543	112.9	4.445	8	14	860.1-1380-112A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	157.6	6.205	151	5.945	2.5	.099
14.00	.551	38.2	1.504	3	14	860.1-1400-038A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.5	.100
14.00	.551	55.2	2.173	3	16	860.1-1400-055A1-GM	★	☆	★	☆	☆	★	16.0	.630	124	4.882	157.6	6.205	77	3.032	2.5	.100
14.00	.551	114.5	4.508	8	14	860.1-1400-114A1-GM	★	☆	★	☆	☆	★	14.0	.551	202	7.953	104.6	4.118	151	5.945	2.5	.100
14.25	.561	42.4	1.669	3	16	860.1-1425-042A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.6	.102
14.25	.561	60.4	2.378	5	16	860.1-1425-060A1-GM	★	☆	★	☆	☆	★	16.0	.630	133	5.236	112.5	4.429	83	3.268	2.6	.102
14.29	.563	42.4	1.669	3	16	860.1-1429-042A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.6	.102
14.50	.571	42.2	1.661	3	16	860.1-1450-042A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.6	.104
14.50	.571	60.2	2.370	5	16	860.1-1450-060A1-GM	★	☆	★	☆	☆	★	16.0	.630	133	5.236	112.5	4.429	83	3.268	2.6	.104
15.00	.591	41.8	1.646	3	16	860.1-1500-041A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.4	4.425	65	2.559	2.7	.107
15.00	.591	59.8	2.354	3	16	860.1-1500-059A1-GM	★	☆	★	☆	☆	★	16.0	.630	133	5.236	130.4	5.134	83	3.268	2.7	.107
15.50	.610	41.4	1.630	3	16	860.1-1550-041A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.3	4.421	65	2.559	2.8	.111
15.87	.625	41.1	1.618	3	16	860.1-1587-041A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.3	4.421	65	2.559	2.9	.114
15.87	.625	59.1	2.327	3	16	860.1-1587-059A1-GM	★	☆	★	☆	☆	★	16.0	.630	133	5.236	130.3	5.130	83	3.268	2.9	.114
16.00	.630	41.0	1.614	3	16	860.1-1600-041A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.2	4.417	65	2.559	2.9	.115
16.00	.630	59.0	2.323	3	6	860.1-1600-059A1-GM	★	☆	★	☆	☆	★	6.0	.236	133	5.236	112.2	4.417	83	3.268	2.9	.115
16.00	.630	130.9	5.154	8	16	860.1-1600-130A1-GM	★	☆	★	☆	☆	★	16.0	.630	227	8.937	130.2	5.126	172	6.772	2.9	.115

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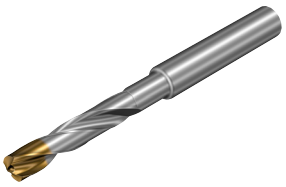
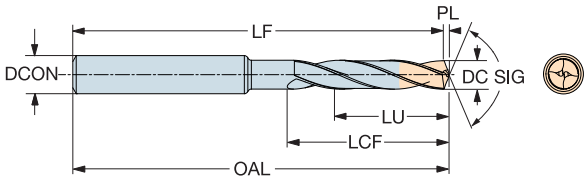
CoroDrill® 860 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°





							P	M	K	N	H	Dimensions, mm, inch									
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
3.00	.118	9.5	.374	3	6	860.1-0300-009A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.00	.118	15.5	.610	5	6	860.1-0300-015A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.10	.122	9.9	.390	3	6	860.1-0310-009A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.10	.122	16.1	.634	5	6	860.1-0310-016A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.20	.126	10.2	.402	3	6	860.1-0320-010A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.20	.126	16.6	.654	5	6	860.1-0320-016A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.30	.130	10.5	.413	3	6	860.1-0330-010A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.30	.130	17.1	.673	5	6	860.1-0330-017A0-GM	★		★	☆	☆	6.0	.236	66	2.598	61.4	2.417	28	1.102	0.6	.024
3.38	.133	17.5	.689	5	6	860.1-0338-017A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.40	.134	10.8	.425	3	6	860.1-0340-010A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.40	.134	17.6	.693	5	6	860.1-0340-017A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	11.1	.437	3	6	860.1-0350-011A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.50	.138	18.1	.713	5	6	860.1-0350-018A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.60	.142	11.5	.453	3	6	860.1-0360-011A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.60	.142	18.7	.736	5	6	860.1-0360-018A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	11.8	.465	3	6	860.1-0370-011A0-GM	★	☆	★	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.70	.146	19.2	.756	5	6	860.1-0370-019A0-GM	★		★	☆	☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.80	.150	12.1	.476	3	6	860.1-0380-012A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024
3.80	.150	19.7	.776	5	6	860.1-0380-019A0-GM	★		★	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024
3.90	.154	12.4	.488	3	6	860.1-0390-012A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
3.90	.154	20.2	.795	5	6	860.1-0390-020A0-GM	★		★	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.00	.157	12.7	.500	3	6	860.1-0400-012A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.00	.157	20.7	.815	5	6	860.1-0400-020A0-GM	★		★	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.10	.161	13.0	.512	3	6	860.1-0410-013A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	73.3	2.886	24	.945	0.7	.028
4.10	.161	21.2	.835	5	6	860.1-0410-021A0-GM	★		★	☆	☆	6.0	.236	74	2.913	65.3	2.571	36	1.417	0.7	.028
4.20	.165	13.4	.528	3	6	860.1-0420-013A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.20	.165	21.8	.858	5	6	860.1-0420-021A0-GM	★		★	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.30	.169	13.7	.539	3	6	860.1-0430-013A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	73.3	2.886	24	.945	0.7	.028
4.30	.169	22.3	.878	5	6	860.1-0430-022A0-GM	★		★	☆	☆	6.0	.236	74	2.913	65.3	2.571	36	1.417	0.7	.028
4.40	.173	14.0	.551	3	6	860.1-0440-014A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.50	.177	14.3	.563	3	6	860.1-0450-014A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.50	.177	23.3	.917	5	6	860.1-0450-023A0-GM	★		★	☆	☆	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.60	.181	14.6	.575	3	6	860.1-0460-014A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	73.2	2.882	24	.945	0.8	.031
4.60	.181	23.8	.937	5	6	860.1-0460-023A0-GM	★		★	☆	☆	6.0	.236	74	2.913	65.2	2.567	36	1.417	0.8	.031
4.70	.185	14.6	.575	3	6	860.1-0470-014A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.80	.189	15.3	.602	3	6	860.1-0480-015A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.80	.189	24.9	.980	5	6	860.1-0480-024A0-GM	★		★	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
4.90	.193	15.6	.614	3	6	860.1-0490-015A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	15.9	.626	3	6	860.1-0500-015A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	25.9	1.020	5	6	860.1-0500-025A0-GM	★		★	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.10	.201	16.2	.638	3	6	860.1-0510-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	81.1	3.193	28	1.102	0.9	.035
5.10	.201	26.4	1.039	5	6	860.1-0510-026A0-GM	★		★	☆	☆	6.0	.236	82	3.228	65.1	2.563	44	1.732	0.9	.035
5.20	.205	16.5	.650	3	6	860.1-0520-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	81.1	3.193	28	1.102	0.9	.035
5.20	.205	26.9	1.059	5	6	860.1-0520-026A0-GM	★		★	☆	☆	6.0	.236	82	3.228	92.1	3.626	44	1.732	0.9	.035
5.30	.209	16.6	.654	3	6	860.1-0530-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.30	.209	27.5	1.083	5	6	860.1-0530-027A0-GM	★		★	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.40	.213	16.5	.650	3	6	860.1-0540-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	92.1	3.626	28	1.102	0.9	.035
5.50	.217	16.4	.646	3	6	860.1-0550-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	28.5	1.122	5	6	860.1-0550-028A0-GM	★		★	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.60	.220	16.3	.642	3	6	860.1-0560-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	81.0	3.189	28	1.102	1.0	.039
5.60	.220	29.0	1.142	5	6	860.1-0560-029A0-GM	★		★	☆	☆	6.0	.236	82	3.228	65.0	2.559	44	1.732	1.0	.039
5.80	.228	16.2	.638	3	6	860.1-0580-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.90	.232	30.6	1.205	5	6	860.1-0590-030A0-GM	★		★	☆	☆	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
6.00	.236	16.0	.630	3	6	860.1-0600-016A0-GM	★	☆	★	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
6.00	.236	31.1	1.224	5	6	860.1-0600-031A0-GM	★		★	☆	☆	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
6.10	.240	19.4	.764	3	8	860.1-0610-019A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	90.0	3.543	34	1.339	1.0	.039
6.10	.240	31.6	1.244	5	8	860.1-0610-031A0-GM	★		★	☆	☆	8.0	.315	91	3.583	104.0	4.094	53	2.087	1.0	.039
6.20	.244	19.7	.776	3	8	860.1-0620-019A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	89.9	3.539	34	1.339	1.1	.043
6.20	.244	32.1	1.264	5	8	860.1-0620-032A0-GM	★		★	☆	☆	8.0	.315	91	3.583	77.9	3.067	53	2.087	1.1	.043

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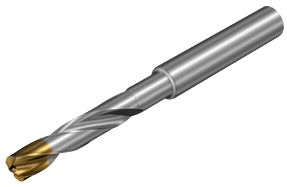
ENG

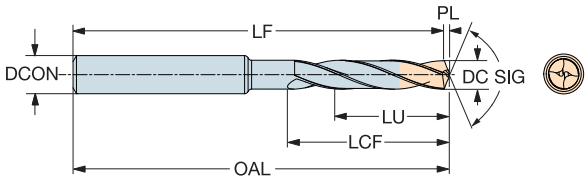
CoroDrill® 860 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°





DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	H X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
6.30	.248	20.0	.787	3	8	860.1-0630-020A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	103.9	4.091	34	1.339	1.1	.043
6.30	.248	32.6	1.283	5	8	860.1-0630-032A0-GM	★		★	☆	☆	8.0	.315	91	3.583	77.9	3.067	53	2.087	1.1	.043
6.40	.252	33.2	1.307	5	8	860.1-0640-033A0-GM	★		★	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.50	.256	20.7	.815	3	8	860.1-0650-020A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.50	.256	33.7	1.327	5	8	860.1-0650-033A0-GM	★		★	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.60	.260	20.6	.811	3	8	860.1-0660-020A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.70	.264	20.5	.807	3	8	860.1-0670-020A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	89.9	3.539	34	1.339	1.1	.043
6.70	.264	34.7	1.366	5	8	860.1-0670-034A0-GM	★		★	☆	☆	8.0	.315	91	3.583	103.9	4.091	53	2.087	1.1	.043
6.80	.268	20.4	.803	3	8	860.1-0680-020A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.047
6.80	.268	35.2	1.386	5	8	860.1-0680-035A0-GM	★		★	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
6.90	.272	35.8	1.409	5	8	860.1-0690-035A0-GM	★		★	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
7.00	.276	22.3	.878	3	8	860.1-0700-022A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	89.8	3.535	41	1.614	1.2	.047
7.00	.276	36.3	1.429	5	8	860.1-0700-036A0-GM	★		★	☆	☆	8.0	.315	91	3.583	77.8	3.063	53	2.087	1.2	.047
7.10	.280	22.6	.890	3	8	860.1-0710-022A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047
7.20	.283	22.9	.902	3	8	860.1-0720-022A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.052
7.50	.295	38.8	1.528	5	8	860.1-0750-038A0-GM	★		★	☆	☆	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051
7.70	.303	24.5	.965	3	8	860.1-0770-024A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.055
7.80	.307	24.8	.976	3	8	860.1-0780-024A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.056
8.00	.315	25.5	1.004	3	8	860.1-0800-025A0-GM	★	☆	★	☆	★	8.0	.315	79	3.110	89.6	3.528	41	1.614	1.5	.057
8.00	.315	38.4	1.512	5	8	860.1-0800-038A0-GM	★		★	☆	☆	8.0	.315	91	3.583	77.6	3.055	53	2.087	1.4	.055
8.10	.319	25.8	1.016	3	10	860.1-0810-025A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	118.6	4.669	47	1.850	1.5	.058
8.20	.323	26.1	1.028	3	10	860.1-0820-026A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.059
8.30	.327	26.4	1.039	3	10	860.1-0830-026A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.059
8.30	.327	43.0	1.693	5	10	860.1-0830-043A0-GM	★		★	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055
8.40	.331	26.7	1.051	3	10	860.1-0840-026A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.060
8.50	.335	27.0	1.063	3	10	860.1-0850-027A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.061
8.50	.335	44.0	1.732	5	10	860.1-0850-044A0-GM	★		★	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.061
8.60	.339	27.4	1.079	3	10	860.1-0860-027A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	101.5	3.996	47	1.850	1.6	.062
8.60	.339	44.6	1.756	5	10	860.1-0860-044A0-GM	★		★	☆	☆	10.0	.394	103	4.055	87.5	3.445	61	2.402	1.6	.062
8.70	.343	27.7	1.091	3	10	860.1-0870-027A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	118.5	4.665	47	1.850	1.6	.062
8.70	.343	45.0	1.772	5	10	860.1-0870-044A0-GM	★		★	☆	☆	10.0	.394	103	4.055	87.5	3.445	61	2.402	1.6	.062
8.80	.346	28.0	1.102	3	10	860.1-0880-028A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	101.5	3.996	47	1.850	1.6	.063
8.80	.346	44.9	1.768	5	10	860.1-0880-044A0-GM	★		★	☆	☆	10.0	.394	103	4.055	87.5	3.445	61	2.402	1.6	.063
9.00	.354	28.6	1.126	3	10	860.1-0900-028A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.6	.064
9.00	.354	44.7	1.760	5	10	860.1-0900-044A0-GM	★		★	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.6	.064
9.30	.366	29.6	1.165	3	10	860.1-0930-029A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.067
9.50	.374	30.2	1.189	3	10	860.1-0950-030A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	101.4	3.992	47	1.850	1.7	.068
9.50	.374	44.3	1.744	5	10	860.1-0950-044A0-GM	★		★	☆	☆	10.0	.394	103	4.055	87.4	3.441	61	2.402	1.7	.068
9.80	.386	30.0	1.181	3	10	860.1-0980-030A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.8	.070
10.00	.394	29.9	1.177	3	10	860.1-1000-029A0-GM	★	☆	★	☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.8	.072
10.00	.394	43.9	1.728	5	10	860.1-1000-043A0-GM	★		★	☆	☆	10.0	.394	103	4.055	101.3	3.988	61	2.402	1.8	.072
10.20	.402	32.5	1.280	3	12	860.1-1020-032A0-GM	★	☆	★	☆	★	12.0	.472	102	4.016	116.3	4.579	55	2.165	1.9	.073
10.20	.402	52.9	2.083	5	12	860.1-1020-052A0-GM	★		★	☆	☆	12.0	.472	118	4.646	100.3	3.949	71	2.795	1.9	.073
10.30	.406	52.9	2.083	5	12	860.1-1030-052A0-GM	★		★	☆	☆	12.0	.472	118	4.646	100.2	3.945	71	2.795	1.9	.074
10.40	.409	33.1	1.303	3	12	860.1-1040-033A0-GM	★	☆	★	☆	★	12.0	.472	102	4.016	116.2	4.575	55	2.165	1.9	.075
10.40	.409	52.8	2.079	5	12	860.1-1040-052A0-GM	★		★	☆	☆	12.0	.472	118	4.646	100.2	3.945	71	2.795	1.9	.075
10.50	.413	33.4	1.315	3	12	860.1-1050-033A0-GM	★	☆	★	☆	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.9	.075
10.50	.413	52.7	2.075	5	12	860.1-1050-052A0-GM	★		★	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.9	.075
10.80	.425	52.5	2.067	5	12	860.1-1080-052A0-GM	★		★	☆	☆	12.0	.472	118	4.646	116.1	4.571	71	2.795	2.0	.077
11.00	.433	35.0	1.378	3	12	860.1-1100-035A0-GM	★	☆	★	☆	★	12.0	.472	102	4.016	116.1	4.571	55	2.165	2.0	.079
11.00	.433	52.3	2.059	5	12	860.1-1100-052A0-GM	★		★	☆	☆	12.0	.472	118	4.646	149.1	5.870	71	2.795	2.0	.079
12.00	.472	35.6	1.402	3	12	860.1-1200-035A0-GM	★	☆	★	☆	★	12.0	.472	102	4.016	99.9	3.933	55	2.165	2.2	.086
12.00	.472	51.6	2.032	5	12	860.1-1200-051A0-GM	★		★	☆	☆	12.0	.472	118	4.646	115.9	4.563	71	2.795	2.2	.086
12.50	.492	39.4	1.551	3	14	860.1-1250-039A0-GM	★	☆	★	☆	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.3	.090
12.60	.496	39.3	1.547	3	14	860.1-1260-039A0-GM	★	☆	★	☆	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.3	.090
13.00	.512	39.0	1.535	3	14	860.1-1300-038A0-GM	★	☆	★	☆	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.4	.093
14.00	.551	38.2	1.504	3	14	860.1-1400-038A0-GM	★	☆	★	☆	★	14.0	.551	107	4.213	121.6	4.787	60	2.362	2.5	.100
14.00	.551	55.2	2.173	3	14	860.1-1400-055A0-GM	★		★	☆	☆	14.0	.551	124	4.882	104.6	4.118	77	3.032	2.5	.100

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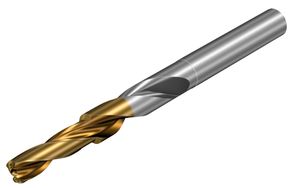
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



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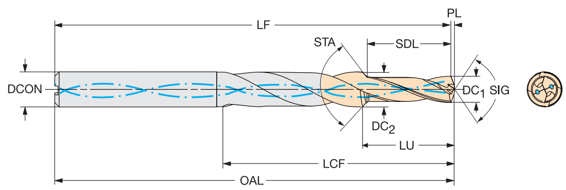
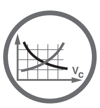


Step and chamfer drill

DC_1	DC_1"	DC_2	DC_2"	SDL	SDL"	STA	LU	LU"	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	S X1BM	H X1BM	Dimensions, mm, inch $DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
3.35	.132	4.50	.177	10.10	.398	90°	11.3	.445	6	860.2-0335-011A1-GM	★	☆	★	☆	☆	★	6.0	.236	66	2.598	61.4	2.417	19	.748	0.6	.024
3.40	.134	4.60	.181	10.20	.402	90°	11.4	.449	6	860.2-0340-011A1-GM	★	☆	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	19	.748	0.6	.024
4.25	.167	5.70	.224	12.80	.504	90°	14.3	.563	6	860.2-0425-014A1-GM	★	☆	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028
4.30	.169	5.80	.228	13.00	.512	90°	14.5	.571	6	860.2-0430-014A1-GM	★	☆	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028
4.65	.183	5.90	.232	14.00	.551	90°	15.5	.610	6	860.2-0465-015A1-GM	★	☆	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	23	.906	0.8	.031
5.00	.197	6.80	.268	15.00	.591	90°	16.8	.661	8	860.2-0500-016A1-GM	★	☆	★	☆	☆	★	8.0	.315	79	3.110	78.2	3.079	28	1.102	0.8	.031
5.10	.201	6.90	.272	15.30	.602	90°	17.1	.673	8	860.2-0510-017A1-GM	★	☆	★	☆	☆	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
5.50	.217	7.40	.291	16.60	.654	90°	18.6	.732	8	860.2-0550-018A1-GM	★	☆	★	☆	☆	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
5.55	.219	7.50	.295	16.70	.657	90°	18.7	.736	8	860.2-0555-018A1-GM	★	☆	★	☆	☆	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
6.60	.260	8.90	.350	19.90	.783	90°	22.3	.878	10	860.2-0660-022A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.9	3.461	37	1.457	1.1	.043
6.75	.266	9.10	.358	20.30	.799	90°	22.7	.894	10	860.2-0675-022A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
6.85	.270	9.20	.362	20.60	.811	90°	23.0	.906	10	860.2-0685-023A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
6.90	.272	9.30	.366	20.70	.815	90°	23.2	.913	10	860.2-0690-023A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
7.00	.276	9.50	.374	21.10	.831	90°	23.6	.929	10	860.2-0700-023A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
7.40	.291	9.80	.386	22.20	.874	90°	24.7	.972	10	860.2-0740-024A1-GM	★	☆	★	☆	☆	★	10.0	.394	89	3.504	87.7	3.453	37	1.457	1.3	.051
8.00	.315	10.80	.425	24.00	.945	90°	26.9	1.059	12	860.2-0800-026A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.6	3.961	42	1.654	1.4	.055
8.50	.335	11.50	.453	25.50	1.004	90°	28.5	1.122	12	860.2-0850-028A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
8.60	.339	11.60	.457	25.80	1.016	90°	28.9	1.138	12	860.2-0860-028A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
8.70	.343	11.70	.461	26.10	1.028	90°	29.2	1.150	12	860.2-0870-029A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
9.00	.354	11.80	.465	27.00	1.063	90°	30.0	1.181	12	860.2-0900-030A1-GM	★	☆	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
10.25	.404	13.80	.543	30.80	1.213	90°	34.4	1.354	14	860.2-1025-034A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.30	.406	13.80	.543	31.00	1.220	90°	34.6	1.362	14	860.2-1030-034A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.40	.409	13.80	.543	31.20	1.228	90°	34.8	1.370	14	860.2-1040-034A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.50	.413	13.80	.543	31.60	1.244	90°	35.2	1.386	14	860.2-1050-035A1-GM	★	☆	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
12.00	.472	15.80	.622	36.00	1.417	90°	40.1	1.579	16	860.2-1200-040A1-GM	★	☆	★	☆	☆	★	16.0	.630	115	4.528	112.9	4.445	59	2.323	2.1	.083
14.00	.551	18.90	.744	42.10	1.657	90°	47.1	1.854	20	860.2-1400-047A1-GM	★	☆	★	☆	☆	★	20.0	.787	131	5.157	128.6	5.063	78	3.071	2.4	.094



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Selecting your cutting data

Chip formation and chip evacuation are critical issues in drilling and depend on the workpiece material, choice of drill/insert geometry, coolant pressure/volume and cutting data. Chip jamming can cause radial movement of the drill and consequently affect hole quality, drill life and reliability or drill/insert breakages.

Chip formation is acceptable when the chips can be evacuated from the drill without disturbance. The best way to identify this is to listen during drilling. A consistent sound means that chip evacuation is good, but an interrupted sound indicates chip jamming. Check the feed force or power monitor. If there are irregularities, chip jamming could be the reason. Look at the chips: if they are long and bent, instead of curled, chip jamming has occurred. Look at the hole: if chip jamming has occurred, an uneven surface will be visible

Effects of cutting speed – v_c

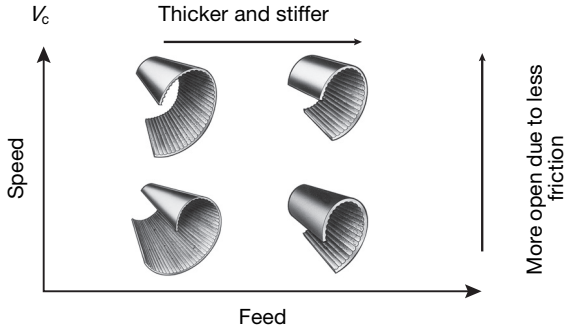
Cutting speed that is too high:
Rapid flank wear
Plastic deformation
Poor hole quality and bad hole tolerance

Cutting speed that is too low:
Built-up edge
Bad chip evacuation
Longer time in cut

Effects of feed – f_n

High feed rate:
Harder chip breaking
Less time in cut
Less tool wear but increased risk for drill breakages
Reduced hole quality

Low feed rate:
Preferable for long-chipping materials
Quality improvement
Accelerated tool wear
Longer time in cut



Achieving good hole quality

Chip evacuation
Make sure chip evacuation is satisfactory. Chip jamming affects hole quality and reliability/tool life. Drill/insert geometry and cutting data are crucial.

Stability, tool set-up
Use the shortest possible drill. Use a rigid and accurate tool holder with minimum run-out. Make sure the machine spindle is in good condition and is well-aligned. Ensure that the component is fixed and stable. Establish correct feed rates for irregular, angular surfaces and cross holes.

Tool life
Check insert wear and establish a predetermined tool life program. The most effective way to supervise drilling is by using a feed force monitor.

Maintenance
Change the insert-clamping screw regularly. Clean the tip seat before changing the insert, and make sure to use a torque wrench. Don't exceed maximum wear before regrinding solid carbide drills.

Drilling deep holes with CoroDrill® DS20
If best possible hole quality is needed when drilling 6-7xD holes with CoroDrill DS20, it is important to utilize a reduced feed rate at the entry (first 1-2 mm) (.039-.787 inch) and exit (last 5 mm) (.197 inch).

CoroDrill® DS20

4-5xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD Min.	Rec.	Max.	Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
									f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev
P	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324	230	340	400	15.00-18.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	0.04-0.1	0.04-0.07	**0.04-0.07**	0.04-0.07	-	0.04-0.09
				4334	210	285	325	18.01-22.00	0.04-0.09	**0.04-0.09**	0.04-0.09	-	0.04-0.11	0.04-0.08	**0.04-0.08**	0.04-0.08	-	0.04-0.1
				4344	190	225	245	22.01-27.00	0.04-0.1	**0.04-0.1**	0.04-0.1	-	0.04-0.12	0.04-0.09	**0.04-0.09**	0.04-0.09	-	0.04-0.11
								27.01-33.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.13	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.12
								33.01-40.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.16	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.14
								40.01-52.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	0.06-0.16	0.06-0.11	**0.06-0.11**	0.06-0.11	-	0.06-0.14
								52.01-65.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	0.06-0.16	0.06-0.11	**0.06-0.11**	0.06-0.11	-	0.06-0.14
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324	230	320	370	15.00-18.00	0.04-0.1	**0.04-0.1**	0.04-0.1	-	0.04-0.1	0.04-0.09	**0.04-0.09**	0.04-0.09	-	0.04-0.09
				4334	200	270	305	18.01-22.00	0.04-0.11	**0.04-0.11**	0.04-0.11	-	0.04-0.11	0.04-0.1	**0.04-0.1**	0.04-0.1	-	0.04-0.1
				4344	170	210	235	22.01-27.00	0.04-0.12	**0.04-0.12**	0.04-0.12	-	0.04-0.12	0.04-0.11	**0.04-0.11**	0.04-0.11	-	0.04-0.11
								27.01-33.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.12
								33.01-40.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.16	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.14
								40.01-52.00	0.06-0.14	**0.06-0.14**	0.06-0.14	-	0.06-0.16	0.06-0.13	**0.06-0.13**	0.06-0.13	-	0.06-0.14
								52.01-65.00	0.06-0.14	**0.06-0.14**	0.06-0.14	-	0.06-0.16	0.06-0.13	**0.06-0.13**	0.06-0.13	-	0.06-0.14
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324	190	265	305	15.00-18.00	-	0.05-0.12	0.06-0.14	**0.06-0.16**	-	-	0.05-0.1	0.06-0.12	**0.06-0.14**	-
				4334	155	215	250	18.01-22.00	-	0.05-0.14	0.06-0.16	**0.06-0.18**	-	-	0.05-0.12	0.06-0.14	**0.06-0.15**	-
				4344	120	165	190	22.01-27.00	-	0.05-0.18	0.06-0.2	**0.06-0.22**	-	-	0.05-0.15	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	0.07-0.22	0.08-0.24	**0.08-0.26**	-	-	0.07-0.19	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	0.07-0.24	0.08-0.26	**0.08-0.28**	-	-	0.07-0.2	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324	170	250	290	15.00-18.00	-	0.05-0.12	0.06-0.14	**0.06-0.16**	-	-	0.05-0.1	0.06-0.12	**0.06-0.14**	-
				4334	140	205	240	18.01-22.00	-	0.05-0.14	0.06-0.16	**0.06-0.18**	-	-	0.05-0.12	0.06-0.14	**0.06-0.15**	-
				4344	105	155	185	22.01-27.00	-	0.05-0.18	0.06-0.2	**0.06-0.22**	-	-	0.05-0.15	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	0.07-0.22	0.08-0.24	**0.08-0.26**	-	-	0.07-0.19	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	0.07-0.24	0.08-0.26	**0.08-0.28**	-	-	0.07-0.2	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324	140	260	325	15.00-18.00	-	0.04-0.12	0.04-0.12	**0.04-0.12**	-	-	0.04-0.1	0.04-0.1	**0.04-0.1**	-
				4334	135	220	265	18.01-22.00	-	0.04-0.13	0.04-0.13	**0.04-0.13**	-	-	0.04-0.11	0.04-0.11	**0.04-0.11**	-
				4344	125	175	200	22.01-27.00	-	0.04-0.14	0.04-0.14	**0.04-0.14**	-	-	0.04-0.12	0.04-0.12	**0.04-0.12**	-
								27.01-33.00	-	0.05-0.15	0.05-0.15	**0.05-0.15**	-	-	0.05-0.13	0.05-0.13	**0.05-0.13**	-
								33.01-40.00	-	0.05-0.16	0.05-0.16	**0.05-0.16**	-	-	0.05-0.14	0.05-0.14	**0.05-0.14**	-
								40.01-52.00	-	0.06-0.16	0.06-0.16	**0.06-0.16**	-	-	0.06-0.14	0.06-0.14	**0.06-0.14**	-
								52.01-65.00	-	0.06-0.16	0.06-0.16	**0.06-0.16**	-	-	0.06-0.14	0.06-0.14	**0.06-0.14**	-
	P2.1.Z.AN	Low alloy steel Annealed	175	4324	180	260	305	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	150	215	250	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	115	165	190	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.2.Z.AN	Low alloy steel Annealed	240	4324	180	250	290	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	150	200	225	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	115	175	205	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324	90	190	245	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	85	155	195	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	75	125	150	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324	110	210	265	15.00-18.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4334	105	175	210	18.01-22.00	-	-	0.06-0.18	**0.06-0.2**	-	-	-	0.06-0.15	**0.06-0.17**	-
				4344	100	140	160	22.01-27.00	-	-	0.06-0.22	**0.06-0.24**	-	-	-	0.06-0.19	**0.06-0.2**	-
								27.01-33.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								33.01-40.00	-	-	0.08-0.28	**0.08-0.3**	-	-	-	0.08-0.24	**0.08-0.26**	-
								40.01-52.00	-	-	0.1-0.28	**0.1-0.3**	-	-	-	0.1-0.24	**0.1-0.26**	-
								52.01-65.00	-	-	0.1-0.28	**0.1-0.3**	-	-	-	0.1-0.24	**0.1-0.26**	-
	P3.0.Z.AN	High alloy steel Annealed	200	4324	160	245	290	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	130	200	240	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	100	150	180	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-

ENG

CoroDrill® DS20

4-5xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD			Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
P	P3.0.Z.HT	High alloy steel	380	4324	80	165	210	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
		Hardened and tempered		4334	75	140	175	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	70	110	130	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P5.0.Z.AN	Ferritic/martensitic	200	4334	115	185	225	15.00-18.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	115	155	175	18.01-22.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Annealed		2044	115	150	165	22.01-27.00	0.05-0.15	**0.05-0.15**	0.05-0.15	-	0.05-0.14	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.18	**0.07-0.18**	0.07-0.18	-	0.07-0.16	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14
								40.01-52.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
								52.01-65.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
	P5.0.Z.HT	Ferritic/martensitic	330	4334	75	135	170	15.00-18.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	70	115	140	18.01-22.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Hardened and tempered		2044	70	115	140	22.01-27.00	0.05-0.15	**0.05-0.15**	0.05-0.15	-	0.05-0.14	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.18	**0.07-0.18**	0.07-0.18	-	0.07-0.16	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14
								40.01-52.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
								52.01-65.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
M	M1.0.Z.AQ	Austenitic stainless steel	200	4334	115	185	225	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	115	165	190	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Annealed/quenched		2044	115	155	180	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M1.1.Z.AQ	Austenitic stainless steel	200	4334	115	195	240	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	115	175	210	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Machinability improved		2044	115	170	200	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M2.0.Z.AQ	Super austenitic	200	4334	80	125	150	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	80	110	125	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
				2044	80	110	125	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
		Annealed/quenched						27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M3.1.Z.AQ	Duplex stainless steel	230	4334	85	125	145	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
		>60% ferrite (N<0.10%)		4344	85	115	130	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
				2044	85	110	125	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M3.2.Z.AQ	Duplex stainless steel	260	4334	75	105	120	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
		<60% ferrite (N>0.10%)		4344	75	100	115	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
				2044	75	100	115	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
S	S2.0.Z.AN	Heat resistant super	350	4334	20	40	50	15.00-18.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	-	0.04-0.07	**0.04-0.07**	0.04-0.07	-	-
	S2.0.Z.AG	Ni based		4344	20	40	50	18.01-22.00	0.04-0.09	**0.04-0.09**	0.04-0.09	-	-	0.04-0.08	**0.04-0.08**	0.04-0.08	-	-
	S2.0.Z.NS			2044	20	40	50	22.01-27.00	0.04-0.1	**0.04-0.1**	0.04-0.1	-	-	0.04-0.09	**0.04-0.09**	0.04-0.09	-	-
								27.01-33.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	-	0.05-0.1	**0.05-0.1**	0.05-0.1	-	-
								33.01-40.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	-	0.05-0.11	**0.05-0.11**	0.05-0.11	-	-
								40.01-52.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	-	0.06-0.11	**0.06-0.11**	0.06-0.11	-	-
								52.01-65.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	-	0.06-0.11	**0.06-0.11**	0.06-0.11	-	-
	S4.2.Z.AN	Heat resistant super	330	H13A	40	90	120	15.00-18.00	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-
	S4.3.Z.AG	Ti based		4344	40	90	120	18.01-22.00	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-
				2044	40	90	120	22.01-27.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
								27.01-33.00	**0.08-0.17**	0.08-0.17	0.08-0.17	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								33.01-40.00	**0.08-0.18**	0.08-0.18	0.08-0.18	-	-	**0.08-0.15**	0.08-0.15	0.08-0.15	-	-
								40.01-52.00	**0.1-0.18**	0.1-0.18	0.1-0.18	-	-	**0.1-0.15**	0.1-0.15	0.1-0.15	-	-
								52.01-65.00	**0.1-0.18**	0.1-0.18	0.1-0.18	-	-	**0.1-0.15**	0.1-0.15	0.1-0.15	-	-

CoroDrill® DS20

4-5xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD			Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324	140	210	245	15.00-18.00	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-	-	0.08-0.13	0.08-0.13	**0.08-0.17**	-
				4334	110	170	200	18.01-22.00	-	0.08-0.18	0.08-0.18	**0.08-0.23**	-	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-
				4344	180	165	155	22.01-27.00	-	0.08-0.21	0.08-0.21	**0.08-0.26**	-	-	0.08-0.18	0.08-0.18	**0.08-0.22**	-
								27.01-33.00	-	0.1-0.24	0.1-0.24	**0.1-0.29**	-	-	0.1-0.2	0.1-0.2	**0.1-0.25**	-
								33.01-40.00	-	0.1-0.27	0.1-0.27	**0.1-0.32**	-	-	0.1-0.23	0.1-0.23	**0.1-0.27**	-
								40.01-52.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
								52.01-65.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324	210	285	325	15.00-18.00	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-	-	0.08-0.13	0.08-0.13	**0.08-0.17**	-
				4334	170	235	270	18.01-22.00	-	0.08-0.18	0.08-0.18	**0.08-0.23**	-	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-
				4344	130	180	205	22.01-27.00	-	0.08-0.21	0.08-0.21	**0.08-0.26**	-	-	0.08-0.18	0.08-0.18	**0.08-0.22**	-
								27.01-33.00	-	0.1-0.24	0.1-0.24	**0.1-0.29**	-	-	0.1-0.2	0.1-0.2	**0.1-0.25**	-
								33.01-40.00	-	0.1-0.27	0.1-0.27	**0.1-0.32**	-	-	0.1-0.23	0.1-0.23	**0.1-0.27**	-
								40.01-52.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
								52.01-65.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324	125	205	245	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
				4334	100	160	195	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
				4344	75	125	150	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
	K3.1.C.UT	Nodular cast iron Ferritic	155	4324	125	190	225	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
				4334	100	155	185	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
				4344	80	120	145	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
	K3.3.C.UT	Nodular cast iron Pearlitic	265	4324	110	175	210	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
				4334	90	145	175	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
				4344	70	110	130	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
	K4.2.C.UT	Compacted graphite iron High tensile strength	230	4324	130	210	250	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
				4334	110	170	200	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
				4344	85	125	150	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
H	H1.3.Z.HA	Extra hard steels Hardened and tempered	60	4324	30	65	85	15.00-18.00	-	0.06-0.13	**0.06-0.13**	0.06-0.13	-	-	0.06-0.11	**0.06-0.11**	0.06-0.11	-
				4334	30	65	85	18.01-22.00	-	0.06-0.14	**0.06-0.14**	0.06-0.14	-	-	0.06-0.12	**0.06-0.12**	0.06-0.12	-
				4344	30	65	85	22.01-27.00	-	0.06-0.15	**0.06-0.15**	0.06-0.15	-	-	0.06-0.13	**0.06-0.13**	0.06-0.13	-
								27.01-33.00	-	0.08-0.16	**0.08-0.16**	0.08-0.16	-	-	0.08-0.14	**0.08-0.14**	0.08-0.14	-
								33.01-40.00	-	0.08-0.18	**0.08-0.18**	0.08-0.18	-	-	0.08-0.15	**0.08-0.15**	0.08-0.15	-
								40.01-52.00	-	0.1-0.18	**0.1-0.18**	0.1-0.18	-	-	0.1-0.15	**0.1-0.15**	0.1-0.15	-
								52.01-65.00	-	0.1-0.18	**0.1-0.18**	0.1-0.18	-	-	0.1-0.15	**0.1-0.15**	0.1-0.15	-

ENG

CoroDrill® DS20

4-5xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD			Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
N	N1.2.Z.AG	Aluminium based alloys	100	H13A	300	365	400	15.00-18.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		AlSi alloys, Si ≤ 1%		4344	300	365	400	18.01-22.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
								22.01-27.00	**0.06-0.2**	0.06-0.2	0.06-0.2	-	-	**0.06-0.17**	0.06-0.17	0.06-0.17	-	-
								27.01-33.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								33.01-40.00	**0.08-0.25**	0.08-0.25	0.08-0.25	-	-	**0.08-0.21**	0.08-0.21	0.08-0.21	-	-
								40.01-52.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
								52.01-65.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
	N1.3.C.UT	Aluminium based alloys	75	H13A	250	350	400	15.00-18.00	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-
		AlSi cast alloys (1% < Si >		4344	250	350	400	18.01-22.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
								22.01-27.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
								27.01-33.00	**0.08-0.2**	0.08-0.2	0.08-0.2	-	-	**0.08-0.17**	0.08-0.17	0.08-0.17	-	-
								33.01-40.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								40.01-52.00	**0.1-0.22**	0.1-0.22	0.1-0.22	-	-	**0.1-0.19**	0.1-0.19	0.1-0.19	-	-
								52.01-65.00	**0.1-0.22**	0.1-0.22	0.1-0.22	-	-	**0.1-0.19**	0.1-0.19	0.1-0.19	-	-
	N1.3.C.AG	Aluminium based alloys	90	H13A	250	315	350	15.00-18.00	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-
		AlSi cast and aged alloys		4344	250	315	350	18.01-22.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
								22.01-27.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
								27.01-33.00	**0.08-0.2**	0.08-0.2	0.08-0.2	-	-	**0.08-0.17**	0.08-0.17	0.08-0.17	-	-
								33.01-40.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								40.01-52.00	**0.1-0.22**	0.1-0.22	0.1-0.22	-	-	**0.1-0.19**	0.1-0.19	0.1-0.19	-	-
								52.01-65.00	**0.1-0.22**	0.1-0.22	0.1-0.22	-	-	**0.1-0.19**	0.1-0.19	0.1-0.19	-	-
	N3.3.U.UT	Copper based alloys	110	H13A	250	350	400	15.00-18.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		Free cutting copper		4344	250	350	400	18.01-22.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
								22.01-27.00	**0.06-0.2**	0.06-0.2	0.06-0.2	-	-	**0.06-0.17**	0.06-0.17	0.06-0.17	-	-
								27.01-33.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								33.01-40.00	**0.08-0.25**	0.08-0.25	0.08-0.25	-	-	**0.08-0.21**	0.08-0.21	0.08-0.21	-	-
								40.01-52.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
								52.01-65.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
	N3.2.C.UT	Copper based alloys	90	H13A	180	220	240	15.00-18.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		Leaded brass and		4344	180	220	240	18.01-22.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
								22.01-27.00	**0.06-0.2**	0.06-0.2	0.06-0.2	-	-	**0.06-0.17**	0.06-0.17	0.06-0.17	-	-
								27.01-33.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								33.01-40.00	**0.08-0.25**	0.08-0.25	0.08-0.25	-	-	**0.08-0.21**	0.08-0.21	0.08-0.21	-	-
								40.01-52.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
								52.01-65.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-

CoroDrill® DS20

6-7xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 6-7xD Min.	Rec.	Max.	Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
									f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev
P	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324	230	305	360	15.00-18.00	0.04-0.06	**0.04-0.06**	0.04-0.06	-	0.04-0.08	0.04-0.05	**0.04-0.05**	0.04-0.05	-	0.04-0.07
				4334	210	255	295	18.01-22.00	0.04-0.07	**0.04-0.07**	0.04-0.07	-	0.04-0.09	0.04-0.06	**0.04-0.06**	0.04-0.06	-	0.04-0.07
				4344	190	205	220	22.01-27.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	0.04-0.1	0.04-0.07	**0.04-0.07**	0.04-0.07	-	0.04-0.08
								27.01-33.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.1	0.05-0.07	**0.05-0.07**	0.05-0.07	-	0.05-0.08
								33.01-40.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.13	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.1
								40.01-52.00	0.06-0.1	**0.06-0.1**	0.06-0.1	-	0.06-0.13	0.06-0.08	**0.06-0.08**	0.06-0.08	-	0.06-0.1
								52.01-65.00	0.06-0.1	**0.06-0.1**	0.06-0.1	-	0.06-0.13	0.06-0.08	**0.06-0.08**	0.06-0.08	-	0.06-0.1
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324	230	290	335	15.00-18.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	0.04-0.08	0.04-0.07	**0.04-0.07**	0.04-0.07	-	0.04-0.07
				4334	200	245	275	18.01-22.00	0.04-0.09	**0.04-0.09**	0.04-0.09	-	0.04-0.09	0.04-0.07	**0.04-0.07**	0.04-0.07	-	0.04-0.07
				4344	170	190	210	22.01-27.00	0.04-0.1	**0.04-0.1**	0.04-0.1	-	0.04-0.1	0.04-0.08	**0.04-0.08**	0.04-0.08	-	0.04-0.08
								27.01-33.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
								33.01-40.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.13	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.1
								40.01-52.00	0.06-0.11	**0.06-0.11**	0.06-0.11	-	0.06-0.13	0.06-0.09	**0.06-0.09**	0.06-0.09	-	0.06-0.1
								52.01-65.00	0.06-0.11	**0.06-0.11**	0.06-0.11	-	0.06-0.13	0.06-0.09	**0.06-0.09**	0.06-0.09	-	0.06-0.1
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324	190	240	275	15.00-18.00	-	0.05-0.08	0.06-0.09	**0.06-0.1**	-	-	0.05-0.07	0.06-0.08	**0.06-0.09**	-
				4334	155	195	225	18.01-22.00	-	0.05-0.09	0.06-0.1	**0.06-0.12**	-	-	0.05-0.08	0.06-0.09	**0.06-0.1**	-
				4344	120	150	170	22.01-27.00	-	0.05-0.12	0.06-0.13	**0.06-0.14**	-	-	0.05-0.1	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	0.07-0.14	0.08-0.16	**0.08-0.17**	-	-	0.07-0.12	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	0.07-0.16	0.08-0.17	**0.08-0.18**	-	-	0.07-0.13	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	0.09-0.16	0.1-0.17	**0.1-0.18**	-	-	0.09-0.13	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	0.09-0.16	0.1-0.17	**0.1-0.18**	-	-	0.09-0.13	0.1-0.14	**0.1-0.15**	-
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324	170	225	260	15.00-18.00	-	0.05-0.08	0.06-0.09	**0.06-0.1**	-	-	0.05-0.07	0.06-0.08	**0.06-0.09**	-
				4334	140	185	215	18.01-22.00	-	0.05-0.09	0.06-0.1	**0.06-0.12**	-	-	0.05-0.08	0.06-0.09	**0.06-0.1**	-
				4344	105	140	165	22.01-27.00	-	0.05-0.12	0.06-0.13	**0.06-0.14**	-	-	0.05-0.1	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	0.07-0.14	0.08-0.16	**0.08-0.17**	-	-	0.07-0.12	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	0.07-0.16	0.08-0.17	**0.08-0.18**	-	-	0.07-0.13	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	0.09-0.16	0.1-0.17	**0.1-0.18**	-	-	0.09-0.13	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	0.09-0.16	0.1-0.17	**0.1-0.18**	-	-	0.09-0.13	0.1-0.14	**0.1-0.15**	-
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324	140	235	295	15.00-18.00	-	0.04-0.08	0.04-0.08	**0.04-0.08**	-	-	0.04-0.07	0.04-0.07	**0.04-0.07**	-
				4334	135	200	240	18.01-22.00	-	0.04-0.08	0.04-0.08	**0.04-0.08**	-	-	0.04-0.07	0.04-0.07	**0.04-0.07**	-
				4344	125	160	180	22.01-27.00	-	0.04-0.09	0.04-0.09	**0.04-0.09**	-	-	0.04-0.08	0.04-0.08	**0.04-0.08**	-
								27.01-33.00	-	0.05-0.1	0.05-0.1	**0.05-0.1**	-	-	0.05-0.08	0.05-0.08	**0.05-0.08**	-
								33.01-40.00	-	0.05-0.1	0.05-0.1	**0.05-0.1**	-	-	0.05-0.09	0.05-0.09	**0.05-0.09**	-
								40.01-52.00	-	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.09	0.06-0.09	**0.06-0.09**	-
								52.01-65.00	-	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.09	0.06-0.09	**0.06-0.09**	-
	P2.1.Z.AN	Low alloy steel Annealed	175	4324	180	235	275	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
				4334	150	195	225	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	115	150	170	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P2.2.Z.AN	Low alloy steel Annealed	240	4324	180	225	260	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
				4334	150	180	205	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	115	160	185	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324	90	170	220	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
				4334	85	140	175	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	75	115	135	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324	110	190	240	15.00-18.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4334	105	160	190	18.01-22.00	-	-	0.06-0.12	**0.06-0.13**	-	-	-	0.06-0.1	**0.06-0.11**	-
				4344	100	125	145	22.01-27.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.13**	-
								27.01-33.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								33.01-40.00	-	-	0.08-0.18	**0.08-0.2**	-	-	-	0.08-0.15	**0.08-0.17**	-
								40.01-52.00	-	-	0.1-0.18	**0.1-0.2**	-	-	-	0.1-0.15	**0.1-0.17**	-
								52.01-65.00	-	-	0.1-0.18	**0.1-0.2**	-	-	-	0.1-0.15	**0.1-0.17**	-
	P3.0.Z.AN	High alloy steel Annealed	200	4324	160	220	260	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
				4334	130	180	215	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	100	135	160	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-

ENG

CoroDrill® DS20

6-7xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
P	P3.0.Z.HT	High alloy steel	380	4324	80	150	190	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
		Hardened and tempered		4334	75	125	160	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	70	100	115	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P5.0.Z.AN	Ferritic/martensitic	200	4334	115	165	205	15.00-18.00	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08	0.05-0.07	**0.05-0.07**	0.05-0.07	-	0.05-0.07
				4344	115	140	160	18.01-22.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		Annealed		2044	115	135	150	22.01-27.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
								27.01-33.00	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1	0.07-0.09	**0.07-0.09**	0.07-0.09	-	0.07-0.08
								33.01-40.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.1	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								40.01-52.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
								52.01-65.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
	P5.0.Z.HT	Ferritic/martensitic	330	4334	75	120	155	15.00-18.00	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08	0.05-0.07	**0.05-0.07**	0.05-0.07	-	0.05-0.07
				4344	70	105	125	18.01-22.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		Hardened and tempered		2044	70	105	125	22.01-27.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
								27.01-33.00	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1	0.07-0.09	**0.07-0.09**	0.07-0.09	-	0.07-0.08
								33.01-40.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.1	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								40.01-52.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
								52.01-65.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
M	M1.0.Z.AQ	Austenitic stainless steel	200	4334	115	165	205	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	115	150	170	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
		Annealed/quenched		2044	115	140	160	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M1.1.Z.AQ	Austenic stainless steel	200	4334	115	175	215	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	115	160	190	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
		Machinability improved		2044	115	155	180	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M2.0.Z.AQ	Super austenitic	200	4334	80	115	135	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	80	100	115	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
				2044	80	100	115	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
		Annealed/quenched						27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M3.1.Z.AQ	Duplex stainless steel	230	4334	85	115	130	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		>60% ferrite (N<0.10%)		4344	85	105	115	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
				2044	85	100	115	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M3.2.Z.AQ	Duplex stainless steel	260	4334	75	95	110	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		<60% ferrite (N>0.10%)		4344	75	90	105	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
				2044	75	90	105	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
S	S2.0.Z.AN	Heat resistant super	350	4334	20	35	45	15.00-18.00	0.04-0.06	**0.04-0.06**	0.04-0.06	-	-	0.04-0.05	**0.04-0.05**	0.04-0.05	-	-
	S2.0.Z.AG	Ni based		4344	20	35	45	18.01-22.00	0.04-0.07	**0.04-0.07**	0.04-0.07	-	-	0.04-0.06	**0.04-0.06**	0.04-0.06	-	-
	S2.0.Z.NS			2044	20	35	45	22.01-27.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	-	0.04-0.07	**0.04-0.07**	0.04-0.07	-	-
								27.01-33.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	-	0.05-0.07	**0.05-0.07**	0.05-0.07	-	-
								33.01-40.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	-	0.05-0.08	**0.05-0.08**	0.05-0.08	-	-
								40.01-52.00	0.06-0.1	**0.06-0.1**	0.06-0.1	-	-	0.06-0.08	**0.06-0.08**	0.06-0.08	-	-
								52.01-65.00	0.06-0.1	**0.06-0.1**	0.06-0.1	-	-	0.06-0.08	**0.06-0.08**	0.06-0.08	-	-
	S4.2.Z.AN	Heat resistant super	330	H13A	40	80	110	15.00-18.00	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
	S4.3.Z.AG	Ti based		4344	40	80	110	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
				2044	40	80	110	22.01-27.00	0.06-0.13	0.06-0.13	0.06-0.13	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-

Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.05 mm/rev.

CoroDrill® DS20

6-7xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324	140	190	220	15.00-18.00	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-	-	0.08-0.08	0.08-0.08	**0.08-0.11**	-
				4334	110	155	180	18.01-22.00	-	0.08-0.12	0.08-0.12	**0.08-0.15**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
				4344	180	150	140	22.01-27.00	-	0.08-0.14	0.08-0.14	**0.08-0.17**	-	-	0.08-0.12	0.08-0.12	**0.08-0.14**	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	**0.1-0.19**	-	-	0.1-0.13	0.1-0.13	**0.1-0.16**	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	**0.1-0.21**	-	-	0.1-0.15	0.1-0.15	**0.1-0.18**	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
								52.01-65.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324	210	255	295	15.00-18.00	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-	-	0.08-0.08	0.08-0.08	**0.08-0.11**	-
				4334	170	210	245	18.01-22.00	-	0.08-0.12	0.08-0.12	**0.08-0.15**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
				4344	130	160	185	22.01-27.00	-	0.08-0.14	0.08-0.14	**0.08-0.17**	-	-	0.08-0.12	0.08-0.12	**0.08-0.14**	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	**0.1-0.19**	-	-	0.1-0.13	0.1-0.13	**0.1-0.16**	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	**0.1-0.21**	-	-	0.1-0.15	0.1-0.15	**0.1-0.18**	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
								52.01-65.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324	125	185	220	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	100	145	175	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	75	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	K3.1.C.UT	Nodular cast iron Ferritic	155	4324	125	170	205	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	100	140	165	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	80	110	130	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	K3.3.C.UT	Nodular cast iron Pearlitic	265	4324	110	160	190	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	90	130	160	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	70	100	115	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	K4.2.C.UT	Compacted graphite iron High tensile strength	230	4324	130	190	225	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	110	155	180	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	85	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
H	H1.3.Z.HA	Extra hard steels Hardened and tempered	60	4324	30	60	75	15.00-18.00	-	0.06-0.08	0.06-0.08	**0.06-0.08**	-	-	0.06-0.07	0.06-0.07	**0.06-0.07**	-
				4334	30	60	75	18.01-22.00	-	0.06-0.09	0.06-0.09	**0.06-0.09**	-	-	0.06-0.08	0.06-0.08	**0.06-0.08**	-
				4344	30	60	75	22.01-27.00	-	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.08	0.06-0.08	**0.06-0.08**	-
								27.01-33.00	-	0.08-0.1	0.08-0.1	**0.08-0.1**	-	-	0.08-0.09	0.08-0.09	**0.08-0.09**	-
								33.01-40.00	-	0.08-0.12	0.08-0.12	**0.08-0.12**	-	-	0.08-0.1	0.08-0.1	**0.08-0.1**	-
								40.01-52.00	-	0.1-0.12	0.1-0.12	**0.1-0.12**	-	-	0.1-0.1	0.1-0.1	**0.1-0.1**	-
								52.01-65.00	-	0.1-0.12	0.1-0.12	**0.1-0.12**	-	-	0.1-0.1	0.1-0.1	**0.1-0.1**	-

ENG

CoroDrill® DS20

6-7xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
N	N1.2.Z.AG	Aluminium based alloys AlSi alloys, Si ≤ 1%	100	H13A 4344	300 300	330 330	360 360	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
								18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
	N1.3.C.UT	Aluminium based alloys AlSi cast alloys (1% < Si >	75	H13A 4344	250 250	315 315	360 360	15.00-18.00	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-	**0.06-0.08**	0.06-0.08	0.06-0.08	-	-
								18.01-22.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
								22.01-27.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.13**	0.08-0.13	0.08-0.13	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
	N1.3.C.AG	Aluminium based alloys AlSi cast and aged alloys	90	H13A 4344	250 250	285 285	315 315	15.00-18.00	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-	**0.06-0.08**	0.06-0.08	0.06-0.08	-	-
								18.01-22.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
								22.01-27.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.13**	0.08-0.13	0.08-0.13	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
	N3.3.U.UT	Copper based alloys Free cutting copper	110	H13A 4344	250 250	315 315	360 360	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
								18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
	N3.2.C.UT	Copper based alloys Leaded brass and	90	H13A 4344	180 180	200 200	215 215	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
								18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-

Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.05 mm/rev.

CoroDrill® DS20

4-5xD

Inch values

ENG

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD Min.	Rec.	Max.	Drill diameter	Drill length 4xD -S5W f_n inch/rev	-L5W f_n inch/rev	-L6W f_n inch/rev	-M7W f_n inch/rev	-H5W f_n inch/rev	Drill length 5xD -S5W f_n inch/rev	-L5W f_n inch/rev	-L6W f_n inch/rev	-M7W f_n inch/rev	-H5W f_n inch/rev
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
P					Min.	Rec.	Max.											
	P1.0.Z.AN	Unalloyed steel	110	4324	755	1115	1310	0.591-0.709	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.004
		C=0.05-0.10%		4334	690	935	1065	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.004
				4344	625	740	805	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.005	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
								1.063-1.299	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.005	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.005
								1.299-1.575	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.006	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.006
								1.575-2.047	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.006	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.006
								2.047-2.559	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.006	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.006
	P1.1.Z.AN	Unalloyed steel	125	4324	755	1055	1215	0.591-0.709	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
		C=0.05-0.25%		4334	655	880	1000	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
				4344	560	695	770	0.866-1.063	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
								1.063-1.299	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
								1.299-1.575	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.006	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.006
								1.575-2.047	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.006	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.006
								2.047-2.559	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.006	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.006
	P1.2.Z.AN	Unalloyed steel	190	4324	625	870	1000	0.591-0.709	-	0.002-0.005	0.002-0.006	**0.002-0.006**	-	-	0.002-0.004	0.002-0.005	**0.002-0.005**	-
		C=0.25-0.55%		4334	510	710	820	0.709-0.866	-	0.002-0.006	0.002-0.006	**0.002-0.007**	-	-	0.002-0.005	0.002-0.005	**0.002-0.006**	-
				4344	395	545	625	0.866-1.063	-	0.002-0.007	0.002-0.008	**0.002-0.009**	-	-	0.002-0.006	0.002-0.007	**0.002-0.007**	-
								1.063-1.299	-	0.003-0.009	0.003-0.009	**0.003-0.01**	-	-	0.003-0.007	0.003-0.008	**0.003-0.009**	-
								1.299-1.575	-	0.003-0.009	0.003-0.01	**0.003-0.011**	-	-	0.003-0.008	0.003-0.009	**0.003-0.009**	-
								1.575-2.047	-	0.004-0.009	0.004-0.01	**0.004-0.011**	-	-	0.004-0.008	0.004-0.009	**0.004-0.009**	-
								2.047-2.559	-	0.004-0.009	0.004-0.01	**0.004-0.011**	-	-	0.004-0.008	0.004-0.009	**0.004-0.009**	-
	P1.3.Z.AN	Unalloyed steel	190	4324	560	815	950	0.591-0.709	-	0.002-0.005	0.002-0.006	**0.002-0.006**	-	-	0.002-0.004	0.002-0.005	**0.002-0.005**	-
		C=0.55-0.80%		4334	460	670	785	0.709-0.866	-	0.002-0.006	0.002-0.006	**0.002-0.007**	-	-	0.002-0.005	0.002-0.005	**0.002-0.006**	-
				4344	345	515	605	0.866-1.063	-	0.002-0.007	0.002-0.008	**0.002-0.009**	-	-	0.002-0.006	0.002-0.007	**0.002-0.007**	-
								1.063-1.299	-	0.003-0.009	0.003-0.009	**0.003-0.01**	-	-	0.003-0.007	0.003-0.008	**0.003-0.009**	-
								1.299-1.575	-	0.003-0.009	0.003-0.01	**0.003-0.011**	-	-	0.003-0.008	0.003-0.009	**0.003-0.009**	-
								1.575-2.047	-	0.004-0.009	0.004-0.01	**0.004-0.011**	-	-	0.004-0.008	0.004-0.009	**0.004-0.009**	-
								2.047-2.559	-	0.004-0.009	0.004-0.01	**0.004-0.011**	-	-	0.004-0.008	0.004-0.009	**0.004-0.009**	-
	P1.5.C.UT	Unalloyed steel	150	4324	460	855	1065	0.591-0.709	-	0.002-0.005	0.002-0.005	**0.002-0.005**	-	-	0.002-0.004	0.002-0.004	**0.002-0.004**	-
		Cast - untreated		4334	445	720	870	0.709-0.866	-	0.002-0.005	0.002-0.005	**0.002-0.005**	-	-	0.002-0.004	0.002-0.004	**0.002-0.004**	-
				4344	410	570	655	0.866-1.063	-	0.002-0.006	0.002-0.006	**0.002-0.006**	-	-	0.002-0.005	0.002-0.005	**0.002-0.005**	-
								1.063-1.299	-	0.002-0.006	0.002-0.006	**0.002-0.006**	-	-	0.002-0.005	0.002-0.005	**0.002-0.005**	-
								1.299-1.575	-	0.002-0.006	0.002-0.006	**0.002-0.006**	-	-	0.002-0.005	0.002-0.005	**0.002-0.005**	-
								1.575-2.047	-	0.002-0.006	0.002-0.006	**0.002-0.006**	-	-	0.002-0.005	0.002-0.005	**0.002-0.005**	-
								2.047-2.559	-	0.002-0.006	0.002-0.006	**0.002-0.006**	-	-	0.002-0.005	0.002-0.005	**0.002-0.005**	-
	P2.1.Z.AN	Low alloy steel	175	4324	590	855	1000	0.591-0.709	-	-	0.002-0.006	**0.002-0.006**	-	-	-	0.002-0.005	**0.002-0.005**	-
		Annealed		4334	490	705	820	0.709-0.866	-	-	0.002-0.006	**0.002-0.007**	-	-	-	0.002-0.005	**0.002-0.006**	-
				4344	375	540	625	0.866-1.063	-	-	0.002-0.008	**0.002-0.009**	-	-	-	0.002-0.007	**0.002-0.007**	-
								1.063-1.299	-	-	0.003-0.009	**0.003-0.01**	-	-	-	0.003-0.008	**0.003-0.009**	-
								1.299-1.575	-	-	0.003-0.01	**0.003-0.011**	-	-	-	0.003-0.009	**0.003-0.009**	-
								1.575-2.047	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
								2.047-2.559	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
	P2.2.Z.AN	Low alloy steel	240	4324	590	825	950	0.591-0.709	-	-	0.002-0.006	**0.002-0.006**	-	-	-	0.002-0.005	**0.002-0.005**	-
		Annealed		4334	490	655	740	0.709-0.866	-	-	0.002-0.006	**0.002-0.007**	-	-	-	0.002-0.005	**0.002-0.006**	-
				4344	375	565	670	0.866-1.063	-	-	0.002-0.008	**0.002-0.009**	-	-	-	0.002-0.007	**0.002-0.007**	-
								1.063-1.299	-	-	0.003-0.009	**0.003-0.01**	-	-	-	0.003-0.008	**0.003-0.009**	-
								1.299-1.575	-	-	0.003-0.01	**0.003-0.011**	-	-	-	0.003-0.009	0.003-0.009	-
								1.575-2.047	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
								2.047-2.559	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
	P2.5.Z.HT	Low alloy steel	330	4324	295	625	805	0.591-0.709	-	-	0.002-0.006	**0.002-0.006**	-	-	-	0.002-0.005	**0.002-0.005**	-
		Hardened and tempered		4334	280	515	640	0.709-0.866	-	-	0.002-0.006	**0.002-0.007**	-	-	-	0.002-0.005	**0.002-0.006**	-
				4344	245	405	490	0.866-1.063	-	-	0.002-0.008	**0.002-0.009**	-	-	-	0.002-0.007	**0.002-0.007**	-
								1.063-1.299	-	-	0.003-0.009	**0.003-0.01**	-	-	-	0.003-0.008	**0.003-0.009**	-
								1.299-1.575	-	-	0.003-0.01	**0.003-0.011**	-	-	-	0.003-0.009	**0.003-0.009**	-
								1.575-2.047	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
								2.047-2.559	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
	P2.6.C.UT	Low alloy steel	200	4324	360	690	870	0.591-0.709	-	-	0.002-0.006	**0.002-0.007**	-	-	-	0.002-0.005	**0.002-0.006**	-
		Cast - untreated		4334	345	570	690	0.709-0.866	-	-	0.002-0.007	**0.002-0.008**	-	-	-	0.002-0.006	**0.002-0.007**	-
				4344	330	455	525	0.866-1.063	-	-	0.002-0.009	**0.002-0.009**	-	-	-	0.002-0.007	**0.002-0.008**	-
								1.063-1.299	-	-	0.003-0.01	**0.003-0.011**	-	-	-	0.003-0.009	**0.003-0.009**	-
								1.299-1.575	-	-	0.003-0.011	**0.003-0.012**	-	-	-	0.003-0.009	**0.003-0.01**	-
								1.575-2.047	-	-	0.004-0.011	**0.004-0.012**	-	-	-	0.004-0.009	**0.004-0.01**	-
								2.047-2.559	-	-	0.004-0.011	**0.004-0.012**	-	-	-	0.004-0.009	**0.004-0.01**	-
	P3.0.Z.AN	High alloy steel	200	4324	525	800	950	0.591-0.709	-	-	0.002-0.006	**0.002-0.006**	-	-	-	0.002-0.005	**0.002-0.005**	-
		Annealed		4334	425	660	785	0.709-0.866	-	-	0.002-0.006	**0.002-0.007**	-	-	-	0.002-0.005	**0.002-0.006**	-
				4344	330	500	590	0.866-1.063	-	-	0.002-0.008	**0.002-0.009**	-	-	-	0.002-0.007	**0.002-0.007**	-
								1.063-1.299	-	-	0.003-0.009	**0.003-0.01**	-	-	-	0.003-0.008	**0.003-0.009**	-
								1.299-1.575	-	-	0.003-0.01	**0.003-0.011**	-	-	-	0.003-0.009	**0.003-0.009**	-
								1.575-2.047	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
								2.047-2.559	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-

ENG

CoroDrill® DS20

4-5xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD			Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
P	P3.0.Z.HT	High alloy steel	380	4324	260	540	690	0.591-0.709	-	-	0.002-0.006	**0.002-0.006**	-	-	-	0.002-0.005	**0.002-0.005**	-
		Hardened and tempered		4334	245	460	575	0.709-0.866	-	-	0.002-0.006	**0.002-0.007**	-	-	-	0.002-0.005	**0.002-0.006**	-
				4344	230	355	425	0.866-1.063	-	-	0.002-0.008	**0.002-0.009**	-	-	-	0.002-0.007	**0.002-0.007**	-
								1.063-1.299	-	-	0.003-0.009	**0.003-0.01**	-	-	-	0.003-0.008	**0.003-0.009**	-
								1.299-1.575	-	-	0.003-0.01	**0.003-0.011**	-	-	-	0.003-0.009	**0.003-0.009**	-
								1.575-2.047	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
								2.047-2.559	-	-	0.004-0.01	**0.004-0.011**	-	-	-	0.004-0.009	**0.004-0.009**	-
	P5.0.Z.AN	Ferritic/martensitic stainless	200	4334	375	610	740	0.591-0.709	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
				4344	375	505	575	0.709-0.866	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004
		Annealed		2044	375	480	540	0.866-1.063	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.006	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
								1.063-1.299	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005
								1.299-1.575	0.003-0.007	**0.003-0.007**	0.003-0.007	-	0.003-0.006	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.005
								1.575-2.047	0.004-0.007	**0.004-0.007**	0.004-0.007	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
								2.047-2.559	0.004-0.007	**0.004-0.007**	0.004-0.007	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
	P5.0.Z.HT	Ferritic/martensitic stainless	330	4334	245	450	560	0.591-0.709	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
				4344	230	380	460	0.709-0.866	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004
		Hardened and tempered		2044	230	380	460	0.866-1.063	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.006	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
								1.063-1.299	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005
								1.299-1.575	0.003-0.007	**0.003-0.007**	0.003-0.007	-	0.003-0.006	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.005
								1.575-2.047	0.004-0.007	**0.004-0.007**	0.004-0.007	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
								2.047-2.559	0.004-0.007	**0.004-0.007**	0.004-0.007	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
M	M1.0.Z.AQ	Austenitic stainless steel	200	4334	375	610	740	0.591-0.709	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
				4344	375	540	625	0.709-0.866	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004
		Annealed/quenched		2044	375	515	590	0.866-1.063	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
								1.063-1.299	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005
								1.299-1.575	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.005
								1.575-2.047	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
								2.047-2.559	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
	M1.1.Z.AQ	Austenitic Stainless steel	200	4334	375	640	785	0.591-0.709	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
				4344	375	580	690	0.709-0.866	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004
		Machinability improved		2044	375	555	655	0.866-1.063	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
								1.063-1.299	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005
								1.299-1.575	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.005
								1.575-2.047	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
								2.047-2.559	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
	M2.0.Z.AQ	Super austenitic (Ni>20%)	200	4334	260	410	490	0.591-0.709	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
				4344	260	360	410	0.709-0.866	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004
				2044	260	360	410	0.866-1.063	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
		Annealed/quenched						1.063-1.299	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005
								1.299-1.575	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.005
								1.575-2.047	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
								2.047-2.559	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
	M3.1.Z.AQ	Duplex stainless steel	230	4334	280	405	475	0.591-0.709	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
		>60% ferrite (N<0.10%)		4344	280	375	425	0.709-0.866	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004
				2044	280	365	410	0.866-1.063	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
								1.063-1.299	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005
								1.299-1.575	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.005
								1.575-2.047	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
								2.047-2.559	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
	M3.2.Z.AQ	Duplex stainless steel	260	4334	245	345	395	0.591-0.709	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004
		<60% ferrite (N≥0.10%)		4344	245	330	375	0.709-0.866	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.004
				2044	245	330	375	0.866-1.063	0.002-0.006	**0.002-0.006**	0.002-0.006	-	0.002-0.005	0.002-0.005	**0.002-0.005**	0.002-0.005	-	0.002-0.005
								1.063-1.299	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005
								1.299-1.575	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.006	0.003-0.006	**0.003-0.006**	0.003-0.006	-	0.003-0.005
								1.575-2.047	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
								2.047-2.559	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.006	0.004-0.006	**0.004-0.006**	0.004-0.006	-	0.004-0.005
S	S2.0.Z.AN	Heat resistant super alloys	350	4334	65	130	165	0.591-0.709	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-
	S2.0.Z.AG	Ni based		4344	65	130	165	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-
	S2.0.Z.NS			2044	65	130	165	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-
								1.063-1.299	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-
								1.299-1.575	0.002-0.005	**0.002-0.005**	0.002-0.005	-	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-
								1.575-2.047	0.002-0.005	**0.002-0.005**	0.002-0.005	-	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-
								2.047-2.559	0.002-0.005	**0.002-0.005**	0.002-0.005	-	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-
	S4.2.Z.AN	Heat resistant super alloys	330	H13A	130	300	395	0.591-0.709	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
	S4.3.Z.AG	Ti-based		4344	130	300	395	0.709-0.866	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
				2044	130	300	395	0.866-1.063	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								1.063-1.299	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-
								1.299-1.575	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-
								1.575-2.047	**0.004-0.007**	0.004-0.007	0.004-0.007	-	-	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-
								2.047-2.559	**0.004-0.007**	0.004-0.007	0.004-0.007	-	-	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-

CoroDrill® DS20

4-5xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD			Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324	460	685	805	0.591-0.709	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-
				4334	360	550	655	0.709-0.866	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-
				4344	590	540	510	0.866-1.063	-	0.003-0.008	0.003-0.008	**0.003-0.01**	-	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-
								1.063-1.299	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-	-	0.004-0.008	0.004-0.008	**0.004-0.01**	-
								1.299-1.575	-	0.004-0.011	0.004-0.011	**0.004-0.013**	-	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-
								1.575-2.047	-	0.005-0.011	0.005-0.011	**0.005-0.013**	-	-	0.005-0.009	0.005-0.009	**0.005-0.011**	-
								2.047-2.559	-	0.005-0.011	0.005-0.011	**0.005-0.013**	-	-	0.005-0.009	0.005-0.009	**0.005-0.011**	-
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324	690	935	1065	0.591-0.709	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-
				4334	560	770	885	0.709-0.866	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-
				4344	425	585	670	0.866-1.063	-	0.003-0.008	0.003-0.008	**0.003-0.01**	-	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-
								1.063-1.299	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-	-	0.004-0.008	0.004-0.008	**0.004-0.01**	-
								1.299-1.575	-	0.004-0.011	0.004-0.011	**0.004-0.013**	-	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-
								1.575-2.047	-	0.005-0.011	0.005-0.011	**0.005-0.013**	-	-	0.005-0.009	0.005-0.009	**0.005-0.011**	-
								2.047-2.559	-	0.005-0.011	0.005-0.011	**0.005-0.013**	-	-	0.005-0.009	0.005-0.009	**0.005-0.011**	-
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324	410	665	805	0.591-0.709	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-	-	0.003-0.004	0.003-0.004	**0.003-0.006**	-
				4334	330	530	640	0.709-0.866	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-
				4344	245	405	490	0.866-1.063	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-
								1.063-1.299	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-	-	0.004-0.007	0.004-0.007	**0.004-0.009**	-
								1.299-1.575	-	0.004-0.01	0.004-0.01	**0.004-0.012**	-	-	0.004-0.008	0.004-0.008	**0.004-0.01**	-
								1.575-2.047	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
								2.047-2.559	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
	K3.1.C.UT	Nodular cast iron Ferritic	155	4324	410	625	740	0.591-0.709	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-	-	0.003-0.004	0.003-0.004	**0.003-0.006**	-
				4334	330	510	605	0.709-0.866	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-
				4344	260	400	475	0.866-1.063	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-
								1.063-1.299	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-	-	0.004-0.007	0.004-0.007	**0.004-0.009**	-
								1.299-1.575	-	0.004-0.01	0.004-0.01	**0.004-0.012**	-	-	0.004-0.008	0.004-0.008	**0.004-0.01**	-
								1.575-2.047	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
								2.047-2.559	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
	K3.3.C.UT	Nodular cast iron Ferritic	265	4324	360	575	690	0.591-0.709	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-	-	0.003-0.004	0.003-0.004	**0.003-0.006**	-
				4334	295	475	575	0.709-0.866	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-
				4344	230	355	425	0.866-1.063	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-
								1.063-1.299	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-	-	0.004-0.007	0.004-0.007	**0.004-0.009**	-
								1.299-1.575	-	0.004-0.01	0.004-0.01	**0.004-0.012**	-	-	0.004-0.008	0.004-0.008	**0.004-0.01**	-
								1.575-2.047	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
								2.047-2.559	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
	K4.2.C.UT	Compacted graphite iron High tensile strength	230	4324	425	680	820	0.591-0.709	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-	-	0.003-0.004	0.003-0.004	**0.003-0.006**	-
				4334	360	550	655	0.709-0.866	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-
				4344	280	415	490	0.866-1.063	-	0.003-0.007	0.003-0.007	**0.003-0.009**	-	-	0.003-0.006	0.003-0.006	**0.003-0.008**	-
								1.063-1.299	-	0.004-0.009	0.004-0.009	**0.004-0.011**	-	-	0.004-0.007	0.004-0.007	**0.004-0.009**	-
								1.299-1.575	-	0.004-0.01	0.004-0.01	**0.004-0.012**	-	-	0.004-0.008	0.004-0.008	**0.004-0.01**	-
								1.575-2.047	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
								2.047-2.559	-	0.005-0.01	0.005-0.01	**0.005-0.012**	-	-	0.005-0.008	0.005-0.008	**0.005-0.01**	-
H	H1.3.Z.HA	Extra hard steel Hardened and tempered	60	4324	100	215	280	0.591-0.709	-	0.002-0.005	**0.002-0.005**	0.002-0.005	-	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-
				4334	100	215	280	0.709-0.866	-	0.002-0.006	**0.002-0.006**	0.002-0.006	-	-	0.002-0.005	**0.002-0.005**	0.002-0.005	-
				4344	100	215	280	0.866-1.063	-	0.002-0.006	**0.002-0.006**	0.002-0.006	-	-	0.002-0.005	**0.002-0.005**	0.002-0.005	-
								1.063-1.299	-	0.003-0.006	**0.003-0.006**	0.003-0.006	-	-	0.003-0.005	**0.003-0.005**	0.003-0.005	-
								1.299-1.575	-	0.003-0.007	**0.003-0.007**	0.003-0.007	-	-	0.003-0.006	**0.003-0.006**	0.003-0.006	-
								1.575-2.047	-	0.004-0.007	**0.004-0.007**	0.004-0.007	-	-	0.004-0.006	**0.004-0.006**	0.004-0.006	-
								2.047-2.559	-	0.004-0.007	**0.004-0.007**	0.004-0.007	-	-	0.004-0.006	**0.004-0.006**	0.004-0.006	-

ENG

CoroDrill® DS20

4-5xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD			Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
N	N1.2.Z.AG	Aluminium based alloys AlSi alloys, Si ≤ 1%	100	H13A 4344	985	1195	1310	0.591-0.709	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								0.709-0.866	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-
								0.866-1.063	**0.002-0.008**	0.002-0.008	0.002-0.008	-	-	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-
								1.063-1.299	**0.003-0.009**	0.003-0.009	0.003-0.009	-	-	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-
								1.299-1.575	**0.003-0.01**	0.003-0.01	0.003-0.01	-	-	**0.003-0.008**	0.003-0.008	0.003-0.008	-	-
								1.575-2.047	**0.004-0.01**	0.004-0.01	0.004-0.01	-	-	**0.004-0.008**	0.004-0.008	0.004-0.008	-	-
								2.047-2.559	**0.004-0.01**	0.004-0.01	0.004-0.01	-	-	**0.004-0.008**	0.004-0.008	0.004-0.008	-	-
	N1.3.C.UT	Aluminium based alloys AlSi alloys, Si ≤ 1%	75	H13A 4344	820	1140	1310	0.591-0.709	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								0.709-0.866	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								0.866-1.063	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-
								1.063-1.299	**0.003-0.008**	0.003-0.008	0.003-0.008	-	-	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-
								1.299-1.575	**0.003-0.009**	0.003-0.009	0.003-0.009	-	-	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-
								1.575-2.047	**0.004-0.009**	0.004-0.009	0.004-0.009	-	-	**0.004-0.007**	0.004-0.007	0.004-0.007	-	-
								2.047-2.559	**0.004-0.009**	0.004-0.009	0.004-0.009	-	-	**0.004-0.007**	0.004-0.007	0.004-0.007	-	-
	N1.3.C.AG	Aluminium based alloys AlSi cast and aged alloys	90	H13A 4344	820	1035	1150	0.591-0.709	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								0.709-0.866	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								0.866-1.063	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-
								1.063-1.299	**0.003-0.008**	0.003-0.008	0.003-0.008	-	-	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-
								1.299-1.575	**0.003-0.009**	0.003-0.009	0.003-0.009	-	-	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-
								1.575-2.047	**0.004-0.009**	0.004-0.009	0.004-0.009	-	-	**0.004-0.007**	0.004-0.007	0.004-0.007	-	-
								2.047-2.559	**0.004-0.009**	0.004-0.009	0.004-0.009	-	-	**0.004-0.007**	0.004-0.007	0.004-0.007	-	-
	N3.3.U.UT	Copper based alloys Free cutting copper based	110	H13A 4344	820	1140	1310	0.591-0.709	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								0.709-0.866	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-
								0.866-1.063	**0.002-0.008**	0.002-0.008	0.002-0.008	-	-	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-
								1.063-1.299	**0.003-0.009**	0.003-0.009	0.003-0.009	-	-	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-
								1.299-1.575	**0.003-0.01**	0.003-0.01	0.003-0.01	-	-	**0.003-0.008**	0.003-0.008	0.003-0.008	-	-
								1.575-2.047	**0.004-0.01**	0.004-0.01	0.004-0.01	-	-	**0.004-0.008**	0.004-0.008	0.004-0.008	-	-
								2.047-2.559	**0.004-0.01**	0.004-0.01	0.004-0.01	-	-	**0.004-0.008**	0.004-0.008	0.004-0.008	-	-
	N3.2.C.UT	Copper based alloys Leaded brass & bronzes (Pb	90	H13A 4344	590	715	785	0.591-0.709	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-
								0.709-0.866	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-	**0.002-0.006**	0.002-0.006	0.002-0.006	-	-
								0.866-1.063	**0.002-0.008**	0.002-0.008	0.002-0.008	-	-	**0.002-0.007**	0.002-0.007	0.002-0.007	-	-
								1.063-1.299	**0.003-0.009**	0.003-0.009	0.003-0.009	-	-	**0.003-0.007**	0.003-0.007	0.003-0.007	-	-
								1.299-1.575	**0.003-0.01**	0.003-0.01	0.003-0.01	-	-	**0.003-0.008**	0.003-0.008	0.003-0.008	-	-
								1.575-2.047	**0.004-0.01**	0.004-0.01	0.004-0.01	-	-	**0.004-0.008**	0.004-0.008	0.004-0.008	-	-
								2.047-2.559	**0.004-0.01**	0.004-0.01	0.004-0.01	-	-	**0.004-0.008**	0.004-0.008	0.004-0.008	-	-

CoroDrill® DS20

6-7xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting data recommendations 6-7xD Min.	Rec.	Max.	Drill diameter	Drill length 6xD -S5W fn inch/rev	-L5W fn inch/rev	-L6W fn inch/rev	-M7W fn inch/rev	-H5W fn inch/rev	Drill length 7xD -S5W fn inch/rev	-L5W fn inch/rev	-L6W fn inch/rev	-M7W fn inch/rev	-H5W fn inch/rev
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
P	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324	755	1005	1180	0.591-0.709	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003	**0.002-0.002**	0.002-0.002	0.002-0.002	-	0.002-0.003
				4334	690	840	960	0.709-0.866	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003	**0.002-0.002**	0.002-0.002	0.002-0.002	-	0.002-0.003
				4344	625	665	725	0.866-1.063	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.004	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003
								1.063-1.299	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.004	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003
								1.299-1.575	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.005	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.004
								1.575-2.047	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.005	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.004
								2.047-2.559	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.005	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.004
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324	755	950	1095	0.591-0.709	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003
				4334	655	790	900	0.709-0.866	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003
				4344	560	625	695	0.866-1.063	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.004	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003
								1.063-1.299	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.004	**0.002-0.003**	0.002-0.003	0.002-0.003	-	0.002-0.003
								1.299-1.575	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.005	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.004
								1.575-2.047	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.005	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.004
								2.047-2.559	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.005	**0.002-0.004**	0.002-0.004	0.002-0.004	-	0.002-0.004
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324	625	785	900	0.591-0.709	-	0.002-0.003	0.002-0.004	**0.002-0.004**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
				4334	510	640	740	0.709-0.866	-	0.002-0.004	0.002-0.004	**0.002-0.005**	-	-	0.002-0.003	0.002-0.003	**0.002-0.004**	-
				4344	395	490	565	0.866-1.063	-	0.002-0.005	0.002-0.005	**0.002-0.006**	-	-	0.002-0.004	0.002-0.004	**0.002-0.005**	-
								1.063-1.299	-	0.003-0.006	0.003-0.006	0.003-0.007	-	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-
								1.299-1.575	-	0.003-0.006	0.003-0.007	**0.003-0.007**	-	-	0.003-0.005	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	0.004-0.006	0.004-0.007	**0.004-0.007**	-	-	0.004-0.005	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	0.004-0.006	0.004-0.007	**0.004-0.007**	-	-	0.004-0.005	0.004-0.006	**0.004-0.006**	-
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324	560	735	855	0.591-0.709	-	0.002-0.003	0.002-0.004	**0.002-0.004**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
				4334	460	605	705	0.709-0.866	-	0.002-0.004	0.002-0.004	**0.002-0.005**	-	-	0.002-0.003	0.002-0.003	**0.002-0.004**	-
				4344	345	465	545	0.866-1.063	-	0.002-0.005	0.002-0.005	**0.002-0.006**	-	-	0.002-0.004	0.002-0.004	**0.002-0.005**	-
								1.063-1.299	-	0.003-0.006	0.003-0.006	**0.003-0.007**	-	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-
								1.299-1.575	-	0.003-0.006	0.003-0.007	**0.003-0.007**	-	-	0.003-0.005	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	0.004-0.006	0.004-0.007	**0.004-0.007**	-	-	0.004-0.005	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	0.004-0.006	0.004-0.007	**0.004-0.007**	-	-	0.004-0.005	0.004-0.006	**0.004-0.006**	-
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324	460	770	960	0.591-0.709	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
				4334	445	650	785	0.709-0.866	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
				4344	410	515	590	0.866-1.063	-	0.002-0.004	0.002-0.004	**0.002-0.004**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
								1.063-1.299	-	0.002-0.004	0.002-0.004	**0.002-0.004**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
								1.299-1.575	-	0.002-0.004	0.002-0.004	**0.002-0.004**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
								1.575-2.047	-	0.002-0.004	0.002-0.004	**0.002-0.004**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
								2.047-2.559	-	0.002-0.004	0.002-0.004	**0.002-0.004**	-	-	0.002-0.003	0.002-0.003	**0.002-0.003**	-
	P2.1.Z.AN	Low alloy steel Annealed	175	4324	590	770	900	0.591-0.709	-	-	0.002-0.004	**0.002-0.004**	-	-	-	0.002-0.003	**0.002-0.003**	-
				4334	490	635	740	0.709-0.866	-	-	0.002-0.004	**0.002-0.005**	-	-	-	0.002-0.003	**0.002-0.004**	-
				4344	375	485	565	0.866-1.063	-	-	0.002-0.005	**0.002-0.006**	-	-	-	0.002-0.004	**0.002-0.005**	-
								1.063-1.299	-	-	0.003-0.006	**0.003-0.007**	-	-	-	0.003-0.005	**0.003-0.006**	-
								1.299-1.575	-	-	0.003-0.007	**0.003-0.007**	-	-	-	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
	P2.2.Z.AN	Low alloy steel Annealed	240	4324	590	745	855	0.591-0.709	-	-	0.002-0.004	**0.002-0.004**	-	-	-	0.002-0.003	**0.002-0.003**	-
				4334	490	590	665	0.709-0.866	-	-	0.002-0.004	**0.002-0.005**	-	-	-	0.002-0.003	**0.002-0.004**	-
				4344	375	510	605	0.866-1.063	-	-	0.002-0.005	**0.002-0.006**	-	-	-	0.002-0.004	**0.002-0.005**	-
								1.063-1.299	-	-	0.003-0.006	**0.003-0.007**	-	-	-	0.003-0.005	**0.003-0.006**	-
								1.299-1.575	-	-	0.003-0.007	**0.003-0.007**	-	-	-	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324	295	565	725	0.591-0.709	-	-	0.002-0.004	**0.002-0.004**	-	-	-	0.002-0.003	**0.002-0.003**	-
				4334	280	465	575	0.709-0.866	-	-	0.002-0.004	**0.002-0.005**	-	-	-	0.002-0.003	**0.002-0.004**	-
				4344	245	365	440	0.866-1.063	-	-	0.002-0.005	**0.002-0.006**	-	-	-	0.002-0.004	**0.002-0.005**	-
								1.063-1.299	-	-	0.003-0.006	0.003-0.007	-	-	-	0.003-0.005	**0.003-0.006**	-
								1.299-1.575	-	-	0.003-0.007	**0.003-0.007**	-	-	-	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324	360	620	785	0.591-0.709	-	-	0.002-0.004	**0.002-0.005**	-	-	-	0.002-0.003	**0.002-0.004**	-
				4334	345	515	620	0.709-0.866	-	-	0.002-0.005	**0.002-0.005**	-	-	-	0.002-0.004	**0.002-0.004**	-
				4344	330	410	475	0.866-1.063	-	-	0.002-0.006	**0.002-0.006**	-	-	-	0.002-0.005	**0.002-0.005**	-
								1.063-1.299	-	-	0.003-0.007	**0.003-0.007**	-	-	-	0.003-0.006	**0.003-0.006**	-
								1.299-1.575	-	-	0.003-0.007	**0.003-0.008**	-	-	-	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	-	0.004-0.007	**0.004-0.008**	-	-	-	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	-	0.004-0.007	**0.004-0.008**	-	-	-	0.004-0.006	**0.004-0.006**	-
	P3.0.Z.AN	High alloy steel Annealed	200	4324	525	720	855	0.591-0.709	-	-	0.002-0.004	**0.002-0.004**	-	-	-	0.002-0.003	**0.002-0.003**	-
				4334	425	595	705	0.709-0.866	-	-	0.002-0.004	**0.002-0.005**	-	-	-	0.002-0.003	**0.002-0.004**	-
				4344	330	450	530	0.866-1.063	-	-	0.002-0.005	**0.002-0.006**	-	-	-	0.002-0.004	**0.002-0.005**	-
								1.063-1.299	-	-	0.003-0.006	**0.003-0.007**	-	-	-	0.003-0.005	0.003-0.006	-
								1.299-1.575	-	-	0.003-0.007	**0.003-0.007**	-	-	-	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-

ENG

CoroDrill® DS20

6-7xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting data recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
P	P3.0.Z.HT	High alloy steel	380	4324	260	485	620	0.591-0.709	-	-	0.002-0.004	**0.002-0.004**	-	-	-	0.002-0.003	**0.002-0.003**	-
		Hardened and tempered		4334	245	415	520	0.709-0.866	-	-	0.002-0.004	**0.002-0.005**	-	-	-	0.002-0.003	**0.002-0.004**	-
				4344	230	320	385	0.866-1.063	-	-	0.002-0.005	**0.002-0.006**	-	-	-	0.002-0.004	**0.002-0.005**	-
								1.063-1.299	-	-	0.003-0.006	**0.003-0.007**	-	-	-	0.003-0.005	**0.003-0.006**	-
								1.299-1.575	-	-	0.003-0.007	**0.003-0.007**	-	-	-	0.003-0.006	**0.003-0.006**	-
								1.575-2.047	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
								2.047-2.559	-	-	0.004-0.007	**0.004-0.007**	-	-	-	0.004-0.006	**0.004-0.006**	-
	P5.0.Z.AN	Ferritic/martensitic stainless	200	4334	375	550	665	0.591-0.709	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				4344	375	455	520	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
		Annealed		2044	375	430	485	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
								1.063-1.299	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004	0.003-0.003	**0.003-0.003**	0.003-0.003	-	0.003-0.003
								1.299-1.575	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.004	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.003
								1.575-2.047	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.004	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.003
								2.047-2.559	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.004	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.003
	P5.0.Z.HT	Ferritic/martensitic stainless	330	4334	245	405	505	0.591-0.709	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				4344	230	340	415	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
		Hardened and tempered		2044	230	340	415	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
								1.063-1.299	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004	0.003-0.003	**0.003-0.003**	0.003-0.003	-	0.003-0.003
								1.299-1.575	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.004	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.003
								1.575-2.047	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.004	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.003
								2.047-2.559	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.004	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.003
	M1.0.Z.AQ	Austenitic stainless steel	200	4334	375	550	665	0.591-0.709	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				4344	375	485	565	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
		Annealed/quenched		2044	375	465	530	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003
								1.063-1.299	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.004	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.299-1.575	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.575-2.047	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
								2.047-2.559	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
M	M1.1.Z.AQ	Austenitic Stainless steel	200	4334	375	575	705	0.591-0.709	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				4344	375	520	620	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
		Machinability improved		2044	375	500	590	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003
								1.063-1.299	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.004	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.299-1.575	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.575-2.047	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
								2.047-2.559	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
	M2.0.Z.AQ	Super austenitic (Ni>20%)	200	4334	260	370	440	0.591-0.709	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				4344	260	325	370	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				2044	260	325	370	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003
		Annealed/quenched						1.063-1.299	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.004	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.299-1.575	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.575-2.047	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
								2.047-2.559	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
	M3.1.Z.AQ	Duplex stainless steel	230	4334	280	365	430	0.591-0.709	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
		>60% ferrite (N<0.10%)		4344	280	340	385	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				2044	280	330	370	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003
								1.063-1.299	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.004	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.299-1.575	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.575-2.047	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
								2.047-2.559	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
	M3.2.Z.AQ	Duplex stainless steel	260	4334	245	310	355	0.591-0.709	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
		<60% ferrite (N≥0.10%)		4344	245	295	340	0.709-0.866	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003	0.002-0.003	**0.002-0.003**	0.002-0.003	-	0.002-0.003
				2044	245	295	340	0.866-1.063	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.004	0.002-0.004	**0.002-0.004**	0.002-0.004	-	0.002-0.003
								1.063-1.299	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.004	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.299-1.575	0.003-0.005	**0.003-0.005**	0.003-0.005	-	0.003-0.005	0.003-0.004	**0.003-0.004**	0.003-0.004	-	0.003-0.004
								1.575-2.047	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
								2.047-2.559	0.004-0.005	**0.004-0.005**	0.004-0.005	-	0.004-0.005	0.004-0.004	**0.004-0.004**	0.004-0.004	-	0.004-0.004
S	S2.0.Z.AN	Heat resistant super alloys	350	4334	65	115	150	0.591-0.709	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-	0.002-0.002	**0.002-0.002**	0.002-0.002	-	-
	S2.0.Z.AG	Ni based		4344	65	115	150	0.709-0.866	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-	0.002-0.002	**0.002-0.002**	0.002-0.002	-	-
	S2.0.Z.NS			2044	65	115	150	0.866-1.063	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-
								1.063-1.299	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-
								1.299-1.575	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-
								1.575-2.047	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-
								2.047-2.559	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-
	S4.2.Z.AN	Heat resistant super alloys	330	H13A	130	270	355	0.591-0.709	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
	S4.3.Z.AG	Ti-based		4344	130	270	355	0.709-0.866	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
				2044	130	270	355	0.866-1.063	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								1.063-1.299	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-	**0.003-0.004**	0.003-0.004	0.003-0.004	-	-
								1.299-1.575	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.575-2.047	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
								2.047-2.559	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-

Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.05 mm/rev.

CoroDrill® DS20

6-7xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting data recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
K	K1.1.C.NS	Malleable cast iron	200	4324	460	615	725	0.591-0.709	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.004**	-
		Low tensile strength		4334	360	495	590	0.709-0.866	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-
				4344	590	485	460	0.866-1.063	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-
								1.063-1.299	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.299-1.575	-	0.004-0.007	0.004-0.007	**0.004-0.008**	-	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-
								1.575-2.047	-	0.005-0.007	0.005-0.007	**0.005-0.008**	-	-	0.005-0.006	0.005-0.006	**0.005-0.007**	-
								2.047-2.559	-	0.005-0.007	0.005-0.007	**0.005-0.008**	-	-	0.005-0.006	0.005-0.006	**0.005-0.007**	-
	K2.1.C.UT	Grey cast iron	180	4324	690	840	960	0.591-0.709	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.004**	-
		Low tensile strength		4334	560	695	795	0.709-0.866	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-
				4344	425	525	605	0.866-1.063	-	0.003-0.005	0.003-0.005	**0.003-0.007**	-	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-
								1.063-1.299	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.299-1.575	-	0.004-0.007	0.004-0.007	**0.004-0.008**	-	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-
								1.575-2.047	-	0.005-0.007	0.005-0.007	**0.005-0.008**	-	-	0.005-0.006	0.005-0.006	**0.005-0.007**	-
								2.047-2.559	-	0.005-0.007	0.005-0.007	**0.005-0.008**	-	-	0.005-0.006	0.005-0.006	**0.005-0.007**	-
	K2.2.C.UT	Grey cast iron	245	4324	410	600	725	0.591-0.709	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.004**	-
		High tensile strength		4334	330	475	575	0.709-0.866	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-
				4344	245	365	440	0.866-1.063	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-
								1.063-1.299	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.299-1.575	-	0.004-0.006	0.004-0.006	**0.004-0.008**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.575-2.047	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
								2.047-2.559	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
	K3.1.C.UT	Nodular cast iron	155	4324	410	565	665	0.591-0.709	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.004**	-
		Ferritic		4334	330	460	545	0.709-0.866	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-
				4344	260	360	430	0.866-1.063	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-
								1.063-1.299	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.299-1.575	-	0.004-0.006	0.004-0.006	**0.004-0.008**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.575-2.047	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
								2.047-2.559	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
	K3.3.C.UT	Nodular cast iron	265	4324	360	520	620	0.591-0.709	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.004**	-
		Ferritic		4334	295	430	520	0.709-0.866	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-
				4344	230	320	385	0.866-1.063	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-
								1.063-1.299	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.299-1.575	-	0.004-0.006	0.004-0.006	**0.004-0.008**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.575-2.047	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
								2.047-2.559	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
	K4.2.C.UT	Compacted graphite iron	230	4324	425	610	740	0.591-0.709	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.004**	-
		High tensile strength		4334	360	495	590	0.709-0.866	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-	-	0.003-0.003	0.003-0.003	**0.003-0.005**	-
				4344	280	375	440	0.866-1.063	-	0.003-0.005	0.003-0.005	**0.003-0.006**	-	-	0.003-0.004	0.003-0.004	**0.003-0.005**	-
								1.063-1.299	-	0.004-0.006	0.004-0.006	**0.004-0.007**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.299-1.575	-	0.004-0.006	0.004-0.006	**0.004-0.008**	-	-	0.004-0.005	0.004-0.005	**0.004-0.006**	-
								1.575-2.047	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
								2.047-2.559	-	0.005-0.006	0.005-0.006	**0.005-0.008**	-	-	0.005-0.005	0.005-0.005	**0.005-0.006**	-
H	H1.3.Z.HA	Extra hard steel	60	4324	100	195	250	0.591-0.709	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-
		Hardened and tempered		4334	100	195	250	0.709-0.866	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-
				4344	100	195	250	0.866-1.063	-	0.002-0.004	**0.002-0.004**	0.002-0.004	-	-	0.002-0.003	**0.002-0.003**	0.002-0.003	-
								1.063-1.299	-	0.003-0.004	**0.003-0.004**	0.003-0.004	-	-	0.003-0.003	**0.003-0.003**	0.003-0.003	-
								1.299-1.575	-	0.003-0.005	**0.003-0.005**	0.003-0.005	-	-	0.003-0.004	**0.003-0.004**	0.003-0.004	-
								1.575-2.047	-	0.004-0.005	**0.004-0.005**	0.004-0.005	-	-	0.004-0.004	**0.004-0.004**	0.004-0.004	-
								2.047-2.559	-	0.004-0.005	**0.004-0.005**	0.004-0.005	-	-	0.004-0.004	**0.004-0.004**	0.004-0.004	-

ENG

CoroDrill® DS20

6-7xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting data recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range					Recommended start value at middle of feed range				
N	N1.2.Z.AG	Aluminium based alloys AlSi alloys, Si ≤ 1%	100	H13A 4344	985	1075	1180	0.591-0.709	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.003**	0.002-0.003	0.002-0.003	-	-
								0.709-0.866	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								0.866-1.063	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								1.063-1.299	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.299-1.575	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.575-2.047	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
								2.047-2.559	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
	N1.3.C.UT	Aluminium based alloys AlSi alloys, Si ≤ 1%	75	H13A 4344	820	1025	1180	0.591-0.709	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.003**	0.002-0.003	0.002-0.003	-	-
								0.709-0.866	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.003**	0.002-0.003	0.002-0.003	-	-
								0.866-1.063	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								1.063-1.299	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-	**0.003-0.004**	0.003-0.004	0.003-0.004	-	-
								1.299-1.575	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.575-2.047	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
								2.047-2.559	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
	N1.3.C.AG	Aluminium based alloys AlSi cast and aged alloys	90	H13A 4344	820	930	1035	0.591-0.709	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.003**	0.002-0.003	0.002-0.003	-	-
								0.709-0.866	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.003**	0.002-0.003	0.002-0.003	-	-
								0.866-1.063	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								1.063-1.299	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-	**0.003-0.004**	0.003-0.004	0.003-0.004	-	-
								1.299-1.575	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.575-2.047	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
								2.047-2.559	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
	N3.3.U.UT	Copper based alloys Free cutting copper based	110	H13A 4344	820	1025	1180	0.591-0.709	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.003**	0.002-0.003	0.002-0.003	-	-
								0.709-0.866	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								0.866-1.063	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								1.063-1.299	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.299-1.575	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.575-2.047	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
								2.047-2.559	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
	N3.2.C.UT	Copper based alloys Leaded brass & bronzes (Pb	90	H13A 4344	590	645	705	0.591-0.709	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-	**0.002-0.003**	0.002-0.003	0.002-0.003	-	-
								0.709-0.866	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								0.866-1.063	**0.002-0.005**	0.002-0.005	0.002-0.005	-	-	**0.002-0.004**	0.002-0.004	0.002-0.004	-	-
								1.063-1.299	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.299-1.575	**0.003-0.006**	0.003-0.006	0.003-0.006	-	-	**0.003-0.005**	0.003-0.005	0.003-0.005	-	-
								1.575-2.047	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-
								2.047-2.559	**0.004-0.006**	0.004-0.006	0.004-0.006	-	-	**0.004-0.005**	0.004-0.005	0.004-0.005	-	-

Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.05 mm/rev.

CoroDrill® 860-GM

Metric values

ISO	Mc No.	Material	Hardness Brinell HB	Cutting speed, vc (m/min)
P		**Unalloyed steel**		(min-start-max)
	P1.1.Z.AN	C = 0.05-0.10%	125	120-145-170
	P1.1.Z.AN	C = 0.1-0.25%	125	120-145-170
	P1.2.Z.AN	C = 0.25-0.55%	150	100-125-150
	P1.3.Z.AN	C = 0.55-0.80%	170	100-125-150
		High carbon steel		
	P1.3.Z.AN	Carbon tool steel	210	100-125-150
		Low alloy steel		
	P2.1.Z.AN	Non hardened	175	100-125-150
	P2.5.Z.HT.1	Hardened and tempered	275	80-100-120
	P2.5.Z.HT.2	Hardened and tempered	350	60-80-100
		High alloy steel		
	P3.0.Z.AN	Annealed	200	64-77-90
	P3.0.Z.HT.1	Hardened tool steel	300	64-77-90
		Steel castings		
	P1.5.C.UT	Unalloyed steel	150	64-77-90
	P2.6.C.UT	Low alloyed (alloying elements < 5%)	200	64-77-90

Inch values

ISO	Mc No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
P		**Unalloyed steel**		(min-start-max)
	P1.1.Z.AN	C = 0.05-0.10%	125	393 - 475 - 557
	P1.1.Z.AN	C = 0.1-0.25%	125	393 - 475 - 557
	P1.2.Z.AN	C = 0.25-0.55%	150	328 - 410 - 492
	P1.3.Z.AN	C = 0.55-0.80%	170	328 - 410 - 492
		High carbon steel		
	P1.3.Z.AN	Carbon tool steel	210	328 - 410 - 492
		Low alloy steel		
	P2.1.Z.AN	Non hardened	175	328 - 410 - 492
	P2.5.Z.HT.1	Hardened and tempered	275	262 - 328 - 393
	P2.5.Z.HT.2	Hardened and tempered	350	196 - 262 - 328
		High alloy steel		
	P3.0.Z.AN	Annealed	200	209 - 252 - 295
	P3.0.Z.HT.1	Hardened tool steel	300	209 - 252 - 295
		Steel castings		
	P1.5.C.UT	Unalloyed steel	150	209 - 252 - 295
	P2.6.C.UT	Low alloyed (alloying elements < 5%)	200	209 - 252 - 295

Metric values

ISO	Mc No.	Material	Hardness Brinell HB	Cutting speed, vc (m/min)
M		**Stainless steel**		(min-start-max)
	M1.0.Z.AQ	Austenitic	200	30-38-46
	M2.0.Z.AQ	Super austenitic Ni>20%	200	28-36-44
	M3.1.Z.AQ	Duplex (austenitic/ferritic)	230	28-35-42
	M3.2.Z.AQ	Duplex (austenitic/ferritic)	260	26-31-35
	M1.0.C.UT	Austenitic	200	28-36-44
	M2.0.C.AQ	Super austenitic Ni>20%	200	28-36-44
	M3.1.C.AQ	Ferritic	230	24-30-36

Inch values

ISO	Mc No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
M		**Stainless steel**		(min-start-max)
	M1.0.Z.AQ	Austenitic	200	98-125-151
	M2.0.Z.AQ	Super austenitic Ni>20%	200	92-118-144
	M3.1.Z.AQ	Duplex (austenitic/ferritic)	230	92-115-138
	M3.2.Z.AQ	Duplex (austenitic/ferritic)	260	85-102-115
	M1.0.C.UT	Austenitic	200	92-118-144
	M2.0.C.AQ	Super austenitic Ni>20%	200	92-118-144
	M3.1.C.AQ	Ferritic	230	79-98-118

CoroDrill® 860-GM

Metric values

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n) mm/r (min-start-max)							
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.09-0.12	0.08-0.11-0.14	0.10-0.14-0.18	0.12-0.17-0.23	0.14-0.21-0.28	0.17-0.24-0.31	0.20-0.27-0.34	0.23-0.30-0.37
0.06-0.09-0.12	0.08-0.11-0.14	0.10-0.14-0.18	0.12-0.17-0.23	0.14-0.21-0.28	0.17-0.24-0.31	0.20-0.27-0.34	0.23-0.30-0.37
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.09-0.12	0.08-0.11-0.14	0.10-0.14-0.18	0.12-0.17-0.23	0.14-0.21-0.28	0.17-0.24-0.31	0.20-0.27-0.34	0.23-0.30-0.37
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40
0.06-0.10-0.14	0.10-0.16-0.22	0.15-0.20-0.25	0.16-0.22-0.28	0.20-0.25-0.30	0.20-0.26-0.34	0.24-0.30-0.38	0.26-0.34-0.40

Inch values

Drill diameter, inch							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Feed (f_n), inch/r (min-start-max)							
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0090-.0118-.0145
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0090-.0118-.0145
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0090-.0118-.0145
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0090-.0118-.0145
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0090-.0118-.0145
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0090-.0118-.0145
.0023-.0035-.0047	.0031-.0043-.0055	.0039-.0055-.0070	.0047-.0066-.0090	.0055-.0082-.0110	.0066-.0094-.0122	.0078-.0106-.0133	.0090-.0118-.0145
.0023-.0035-.0047	.0031-.0043-.0055	.0039-.0055-.0070	.0047-.0066-.0090	.0055-.0082-.0110	.0066-.0094-.0122	.0078-.0106-.0133	.0090-.0118-.0145
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0102-.0133-.0157
.0023-.0035-.0047	.0031-.0043-.0055	.0039-.0055-.0070	.0047-.0066-.0090	.0055-.0082-.0110	.0066-.0094-.0122	.0078-.0106-.0133	.0090-.0118-.0145
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0102-.0133-.0157
.0023-.0039-.0055	.0039-.0062-.0086	.0059-.0078-.0098	.0062-.0086-.0110	.0078-.0098-.0118	.0078-.0102-.0133	.0094-.0118-.0149	.0102-.0133-.0157

Metric values

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n) mm/r (min-start-max)							
0.08-0.10-0.12	0.10-0.12-0.14	0.11-0.15-0.17	0.18-0.20-0.22	0.24-0.28-0.32	0.24-0.28-0.32	0.28-0.32-0.36	0.30-0.34-0.38
0.08-0.10-0.12	0.10-0.12-0.14	0.13-0.15-0.17	0.18-0.20-0.22	0.24-0.28-0.32	0.24-0.28-0.32	0.28-0.32-0.36	0.30-0.34-0.38
0.06-0.07-0.09	0.06-0.08-0.10	0.09-0.11-0.13	0.11-0.14-0.17	0.14-0.17-0.20	0.16-0.20-0.24	0.21-0.23-0.25	0.22-0.24-0.26
0.06-0.07-0.09	0.06-0.08-0.10	0.09-0.11-0.13	0.11-0.14-0.17	0.14-0.17-0.20	0.16-0.20-0.24	0.21-0.23-0.25	0.22-0.24-0.26
0.08-0.10-0.12	0.10-0.12-0.14	0.13-0.15-0.17	0.18-0.20-0.22	0.24-0.28-0.32	0.24-0.28-0.32	0.28-0.32-0.36	0.30-0.34-0.38
0.08-0.10-0.12	0.10-0.12-0.14	0.13-0.15-0.17	0.18-0.20-0.22	0.24-0.28-0.32	0.24-0.28-0.32	0.28-0.32-0.36	0.30-0.34-0.38
0.05-0.07-0.09	0.06-0.08-0.10	0.09-0.11-0.13	0.11-0.14-0.17	0.14-0.17-0.20	0.16-0.20-0.24	0.21-0.23-0.25	0.22-0.24-0.26

Inch values

Drill diameter, inch							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Feed f_n inch/r (min-start-max)							
.0031-.0039-.0047	.0039-.0047-.0055	.0043-.0059-.0067	.0071-.0079-.0087	.0094-.0110-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0031-.0039-.0047	.0039-.0047-.0055	.0051-.0059-.0067	.0071-.0079-.0087	.0094-0.011-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0024-.0028-.0035	.0024-.0031-.0039	.0035-.0043-.0051	.0043-.0055-.0067	.0055-.0067-.0079	.0063-.0079-.0094	.0083-.0091-.0098	.0087-.0094-.0102
.0024-.0028-.0035	.0024-.0031-.0039	.0035-.0043-.0051	.0043-.0055-.0067	.0055-.0067-.0079	.0063-.0079-.0094	.0083-.0091-.0098	.0087-.0094-.0102
.0031-.0039-.0047	.0039-.0047-.0055	.0051-.0059-.0067	.0071-.0079-.0087	.0094-.0110-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0031-.0039-.0047	.0039-.0047-.0055	.0051-.0059-.0067	.0071-.0079-.0087	.0094-.0110-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0020-.0028-.0035	.0024-.0031-.0039	.0035-.0043-.0051	.0043-.0055-.0067	.0055-.0067-.0079	.0063-.0079-.0094	.0083-.0091-.0098	.0087-.0094-.0102

CoroDrill® 860-GM

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed, vc (m/min)
K		**Malleable iron**		(min-start-max)
	K1.1.C.NS	Ferritic Pearlitic	200	80-100-120
		Grey cast iron		
	K2.1.C.UT	Low tensile strength	180	100-120-140
	K2.2.C.UT	High tensile strength	245	80-100-120
	K2.3.C.UT	High tensile strength	175	100-120-140
		Nodular cast iron		
	K3.1.C.UT	Ferritic	155	100-120-140
	K3.2.C.UT	Perlitic	215	80-100-120
	K3.3.C.UT	Perlitic	265	100-120-140
	K3.5.C.UT	Perlitic	190	100-120-140
	K5.1.C.UT	ADI	300	60-80-100

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
K		**Malleable iron**		(min-start-max)
	K1.1.C.NS	Ferritic Pearlitic	200	262-328-393
		Grey cast iron		
	K2.1.C.UT	Low tensile strength	180	328-393-459
	K2.2.C.UT	High tensile strength	245	262-328-393
	K2.3.C.UT	High tensile strength	175	328-393-459
		Nodular cast iron		
	K3.1.C.UT	Ferritic	155	328-393-459
	K3.2.C.UT	Perlitic	215	262-328-393
	K3.3.C.UT	Perlitic	265	328-393-459
	K3.5.C.UT	Perlitic	190	328-393-459
	K5.1.C.UT	ADI	300	196-262-328

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed, vc (m/min)
S		**Heat resistant super alloys – Nickel base**		(min-start-max)
	S2.0.Z.AN	Annealed or solution treated	250	15-20-25
	S2.0.Z.AG	Aged or solution treated and aged	350	10-15-20
	S2.0.C.NS	Cast or cast and aged	320	10-15-20
		Titanium alloys		
	S4.1.Z.UT	Austenitic	200	40-50-60
	S4.2.Z.AN	Annealed	180	40-50-60
	S4.3.Z.AG	Alloys in aged condition	245	30-40-50

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
S		**Heat resistant super alloys – Nickel base**		(min-start-max)
	S2.0.Z.AN	Annealed or solution treated	250	49-65-82
	S2.0.Z.AG	Aged or solution treated and aged	350	32-49-65
	S2.0.C.NS	Cast or cast and aged	320	32-49-65
		Titanium alloys		
	S4.1.Z.UT	Austenitic	200	131-164-196
	S4.2.Z.AN	Annealed	180	131-164-196
	S4.3.Z.AG	Alloys in aged condition	245	98-131-164

ENG

CoroDrill® 860-GM

Metric values

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n) mm/r (min-start-max)							
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.15-0.20	0.14-0.18-0.23	0.16-0.22-0.27	0.20-0.26-0.312	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.15-0.20	0.14-0.18-0.23	0.16-0.22-0.27	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.12-0.16	0.12-0.15-0.18	0.14-0.18-0.20	0.18-0.23-0.28	0.20-0.27-0.34	0.24-0.30-0.36	0.25-0.32-0.38	0.27-0.34-0.40
0.08-0.12-0.16	0.12-0.15-0.18	0.14-0.18-0.20	0.18-0.23-0.28	0.20-0.27-0.34	0.24-0.30-0.36	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.12-0.16	0.12-0.15-0.18	0.14-0.18-0.20	0.18-0.23-0.28	0.20-0.27-0.34	0.24-0.30-0.36	0.25-0.32-0.38	0.27-0.34-0.40

Inch values

Drill diameter, inch							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Feed (f_n), inch/r (min-start-max)							
.0031-.0039-.0047	.0039-.0047-.0055	.0047-.0062-.0071	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0160-.0133-.0157
.0039-.0059-.0078	.0055-.0070-.0090	.0062-.0086-.0106	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0031-.0039-.0047	.0039-.0047-.0055	.0047-.0062-.0071	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0160-.0133-.0157
.0039-.0059-.0078	.0055-.0070-.0090	.0062-.0086-.0106	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0039-.0051-.0059	.0047-.0059-.0070	0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0031-.0047-.0062	.0047-.0059-.0070	.0055-.0070-.0078	.0070-.0090-.0110	.0078-.0106-.0133	.0094-.0128-.0141	.0098-.0125-.0149	.0160-.0133-.0157
.0031-.0047-.0062	.0047-.0059-.0070	.0055-.0070-.0078	.0070-.0090-.0110	.0078-.0106-.0133	.0094-.0128-.0141	.0098-.0125-.0149	.0160-.0133-.0157
.0039-.0051-.0059	.0047-.0059-.0070	0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0157	.0118-.0149-.0177	.0133-.0169-.0200	.0141-.0177-.0213
.0031-.0047-.0062	.0047-.0059-.0070	.0055-.0070-.0078	.0070-.0090-.0110	.0078-.0106-.0133	.0094-.0128-.0141	.0098-.0125-.0149	.0160-.0133-.0157

Metric values

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n) mm/r (min-start-max)							
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.15	0.10-0.12-0.15	0.10-0.12-0.15
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.15	0.10-0.12-0.15	0.10-0.12-0.15
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.15	0.10-0.12-0.15	0.10-0.12-0.15
0.06-0.08-0.12	0.06-0.08-0.12	0.06-0.08-0.12	0.08-0.12-0.16	0.10-0.14-0.16	0.12-0.16-0.20	0.16-0.20-0.24	0.20-0.25-0.30
0.06-0.08-0.12	0.06-0.08-0.12	0.06-0.08-0.12	0.08-0.12-0.16	0.10-0.14-0.16	0.12-0.16-0.20	0.16-0.20-0.24	0.20-0.25-0.30
0.06-0.08-0.12	0.06-0.08-0.12	0.06-0.08-0.12	0.08-0.12-0.16	0.10-0.14-0.16	0.12-0.16-0.20	0.16-0.20-0.24	0.20-0.25-0.30

Inch values

Drill diameter, inch							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Feed (f_n), inch/r (min-start-max)							
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0039-.0047-.0059	.0039-.0047-.0059
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0039-.0047-.0059	.0039-.0047-.0059
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0039-.0047-.0059	.0039-.0047-.0059
.0023-.0031-.0051	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0047-.0062	.0039-.0055-.0062	.0047-.0062-.0078	.0062-.0078-.0094	.0078-.0098-.0118
.0023-.0031-.0051	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0047-.0062	.0039-.0055-.0062	.0047-.0062-.0078	.0062-.0078-.0094	.0078-.0098-.0118
.0023-.0031-.0051	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0047-.0062	.0039-.0055-.0062	.0047-.0062-.0078	.0062-.0078-.0094	.0078-.0098-.0118

CoroDrill® 860-GM

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed, vc (m/min)
N		**Aluminium based alloys**		(min-start-max)
	N1.2.Z.UT	Commercial pure	60	170-225-280
	N1.2.Z.AG	**AlSi alloys, Si ≤ 1%**	100	170-225-280
	N1.3.C.UT	Cast, non-aging	75	170-225-280
	N1.3.C.AG	Cast or cast and aged	90	160-200-240
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	130	120-150-180
		Copper based alloys		
	N3.3.U.UT	Free cutting alloys (Pb > 1%)	110	110-140-170
	N3.1.U.UT	Non-leaded copper alloys (incl. electrolytic copper)	100	100-125-150

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
N		**Aluminium based alloys**		(min-start-max)
	N1.2.Z.UT	Commercial pure	60	557-738-918
	N1.2.Z.AG	**AlSi alloys, Si ≤ 1%**	100	557-738-918
	N1.3.C.UT	Cast, non-aging	75	557-738-918
	N1.3.C.AG	Cast or cast and aged	90	524-656-787
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	130	393-492-590
		Copper based alloys		
	N3.3.U.UT	Free cutting alloys (Pb > 1%)	110	360-459-557
	N3.1.U.UT	Non-leaded copper alloys (incl. electrolytic copper)	100	328-410-492

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed, vc (m/min)
H		**Extra hard steel**		(min-start-max)
	H1.3.Z.HA	Hardened and tempered	47-60 HRC	15-20-25
	H1.3.Z.HA		47-60 HRC	15-20-25
	H1.1.Z.HA	Hardened and tempered	50 HRC	15-20-25
	H2.0.C.UT.4	Chilled cast iron	64HRC	12-15-18

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
H		**Extra hard steel**		(min-start-max)
	H1.3.Z.HA	Hardened and tempered	47-60 HRC	49-65-82
	H1.3.Z.HA		47-60 HRC	49-65-82
	H1.1.Z.HA	Hardened and tempered	50 HRC	49-65-82
	H2.0.C.UT.4	Chilled cast iron	64HRC	39-49-59

ENG

CoroDrill® 860-GM

Metric values

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n) mm/r							
(min-start-max)							
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.30	0.26-0.33-0.39	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.30	0.26-0.33-0.39	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40
0.10-0.13-0.15	0.10-0.12-0.14	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.10-0.13-0.15	0.12-0.15-0.18	0.16-0.20-0.24	0.20-0.26-0.31	0.26-0.33-0.40	0.30-0.38-0.45	0.34-0.43-0.51	0.36-0.45-0.54
0.08-0.10-0.12	0.10-0.12-0.14	0.12-0.16-0.18	0.16-0.20-0.24	0.20-0.25-0.30	0.22-0.28-0.33	0.25-0.32-0.38	0.27-0.34-0.40

Inch values

Drill diameter, inch							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Feed (f_n), inch/r							
(min-start-max)							
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0153	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0153	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0167	.0118-.0149-.0178	.0134-.0169-.0201	.0141-.0177-.0212
.0031-.0039-.0048	.0039-.0047-.0055	.0047-.0062-.0070	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0167	.0118-.0149-.0178	.0134-.0169-.0201	.0141-.0177-.0212
.0039-.0051-.0060	.0047-.0059-.0070	.0062-.0078-.0094	.0078-.0102-.0122	.0102-.0129-.0167	.0118-.0149-.0178	.0134-.0169-.0201	.0141-.0177-.0212
.0031-.0039-.0048	.0039-.0047-.0055	.0047-.0062-.0070	.0062-.0078-.0094	.0078-.0098-.0118	.0086-.0110-.0129	.0098-.0125-.0149	.0106-.0133-.0157

Metric values

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n) mm/r							
(min-start-max)							
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.12-0.15	0.12-0.15-0.18	0.12-0.15-0.18	0.12-0.15-0.18
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.11-0.13	0.10-0.11-0.13	0.12-0.13-0.15	0.12-0.13-0.15
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.12-0.15	0.12-0.15-0.18	0.12-0.15-0.18	0.12-0.15-0.18
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.11-0.13	0.10-0.11-0.13	0.12-0.13-0.15	0.12-0.13-0.15

Inch values

Drill diameter, inch							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Feed (f_n), inch/r							
(min-start-max)							
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0047-.0059-.0070	.0047-.0059-.0070	.0047-.0059-.0070
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0043-.0051	.0039-.0043-.0051	.0047-.0051-.0059	.0047-.0051-.0059
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0047-.0059	.0047-.0059-.0070	.0047-.0059-.0070	.0047-.0059-.0070
.0023-.0031-.0039	.0023-.0031-.0039	.0023-.0031-.0039	.0031-.0039-.0047	.0039-.0043-.0051	.0039-.0043-.0051	.0047-.0051-.0059	.0047-.0051-.0059

Boring

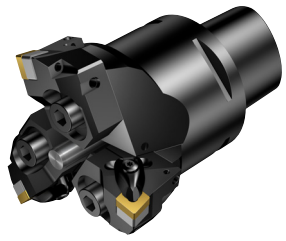
For complete assortment, see www.sandvik.coromant.com

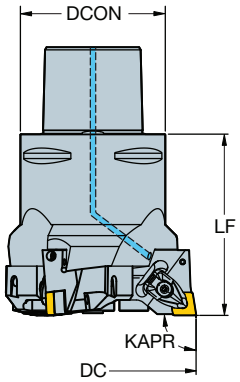
ENG

CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR 90°





CNMM
CNMG
CNMA, CNGA

DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{RDL}$	LF	BAR PSI	KG	CICT	MIID
106.00	122.00	12	1/2	C8	3	**BR30-122CN12F-C8**	80.00	8.00	100.00	70	4.190	3	CNMG 12 04 08
4.173	4.803						3.150	.315	3.937	1015			
121.00	137.00	12	1/2	C8	3	**BR30-137CN12F-C8**	80.00	8.00	100.00	70	4.340	3	CNMG 12 04 08
4.764	5.394						3.150	.315	3.937	1015			
136.00	152.00	12	1/2	C8	3	**BR30-152CN12F-C8**	80.00	8.00	100.00	70	4.820	3	CNMG 12 04 08
5.354	5.984						3.150	.315	3.937	1015			
151.00	167.00	12	1/2	C8	3	**BR30-167CN12F-C8**	80.00	8.00	100.00	70	4.970	3	CNMG 12 04 08
5.945	6.575						3.150	.315	3.937	1015			

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

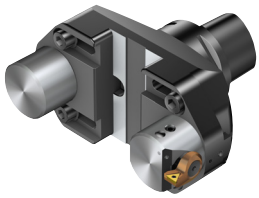
97 100

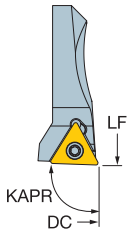
CoroBore® 826 XL fine boring tool

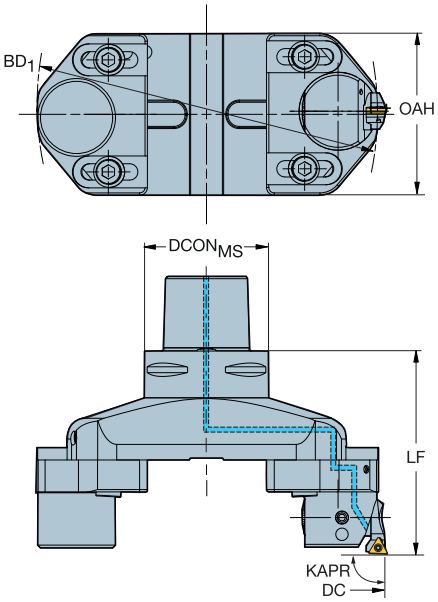
Coromant Capto® - High precision coolant supply

KAPR
STDNO

92°
ISO26623-1







TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

DCN	DCX	⟷	IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR PSI	KG	CICT	MIID
154.35	207.65	11	1/4	C6	3	**826-207TC11-C6HP**	63.00	26.65	125.00	104.00	145.00	70	3.560	1	TCMT 11 03 04
6.077	8.175						2.480	1.049	4.921	4.094	5.709	1015			
154.35	207.65	11	1/4	C8	3	**826-207TC11-C8HP**	80.00	26.65	137.00	104.00	145.00	70	6.430	1	TCMT 11 03 04
6.077	8.175						3.150	1.049	5.394	4.094	5.709	1015			
204.35	257.65	11	1/4	C6	3	**826-257TC11-C6HP**	63.00	26.65	125.00	104.00	195.00	70	3.880	1	TCMT 11 03 04
8.045	10.144						2.480	1.049	4.921	4.094	7.677	1015			
204.35	257.65	11	1/4	C8	3	**826-257TC11-C8HP**	80.00	26.65	137.00	104.00	195.00	70	7.630	1	TCMT 11 03 04
8.045	10.144						3.150	1.049	5.394	4.094	7.677	1015			
254.35	307.65	11	1/4	C6	3	**826-307TC11-C6HP**	63.00	26.65	125.00	104.00	245.00	70	4.240	1	TCMT 11 03 04
10.014	12.112						2.480	1.049	4.921	4.094	9.646	1015			
254.35	307.65	11	1/4	C8	3	**826-307TC11-C8HP**	80.00	26.65	137.00	104.00	245.00	70	8.720	1	TCMT 11 03 04
10.014	12.112						3.150	1.049	5.394	4.094	9.646	1015			

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

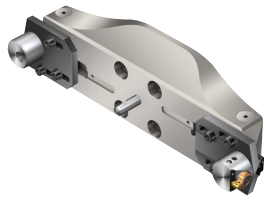
For inserts, see Turning tools catalogue

97 100

ENG

CoroBore® 826 XL fine boring tool

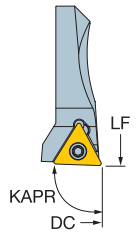
Arbor - High precision coolant supply



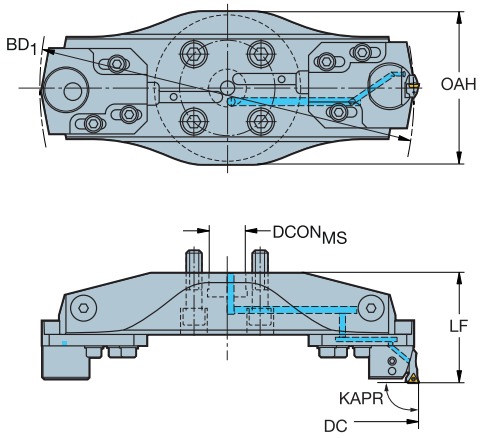
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR



92°



DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR PSI	KG	CICT	MIID
304.35	387.65	11	1/4	40X	1	**826-387TC11HP**	40.00	41.65	121.00	164.00	295.00	70	8.870	1	TCMT 11 03 04
11.982	15.262						1.575	1.640	4.764	6.457	11.614	1015			
384.35	467.65	11	1/4	40X	1	**826-467TC11HP**	40.00	41.65	126.00	164.00	375.00	70	10.400	1	TCMT 11 03 04
15.132	18.411						1.575	1.640	4.961	6.457	14.764	1015			
464.35	547.65	11	1/4	40X	1	**826-547TC11HP**	40.00	41.65	131.00	164.00	455.00	70	12.340	1	TCMT 11 03 04
18.282	21.561						1.575	1.640	5.157	6.457	17.913	1015			

Diameters are valid when frontboring.
Backboring is not recommended with CoroBore® 826
Use with 40X CoroBore XL holders only. To be ordered separately. See Rotating tools catalogue
In case of direct flange to the machine spindle, use centering plug, see Rotating tools catalogue

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

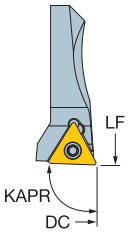
97 100

CoroBore® 826 XL fine boring tool

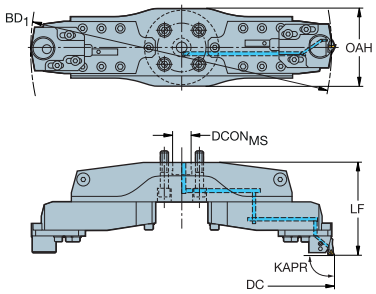
Arbor - High precision coolant supply

With bridge extension

KAPR



92°



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

DCN	DCX	⟷	IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR PSI	KG	CICT	MIID
544.35	787.65	11	1/4	40X	1	**826-787TC11HP**	40.00	121.65	205.00	164.00	535.00	70	24.430	1	TCMT 11 03 04
21.431	*31.010*						*1.575*	*4.789*	*8.071*	*6.457*	*21.063*	*1015*			
784.35	1027.65	11	1/4	40X	1	**826-1027TC11HP**	40.00	121.65	225.00	164.00	775.00	70	35.060	1	TCMT 11 03 04
30.880	*40.459*						*1.575*	*4.789*	*8.858*	*6.457*	*30.512*	*1015*			
1024.35	1267.65	11	1/4	40X	1	**826-1267TC11HP**	40.00	121.65	225.00	164.00	1015.0	70	44.110	1	TCMT 11 03 04
40.329	*49.908*						*1.575*	*4.789*	*8.858*	*6.457*	*39.961*	*1015*			

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

Use with 40X CoroBore XL holders only. To be ordered separately. See Rotating tools catalogue

In case of direct flange to the machine spindle, use centering plug, see Rotating tools catalogue

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

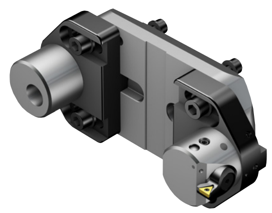
97 100

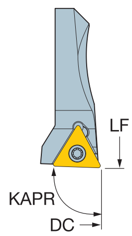
ENG

CoroBore® 826 XL fine boring tool

Arbor - High precision coolant supply

Dedicated for Silent Tools boring





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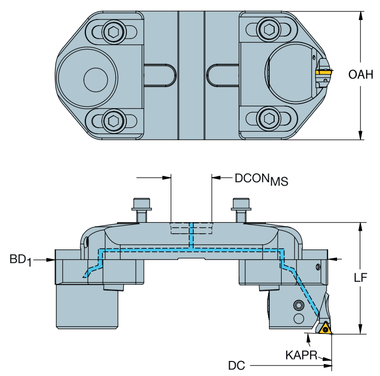
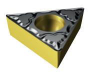




TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX		IC	CZCMS	CNSC	Ordering code	DCONMS	ADJLXRDL	LF	OAH	BD1	BAR PSI	KG	CICT	MIID
							Dimensions, mm, inch								
154.35	207.65	11	1/4	33	1	826D-207TC11HP	33.00	26.65	97.00	104.00	145.00	70	2.770	1	TCMT 11 03 04
6.077	*8.175*						*1.299*	*1.049*	*3.819*	*4.094*	*5.709*	*1015*			
204.35	257.65	11	1/4	33	1	826D-257TC11HP	33.00	26.65	97.00	104.00	195.00	70	3.110	1	TCMT 11 03 04
8.045	*10.144*						*1.299*	*1.049*	*3.819*	*4.094*	*7.677*	*1015*			
254.35	307.65	11	1/4	33	1	826D-307TC11HP	33.00	26.65	97.00	104.00	245.00	70	3.470	1	TCMT 11 03 04
10.014	*12.112*						*1.299*	*1.049*	*3.819*	*4.094*	*9.646*	*1015*			

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see Rotating tools catalogue

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

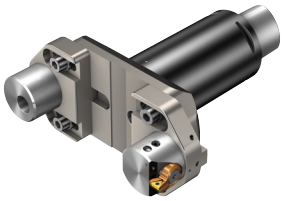
For inserts, see Turning tools catalogue

ISO 13399 97

CNSC CXSC 100

CoroBore® 826 XL lightweight fine boring tool

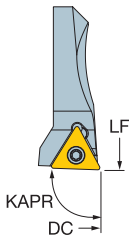
Coromant Capto® - High precision coolant supply

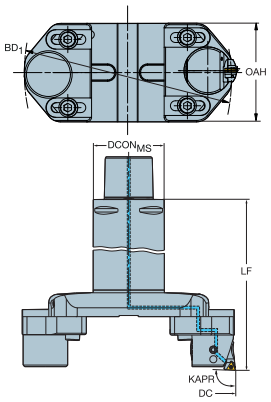


TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°





DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR PSI	KG	CICT	MIID
154.35	207.65	11	1/4	C8	3	**826L-207TC11-C8HP**	80.00	26.65	237.00	104.00	145.00	70	6.300	1	TCMT 11 03 04
6.077	*8.175*						*3.150*	*1.049*	*9.331*	*4.094*	*5.709*	*1015*			
204.35	257.65	11	1/4	C8	3	**826L-257TC11-C8HP**	80.00	26.65	237.00	104.00	195.00	70	6.660	1	TCMT 11 03 04
8.045	*10.144*						*3.150*	*1.049*	*9.331*	*4.094*	*7.677*	*1015*			
254.35	307.65	11	1/4	C8	3	**826L-307TC11-C8HP**	80.00	26.65	237.00	104.00	245.00	70	7.030	1	TCMT 11 03 04
10.014	*12.112*						*3.150*	*1.049*	*9.331*	*4.094*	*9.646*	*1015*			

Backboring is not recommended with CoroBore® 826

Diameters are valid when frontboring.

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

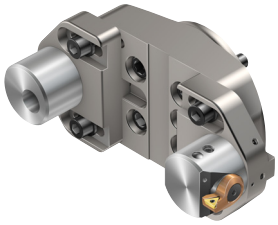
For inserts, see Turning tools catalogue

97 100

ENG

CoroBore® 826 XL lightweight fine boring tool

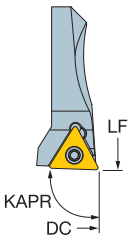
Arbor - High precision coolant supply



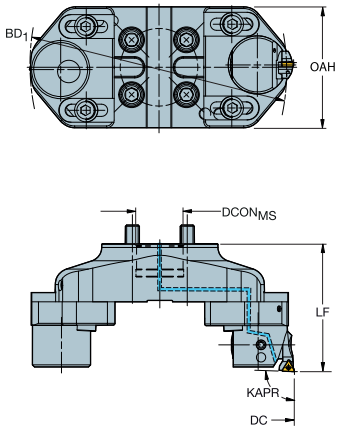
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR



92°



DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	ISO	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR PSI	KG	CICT	MIID
154.35	207.65	11	1/4	40S	1	**826L-207TC11HP**	40.00	C	26.65	117.00	104.00	145.00	70	3.310	1	TCMT 11 03 04
6.077	*8.175*						*1.575*		*1.049*	*4.606*	*4.094*	*5.709*	*1015*			
204.35	257.65	11	1/4	40S	1	**826L-257TC11HP**	40.00	C	26.65	117.00	104.00	195.00	70	3.650	1	TCMT 11 03 04
8.045	*10.144*						*1.575*		*1.049*	*4.606*	*4.094*	*7.677*	*1015*			
254.35	307.65	11	1/4	40S	1	**826L-307TC11HP**	40.00	C	26.65	117.00	104.00	245.00	70	4.320	1	TCMT 11 03 04
10.014	*12.112*						*1.575*		*1.049*	*4.606*	*4.094*	*9.646*	*1015*			

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.
Backboring is not recommended with CoroBore® 826
Diameters are valid when frontboring.

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

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Rotating tool adaptors

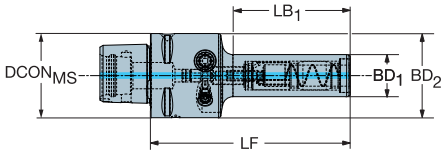
Adaptors

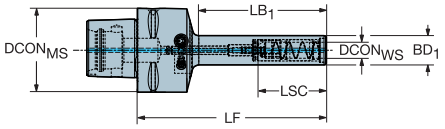
ENG

Coromant Capto® to CoroChuck™ 930

Pencil design

DSGN 2 5





						Dimensions, mm, inch													
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR PSI	NM	KG	RPMX
C4	8	3	1	2	930-C4-P-08-085	40.0	8.0	37	85.0	45.8	85.0		17.5	40.0		80	8.0	0.45	39000
						1.575	.315	1.457	3.346	1.803	3.346		.689	1.575		1160			
	10	3	1	2	930-C4-P-10-095	40.0	10.0	41	95.0	55.8	95.0		20.0	40.0		80	8.0	0.50	39000
						1.575	.394	1.614	3.740	2.197	3.740		.787	1.575		1160			
	10	3	1	2	930-C4-P-10-135	40.0	10.0	41	135.0	95.8	135.0		20.0	40.0		80	8.0	0.59	39000
						1.575	.394	1.614	5.315	3.772	5.315		.787	1.575		1160			
C5	8	3	1	5	930-C5-P-08-088	50.0	8.0	37	88.0	45.8	64.9	88.0	17.5	40.0	50.0	80	8.0	0.65	28000
						1.969	.315	1.457	3.465	1.803	2.555	3.465	.689	1.575	1.969	1160			
	10	3	1	5	930-C5-P-10-098	50.0	10.0	41	98.0	55.8	74.9	98.0	20.0	40.0	50.0	80	8.0	0.70	28000
						1.969	.394	1.614	3.858	2.197	2.949	3.858	.787	1.575	1.969	1160			
	10	3	1	5	930-C5-P-10-138	50.0	10.0	41	138.0	95.8	114.9	138.0	20.0	40.0	50.0	80	8.0	0.80	28000
						1.969	.394	1.614	5.433	3.772	4.524	5.433	.787	1.575	1.969	1160			
C6	8	3	1	5	930-C6-P-08-091	63.0	8.0	37	91.0	45.8	64.9	91.0	17.5	40.0	63.0	80	8.0	1.00	20000
						2.480	.315	1.457	3.583	1.803	2.555	3.583	.689	1.575	2.480	1160			
	10	3	1	5	930-C6-P-10-102	63.0	10.0	41	102.0	55.8	75.0	102.0	20.0	40.0	63.0	80	8.0	1.07	20000
						2.480	.394	1.614	4.016	2.197	2.953	4.016	.787	1.575	2.480	1160			
	10	3	1	5	930-C6-P-10-142	63.0	10.0	41	142.0	95.8	115.0	142.0	20.0	40.0	63.0	80	8.0	1.16	20000
						2.480	.394	1.614	5.591	3.772	4.528	5.591	.787	1.575	2.480	1160			

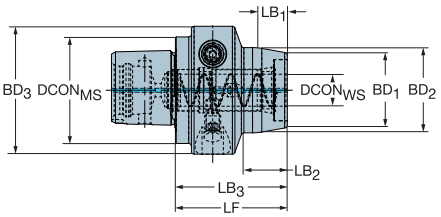
For spare parts, visit www.sandvik.coromant.com

97 100

Coromant Capto® to CoroChuck™ 930

For driven tool holders

Segment clamping and manual tool change only



					Dimensions, mm, inch												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	BD_3	$BHTA_1$	BAR PSI	NM	KG	RPMX
C3	6	3	1	**930-C3-T-06-036**	32.0	6.0	37	36.0	9.3	12.8	22.0	26.0	42.0	12°	80	8.0	0.26	10000
					1.260	.236	1.457	1.417	.366	.504	.866	1.024	1.654		1160			
	8	3	1	**930-C3-T-08-036**	32.0	8.0	37	36.0	9.3	12.8	24.0	28.0	44.0	12°	80	8.0	0.28	10000
					1.260	.315	1.457	1.417	.366	.504	.945	1.102	1.732		1160			
	10	3	1	**930-C3-T-10-038**	32.0	10.0	41	38.0	11.3	14.8	26.0	30.0	46.0	10°	80	8.0	0.31	10000
					1.260	.394	1.614	1.496	.445	.583	1.024	1.181	1.811		1160			
C4	6	3	1	**930-C4-T-06-036**	40.0	6.0	37	36.0	9.3	12.8	22.0	26.0	42.0	12°	80	8.0	0.33	10000
					1.575	.236	1.457	1.417	.366	.504	.866	1.024	1.654		1160			
	8	3	1	**930-C4-T-08-036**	40.0	8.0	37	36.0	9.3	12.8	24.0	28.0	44.0	12°	80	8.0	0.34	10000
					1.575	.315	1.457	1.417	.366	.504	.945	1.102	1.732		1160			
	10	3	1	**930-C4-T-10-038**	40.0	10.0	41	38.0	11.3	14.8	26.0	30.0	46.0	10°	80	8.0	0.37	10000
					1.575	.394	1.614	1.496	.445	.583	1.024	1.181	1.811		1160			
C5	6	3	1	**930-C5-T-06-036**	50.0	6.0	37	36.0	9.3	12.8	22.0	26.0	50.0	12°	80	8.0	0.49	10000
					1.969	.236	1.457	1.417	.366	.504	.866	1.024	1.969		1160			
	8	3	1	**930-C5-T-08-036**	50.0	8.0	37	36.0	9.3	12.8	24.0	28.0	50.0	12°	80	8.0	0.50	10000
					1.969	.315	1.457	1.417	.366	.504	.945	1.102	1.969		1160			
	10	3	1	**930-C5-T-10-038**	50.0	10.0	41	38.0	11.3	14.8	26.0	30.0	50.0	10°	80	8.0	0.51	10000
					1.969	.394	1.614	1.496	.445	.583	1.024	1.181	1.969		1160			

For spare parts, visit www.sandvik.coromant.com

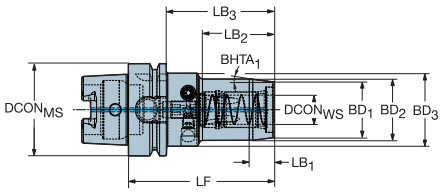
97 100

ENG

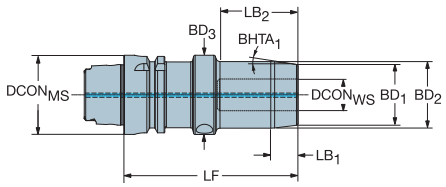
HSK to CoroChuck™ 930

Slender design

Machine side interface HSK A/C



					Dimensions, mm, inch														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	BAR PSI	NM	KG	RPMX
40.0	6	1	1	**930-HA04-S-06-070**	40.0	6.0	37	70.0	11.3	33.2	50.0	22.0	26.0	32.0	40.0	10°	80	8.0	0.40	30000
					1.575	.236	1.457	2.756	.445	1.307	1.969	.866	1.024	1.260	1.575		1160			
	8	1	1	**930-HA04-S-08-070**	40.0	8.0	37	70.0	11.3	35.3	50.0	24.0	28.0	32.0	40.0	10°	80	8.0	0.42	30000
					1.575	.315	1.457	2.756	.445	1.390	1.969	.945	1.102	1.260	1.575		1160			
	10	1	1	**930-HA04-S-10-075**	40.0	10.0	41	75.0	11.3	39.6	55.0	26.0	30.0	32.0	40.0	10°	80	8.0	0.46	30000
					1.575	.394	1.614	2.953	.445	1.559	2.165	1.024	1.181	1.260	1.575		1160			
	12	1	1	**930-HA04-S-12-080**	40.0	12.0	46	80.0	11.3	41.0	60.0	28.0	32.0	33.5	40.0	10°	80	8.0	0.51	30000
					1.575	.472	1.811	3.150	.445	1.614	2.362	1.102	1.260	1.319	1.575		1160			
50.0	6	1	1	**930-HA05-S-06-074**	50.0	6.0	37	74.0	11.3	30.2	48.0	22.0	26.0	40.0	50.0	10°	80	8.0	0.64	25000
					1.969	.236	1.457	2.913	.445	1.189	1.890	.866	1.024	1.575	1.969		1160			
	8	1	1	**930-HA05-S-08-074**	50.0	8.0	37	74.0	11.3	30.2	48.0	24.0	28.0	40.0	50.0	10°	80	8.0	0.65	25000
					1.969	.315	1.457	2.913	.445	1.189	1.890	.945	1.102	1.575	1.969		1160			
	10	1	1	**930-HA05-S-10-080**	50.0	10.0	41	80.0	11.3	34.2	54.0	26.0	30.0	40.0	50.0	10°	80	8.0	0.71	25000
					1.969	.394	1.614	3.150	.445	1.346	2.126	1.024	1.181	1.575	1.969		1160			
	12	1	1	**930-HA05-S-12-085**	50.0	12.0	46	85.0	11.3	38.2	59.0	28.0	32.0	40.0	50.0	10°	80	8.0	0.75	25000
					1.969	.472	1.811	3.346	.445	1.504	2.323	1.102	1.260	1.575	1.969		1160			



					Dimensions, mm, inch													
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	$BHTA_1$	BAR PSI	NM	KG	RPMX	
50.0	20	1	1	**930-HA05-S-20-090**	50.0	20.0	51	90.0	16.0	64.0	37.6	41.5	7°	80	8.0	0.89	25000	
					1.969	.787	2.008	3.543	.630	2.520	1.480	1.634		1160				

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97 100

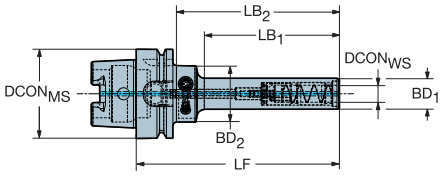
ISO 13399

CNSC CXSC

HSK to CoroChuck™ 930

Pencil design

Machine side interface HSK A/C



					Dimensions, mm, inch								BAR PSI	NM	KG	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2				RPMX
63.0	8	1	1	**930-HA06-P-08-094**	63.0	8.0	37	94.0	45.8	65.5	17.5	40.0	80	8.0	0.87	20000
					2.480	.315	1.457	3.701	1.803	2.579	.689	1.575	1160			
	10	1	1	**930-HA06-P-10-104**	63.0	10.0	41	104.0	55.8	75.5	20.0	40.0	80	8.0	0.91	20000
					2.480	.394	1.614	4.094	2.197	2.972	.787	1.575	1160			
	10	1	1	**930-HA06-P-10-144**	63.0	10.0	41	144.0	95.8	115.5	20.0	40.0	80	8.0	1.01	20000
					2.480	.394	1.614	5.669	3.772	4.547	.787	1.575	1160			

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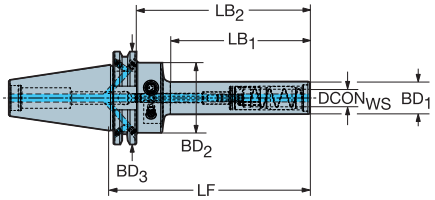
ENG

BIG-PLUS ISO to CoroChuck™ 930

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



Pencil design

					Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	BD_1	BD_2	BD_3	BAR PSI	NM	KG	RPMX
40.0	8	7	1	**930-IB40-P-08-088**	8.0	M16	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.06	18000
					.315		1.457	3.465	1.803	2.618	.689	1.575	2.500	1160			
	10	7	1	**930-IB40-P-10-098**	10.0	M16	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.10	18000
					.394		1.614	3.858	2.197	3.012	.787	1.575	2.500	1160			
	10	7	1	**930-IB40-P-10-138**	10.0	M16	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.20	18000
					.394		1.614	5.433	3.772	4.587	.787	1.575	2.500	1160			

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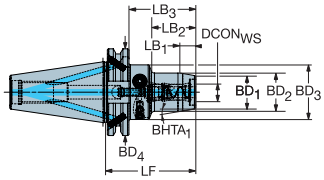
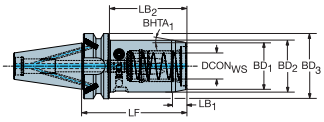
BIG-PLUS MAS-BT to CoroChuck™ 930

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN 10 6





Slender design

						Dimensions, mm, inch												BAR PSI	NM	KG	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_1$			RPMX
30.0	6	1	1	6	**930-BB30-S-06-048**	6.0	M12	37	48.0	9.3	12.8	48.0		22.0	26.0	46.0		12°	80	8.0	0.56	25000
						.236		1.457	1.890	.366	.504	1.890		.866	1.024	1.811			1160			
	8	1	1	6	**930-BB30-S-08-048**	8.0	M12	37	48.0	9.3	12.8	48.0		24.0	28.0	46.0		12°	80	8.0	0.57	25000
						.315		1.457	1.890	.366	.504	1.890		.945	1.102	1.811			1160			
	10	1	1	6	**930-BB30-S-10-048**	10.0	M12	41	48.0	9.3	13.8	48.0		26.0	30.0	46.0		12°	80	8.0	0.56	25000
						.394		1.614	1.890	.366	.543	1.890		1.024	1.181	1.811			1160			
	12	1	1	10	**930-BB30-S-12-082**	12.0	M12	46	82.0	11.3	38.2	60.0	82.0	28.0	32.0	40.0	46	10°	80	8.0	0.76	25000
						.472		1.811	3.228	.445	1.504	2.362	3.228	1.102	1.260	1.575	1.811		1160			
	20	1	1	6	**930-BB30-S-20-088**	20.0	M12	51	88.0	16.0	66.0	88.0		38.0	42.0	46.0		7°	80	8.0	0.94	25000
						.787		2.008	3.465	.630	2.598	3.465		1.496	1.654	1.811			1160			

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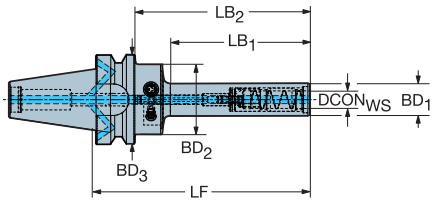
ENG

BIG-PLUS MAS-BT to CoroChuck™ 930

Machine side interface compatible with MAS-BT 403 and JIS B 6339



Pencil design

					Dimensions, mm, inch									BAR PSI	NM	KG	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	BD_1	BD_2	BD_3				RPMX
30.0	8	1	1	**930-BB30-P-08-088**	8.0	M12	37	88.0	45.8	66.0	17.5	40.0	46.0	80	8.0	0.60	25000
					.315		1.457	3.465	1.803	2.598	.689	1.575	1.811	1160			
	10	1	1	**930-BB30-P-10-098**	10.0	M12	41	98.0	55.8	76.0	20.0	40.0	46.0	80	8.0	0.64	25000
					.394		1.614	3.858	2.197	2.992	.787	1.575	1.811	1160			
	10	1	1	**930-BB30-P-10-138**	10.0	M12	41	138.0	95.8	116.0	20.0	40.0	46.0	80	8.0	0.74	25000
					.394		1.614	5.433	3.772	4.567	.787	1.575	1.811	1160			
40.0	8	7	1	**930-BB40-P-08-095**	8.0	M16	37	95.0	45.8	65.5	17.5	40.0	63.0	80	8.0	1.21	18000
					.315		1.457	3.740	1.803	2.579	.689	1.575	2.480	1160			
	10	7	1	**930-BB40-P-10-105**	10.0	M16	41	105.0	55.8	75.5	20.0	40.0	63.0	80	8.0	1.25	18000
					.394		1.614	4.134	2.197	2.972	.787	1.575	2.480	1160			
	10	7	1	**930-BB40-P-10-145**	10.0	M16	41	145.0	95.8	115.5	20.0	40.0	63.0	80	8.0	1.35	18000
					.394		1.614	5.709	3.772	4.547	.787	1.575	2.480	1160			

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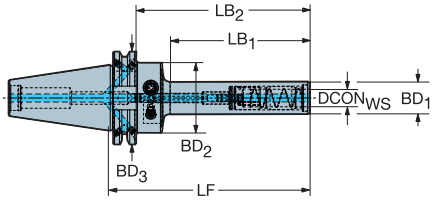
BIG-PLUS CAT-V to CoroChuck™ 930

Machine side interface compatible with ASME B5.50-2009

Pencil design



Metric bore

					Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	BD_1	BD_2	BD_3	BAR PSI	NM	KG	RPMX
40.0	8	7	1	**930-VB40-P-08-088**	8.0	5/8"-11	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.07	18000
					.315		*1.457*	*3.465*	*1.803*	*2.618*	*.689*	*1.575*	*2.500*	*1160*			
	10	7	1	**930-VB40-P-10-098**	10.0	5/8"-11	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.11	18000
					.394		*1.614*	*3.858*	*2.197*	*3.012*	*.787*	*1.575*	*2.500*	*1160*			
	10	7	1	**930-VB40-P-10-138**	10.0	5/8"-11	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.21	18000
					.394		*1.614*	*5.433*	*3.772*	*4.587*	*.787*	*1.575*	*2.500*	*1160*			

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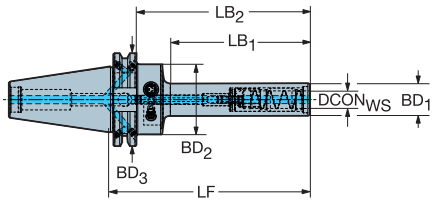
ENG

ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB



Pencil design

					Dimensions, mm, inch									BAR PSI	NM	KG	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	BD_1	BD_2	BD_3				RPMX
40.0	8	7	1	**930-I40-P-08-088**	8.0	M16	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.04	18000
					.315		1.457	3.465	1.803	2.618	.689	1.575	2.500	1160			
	10	7	1	**930-I40-P-10-098**	10.0	M16	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.09	18000
					.394		1.614	3.858	2.197	3.012	.787	1.575	2.500	1160			
	10	7	1	**930-I40-P-10-138**	10.0	M16	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.18	18000
					.394		1.614	5.433	3.772	4.587	.787	1.575	2.500	1160			

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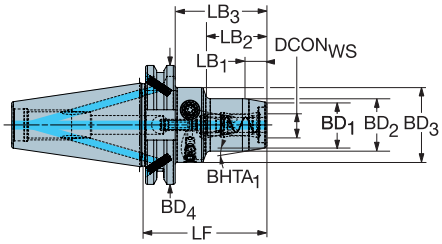
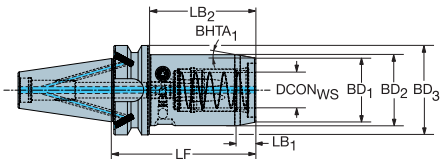
97 100

MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

DSGN 10 6





Slender design

						Dimensions, mm, inch															
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	BAR PSI	NM	KG	RPMX
30.0	6	1	1	6	930-B30-S-06-048	6.0	M12	37	48.0	9.3	12.8	48.0		22.0	26.0	46.0		12°	80	8.0	0.55	25000
						.236		1.457	1.890	.366	.504	1.890		.866	1.024	1.811			1160			
	8	1	1	6	930-B30-S-08-048	8.0	M12	37	48.0	9.3	12.8	48.0		24.0	28.0	46.0		12°	80	8.0	0.56	25000
						.315		1.457	1.890	.366	.504	1.890		.945	1.102	1.811			1160			
	10	1	1	6	930-B30-S-10-048	10.0	M12	41	48.0	9.3	13.8	48.0		26.0	30.0	46.0		12°	80	8.0	0.55	25000
						.394		1.614	1.890	.366	.543	1.890		1.024	1.181	1.811			1160			
	12	1	1	10	930-B30-S-12-082	12.0	M12	46	82.0	11.3	38.2	60.0	82.0	28.0	32.0	40.0	46	10°	80	8.0	0.75	25000
						.472		1.811	3.228	.445	1.504	2.362	3.228	1.102	1.260	1.575	1.811		1160			
	20	1	1	6	930-B30-S-20-088	20.0	M12	51	88.0	16.0	66.0	88.0		38.0	42.0	46.0		7°	80	8.0	0.93	25000
						.787		2.008	3.465	.630	2.598	3.465		1.496	1.654	1.811			1160			

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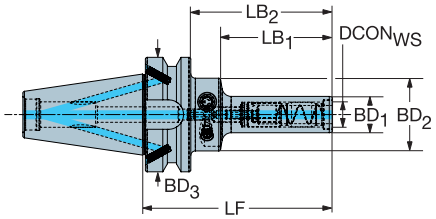
ENG

MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

Pencil design



					Dimensions, mm, inch												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	BD_1	BD_2	BD_3	BAR PSI	NM	KG	RPMX
30.0	8	1	1	930-B30-P-08-088	8.0	M12	37	88.0	45.8	66.0	17.5	40.0	46.0	80	8.0	0.59	25000
					.315		1.457	3.465	1.803	2.598	.689	1.575	1.811	1160			
	10	1	1	930-B30-P-10-098	10.0	M12	41	98.0	55.8	76.0	20.0	40.0	46.0	80	8.0	0.63	25000
					.394		1.614	3.858	2.197	2.992	.787	1.575	1.811	1160			
	10	1	1	930-B30-P-10-138	10.0	M12	41	138.0	95.8	116.0	20.0	40.0	46.0	80	8.0	0.73	25000
					.394		1.614	5.433	3.772	4.567	.787	1.575	1.811	1160			
40.0	8	7	1	930-B40-P-08-095	8.0	M16	37	95.0	45.8	65.5	17.5	40.0	63.0	80	8.0	1.20	18000
					.315		1.457	3.740	1.803	2.579	.689	1.575	2.480	1160			
	10	7	1	930-B40-P-10-105	10.0	M16	41	105.0	55.8	75.5	20.0	40.0	63.0	80	8.0	1.24	18000
					.394		1.614	4.134	2.197	2.972	.787	1.575	2.480	1160			
	10	7	1	930-B40-P-10-145	10.0	M16	41	145.0	95.8	115.5	20.0	40.0	63.0	80	8.0	1.34	18000
					.394		1.614	5.709	3.772	4.547	.787	1.575	2.480	1160			

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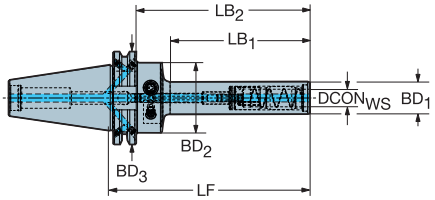
CAT-V to CoroChuck™ 930

Pencil design

Machine side interface ASME B5.50-2009



					Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	BD_1	BD_2	BD_3	BAR PSI	NM	KG	RPMX
40.0	8	7	1	**930-V40-P-08-088**	8.0	5/8"-11	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.05	18000
					.315		1.457	3.465	1.803	2.618	.689	1.575	2.500	1160			
	10	7	1	**930-V40-P-10-098**	10.0	5/8"-11	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.09	18000
					.394		1.614	3.858	2.197	3.012	.787	1.575	2.500	1160			
	10	7	1	**930-V40-P-10-138**	10.0	5/8"-11	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.19	18000
					.394		1.614	5.433	3.772	4.587	.787	1.575	2.500	1160			

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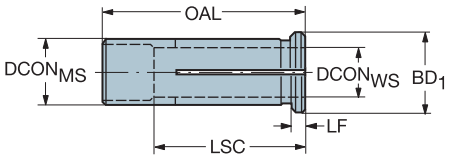
97 100

ENG

Cylindrical sleeves

Precision coolant supply



Inch version

					Dimensions, inch						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	OAL	LF	PSI	LBS
12	1/8	1	4	**A393.CF-12 02 40**	.472	.125	1.574	1.732	.157	1160	.079
	3/16	1	4	**A393.CF-12 03 40**	.472	.187	1.574	1.732	.157	1160	.066

For extractors for cylindrical collets, see Rotating tools catalogue

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General information

ISO 13399 is an international standard that strives to simplify the exchange of data for cutting tools. You will notice a slight difference through the new parameters and descriptions of each tool.

For the first time ever, there is a standardized way of describing product data regarding cutting tools. When all tools in the industry share the same parameters and definitions, communicating tool information becomes very straightforward.

What does this mean to you?

Basically, it means that your systems can talk to ours, as they all speak the same language. Download product data from our web site and use it directly in your CAD/CAM software to assemble tools that you use in production. No need to look for information in catalogues and interpret data from one system to another. Imagine how much time this will save you!

Short name	Preferred Name
ADJLN	Minimum adjustment limit
ADJLX	Maximum adjustment limit
ADJRG	Adjustment range
ALP	Clearance angle axial
AN	Clearance angle major
ANN	Clearance angle minor
APMX	Depth of cut maximum
APMX_EFW	Depth of cut maximum - end feed
APMX_FFW	Depth of cut maximum - side feed
AZ	Maximum plunge depth
B	Shank width
BAWS	Body angle workpiece side
BAMS	Body angle machine side
BBD	Balanced by design
BBR	Balanced by rotational test
BCH	Corner chamfer length
BD	Body diameter
BHTA	Body half taper angle
BN	Face land width
BS	Wiper edge length
BSG	Basic standard group
BSR	Wiper edge radius
CBMD	Chip breaker manufacturer
CDX	Cutting depth maximum
CEMR	Cutting edge major radius
CF	Spot chamfer
CHBA	Chamfer body angle
CHBL	Chamfer body length
CHW	Corner chamfer width
CICT	Cutting item count
$CICT_{BALL}$	Cutting item count - Ball nose insert
$CICT_{E}$	Cutting item count - end position
$CICT_{P}$	Cutting item count - peripheral position
$CICT_{S}$	Cutting item count - side position
$CICT_{SP}$	Cutting item count - Shank protection insert
$CICT_{T}$	Cutting item count - total
CND	Coolant entry diameter
CNSC	Coolant entry style code
CNT	Coolant entry thread size
COATING	Coating
CP	Max coolant pressure
CRKS	Connection retention knob thread size
CRNT	Coolant radial entry thread size
CTPT	Operation type
CUTDIA	Work piece parting diameter maximum
CW	Cutting width
CWN	Minimum cutting width
CWTOLL	Cutting width lower tolerance
CWTOLU	Cutting width upper tolerance
CWX	Cutting width maximum
CXSC	Coolant exit style code
CZC	Connection size code
CZC_{MS}	Connection size code machine side
CZC_{WS}	Connection size code workpiece side
D1	Fixing hole diameter
DAH	Diameter access hole
DAXIN	Axial groove inside diameter minimum
DAXN	Minimum axial groove outside diameter

DAXX	Axial groove outside diameter maximum
DBC	Diameter bolt circle
DC	Cutting diameter
DCB	Connection bore diameter
DCBN	Connection bore diameter minimum
DCBX	Connection bore diameter maximum
DCF	Cutting diameter face contact
DCIN	Cutting diameter internal
DCN	Cutting diameter minimum
DCON	Connection diameter
$DCON_{MS}$	Connection diameter machine side
$DCON_{WS}$	Connection diameter workpiece side
$DCONN_{WS}$	Connection diameter minimum workpiece side
$DCONX_{WS}$	Connection diameter maximum workpiece side
DCPS	Data chip provision size
$DCSF_{MS}$	Contact surface diameter machine side
$DCSF_{WS}$	Contact surface diameter workpiece side
DCX	Cutting diameter maximum
DHUB	Hub diameter
DIX	Tool changer interference diameter maximum
DMIN	Minimum bore diameter
DMM	Shank diameter
DN	Neck diameter
DRVCT	Drive count
DSGN	Design
EPSR	Insert included angle
FHA	Flute helix angle
FLGT	Flange thickness
FTDZ	For thread diameter size
GB	Face land angle
H	Shank height
HA	Thread height theoretical
HB	Thread height difference
HBH	Head bottom offset height
HC	Thread height actual
HF	Functional height
HRY	Lowest point from reference plain
HSUP	Support height
HTB	Body height
HTH	Height
IC	Inscribed circle diameter
INSL	Insert length
INSUC	Insert usage code
IZC	Insert size code
KAPR	Tool cutting edge angle
KAPR_EFW	Tool cutting edge angle - end feed
KCH	Corner chamfer
KRINS	Major cutting edge angle
KWW	Keyway width
L	Cutting edge length
LAMS	Inclination angle
LB	Body length
LCF	Length chip flute
LCOX	Cut off length maximum
LE	Cutting edge effective length
LF	Functional length
LFN	Minimum functional length
LH	Head length
LPR	Protruding length
LS	Shank length
LSC	Clamping length
LSCN	Clamping length minimum
LSCS	Distance to clamping start
LSCX	Clamping length maximum
LSD	Dead shank length
LU	Usable length (max. recommended)
LU_BFW	Usable length - back facing
LUX	Usable length maximum
MHD	Mounting hole distance
MIID	Master insert identification
$MIID_E$	Master insert identification - end position
$MIID_S$	Master insert identification - side position
$MIID_C$	Master insert identification - central position
$MIID_P$	Master insert identification - peripheral position
$MIID_I$	Master insert identification - intermediate position
MMCC	Code for preset torque
MMCX	Max. cutting torque
NOF	Flute count
NT	Tooth count
OAH	Overall height
OAL	Overall length
OAW	Overall width
OH	Overhang recommended
OHN	Overhang minimum

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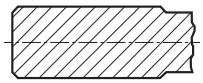
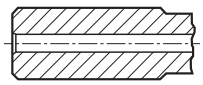
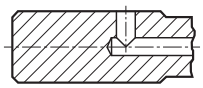
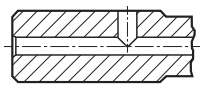
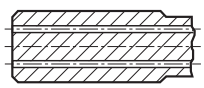
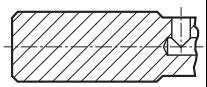
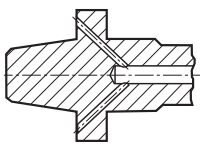
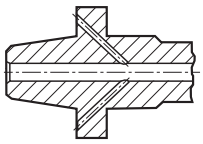
OHX	Overhang maximum
ORDCODE	Ordercode
PCL	Peripheral cylindrical length
PDX	Profile distance ex
PDY	Profile distance ey
PHD	Premachined hole diameter
PHDX	Maximum premachined hole diameter
PL	Point length
PNA	Profile included angle
PRFRAD	Profile radius
PRSPC	Profile specification
PSIR	Tool lead angle
PSIRL	Cutting edge angle major left hand
PSIRR	Cutting edge angle major right hand
PSW	Premachined slot width
RADH	Radial body height
RADW	Radial body width
RAR	Right hand relief angle
RE	Corner radius
REEQ	Corner radius equivalent
REL	Corner radius left
RER	Corner radius right
RETOLL	Corner radius lower tolerance
RETOLU	Corner radius upper tolerance
RGL	Regrind length
RMPX	Maximum ramping angle
RPMX	Rotational speed maximum
S	Insert thickness
SDL	Step diameter length
SIG	Point angle
SPTL	Splitline
SSC	Insert seat size code
SSC_E	Insert seat size code - end position
SSC_P	Insert seat size code - peripheral position
SSC_S	Insert seat size code - side position
STA	Step included angle
STDNO	Standard number
SUBSTRATE	Substrate
TCDC	Tolerance class cutting diameter
TCDCON	Connection diameter tolerance
TCDMM	Shank diameter tolerance
TCHA	Achievable hole tolerance
TCHAL	Achievable hole tolerance lower
TCHAU	Achievable hole tolerance upper
TCT	Tolerance class tool
TCTR	Thread tolerance class
TD	Thread diameter
TDZ	Thread diameter size
TFLA	Tap floating length ahead
TFLB	Tap floating length behind
TG	Taper gradient
THBTP	Thread back taper property
THCA	Thread helix correction angle
THCHT	Threading chamfer type
THFT	Form type
THFTS	Thread form standard series
THL	Thread length
THUB	Hub thickness
TP	Thread pitch
TPI	Threads per inch
TPIN	Threads per inch minimum
TPIX	Threads per inch maximum
TPN	Thread pitch minimum
TPT	Thread profile type
TPX	Maximum thread pitch
TRMAX	Tap range max
TQ	Torque
TSYC	Tool style code
TTP	Thread type
ULDR	Usable length diameter ratio
VCX	Maximum cutting speed
W1	Insert width
WB	Body width
WF	Functional width
WFCIRP	Width to cutting item reference point
WSC	Clamping width
WT	Weight of item
ZADJ	Insert adjustable count
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count (ZEFP)
ZWX	Maximum number of Wiper inserts

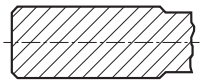
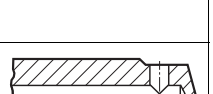
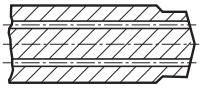
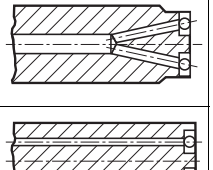
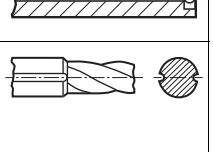
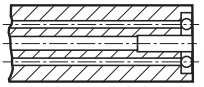
CNSC

Coolant entry style code

Code	Description	Image
0	Without coolant	
1	Axial concentric entry	
2	Radial entry	
3	Axial concentric and radial entry	
4	Axial concentric entry on circle	
5	Radial entry before adaptor	
6	Decentral over flange	
7	Decentral over flange and axial	
8	Decentral over slots on the shank	

CXSC

Coolant exit style code

Code	Description	Image
0	No coolant exit	
1	Axial concentric exit	
2	Radial exit	
3	Axial inclined exit	
4	Axial concentric on circle	
5	Axial inclined exit with nozzle, adjustable	
6	Decentral exit with nozzle, adjustable	
7	Decentral over slots on the shank	
8	Axial or decentral with nozzle, adjustable	

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Reconditioning

We offer more than just traditional "regrinding". With our reconditioning service we guarantee repeated original performance of your tools to reduce your cost per application.

Our offer

100%

Reliability
Our specialists are available for you with support and know-how.

x3

Original performance
The original tool quality is guaranteed - up to three times.

50%

Savings
With reconditioning you can reduce your tool costs up to 50%.

Products in service

Drilling

Milling

Reaming

As indicated by the reconditioning symbol on family and product pages.

Additional information

Reconditioning box
The box can be ordered in two sizes:
- Small (300 x 200 x 138mm)
Article number: 6949557

- Medium (400 x 300 x 138mm)
Article number: 6949558

All Sandvik Coromant tool types can be shipped in same box.

Reconditioning service
- - Prior to reconditioning, an inspection will determine if your tool can be reconditioned. Non-reconditionable tools will be returned

- A laser mark on the tool shank indicates each reconditioning service performed

- The tools are delivered back in original packaging

What happens with your tools?
- - Complete geometry restoration

- Drill length is reduced

- End mill diameter and length are reduced (Minimum diameter is about 0.9xDc)

- Reamer diameter tolerance is maintained

For prices contact your local Sandvik Coromant representative.

Safety information in connection with grinding of cemented carbide

Material compositon

Most metal products contain tungsten carbide and cobalt. Other substances that may be present in hard metal are titanium carbide, tantalum carbide, niobium carbide, chromium carbide, molybdenum carbide or vanadium carbide. Some grades contain titanium carbonitride and/or nickel.

Routes of exposure

Grinding or heating of hard metal blanks or hard metal products will produce products that give off dangerous dust and fumes. Avoiding ingestion and contact with skin or eyes is very important.

Acute toxicity

Intake of the aforementioned substances is toxic. Inhalation may cause irritation and inflammation of the airways. Significantly higher acute inhalation toxicity has been reported during simultaneous inhalation of cobalt and tungsten carbide compared to inhalation of cobalt alone.
Skin contact can cause irritation and rash. Sensitive individuals may even experience an allergic reaction.

Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction of the airways. Prolonged exposure to increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers previously exposed to high concentrations of tungsten carbide/cobalt carried an increased risk of developing lung cancer.
Cobalt and nickel are potent skin sensitizers. Repeated or prolonged contact can cause irritation and sensitization.

Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation
Toxic when inhaled
Limited evidence of a carcinogenic effect.
May cause sensitization by inhalation and skin contact

Preventive measures

Avoid formation and inhalation of dust. Use adequate local exhaust ventilation to keep personal exposure well below nationally authorised limits.
If ventilation is not available or adequate, use respirators appropriately approved for the purpose.
Use safety goggles or glasses with side shields when necessary.
Avoid repeated skin contact. Wear suitable gloves. Wash skin thoroughly after handling.
Use suitable protective clothing. Launder clothing if needed.
Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.

For the sake of the environment

Get into the Sandvik Coromant Recycling Concept (CRC) now!

The Sandvik Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts and solid carbide tools offered by Sandvik Coromant to all its customers.
In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers.
Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way.
All used carbide inserts are collected in the collection box at the workplace.
When the collection box is sufficiently full, its contents are transferred to the transport box.
The full transport box is then sent to the nearest Sandvik Coromant office or to your Sandvik Coromant dealer who can also give you more information.

The benefits of the CRC speak for themselves

- A worldwide ISO and OHAS certified recycling system.
- Open to all Sandvik Coromant customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.

Order collection boxes for each lathe, milling machine, drill or for your machining centre. We recommend one collection box for inserts and one separate box for solid carbide tools for each cutting workplace.
For detailed instructions on how to sell your used cemented carbide, please visit www.sandvik.coromant.com and select your market.

	Order numbers
Collection box:	91617
Transport box for solid carbide tools (plywood):	92994
Transport box inserts (plywood):	92995