

Central insert



Peripheral insert



Drill bodies

Connection type

L = ISO9766 shank
LX = ISO9766 shank (inch)
DM = Modular Drilling Interface

Family name

D S 2 0 - D 2 0 0 0 L 2 5 - 0 7

Drill diameter

Connection size

Drill length
04-07 × DC

Inserts

Family name

Corner radius

Geometry

D S 2 0 - 0 3 0 6 - P - L 6 W 4 3 4 4

Insert size
01-07

P = Peripheral position
C = Central position

Grade

First choice

	Central insert	Peripheral insert
P Low-carbon steel	- L5 1344	- L5W 4334
P Low-alloy steel	- M7 1344	- M7W 4334
M Stainless steel	- L5 1144	- L5W 2044
K Cast iron	- M7 1344	- M7W 4334
S HRSA	- L5 1344	- L6W 4344 (Inconel) - S5W 4344 (Titanium)
N Non-ferrous	- L5 H13A	- S5W H13A
H Hardened steel	- L5 1344	- L6W 4344

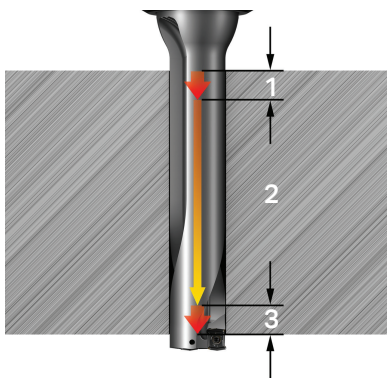
Geometry description

Geometry	Description
- M7W	- Low to high feed - Strong reinforced edge - Good chip control in high feed
- L6W	- Low to medium feed - Light cutting - Multi-purpose geometry with good chip control in most materials
- L5W	- Low to medium feed - Light cutting - Good chip control in long chipping materials
- S5W	- Low feed - Sharp and extremely light cutting
- H5W	- Low to medium feed - Negative T-land for hard to break materials - Expect slightly increased cutting forces

Use CoroPlus® ToolGuide for cutting data recommendations and details specific for your application
www.coroguide.com



Drilling strategy for deep holes



- Apply soft entries and exits to maintain the hole tolerance (recommendations can be found in CoroPlus® ToolGuide):
 1. f_n at hole entry: $f_n \times 75\%$. Length of entry: 1 mm (0.039 inch)
 2. f_n at continuous drilling: recommendations from CoroPlus® ToolGuide
 3. f_n at hole exit: 0.05 mm/rev (0.002 in/rev) or even lower if high demands on hole quality Length of exit: 3–5 mm (0.118–0.196 inch)No v_c change in the different sections of the hole.



Caution!

When drilling through-holes a disc will be produced as the drill breaks through. This disc is often ejected at high speed from between the jaws of the chuck and could inflict damage or injury. To prevent this, the chuck should be enclosed with an adequate guard.

Varning!

Vid borming av genomgående hål bildas en ändbricka när borren bryter igenom. Denna ändbricka kastas ofta med hög hastighet ut ur chucken, vilket kan förorsaka skador. För att förhindra detta bör chucken förses med en lämplig skyddsskäpa.

Warnung!

Bei der Herstellung von Durchgangsbohrungen mit nicht rotierendem Bohrer entsteht beim Austritt des Bohrers aus dem Werkstück eine Scheibe, die oft mit hoher Geschwindigkeit aus dem Spannfutter geschleudert wird und Schäden und Verletzungen verursachen kann. Um dies zu verhindern, muss das Spannfutter mit einer Schutzabdeckung versehen sein.

Attention!

Le perçage de trous débouchants entraîne la formation d'un disque, souvent éjecté à grande vitesse à travers les mors du mandrin, qui risque d'occasionner blessures ou dommages. Pour y remédier, prévoyez une protection adéquate autour du mandrin.

¡Precaución!

Cuando se taladran agujeros pasantes se produce un disco cuando la broca termina el agujero. Frecuentemente, este disco es lanzado a gran velocidad por las garras del plato, pudiendo producir daños o accidentes. Para evitar que esto se produzca, el plato debe ir encerrado en una protección adecuada.

Attenzione!

Quando si eseguono fori passanti, l'uscita della punta produce un disco all'estremità posteriore del pezzo. Questo disco viene spesso espulso ad elevata velocità dalle ganasce del mandrino autocentrante, con il rischio di ferire l'operatore. Per evitare danni, si consiglia di montare un'adeguata protezione sul mandrino.

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