SANDVIK Coromant

2019.2

Supplement

– TO TURNING TOOLS, ROTATING TOOLS AND SOLID ROUND TOOLS CATALOGUES

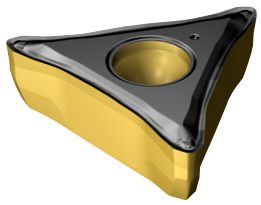
General turning

CoroTurn® Prime

Wiper insert

Wiper insert for improved surface finish at high feed rate.

See page A2



CoroTurn® Prime cutting unit for turning

SL heads for internal machining

- A- and B-type insert for inside-out direction
- B-type insert for outside-in direction

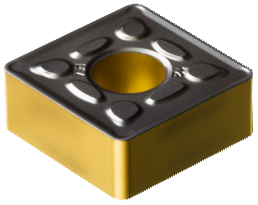
See page A3

GC4305 and GC4315

Inserts for heavy turning, railway turning and railway re-turning

Grade update for T-Max® P and CoroTurn® 107 inserts in sizes above 19.05 mm (.250 inch).

See chapter A

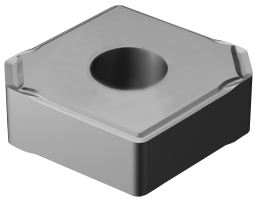


CC6160

Ceramic inserts

Ceramic insert with chip breaker for good chip control at high cutting speeds in HRSA components.

See chapter A



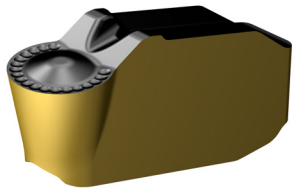
Parting and grooving

CoroCut® QD

Insert for profiling

RM geometry for profiling with long overhangs in narrow grooves, providing better tool life and chip control.

See page B2



Turning tool adaptors

CoroTurn® SL

New adaptors

The new assortment consists of CoroTurn® SL adaptors with Coromant Capto® , HSK-A/C/T, VDI and cylindrical shank. For internal turning within all segments.

See page C2

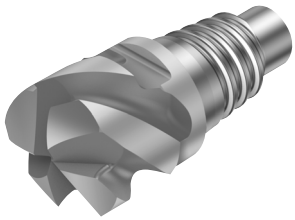
Milling

GC1730

CoroMill® 316

Grade GC1730 features a fine-grained substrate and a TiAlN multi-layer coating that provides enhanced tool life and excellent productivity gains. It is suitable for both dry and wet milling and is the first choice for ISO P and ISO M materials.

See chapter D



Drilling

CoroDrill® DS20

Indexable insert drill

A new indexable insert drill concept for your 4-7xDC drilling operations. The drill is reliable, predictable and boasts outstanding penetration rates.
With ISO 9766 shank as well as a new Modular Drilling Interface (MDI), available in Coromant Capto® and HSK. The MDI provides high precision and excellent centering capabilities.

See page E2

CoroDrill® 860

Solid drill for ISO S applications

Optimized for short hole drilling in heat resistant super alloys, titanium alloys and Inconel.
The new grade combined with robust cutting edges will give you high process stability, improved hole tolerance and excellent tool life.

See page E12

CoroDrill® 863

Drill for composite materials

Features a high axial rake angle for reduced delamination and a new grade for improved wear resistance that offers high tool life and reliable performance. Designed for drilling composite materials commonly used in aerospace applications.

See page E13

Rotating tool adaptors and accessories

MDI

Drilling adaptors

MDI adaptors for the new CoroDrill® DS20. Available with Coromant Capto® and HSK.

See page F2

CoroChuck™ 930

New chucks for small operations

Slender designed chucks with bore sizes 6, 8 and 10 mm. Higher performance and better run-out in smaller operations.

See chapter F

Torque wrenches

Torque wrench with bits that fit ER and MDI nuts.

See page G2

General turning

CoroTurn® Prime

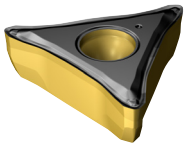
CoroTurn® 107

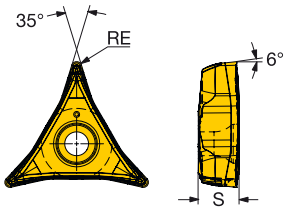
T-Max® P

T-Max®

CoroTurn® Prime insert for turning

A-type insert





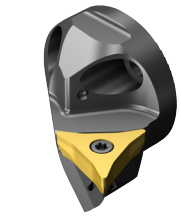
Metric version

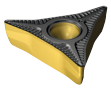
	SSC	S	RE	ISO CODE	P 4325
L3WX	CP-A	6.00	0.79	CP-A1108-L3WX	★

CoroTurn® Prime cutting unit for turning

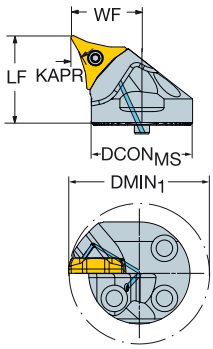
Screw clamp design

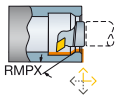
KAPR 30.0°





CP-A



	SSC	CZC_{MS}	$DMIN_1$	APMX	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
 RMPX	CP-A	32	40.0	3.0	1	SL-CP-30AR/L-32-11C40	32	32.0	22.0	70	3.0	0.10	CP-A1108
			1.575	*.118*			*1.260*	*1.260*	*.866*	*1015*			
		40	50.0	3.0	1	SL-CP-30AR/L-40-11C50	40	35.0	28.0	70	3.0	0.18	CP-A1108
			1.969	*.118*			*1.575*	*1.378*	*1.102*	*1015*			

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


A2


C1

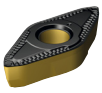
H2

H7

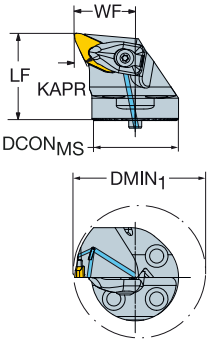
CoroTurn® Prime cutting unit for turning

Rigid clamp design

KAPR 25.0°

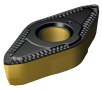


CP-B

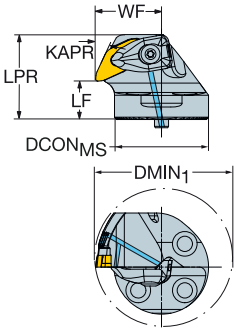


	SSC	CZCMS	DMIN1	APMX	CNSC	Ordering code	DCONMS	LF	WF	BAR PSI	NM	KG	MIID
							Dimensions, mm, inch						
RMPX	CP-B	40	50.0	4.0	1	SL-CP-25BR/L-40-11B50	40	40.0	28.0	70	3.0	0.19	CP-B1108
			1.969	*.157*			*1.575*	*1.575*	*1.102*	*1015*			

KAPR 25.0°



CP-B



	SSC	CZCMS	DMIN1	APMX	RMPX	CNSC	Ordering code	DCONMS	LPR	LF	WF	BAR PSI	NM	KG	MIID
								Dimensions, mm, inch							
RMPX	CP-B	40	50.0	4.0	23°	1	SL-CPX25BR/L-40-11B50	40	36.0	16.0	28.0	70	3.0	0.16	CP-B1108
			1.969	*.157*				*1.575*	*1.417*	*.630*	*1.102*	*1015*			

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

R = Right hand, L = Left hand

A2 C1 H2 H7

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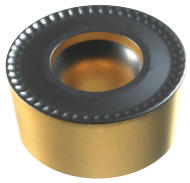
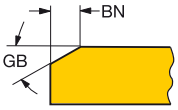
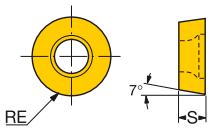
CoroTurn® 107 insert for turning

R-style insert (Round)







Metric version

			S	RE	GB	BN	ISO CODE	P 4305	P 4315
Medium	M0	20	6.35	10.00	15°	0.15	RCMT 20 06 M0	☆	★
		25	7.94	12.50	15°	0.20	RCMT 25 07 M0	☆	★

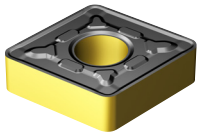
Inch version

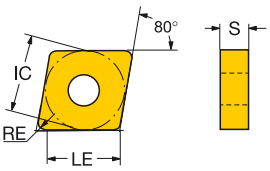
	IC	S	RE	GB	BN	ISO CODE	P 4315	ANSI CODE
Medium	3/4	.250	.375	15°	.006	RCMT 19 06 00	★	RCMT 64

A12 H2 H8

T-Max® P insert for turning

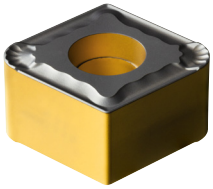
C-style insert (Rhombic 80°)

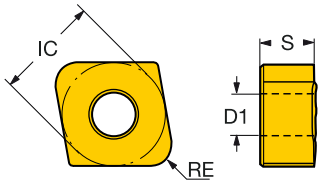




		IC	LE	S	RE	ISO CODE	P 4315	ANSI CODE
Roughing	PR	25	23.4	9.53	2.38	CNMG 25 09 24-PR	★	CNMG 866-PR
		1	.921	.375	.094			
	HR	25	23.4	9.53	2.38	CNMM 25 09 24-HR	★	CNMM 866-PR
		1	.921	.375	.094			

Finishing geometry





		IC	LE	S	RE	ISO CODE	P 4315
Finishing	PF	19	15.3	11.00	4.00	CNMX 19 11 40-PF	★
		3/4	.604	.433	.157		

A12 H2 H8

SANDVIK Coromant

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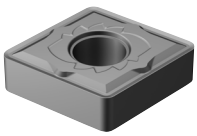
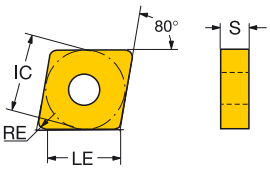
T-Max® P insert for turning

C-style insert (Rhombic 80°)

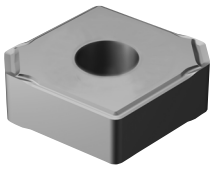
Advanced cutting materials

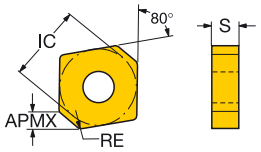




		IC	IC	S	RE	ISO CODE	S 6160	ANSI CODE
Medium	SM	12	1/2	4.76	0.79	CNMG 12 04 08-SM	★	CNMG 432-SM
				.188	*.031*			

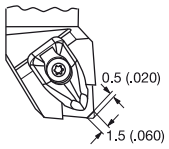
High feed geometry



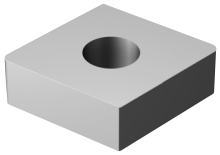


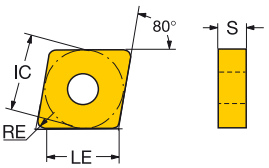
		IC	IC	LE	S	RE	APMX	KCH	CHW	ISO CODE	S 6160	ANSI CODE
Roughing	SM	12	1/2	2.8	4.76	0.80	2.5	50°	2.5	CNMX 12 04 A2-SM	★	CNMX 43A2-SM
				.110	*.188*	*.031*	*.098*	*50°*	*.098*			

The holders taking the CNMX inserts need to be modified.



Shims
5322 234-07 for T-Max P lever design holders
5322 234-08 for CoroTurn RC holders



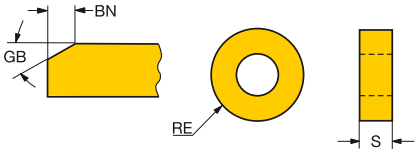


	IC	IC	LE	S	RE	ISO CODE	S 6160	ANSI CODE
E	12	1/2	12.1	4.76	0.79	CNMA 12 04 08E	★	CNMA 432A
			.476	*.188*	*.031*			

A12 H2 H8

T-Max® P insert for turning

R-style insert (Round)



	IC	S	RE	GB	BN	ISO CODE	P 4305	P 4315	ANSI CODE
Medium	19	6.35	9.53			RNMG 19 06 00		★	RNMG 64
	3/4	*.250*	*.375*						
	20	6.35	10.00	15°	0.30	RCMX 20 06 00	☆	★	
	.787	*.250*	*.394*	*15°*	*.012*				
	25	7.94	12.50	15°	0.40	RCMX 25 07 00	☆	★	RCMX 85
	.984	*.313*	*.492*	*15°*	*.016*				
	32	9.53	16.00	15°	0.40	RCMX 32 09 00	☆	★	
	1	*.375*	*.630*	*15°*	*.016*				

A12 H2 H8

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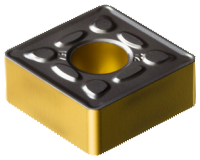
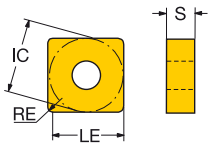
T-Max® P insert for turning

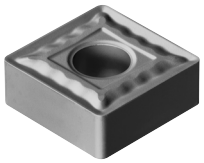
S-style insert (Square)

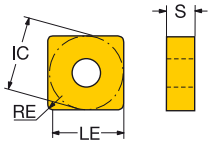




		IC	LE	S	RE	ISO CODE	P 4305	P 4315	ANSI CODE
Medium	HM	25	23.0	9.53	2.38	SNMG 25 09 24-HM	★		SNMG 866-HM
		1	.906	.375	.094				
	MR	25	23.0	7.94	2.38	SNMM 25 07 24-MR		★	SNMM 856-MR
		1	.906	.313	.094				
	PR	25	23.0	7.94	2.38	SNMG 25 07 24-PR		★	SNMG 856-PR
		1	.906	.313	.094				
			23.0	9.53	2.38	SNMG 25 09 24-PR		★	SNMG 866-PR
			.906	.375	.094				
	QR	25	23.0	7.94	2.38	SNMM 25 07 24-QR		★	SNMM 856-QR
		1	.906	.313	.094				
	HR	25	23.0	7.94	2.38	SNMM 25 07 24-HR		★	SNMM 856-HR
		1	.906	.313	.094				
			22.2	7.94	3.18	SNMM 25 07 32-HR		★	SNMM 858-HR
			.874	.313	.125				
			23.0	9.53	2.38	SNMM 25 09 24-HR		★	SNMM 866-HR
			.906	.375	.094				
			22.2	9.53	3.18	SNMM 25 09 32-HR		★	SNMM 868-HR
			.874	.375	.125				

Advanced cutting materials



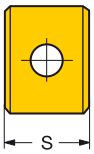


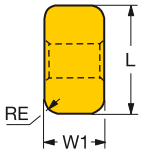
		IC	S	RE	ISO CODE	S 6160	ANSI CODE
Medium	QM	15	6.35	1.19	SNMG 15 06 12-QM	★	SNMG 543-QM
		5/8	.250	.047			

A12 H2 H8

T-Max® P insert for turning

Insert for railway wheel re-turning





	LE	S	RE	W1	ISO CODE	P 4315	
PF	19	15.1	19.05	4.00	10.0	LNUX 19 19 40-PF	★	
		.593	*.750*	*.157*	*.394*			
PM	19	15.1	19.05	4.00	10.0	LNMX 19 19 40-PM	★	
		.593	*.750*	*.157*	*.394*			
	30	26.0	19.05	4.00	12.0	LNMX 30 19 40-PM	★	
		1.024	*.750*	*.157*	*.472*			
	19	15.1	19.05	4.00	10.0	LNUX 19 19 40-PM	★	
		.593	*.750*	*.157*	*.394*			
PR	30	26.0	19.05	4.00	12.0	LNMX 30 19 40-PR	★	
		1.024	*.750*	*.157*	*.472*			
		26.0	19.05	4.00	12.0	LNUX 30 19 40-PR	★	
		1.024	*.750*	*.157*	*.472*			
	32		12.70	4.75	19.1	LNUX 32 12 48-PR	★	
			.500	*.187*	*.750*			

A12 H2 H8

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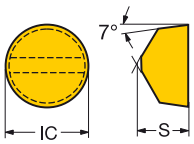
T-Max® insert for turning

R-style insert (Round)



	IC	S	RE	ISO CODE	S 6160	ANSI CODE
SM	09	7.94	4.76	RCMX 09 07 00-SM	★	RCMX35-SM
	3/8	.313	.187			

A12 H2 H8

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO P		Steel	Specific cutting force k_{c1}	Hardness Brinell			
					GC4325	GC4315	GC4305
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8
MC No.	No.	Material	N/mm²	HB	Cutting speed (v_c), m/min		
		Unalloyed steel					
P1.1.Z.AN	01.1	C = 0.1–0.25%	1500	125	510-345-245	570-405-300	620-450-330
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	455-305-215	510-365-265	560-405-295
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	425-290-205	460-330-240	530-385-275
		Low-alloy steel (alloying elements ≤5%)					
P2.1.Z.AN	02.1	Non-hardened	1700	180	460-305-215	560-370-260	610-410-285
P2.1.Z.AN	02.12	Ball bearing steel	1800	210	395-265-190	460-305-215	530-350-250
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	205-145-110	300-210-155	330-230-175
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	205-145-110	240-170-125	265-185-140
		High-alloy steel (alloying elements >5%)					
P3.0.Z.AN	03.11	Annealed	1950	200	300-205-150	405-270-200	445-295-215
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	135-95-75	200-130-95	220-140-105
		Steel castings					
P1.5.C.UT	06.1	Unalloyed	1550	180	240-180-130	300-215-170	335-235-185
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	210-140-100	260-185-140	290-205-155
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	200-165-125	205-135-105	225-150-115

ISO S		Heat resistant material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CC6160		
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.1-0.2-0.3		
MC No.	No.	Material	N/mm²	HB	Cutting speed (v_c), m/min		
		Heat resistant super alloys					
		Iron base					
S1.0.U.AN	20.11	Annealed or solution treated	2400	200	-		
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	-		
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	400-325-270		
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	300-235-190		
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	240-205-175		
		Cobalt alloys					
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	-		
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	-		
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	-		
		Titanium alloys[2]		**Rm**[3]			
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	1300	400	-		
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	1400	950	-		
S4.3.Z.AG	23.22	α+β alloys in aged conditions. β alloys. Annealed or aged	1400	1050	-		

1) The cutting speeds, shown in the table, are valid for all feeds within the feed range.

2) 45–60° entering angle, positive cutting geometry and coolant should be used.

3) Rm = ultimate tensile strength measured in MPa.

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Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO P		Steel	Specific cutting force k_{c1}	Hardness Brinell			
					GC4325	GC4315	GC4305
					h_{ex}, inch ≈ feed, f_n inch/rev. at 0° to -5° lead		
	CMC				.004-.016-.031	.004-.016-.031	.004-.016-.031
MC No.	No.	Material	lbs/in²	HB	Cutting speed v_c, ft/min		
		Unalloyed steel					
P1.1.Z.AN	01.1	C = 0.1–0.25%	216.500	125	1400-890-660	1850-1350-990	2050-1450-1100
P1.2.Z.AN	01.2	C = 0.25–0.55%	233.000	150	1250-800-590	1650-1200-880	1850-1300-970
P1.3.Z.AN	01.3	C = 0.55–0.80%	247.000	170	1200-760-560	1500-1100-790	1750-1250-920
		Low-alloy steel (alloying elements ≤5%)					
P2.1.Z.AN	02.1	Non-hardened	249.500	180	980-600-445	1800-1200-860	2000-1350-940
P2.1.Z.AN	02.12	Ball bearing steel	259.500	210	820-500-365	1500-990-710	1750-1150-820
P2.5.Z.HT	02.2	Hardened and tempered	268.000	275	600-385-280	980-680-510	1050-750-570
P2.5.Z.HT	02.2	Hardened and tempered	298.000	350	485-310-225	790-550-415	870-610-460
		High-alloy steel (alloying elements >5%)					
P3.0.Z.AN	03.11	Annealed	282.000	200	780-500-345	1350-880-650	1450-970-720
P3.0.Z.HT	03.21	Hardened tool steel	435.500	325	360-225-165	650-415-315	710-460-345
		Steel castings					
P1.5.C.UT	06.1	Unalloyed	225.000	180	600-450-335	990-700-550	1100-770-610
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230.500	200	540-320-235	860-610-470	950-670-510
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	300.500	225	470-305-220	660-450-345	730-490-380

ISO S		Heat resistant material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CC6160		
					h_{ex}, inch ≈ feed, f_n inch/rev. at 0° to -5° lead		
	CMC				.004-.008-.012		
MC No.	No.	Material	lbs/in²	HB	Cutting speed (v_c), ft/min		
		Heat resistant super alloys					
		Iron base					
S1.0.U.AN	20.11	Annealed or solution treated	348.000	200	-		
S1.0.U.AG	20.12	Aged or solution treated and aged	359.000	280	-		
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	383.000	250	1300-1050-880		
S2.0.Z.AG	20.22	Aged or solution treated and aged	420.500	350	980-770-620		
S2.0.C.NS	20.24	Cast or cast and aged	436.500	320	790-660-570		
		Cobalt alloys					
S3.0.Z.AN	20.31	Annealed or solution treated	391.500	200	-		
S3.0.Z.AG	20.32	Solution treated and aged	432.000	300	-		
S3.0.C.NS	20.33	Cast or cast and aged	450.500	320	-		
		Titanium alloys[2]		**Rm**[3]			
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	188.500	400	-		
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	203.000	950	-		
S4.3.Z.AG	23.22	α+β alloys in aged conditions. β alloys. Annealed or aged	203.000	1050	-		

1) The cutting speeds, shown in the table, are valid for all feeds within the feed range.

2) 45–60° entering angle, positive cutting geometry and coolant should be used.

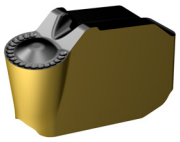
3) Rm = ultimate tensile strength measured in MPa.

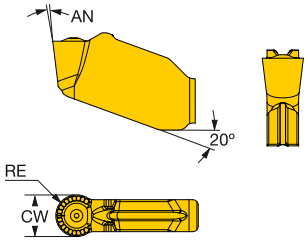
Parting and grooving

CoroCut® QD

Inserts

CoroCut® QD insert for profiling





	SSC	CW	RE	APMX	Ordering code	P			M		K			N	S		Dimensions, mm, inch		
						1125	1135	4335	1125	1135	1125	1135	4335	1125	1125	1135	AN	CWTOLL	CWTOLU
Medium	G	3.00	1.50	1.3	QD-NG-0300-RM	☆	★	☆	☆	★	★	☆	☆	☆	★	☆	7°	-0.050	0.050
		.118	*.059*	*.049*														*-.0020*	*.0020*
	H	4.00	2.00	1.8	QD-NH-0400-RM	☆	★	☆	☆	★	★	☆	☆	☆	★	☆	7°	-0.050	0.050
		.157	*.079*	*.071*														*-.0020*	*.0020*
	K	6.00	3.00	2.5	QD-NK-0600-RM	☆	★	☆	☆	★	★	☆	☆	☆	★	☆	7°	-0.050	0.050
		.236	*.118*	*.098*														*-.0020*	*.0020*
	L	8.00	4.00	3.5	QD-NL-0800-RM	☆	★	☆	☆	★	★	☆	☆	☆	★	☆	7°	-0.050	0.050
		.315	*.157*	*.138*														*-.0020*	*.0020*

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Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO P		Steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC4335	GC1125	GC1135
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC					0.05-0.5	0.05-0.5
MC No.	No.	Material	N/mm²	HB	Cutting speed (v_c), m/min		
		Unalloyed					
P1.1.Z.AN	01.1	C = 0.1–0.25%	1500	125	475-245	295-145	205-100
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	435-225	265-115	180-75
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	410-210	235-105	175-70
		Low-alloy ≤5%					
P2.1.Z.AN	02.1	Non-hardened	1700	180	355-170	235-110	175-80
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	205-105	205-95	155-70
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	165-85	165-75	125-55
		High-alloy >5%					
P3.0.Z.AN	03.11	Annealed	1950	200	250-140	205-95	155-70
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	125-60	150-65	105-45
		Castings					
P1.5.C.UT	06.1	Unalloyed	1550	180	180-125	135-65	105-50
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	200-90	160-85	120-60
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	160-85	120-50	90-40
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	2900	250	150-30	70-40	50-29

ISO M		Stainless steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC1125	GC1135	
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.5	0.05-0.5	
MC No.	No.	Material	N/mm²	HB	Cutting speed (v_c), m/min		
		Ferritic/martensitic					
		Bars/forged					
P5.0.Z.AN	05.11	Non-hardened	1800	200	190-85	145-65	
P5.0.Z.PH	05.12	PH-hardened	2850	330	150-65	110-45	
P5.0.Z.HT	05.13	Hardened	2350	330	160-70	120-50	
		Austenitic					
		Bars/forged					
M1.0.Z.AQ	05.21	Austenitic	1800	180	215-100	165-70	
M1.0.Z.PH	05.22	PH-hardened	2850	330	150-70	105-50	
M2.0.Z.AQ	05.23	Super austenitic	2250	200	160-75	115-55	
		Austenitic-ferritic (Duplex)					
		Bars/forged					
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	180-85	135-60	
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	150-70	110-50	
		Ferritic/martensitic					
		Cast					
P5.0.C.UT	15.11	Non-hardened	1700	200	175-80	130-60	
P5.0.C.HT	15.13	Hardened	2150	330	145-65	110-45	
		Austenitic					
		Cast					
M1.0.C.UT	15.21	Austenitic	1700	180	185-90	135-60	
	15.22	PH-hardened	2450	330	120-65	90-45	
		Austenitic-ferritic (Duplex)					
		Cast					
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	155-75	115-55	
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	125-65	95-45	

ISO K		Cast iron	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC4335	GC1135	GC1125
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC					0.05-0.5	0.05-0.5
MC No.	No.	Material	N/mm²	HB	Cutting speed (v_c), m/min		
		Malleable					
	07.1	Ferritic (short chipping)	790	130	150-120	320-170	255-125
K1.1.C.NS	07.2	Pearlitic (long chipping)	900	230	110-90	235-110	170-95
		Grey					
K2.1.C.UT	08.1	Low tensile strength	890	180	240-155	275-130	210-110
K2.2.C.UT	08.2	High tensile strength	970	220	185-115	240-115	175-90
		Nodular SG iron					
K3.1.C.UT	09.1	Ferritic	900	160	210-115	250-105	185-95
K3.3.C.UT	09.2	Pearlitic	1350	250	120-90	195-90	150-75
K3.4.C.UT	09.3	Martensitic	2100	380	95-35	140-70	100-55

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO N		Non-ferrous material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC1125		
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.8		
MC No.	No.	Material	N/mm²	HB	Cutting speed (v_c), m/min		
		Aluminium alloys					
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	400	60	1500 (1900 - 190)		
N1.2.Z.AG	30.12		650	100	1500 (1900 - 190)		
		Aluminium alloys					
N1.3.C.UT	30.21	Cast. non aging	600	75	1500 (1900 - 190)		
N1.3.C.AG	30.22	Cast or cast and aged	700	90	1500 (1900 - 190)		
		Aluminium alloys					
	30.41	Cast, 13–15% Si	700	130	400 (500 - 50)		
N1.4.C.NS	30.42	Cast, 16–22% Si	700	130	250 (315 - 31)		
		Copper and copper alloys					
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	550	110	350 (440 - 45)		
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	550	90	400 (500 - 50)		
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	1350	100	250 (315 - 31)		

ISO S		Heat resistant super alloys	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC1125	GC1135	
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.3	0.05-0.3	
MC No.	No.	Material	N/mm²	HB	Cutting speed (v_c), m/min		
		Iron base					
S1.0.U.AN	20.11	Annealed or solution treated	2400	200	80-45	50-29	
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	55-33	40-26	
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	50-32	40-26	
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	45-26	35-21	
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	35-18	25-10	
		Cobalt alloys					
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	55-38	45-28	
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	45-26	35-17	
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	35-18	25-14	
		Titanium alloys		Rm[1]			
S4.1.Z.UT	23.1	Commercial pure (99.5% Ti)	1300	400	220-100	170-80	
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	1400	950	80-45	65-35	
S4.3.Z.AG	23.22	α + β alloys in aged conditions, β alloys, annealed or aged	1400	1050	75-37	60-30	

1) Rm = ultimate tensile strength measured in MPa.

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Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO P		Steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC4335	GC1125	GC1135
					h_{ex}, inch ≈ feed, f_n inch/r		
	CMC					.002-.020	.002-.020
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Unalloyed					
P1.1.Z.AN	01.1	C = 0.1–0.25%	216,500	125	1560-800	960-475	670-330
P1.2.Z.AN	01.2	C = 0.25–0.55%	233,000	150	1430-740	860-380	590-250
P1.3.Z.AN	01.3	C = 0.55–0.80%	247,000	170	1350-690	770-340	570-235
		Low-alloy ≤5%					
P2.1.Z.AN	02.1	Non-hardened	249,500	180	1160-560	770-365	570-260
P2.5.Z.HT	02.2	Hardened and tempered	268,000	275	670-340	660-305	500-220
P2.5.Z.HT	02.2	Hardened and tempered	298,000	350	540-280	530-245	400-180
		High-alloy >5%					
P3.5.Z.AN	03.11	Annealed	282,000	200	820-460	670-305	500-225
P3.5.Z.HT	03.21	Hardened tool steel	435,000	325	410-200	490-205	335-140
		Castings					
P1.5.C.UT	06.1	Unalloyed	225,000	180	590-410	440-210	335-160
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230,500	200	660-300	520-275	390-200
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	300,500	225	520-280	395-170	295-130
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	420,500	250	490-100	225-130	160-95

ISO M		Stainless steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC1125	GC1135	
					h_{ex}, inch ≈ feed, f_n inch/r		
	CMC				.002-.020	.002-.020	
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Ferritic/martensitic					
		Bars/forged					
P5.0.Z.AN	05.11	Non-hardened	262,000	200	620-285	470-210	
P5.0.Z.PH	05.12	PH-hardened	411,500	330	480-220	350-150	
P5.0.Z.HT	05.13	Hardened	340,000	330	520-235	385-165	
		Austenitic					
		Bars/forged					
M1.0.Z.AQ	05.21	Austenitic	259,000	180	700-335	530-230	
M1.0.Z.PH	05.22	PH-hardened	414,000	330	485-230	340-160	
M2.0.Z.AQ	05.23	Super austenitic	328,000	200	520-250	370-180	
		Austenitic-ferritic (Duplex)					
		Bars/forged					
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	286,500	230	580-280	440-190	
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	490-235	360-165	
		Ferritic/martensitic					
		Cast					
P5.0.C.UT	15.11	Non-hardened	246,500	200	560-260	425-190	
P5.0.C.HT	15.13	Hardened	311,000	330	470-215	360-150	
		Austenitic					
		Cast					
M1.0.C.UT	15.21	Austenitic	248,000	180	600-290	445-190	
	15.22	PH-hardened	356,000	330	395-205	295-145	
		Austenitic-ferritic (Duplex)					
		Cast					
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	258,000	230	510-245	375-170	
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,500	260	405-210	300-145	

ISO K		Cast iron	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC4335	GC1125	GC1135
					h_{ex}, inch ≈ feed, f_n inch/r		
	CMC					.002-.020	.002-0.020
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Malleable					
	07.1	Ferritic (short chipping)	115,000	130	490-390	830-415	1050-550
K1.1.C.NS	07.2	Pearlitic (long chipping)	131,000	230	360-300	560-310	760-350
		Grey					
K2.1.C.UT	08.1	Low tensile strength	130,000	180	790-510	680-365	900-430
K2.2.C.UT	08.2	High tensile strength	140,500	220	610-380	570-295	780-370
		Nodular SG iron					
K3.1.C.UT	09.1	Ferritic	130,000	160	690-380	600-320	810-350
K3.3.C.UT	09.2	Pearlitic	194,500	250	390-300	485-250	640-300
K3.4.C.UT	09.3	Martensitic	307,500	380	310-110	330-180	450-220

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

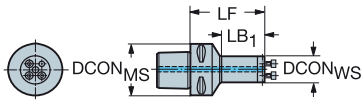
ISO N		Non-ferrous material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC1125		
					h_{ex}, inch ≈ feed, f_n inch/r		
	CMC				.002-.031		
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Aluminium alloys					
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	58,000	60	4900 (6150-610)		
N1.2.Z.AG	30.12		94,500	100	4900 (6150-610)		
		Aluminium alloys					
N1.3.C.UT	30.21	Cast. non aging	87,000	75	4900 (6150-610)		
N1.3.C.AG	30.22	Cast or cast and aged	101,500	90	4900 (6150-610)		
	30.41	Cast, 13–15% Si	101,500	130	1300 (1650-165)		
N1.4.C.NS	30.42	Cast, 16–22% Si	101,500	130	820 (1050-105)		
		Copper and copper alloys					
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	79,500	110	1150 (1450-145)		
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	80,000	90	1300 (1650-165)		
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	196,000	100	820 (1050-105)		

ISO S		Heat resistant super alloys	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC1125	GC1135	
					h_{ex}, inch ≈ feed, f_n inch/r		
	CMC				.002-.012	.002-.012	
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Iron base					
S1.0.U.AN	20.11	Annealed or solution treated	348,000	200	260-140	165-95	
S1.0.U.AG	20.12	Aged or solution treated and aged	359,000	280	185-110	130-85	
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	383,000	250	170-105	130-85	
S2.0.ZAG	20.22	Aged or solution treated and aged	420,500	350	150-85	115-70	
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	115-60	80-31	
		Cobalt alloys					
S3.0.Z.AN	20.31	Annealed or solution treated	391,500	200	185-125	145-90	
S3.0.Z.AG	20.32	Solution treated and aged	432,000	300	150-85	115-55	
S3.0.C.NS	20.33	Cast or cast and aged	450,500	320	115-60	80-45	
Titanium		**Commercial pure**		**Rm[1)]**			
S4.1.Z.UT	23.1	(99.5% Ti)	188,500	**400**	720-325	550-265	
		Titanium alloys					
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	203,000	**950**	265-140	-	
S4.3.Z.AG	23.22	α + β alloys in aged conditions, β alloys, annealed or aged	203,000	**1050**	245-120	-	

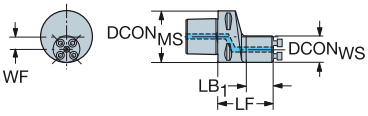
1) Rm = ultimate tensile strength measured in MPa.

Turning tool adaptors

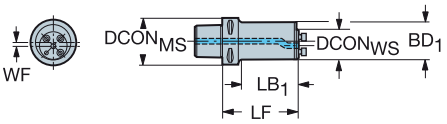
Coromant Capto® to CoroTurn® SL adaptor



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LB$_1$	LF	BAR PSI	KG
C8	40	3	1	C8-570-2C 40 110	80.0	40	78	110	150	2.540
					3.150	*1.575*	*3.071*	*4.331*	*2175*	



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	WF	BAR PSI	KG
C8	40	3	1	C8-570-2C 40 089R/L	80.0	40	89	20.0	150	2.380
					3.150	*1.575*	*3.504*	*.787*	*2175*	



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	BD$_1$	LB$_1$	LF	WF	BAR PSI	KG
C8	40	3	1	C8-570-2C 50 107-40R/L	80.0	40	50	73	107	5.0	150	2.890
					3.150	*1.575*	*1.969*	*2.874*	*4.213*	*.787*	*2175*	
		3	1	C8-570-2C 50 133-40R/L	80.0	40	50	104	133	5.0	150	3.290
					3.150	*1.575*	*1.969*	*4.094*	*5.236*	*.197*	*2175*	
		3	1	C8-570-2C 60 125-40R/L	80.0	40	60	94	125	10.0	150	3.750
					3.150	*1.575*	*2.362*	*3.701*	*4.921*	*.787*	*2175*	
		3	1	C8-570-2C 60 158-40R/L	80.0	40	60	131	158	10.0	150	4.450
					3.150	*1.575*	*2.362*	*5.157*	*6.220*	*.394*	*2175*	

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

R = Right hand, L = Left hand

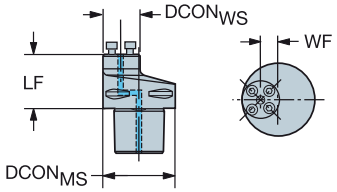
ISO 13399 H2

CNSC CXSC H7

SANDVIK Coromant

ENG

Coromant Capto® to CoroTurn® SL adaptor



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	WF	BAR PSI	KG
C8	32	3	1	**C8-570-32-R/LGM**	80.0	32	66	24.0	150	2.070
					3.150	*1.260*	*2.598*	*.945*	*2175*	
	40	3	1	**C8-570-40-R/LGM**	80.0	40	67	20.0	150	2.170
					3.150	*1.575*	*2.638*	*.787*	*2175*	

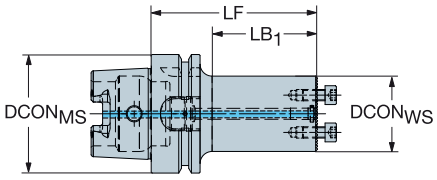
For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

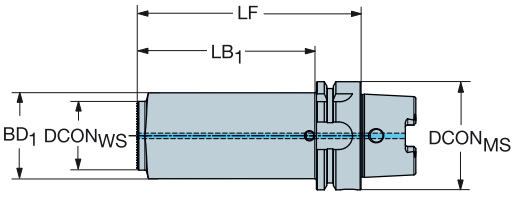
ISO 13399 H2

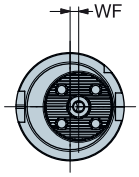
CNSC CXSC H7

HSK to CoroTurn® SL adaptor



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LB$_1$	LF	BAR PSI	KG
63	32	1	1	HT06-32-SL32N 094	63.0	32	64	94	150	1.05
					2.480	*1.260*	*2.520*	*3.701*	*2175*	
	40	1	1	HT06-40-SL40N 110	63.0	40	80	110	150	1.45
					2.480	*1.575*	*3.150*	*4.331*	*2175*	





CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	BD$_1$	LB$_1$	LF	BAR PSI	KG
63	40	1	1	HT06-50-SL40R/L 130	63.0	40	50	100	130	150	2.20
					2.480	*1.575*	*1.969*	*3.937*	*5.118*	*2175*	

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

R = Right hand, L = Left hand

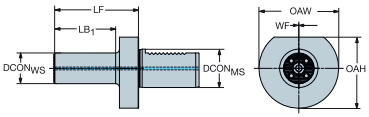
ISO 13399 H2

CNSC CXSC H7

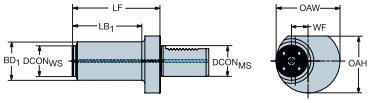
SANDVIK Coromant

ENG

VDI to CoroTurn® SL adaptor



					Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LB_1	LF	OAW	OAH	BAR PSI	NM	KG
30	32	7	1	**VDI30-32-SL32N 088**	30.0	32	64	88	68	62	150	35	1.25
					1.181	*1.260*	*2.520*	*3.465*	*2.677*	*2.441*	*2175*		
40	32	7	1	**VDI40-32-SL32N 088**	40.0	32	64	88	83	74	150	50	1.80
					1.575	*1.260*	*2.520*	*3.465*	*3.268*	*2.913*	*2175*		
	40	7	1	**VDI40-40-SL40N 104**	40.0	40	80	104	83	74	150	50	2.20
					1.575	*1.575*	*3.150*	*4.094*	*3.268*	*2.913*	*2175*		
50	40	7	1	**VDI50-40-SL40N 109**	50.0	40	80	109	98	84	150	50	3.30
					1.969	*1.575*	*3.150*	*4.291*	*3.858*	*3.307*	*2175*		



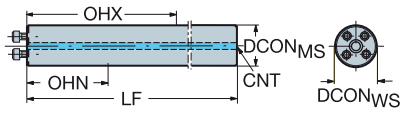
					Dimensions, mm, inch										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	BD_1	LB_1	LF	OAW	OAH	BAR PSI	NM	KG
40	40	7	1	**VDI40-50-SL40R/L 114**	40.0	40	50	90	114	83	74	150	50	2.80
					1.575	*1.575*	*1.969*	*3.543*	*4.488*	*3.268*	*2.913*	*2175*		
50	40	7	1	**VDI50-50-SL40R/L 119**	50.0	40	50	90	119	98	84	150	50	3.85
					1.969	*1.575*	*1.969*	*3.543*	*4.685*	*3.858*	*3.307*	*2175*		
60	40	7	1	**VDI50-60-SL40R/L 119**	60.0	40	60	90	119	123	104	150	90	4.45
					2.362	*1.575*	*2.362*	*3.543*	*4.685*	*4.843*	*4.094*	*2175*		

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

ISO 13399 H2

CNSC CXSC H7

Cylindrical shank to CoroTurn® SL adaptor



Metric version

CZC$_{MS}$	CZC$_{WS}$	OHN	OHX	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LF	BAR	KG
16	16	16.0	41.0	1	1	SL-2C 16 105	16.0	16.0	105.0	150	0.16
20	20	20.0	60.0	1	1	SL-2C 20 140	20.0	20.0	140.0	150	0.33
25	25	25.0	100.0	1	1	SL-2C 25 200	25.0	25.0	200.0	150	0.74

Inch version

CZC$_{MS}$	CZC$_{WS}$	OHN	OHX	CNSC	CXSC	Ordering code	Dimensions, inch DCON$_{MS}$	DCON$_{WS}$	BD$_1$	LF	PSI	LBS
5/8	16	.630	1.614	1	1	SL-2C A10 105-16	.625	.630	.630	4.134	2175	0.4
3/4	20	.787	2.362	1	1	SL-2C A12 140-20	.750	.787	.787	5.512	2175	0.7
1	25	.984	3.937	1	1	SL-2C A16 200-25	1.000	.984	1.000	7.874	2175	1.6

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

ISO 13399 H2

CNSC CXSC H7

Milling

Solid milling tools

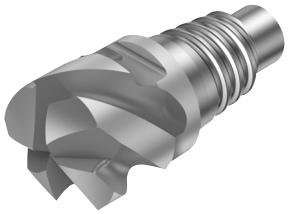
Cutting data

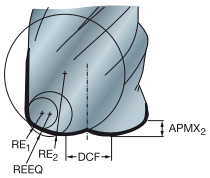
CoroMill® 316 solid carbide head for high feed face milling

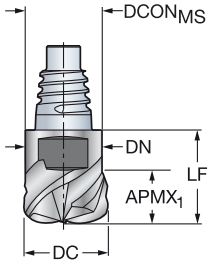
For multi-material with hardness ≤ 48 HRc

Optimized

FHA 50°
BSG COROMANT
TCDC h9







Metric version

DC	CZC$_{MS}$	APMX$_1$	APMX$_2$	RE$_1$	RE$_2$	LU	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	E10	5.5	0.7	1.50	5.00	12.4	3	316-10HM350-10015P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	0.7	1.50	5.00	12.4	4	316-10HM450-10015P	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	0.8	1.50	6.00	14.5	3	316-12HM350-12015P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	0.8	1.50	6.00	14.5	4	316-12HM450-12015P	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	1.0	2.00	8.00	18.7	3	316-16HM350-16020P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	1.0	2.00	8.00	18.7	4	316-16HM450-16020P	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	1.3	2.00	10.00	21.3	4	316-20HM450-20020P	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	1.6	3.00	12.00	25.6	4	316-25HM450-25030P	★	★	☆	☆	24.2	25.6	24.2

Inch version

DC	CZC$_{MS}$	APMX$_1$	APMX$_2$	RE$_1$	RE$_2$	LU	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCON$_{MS}$	LF	DN
.375	E10	.209	.024	.060	.181	.488	4	A316-10HM450-03715P	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.033	.060	.236	.575	4	A316-12HM450-05015P	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.039	.080	.315	.736	4	A316-16HM450-06220P	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.047	.080	.354	.839	4	A316-20HM450-07520P	★	★	☆	☆	.728	.839	.728

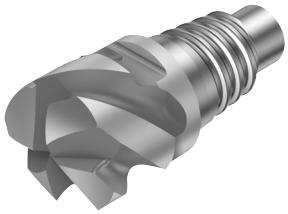
D7 H2

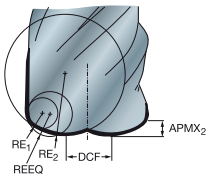
ENG

CoroMill® 316 solid carbide head for high feed face milling

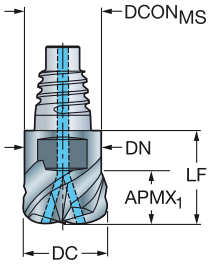
For multi-material with hardness ≤ 48 HRc

Optimized





FHA 50°
BSG COROMANT
TCDC h9



Metric version

DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	LU	CNSC	CXSC	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm $DCON_{MS}$	LF	DN
10.0	E10	6.0	0.7	1.50	5.00	12.4	1	2	4	316-10HM450C10015P	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	7.5	0.8	1.50	6.00	14.5	1	2	4	316-12HM450C12015P	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	10.0	1.0	2.00	8.00	18.7	1	2	4	316-16HM450C16020P	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	12.0	1.3	2.00	10.00	21.3	1	2	4	316-20HM450C20020P	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.0	1.6	3.00	12.00	25.6	1	3	5	316-25HM550C25030P	★	★	☆	☆	24.2	25.6	24.2

Inch version

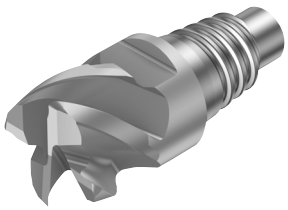
DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	LU	CNSC	CXSC	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch $DCON_{MS}$	LF	DN
.375	E10	.236	.024	.060	.181	.488	1	3	4	A316-10HM450C03715P	★	★	☆	☆	.364	.488	.364
.500	E12	.315	.033	.060	.236	.571	1	3	4	A316-12HM450C05015P	★	★	☆	☆	.484	.571	.484
.625	E16	.394	.039	.080	.315	.736	1	3	4	A316-16HM450C06220P	★	★	☆	☆	.610	.736	.610
.750	E20	.453	.047	.080	.354	.839	1	3	4	A316-20HM450C07520P	★	★	☆	☆	.728	.839	.728

D7 H2

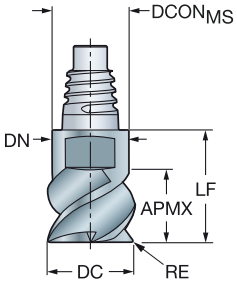
CoroMill® 316 solid carbide head for stable multi-operations milling

For multi-material with hardness ≤ 48 HRc

Optimized



FHA 50°
BSG COROMANT
TCDC h9



Metric version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm $DCON_{MS}$	LF	DN
10.0	E10	5.5	0.50	4	316-10SM450-10005P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	0.50	3	316-10SM350-10005P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.00	4	316-10SM450-10010P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.00	3	316-10SM350-10010P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.50	4	316-10SM450-10015P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	2.00	4	316-10SM450-10020P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	3.00	4	316-10SM450-10030P	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	0.50	4	316-12SM450-12005P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	0.50	3	316-12SM350-12005P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	1.00	4	316-12SM450-12010P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	1.00	3	316-12SM350-12010P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	1.50	4	316-12SM450-12015P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	2.00	4	316-12SM450-12020P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	3.00	4	316-12SM450-12030P	★	★	☆	☆	11.7	14.5	11.7
	E12	6.5	4.00	4	316-12SM450-12040P	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	0.50	4	316-16SM450-16005P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	0.50	3	316-16SM350-16005P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	1.00	4	316-16SM450-16010P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	1.00	3	316-16SM350-16010P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	1.50	4	316-16SM450-16015P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	2.00	4	316-16SM450-16020P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	3.00	4	316-16SM450-16030P	★	★	☆	☆	15.5	18.7	15.5
	E16	8.5	4.00	4	316-16SM450-16040P	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	0.50	3	316-20SM350-20005P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	0.50	4	316-20SM450-20005P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	1.00	3	316-20SM350-20010P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	1.00	4	316-20SM450-20010P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	1.50	4	316-20SM450-20015P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	2.00	4	316-20SM450-20020P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	3.00	4	316-20SM450-20030P	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	4.00	4	316-20SM450-20040P	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	1.00	5	316-25SM550-25010P	★	★	☆	☆	24.2	25.6	24.2
	E25	13.5	1.50	5	316-25SM550-25015P	★	★	☆	☆	24.2	25.6	24.2
	E25	13.5	2.00	5	316-25SM550-25020P	★	★	☆	☆	24.2	25.6	24.2

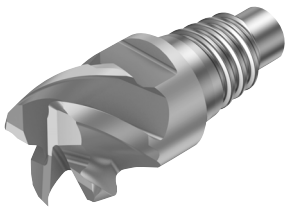
D7 H2

ENG

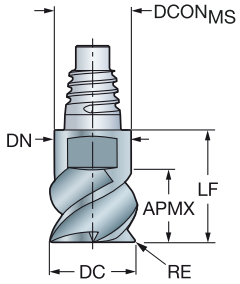
CoroMill® 316 solid carbide head for stable multi-operations milling

For multi-material with hardness ≤ 48 HRc

Optimized

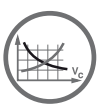


FHA	50°
BSG	COROMANT
TCDC	h9



Inch version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	$DCON_{MS}$	LF	DN
.375	E10	.209	.015	3	A316-10SM350-03704P	★	★	☆	☆	.364	.488	.364
	E10	.209	.015	4	A316-10SM450-03704P	★	★	☆	☆	.364	.488	.364
	E10	.209	.031	3	A316-10SM350-03708P	★	★	☆	☆	.364	.488	.364
	E10	.209	.031	4	A316-10SM450-03708P	★	★	☆	☆	.364	.488	.364
	E10	.209	.062	3	A316-10SM350-03715P	★	★	☆	☆	.364	.488	.364
	E10	.209	.062	4	A316-10SM450-03715P	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.015	3	A316-12SM350-05004P	★	★	☆	☆	.484	.575	.484
	E12	.276	.015	4	A316-12SM450-05004P	★	★	☆	☆	.484	.575	.484
	E12	.276	.031	3	A316-12SM350-05008P	★	★	☆	☆	.484	.575	.484
	E12	.276	.031	4	A316-12SM450-05008P	★	★	☆	☆	.484	.575	.484
	E12	.276	.062	3	A316-12SM350-05015P	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.015	3	A316-16SM350-06204P	★	★	☆	☆	.610	.736	.610
	E16	.335	.031	4	A316-16SM450-06208P	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.031	3	A316-20SM350-07508P	★	★	☆	☆	.728	.839	.728
	E20	.413	.031	4	A316-20SM450-07508P	★	★	☆	☆	.728	.839	.728
	E20	.413	.125	4	A316-20SM450-07532P	★	★	☆	☆	.728	.839	.728
	E20	.413	.250	4	A316-20SM450-07563P	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.062	5	A316-25SM550-10015P	★	★	☆	☆	.965	1.008	.965
	E25	.551	.125	5	A316-25SM550-10032P	★	★	☆	☆	.965	1.008	.965
	E25	.551	.188	5	A316-25SM550-10047P	★	★	☆	☆	.965	1.008	.965
	E25	.551	.250	5	A316-25SM550-10063P	★	★	☆	☆	.965	1.008	.965



D7

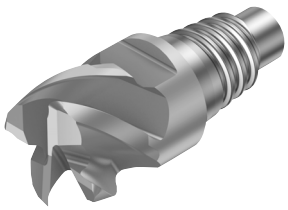
H2

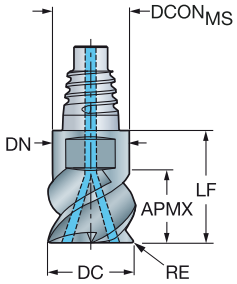
CoroMill® 316 solid carbide head for stable multi-operations milling

For multi-material with hardness ≤ 48 HRc

Optimized

FHA 50°
BSG COROMANT
TCDC h9



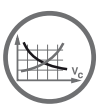


Metric version

DC	CZCMS	APMX	RE	CNSC	CXSC	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCONMS	LF	DN
10.0	E10	6.0	0.50	1	2	4	316-10SM450C10005P	★	★	☆	☆	9.7	12.4	9.7
	E10	6.0	1.00	1	2	4	316-10SM450C10010P	★	★	☆	☆	9.7	12.4	9.7
	E10	6.0	1.50	1	2	4	316-10SM450C10015P	★	★	☆	☆	9.7	12.4	9.7
	E10	6.0	2.00	1	2	4	316-10SM450C10020P	★	★	☆	☆	9.7	12.4	9.7
	E10	6.0	3.00	1	2	4	316-10SM450C10030P	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	7.5	0.50	1	2	4	316-12SM450C12005P	★	★	☆	☆	11.7	14.5	11.7
	E12	7.5	1.00	1	2	4	316-12SM450C12010P	★	★	☆	☆	11.7	14.5	11.7
	E12	7.5	2.00	1	2	4	316-12SM450C12020P	★	★	☆	☆	11.7	14.5	11.7
	E12	7.5	3.00	1	2	4	316-12SM450C12030P	★	★	☆	☆	11.7	14.5	11.7
	E12	7.5	4.00	1	2	4	316-12SM450C12040P	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	10.0	0.50	1	3	4	316-16SM450C16005P	★	★	☆	☆	15.5	18.7	15.5
	E16	10.0	1.00	1	2	4	316-16SM450C16010P	★	★	☆	☆	15.5	18.7	15.5
	E16	10.0	1.50	1	2	4	316-16SM450C16015P	★	★	☆	☆	15.5	18.7	15.5
	E16	10.0	2.00	1	2	4	316-16SM450C16020P	★	★	☆	☆	15.5	18.7	15.5
	E16	10.0	3.00	1	2	4	316-16SM450C16030P	★	★	☆	☆	15.5	18.7	15.5
	E16	10.0	4.00	1	2	4	316-16SM450C16040P	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	12.0	0.50	1	3	4	316-20SM450C20005P	★	★	☆	☆	19.3	21.3	19.3
	E20	12.0	1.00	1	2	4	316-20SM450C20010P	★	★	☆	☆	19.3	21.3	19.3
	E20	12.0	1.50	1	2	4	316-20SM450C20015P	★	★	☆	☆	19.3	21.3	19.3
	E20	12.0	2.00	1	2	4	316-20SM450C20020P	★	★	☆	☆	19.3	21.3	19.3
	E20	12.0	3.00	1	2	4	316-20SM450C20030P	★	★	☆	☆	19.3	21.3	19.3
	E20	12.0	4.00	1	2	4	316-20SM450C20040P	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	15.0	1.00	1	2	5	316-25SM550C25010P	★	★	☆	☆	24.2	25.6	24.2
	E25	15.0	1.50	1	2	5	316-25SM550C25015P	★	★	☆	☆	24.2	25.6	24.2
	E25	15.0	2.00	1	2	5	316-25SM550C25020P	★	★	☆	☆	24.2	25.6	24.2

Inch version

DC	CZCMS	APMX	RE	CNSC	CXSC	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCONMS	LF	DN
.375	E10	.236	.015	1	3	4	A316-10SM450C03704P	★	★	☆	☆	.364	.488	.364
	E10	.236	.031	1	3	4	A316-10SM450C03708P	★	★	☆	☆	.364	.488	.364
.500	E12	.315	.015	1	3	4	A316-12SM450C05004P	★	★	☆	☆	.484	.571	.484
	E12	.315	.031	1	3	4	A316-12SM450C05008P	★	★	☆	☆	.484	.571	.484
	E12	.315	.062	1	3	4	A316-12SM450C05015P	★	★	☆	☆	.484	.571	.484
.625	E16	.394	.031	1	3	4	A316-16SM450C06208P	★	★	☆	☆	.610	.736	.610
	E16	.394	.062	1	3	4	A316-16SM450C06215P	★	★	☆	☆	.610	.736	.610
.750	E20	.453	.031	1	3	4	A316-20SM450C07508P	★	★	☆	☆	.728	.839	.728
	E20	.453	.062	1	3	4	A316-20SM450C07515P	★	★	☆	☆	.728	.839	.728
	E20	.453	.125	1	3	4	A316-20SM450C07532P	★	★	☆	☆	.728	.839	.728
	E20	.453	.250	1	3	4	A316-20SM450C07563P	★	★	☆	☆	.728	.839	.728
1.000	E25	.610	.125	1	3	5	A316-25SM550C10032P	★	★	☆	☆	.965	1.008	.965
	E25	.610	.188	1	3	5	A316-25SM550C10047P	★	★	☆	☆	.965	1.008	.965
	E25	.610	.250	1	3	5	A316-25SM550C10063P	★	★	☆	☆	.965	1.008	.965


D7

H2

SANDVIK Coromant

ENG

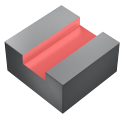
Optimized - CoroMill® 316 solid carbide head for high feed face milling

a_e = 0.5 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	G	110	361
	P2.2.Z.AN	02.2	Low-alloyed steel	240	G	100	328
	P3.0.Z.HT	03.21	High alloyed steel	380	G	60	197
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	G	50	164
	M1.0.Z.AQ	05.21	Austenic stainless steel	200	G	60	197
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	G	50	164
K	K1.1.C.NS	07.2	Malleable cast iron	200	G	120	394
	K2.1.C.UT	08.2	Grey cast iron	180	G	120	394
	K3.2.C.UT	09.2	Nodular cast iron	215	G	110	361
S	S1.0.U.AG	20.12	Iron based superalloys	280	G	50	165
	S2.0.Z.AG	20.22	Nickel based super alloys	350	G	35	115
	S4.2.Z.AN	23.22	Titanium based alloys	320	G	75	246
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	H	110	361
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC	H	110	361
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC	H	60	197

Optimized - CoroMill® 316 solid carbide head for stable multi-operations milling



	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	A	165	541	B	215	705	C	305	1001
	P2.2.Z.AN	02.2	Low-alloyed steel	240	A	125	410	B	160	525	C	220	722
	P3.0.Z.HT	03.21	High alloyed steel	380	A	75	246	B	95	312	C	130	427
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	A	45	148	B	65	213	C	85	279
	M1.0.Z.AQ	05.21	Austenic stainless steel	200	D	60	197	E	75	246	F	110	361
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	D	45	148	E	65	213	F	85	279
K	K1.1.C.NS	07.2	Malleable cast iron	200	A	135	443	B	170	558	C	240	787
	K2.1.C.UT	08.2	Grey cast iron	180	A	135	443	B	165	541	C	240	787
	K3.2.C.UT	09.2	Nodular cast iron	215	A	125	410	B	150	492	C	215	705
S	S1.0.U.AG	20.12	Iron based superalloys	280	D	25	82	E	35	115	F	60	197
	S2.0.Z.AG	20.22	Nickel based super alloys	350	I	15	49	I	25	82	I	30	98
	S4.2.Z.AN	23.22	Titanium based alloys	320	D	40	131	E	55	180	F	95	312
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	D	50	164	E	80	262	F	90	295
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC	D	50	164	E	80	262	F	90	295
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC	D	30	98	E	50	164	F	50	164

Cutting feed recommendations

CoroMill® 316

DC	mm inch	9.525 .375	10.000 .394	12.000 .472	12.700 .500	15.875 .625	16.000 .630	19.050 .750	20.000 .787	25.000 .984	25.400 1.000
A	mm/tooth	0.060	0.060	0.070	0.070	0.090	0.090	0.100	0.100	0.100	0.100
B	mm/tooth	0.100	0.100	0.100	0.100	0.120	0.120	0.120	0.140	0.160	0.160
C	mm/tooth	0.120	0.120	0.120	0.120	0.120	0.120	0.180	0.200	0.200	0.200
D	mm/tooth	0.050	0.050	0.060	0.060	0.070	0.070	0.080	0.080	0.080	0.080
E	mm/tooth	0.080	0.080	0.080	0.080	0.100	0.100	0.100	0.110	0.130	0.130
F	mm/tooth	0.100	0.100	0.100	0.100	0.100	0.120	0.140	0.160	0.160	0.160
G	mm/tooth	0.300	0.300	0.350	0.350	0.500	0.500	0.700	0.700	0.700	0.700
H	mm/tooth	0.240	0.240	0.280	0.280	0.400	0.400	0.560	0.560	0.560	0.560
I	mm/tooth	0.030	0.031	0.038	0.040	0.050	0.050	0.060	0.063	0.078	0.078

Drilling

Indexable drills

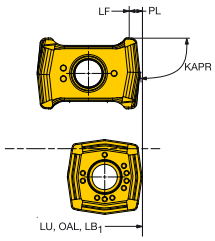
Solid drills

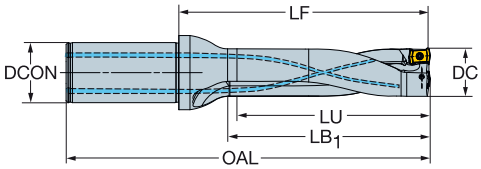
Cutting data

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





Metric design

DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
15.00	01C	01P	60.00	20	1.00	0.00	0.27	DS20-D1500L20-04	20.00	80.69	131.00	63.00	0.46	81°	10	0.190	24000
			75.00	20	1.00	0.00	0.27	DS20-D1500L20-05	20.00	95.69	146.00	78.00	0.46	81°	10	0.200	15000
			90.00	20	1.00	-0.10	0.40	DS20-D1500L20-06	20.00	110.69	161.00	93.00	0.46	81°	10	0.210	11000
			105.00	20	1.00	-0.10	0.40	DS20-D1500L20-07	20.00	125.69	176.00	108.00	0.46	81°	10	0.219	8000
16.00	01C	01P	64.00	20	0.75	0.00	0.27	DS20-D1600L20-04	20.00	84.69	135.00	67.00	0.46	81°	10	0.200	22000
			80.00	20	0.75	0.00	0.27	DS20-D1600L20-05	20.00	100.69	151.00	83.00	0.46	81°	10	0.212	14000
			96.00	20	0.75	-0.10	0.40	DS20-D1600L20-06	20.00	116.69	167.00	99.00	0.46	81°	10	0.224	10000
			112.00	20	0.75	-0.10	0.40	DS20-D1600L20-07	20.00	132.69	183.00	115.00	0.46	81°	10	0.236	7000
17.00	01C	01P	68.00	20	0.50	0.00	0.27	DS20-D1700L20-04	20.00	88.69	139.00	71.00	0.46	81°	10	0.211	21000
			85.00	20	0.50	0.00	0.27	DS20-D1700L20-05	20.00	105.69	156.00	88.00	0.46	81°	10	0.226	13000
			102.00	20	0.50	-0.10	0.40	DS20-D1700L20-06	20.00	122.69	173.00	105.00	0.46	81°	10	0.240	9000
			119.00	20	0.50	-0.10	0.40	DS20-D1700L20-07	20.00	139.69	190.00	122.00	0.46	81°	10	0.255	7000
18.00	01C	01P	72.00	25	0.25	0.00	0.27	DS20-D1800L25-04	25.00	96.69	153.00	75.00	0.46	81°	10	0.348	20000
			90.00	25	0.25	0.00	0.27	DS20-D1800L25-05	25.00	114.69	171.00	93.00	0.46	81°	10	0.366	13000
			108.00	25	0.25	-0.10	0.40	DS20-D1800L25-06	25.00	132.69	189.00	111.00	0.46	81°	10	0.383	9000
			126.00	25	0.25	-0.10	0.40	DS20-D1800L25-07	25.00	150.69	207.00	129.00	0.46	81°	10	0.400	6000
19.00	02C	02P	76.00	25	1.06	0.00	0.33	DS20-D1900L25-04	25.00	100.62	157.00	79.00	0.55	81°	10	0.348	19000
			95.00	25	1.06	0.00	0.33	DS20-D1900L25-05	25.00	119.62	176.00	98.00	0.55	81°	10	0.367	12000
			114.00	25	1.06	-0.10	0.40	DS20-D1900L25-06	25.00	138.62	195.00	117.00	0.55	81°	10	0.387	8000
			133.00	25	1.06	-0.10	0.40	DS20-D1900L25-07	25.00	157.62	214.00	136.00	0.55	81°	10	0.405	6000
20.00	02C	02P	80.00	25	0.82	0.00	0.33	DS20-D2000L25-04	25.00	104.62	161.00	83.00	0.55	81°	10	0.364	18000
			100.00	25	0.82	0.00	0.33	DS20-D2000L25-05	25.00	124.62	181.00	103.00	0.55	81°	10	0.386	11000
			120.00	25	0.82	-0.10	0.40	DS20-D2000L25-06	25.00	144.62	201.00	123.00	0.55	81°	10	0.409	8000
			140.00	25	0.82	-0.10	0.40	DS20-D2000L25-07	25.00	164.62	221.00	143.00	0.55	81°	10	0.431	6000
21.00	02C	02P	84.00	25	0.58	0.00	0.33	DS20-D2100L25-04	25.00	108.62	165.00	87.00	0.55	81°	10	0.381	17000
			105.00	25	0.58	0.00	0.33	DS20-D2100L25-05	25.00	129.62	186.00	108.00	0.55	81°	10	0.407	11000
			126.00	25	0.58	-0.10	0.40	DS20-D2100L25-06	25.00	150.62	207.00	129.00	0.55	81°	10	0.434	8000
			147.00	25	0.58	-0.10	0.40	DS20-D2100L25-07	25.00	171.62	228.00	150.00	0.55	81°	10	0.460	5000
22.00	02C	02P	88.00	25	0.34	0.00	0.33	DS20-D2200L25-04	25.00	112.62	169.00	91.00	0.55	81°	10	0.401	16000
			110.00	25	0.34	0.00	0.33	DS20-D2200L25-05	25.00	134.62	191.00	113.00	0.55	81°	10	0.431	10000
			132.00	25	0.34	-0.10	0.40	DS20-D2200L25-06	25.00	156.62	213.00	135.00	0.55	81°	10	0.463	7000
			154.00	25	0.34	-0.10	0.40	DS20-D2200L25-07	25.00	178.62	235.00	157.00	0.55	81°	10	0.494	5000
23.00	03C	03P	92.00	25	1.30	0.00	0.33	DS20-D2300L25-04	25.00	117.53	174.00	96.00	0.66	81°	10	0.417	15000
			115.00	25	1.30	0.00	0.33	DS20-D2300L25-05	25.00	140.53	197.00	119.00	0.66	81°	10	0.452	10000
			138.00	25	1.30	-0.10	0.40	DS20-D2300L25-06	25.00	163.53	220.00	142.00	0.66	81°	10	0.488	7000
			161.00	25	1.30	-0.10	0.40	DS20-D2300L25-07	25.00	186.53	243.00	165.00	0.66	81°	10	0.524	5000
24.00	03C	03P	96.00	25	1.10	0.00	0.33	DS20-D2400L25-04	25.00	121.53	178.00	100.00	0.66	81°	10	0.439	15000
			120.00	25	1.10	0.00	0.33	DS20-D2400L25-05	25.00	145.53	202.00	124.00	0.66	81°	10	0.480	9000
			144.00	25	1.10	-0.10	0.40	DS20-D2400L25-06	25.00	169.53	226.00	148.00	0.66	81°	10	0.520	6000
			168.00	25	1.10	-0.10	0.40	DS20-D2400L25-07	25.00	193.53	250.00	172.00	0.66	81°	10	0.561	5000
25.00	03C	03P	100.00	25	0.90	0.00	0.33	DS20-D2500L25-04	25.00	125.53	182.00	104.00	0.66	81°	10	0.463	14000
			125.00	25	0.90	0.00	0.33	DS20-D2500L25-05	25.00	150.53	207.00	129.00	0.66	81°	10	0.510	9000
			150.00	25	0.90	-0.10	0.40	DS20-D2500L25-06	25.00	175.53	232.00	154.00	0.66	81°	10	0.557	6000
			175.00	25	0.90	-0.10	0.40	DS20-D2500L25-07	25.00	200.53	257.00	179.00	0.66	81°	10	0.603	4000
26.00	03C	03P	104.00	32	0.70	0.00	0.33	DS20-D2600L32-04	32.00	133.53	194.00	108.00	0.66	81°	10	0.705	14000
			130.00	32	0.70	0.00	0.33	DS20-D2600L32-05	32.00	159.53	220.00	134.00	0.66	81°	10	0.758	9000
			156.00	32	0.70	-0.10	0.40	DS20-D2600L32-06	32.00	185.53	246.00	160.00	0.66	81°	10	0.812	6000
			182.00	32	0.70	-0.10	0.40	DS20-D2600L32-07	32.00	211.53	272.00	186.00	0.66	81°	10	0.865	4000
27.00	03C	03P	108.00	32	0.50	0.00	0.33	DS20-D2700L32-04	32.00	136.53	197.00	112.00	0.66	81°	10	0.734	13000
			135.00	32	0.50	0.00	0.33	DS20-D2700L32-05	32.00	163.53	224.00	139.00	0.66	81°	10	0.794	8000
			162.00	32	0.50	-0.10	0.40	DS20-D2700L32-06	32.00	190.53	251.00	166.00	0.66	81°	10	0.854	6000
			189.00	32	0.50	-0.10	0.40	DS20-D2700L32-07	32.00	217.53	278.00	193.00	0.66	81°	10	0.912	4000


E12


C1

H2

H7

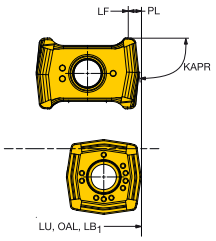
SANDVIK Coromant

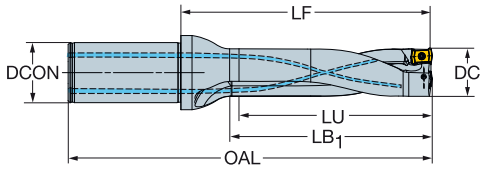
ENG

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





Metric design

DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
34.00	05C	05P	136.00	40	2.16	0.00	0.35	DS20-D3400L40-04	40.00	169.28	240.00	140.00	1.00	81°	10	1.354	11000
			170.00	40	2.16	0.00	0.35	DS20-D3400L40-05	40.00	203.28	274.00	174.00	1.00	81°	10	1.471	7000
			204.00	40	2.16	-0.10	0.40	DS20-D3400L40-06	40.00	237.28	308.00	208.00	1.00	81°	10	1.588	4000
			238.00	40	2.16	-0.10	0.40	DS20-D3400L40-07	40.00	271.28	342.00	242.00	1.00	81°	10	1.705	3000
35.00	05C	05P	140.00	40	1.92	0.00	0.35	DS20-D3500L40-04	40.00	173.28	244.00	144.00	1.00	81°	10	1.398	10000
			175.00	40	1.92	0.00	0.35	DS20-D3500L40-05	40.00	208.28	279.00	179.00	1.00	81°	10	1.525	6000
			210.00	40	1.92	-0.10	0.40	DS20-D3500L40-06	40.00	243.28	314.00	214.00	1.00	81°	10	1.653	4000
			245.00	40	1.92	-0.10	0.40	DS20-D3500L40-07	40.00	278.28	349.00	249.00	1.00	81°	10	1.781	3000
36.00	05C	05P	144.00	40	1.68	0.00	0.35	DS20-D3600L40-04	40.00	177.28	248.00	148.00	1.00	81°	10	1.443	10000
			180.00	40	1.68	0.00	0.35	DS20-D3600L40-05	40.00	213.28	284.00	184.00	1.00	81°	10	1.582	6000
			216.00	40	1.68	-0.10	0.40	DS20-D3600L40-06	40.00	249.28	320.00	220.00	1.00	81°	10	1.721	4000
			252.00	40	1.68	-0.10	0.40	DS20-D3600L40-07	40.00	285.28	356.00	256.00	1.00	81°	10	1.860	3000
37.00	05C	05P	148.00	40	1.44	0.00	0.35	DS20-D3700L40-04	40.00	181.28	252.00	152.00	1.00	81°	10	1.492	10000
			185.00	40	1.44	0.00	0.35	DS20-D3700L40-05	40.00	218.28	289.00	189.00	1.00	81°	10	1.643	6000
			222.00	40	1.44	-0.10	0.40	DS20-D3700L40-06	40.00	255.28	326.00	226.00	1.00	81°	10	1.794	4000
			259.00	40	1.44	-0.10	0.40	DS20-D3700L40-07	40.00	292.28	363.00	263.00	1.00	81°	10	1.945	3000
38.00	05C	05P	152.00	40	1.20	0.00	0.35	DS20-D3800L40-04	40.00	185.28	256.00	156.00	1.00	81°	10	1.543	9000
			190.00	40	1.20	0.00	0.35	DS20-D3800L40-05	40.00	223.28	294.00	194.00	1.00	81°	10	1.707	6000
			228.00	40	1.20	-0.10	0.40	DS20-D3800L40-06	40.00	261.28	332.00	232.00	1.00	81°	10	1.870	4000
			266.00	40	1.20	-0.10	0.40	DS20-D3800L40-07	40.00	299.28	370.00	270.00	1.00	81°	10	2.034	3000
39.00	05C	05P	156.00	40	0.96	0.00	0.35	DS20-D3900L40-04	40.00	189.28	260.00	160.00	1.00	81°	10	1.597	9000
			195.00	40	0.96	0.00	0.35	DS20-D3900L40-05	40.00	228.28	299.00	199.00	1.00	81°	10	1.774	6000
			234.00	40	0.96	-0.10	0.40	DS20-D3900L40-06	40.00	267.28	338.00	238.00	1.00	81°	10	1.950	4000
			273.00	40	0.96	-0.10	0.40	DS20-D3900L40-07	40.00	306.28	377.00	277.00	1.00	81°	10	2.127	3000
40.00	05C	05P	160.00	40	0.72	0.00	0.35	DS20-D4000L40-04	40.00	193.28	264.00	164.00	1.00	81°	10	1.654	9000
			200.00	40	0.72	0.00	0.35	DS20-D4000L40-05	40.00	233.28	304.00	204.00	1.00	81°	10	1.844	6000
			240.00	40	0.72	-0.10	0.40	DS20-D4000L40-06	40.00	273.28	344.00	244.00	1.00	81°	10	2.035	4000
			280.00	40	0.72	-0.10	0.40	DS20-D4000L40-07	40.00	313.28	384.00	284.00	1.00	81°	10	2.226	3000


E12


C1

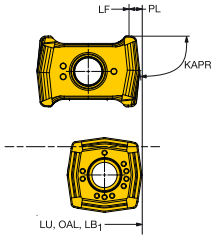
H2

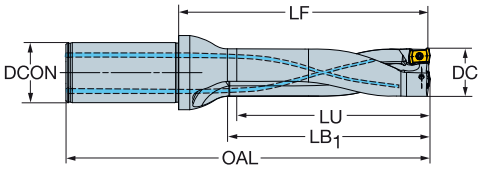
H7

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





Inch design

DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, inch DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	PSI	LBS	RPMX
.625	01C	01P	2.500	3/4	.030	.000	.011	DS20-D1588LX19-04	.750	3.304	5.285	2.611	.018	81°	145	0.480	22000
			3.125	3/4	.030	.000	.011	DS20-D1588LX19-05	.750	3.929	5.910	3.236	.018	81°	145	0.504	14000
			3.750	3/4	.030	-.004	.016	DS20-D1588LX19-06	.750	4.554	6.535	3.861	.018	81°	145	0.540	10000
			4.375	3/4	.030	-.004	.016	DS20-D1588LX19-07	.750	5.179	7.160	4.486	.018	81°	145	0.440	7000
.655	01P	01P	2.624	3/4	.023	.000	.011	DS20-D1666LX19-04	.750	3.426	5.407	2.735	.018	81°	145	0.500	21000
			3.280	3/4	.023	.000	.011	DS20-D1666LX19-05	.750	4.082	6.063	3.391	.018	81°	145	0.529	14000
			3.936	3/4	.023	-.004	.016	DS20-D1666LX19-06	.750	4.738	6.719	4.047	.018	81°	145	0.570	10000
			4.592	3/4	.023	-.004	.016	DS20-D1666LX19-07	.750	5.394	7.375	4.703	.018	81°	145	0.599	7000
.687	01P	01P	2.748	1	.015	.000	.011	DS20-D1745LX25-04	1.000	3.698	5.915	2.859	.018	81°	145	0.661	21000
			3.435	1	.015	.000	.011	DS20-D1745LX25-05	1.000	4.385	6.602	3.546	.018	81°	145	0.800	13000
			4.122	1	.015	-.004	.016	DS20-D1745LX25-06	1.000	5.072	7.289	4.233	.018	81°	145	0.881	9000
			4.809	1	.015	-.004	.016	DS20-D1745LX25-07	1.000	5.759	7.976	4.920	.018	81°	145	1.018	7000
.750	02C	02P	3.000	1	.041	.000	.013	DS20-D1905LX25-04	1.000	3.950	6.170	3.119	.022	81°	145	0.870	19000
			3.750	1	.041	.000	.013	DS20-D1905LX25-05	1.000	4.700	6.920	3.869	.022	81°	145	0.921	12000
			4.500	1	.041	-.004	.016	DS20-D1905LX25-06	1.000	5.450	7.670	4.619	.022	81°	145	0.870	8000
			5.250	1	.041	-.004	.016	DS20-D1905LX25-07	1.000	6.200	8.420	5.369	.022	81°	145	1.051	6000
.812	02C	02P	3.248	1	.026	.000	.013	DS20-D2062LX25-04	1.000	4.193	6.413	3.367	.022	81°	145	0.939	17000
			4.060	1	.026	.000	.013	DS20-D2062LX25-05	1.000	5.005	7.225	4.179	.022	81°	145	0.881	11000
			4.872	1	.026	-.004	.016	DS20-D2062LX25-06	1.000	5.817	8.037	4.991	.022	81°	145	1.102	8000
			5.684	1	.026	-.004	.016	DS20-D2062LX25-07	1.000	6.629	8.849	5.803	.022	81°	145	1.322	6000
.875	03C	03P	3.500	1	.057	.000	.013	DS20-D2223LX25-04	1.000	4.444	6.667	3.626	.026	81°	145	0.899	16000
			4.375	1	.057	.000	.013	DS20-D2223LX25-05	1.000	5.319	7.542	4.501	.026	81°	145	1.075	10000
			5.250	1	.057	-.004	.016	DS20-D2223LX25-06	1.000	6.194	8.417	5.376	.026	81°	145	1.102	7000
			6.125	1	.057	-.004	.016	DS20-D2223LX25-07	1.000	7.069	9.292	6.251	.026	81°	145	1.102	5000
.937	03C	03P	3.748	1	.044	.000	.013	DS20-D2380LX25-04	1.000	4.687	6.910	3.874	.026	81°	145	1.073	15000
			4.685	1	.044	.000	.013	DS20-D2380LX25-05	1.000	5.624	7.847	4.811	.026	81°	145	1.322	10000
			5.622	1	.044	-.004	.016	DS20-D2380LX25-06	1.000	6.561	8.784	5.748	.026	81°	145	1.322	7000
			6.559	1	.044	-.004	.016	DS20-D2380LX25-07	1.000	7.498	9.721	6.685	.026	81°	145	1.234	5000
1.000	03C	03P	4.000	1	.032	.000	.013	DS20-D2540LX25-04	1.000	4.934	7.157	4.126	.026	81°	145	1.155	14000
			5.000	1	.032	.000	.013	DS20-D2540LX25-05	1.000	5.934	8.157	5.126	.026	81°	145	1.309	9000
			6.000	1	.032	-.004	.016	DS20-D2540LX25-06	1.000	6.934	9.157	6.126	.026	81°	145	1.543	6000
			7.000	1	.032	-.004	.016	DS20-D2540LX25-07	1.000	7.934	10.157	7.126	.026	81°	145	1.543	4000
1.062	03C	03P	4.248	1 1/4	.020	.000	.013	DS20-D2697LX31-04	1.250	5.339	7.719	4.374	.026	81°	145	1.984	13000
			5.310	1 1/4	.020	.000	.013	DS20-D2697LX31-05	1.250	6.401	8.781	5.436	.026	81°	145	1.984	8000
			6.372	1 1/4	.020	-.004	.016	DS20-D2697LX31-06	1.250	7.463	9.843	6.498	.026	81°	145	2.425	6000
			7.434	1 1/4	.020	-.004	.016	DS20-D2697LX31-07	1.250	8.525	10.905	7.560	.026	81°	145	1.999	4000
1.312	05C	05P	5.248	1 1/2	.091	.000	.014	DS20-D3332LX38-04	1.500	6.552	9.336	5.402	.039	81°	145	2.813	11000
			6.560	1 1/2	.091	.000	.014	DS20-D3332LX38-05	1.500	7.864	10.648	6.714	.039	81°	145	3.055	7000
			7.872	1 1/2	.091	-.004	.016	DS20-D3332LX38-06	1.500	9.176	11.960	8.026	.039	81°	145	3.300	5000
			9.184	1 1/2	.091	-.004	.016	DS20-D3332LX38-07	1.500	10.488	13.272	9.338	.039	81°	145	3.542	3000
1.375	05C	05P	5.500	1 1/2	.076	.000	.014	DS20-D3493LX38-04	1.500	6.799	9.583	5.654	.039	81°	145	2.960	10000
			6.875	1 1/2	.076	.000	.014	DS20-D3493LX38-05	1.500	8.174	10.958	7.029	.039	81°	145	3.240	6000
			8.250	1 1/2	.076	-.004	.016	DS20-D3493LX38-06	1.500	9.549	12.333	8.404	.039	81°	145	3.518	4000
			9.625	1 1/2	.076	-.004	.016	DS20-D3493LX38-07	1.500	10.924	13.708	9.779	.039	81°	145	4.409	3000
1.437	05C	05P	5.748	1 1/2	.061	.000	.014	DS20-D3650LX38-04	1.500	7.042	9.826	5.902	.039	81°	145	3.527	10000
			7.185	1 1/2	.061	.000	.014	DS20-D3650LX38-05	1.500	8.479	11.263	7.339	.039	81°	145	3.437	6000
			8.622	1 1/2	.061	-.004	.016	DS20-D3650LX38-06	1.500	9.916	12.700	8.776	.039	81°	145	3.756	4000
			10.059	1 1/2	.061	-.004	.016	DS20-D3650LX38-07	1.500	11.353	14.137	10.213	.039	81°	145	4.076	3000
1.500	05C	05P	6.000	1 1/2	.046	.000	.014	DS20-D3810LX38-04	1.500	7.289	10.073	6.154	.039	81°	145	3.527	9000
			7.500	1 1/2	.046	.000	.014	DS20-D3810LX38-05	1.500	8.789	11.573	7.654	.039	81°	145	3.747	6000
			9.000	1 1/2	.046	-.004	.016	DS20-D3810LX38-06	1.500	10.289	13.073	9.154	.039	81°	145	4.629	4000
			10.500	1 1/2	.046	-.004	.016	DS20-D3810LX38-07	1.500	11.789	14.573	10.654	.039	81°	145	5.291	3000
1.562	05C	05P	6.248	1 1/2	.031	.000	.014	DS20-D3967LX38-04	1.500	7.533	10.317	6.402	.039	81°	145	3.481	9000
			7.810	1 1/2	.031	.000	.014	DS20-D3967LX38-05	1.500	9.095	11.879	7.964	.039	81°	145	3.891	6000
			9.372	1 1/2	.031	-.004	.016	DS20-D3967LX38-06	1.500	10.657	13.441	9.526	.039	81°	145	4.301	4000
			10.934	1 1/2	.031	-.004	.016	DS20-D3967LX38-07	1.500	12.219	15.003	11.088	.039	81°	145	4.711	3000

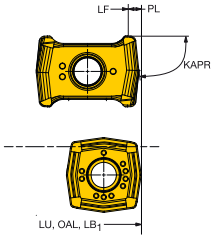
E12 C1 H2 H7

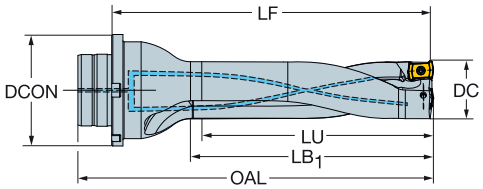
ENG

CoroDrill® DS20 indexable insert drill

Modular drill interface

Internal coolant supply





Metric design

DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
									Dimensions, mm								
15.00	01C	01P	60.00	MDI-20	1.00	0.00	0.27	DS20-D1500DM20-04	20.00	88.69	104.00	63.00	0.46	81°	10	0.174	24000
			105.00	MDI-20	1.00	-0.10	0.40	DS20-D1500DM20-07	20.00	133.69	149.00	108.00	0.46	81°	10	0.204	8000
15.87	01C	01P	63.50	MDI-20	0.78	0.00	0.27	DS20-D1588DM20-04	20.00	91.91	107.22	66.31	0.46	81°	10	0.181	22000
			111.12	MDI-20	0.78	-0.10	0.40	DS20-D1588DM20-07	20.00	139.54	154.85	113.94	0.46	81°	10	0.217	7000
16.00	01C	01P	64.00	MDI-20	0.75	0.00	0.27	DS20-D1600DM20-04	20.00	92.69	108.00	67.00	0.46	81°	10	0.183	22000
			112.00	MDI-20	0.75	-0.10	0.40	DS20-D1600DM20-07	20.00	140.69	156.00	115.00	0.46	81°	10	0.219	7000
16.66	01C	01P	66.64	MDI-20	0.59	0.00	0.27	DS20-D1666DM20-04	20.00	95.01	110.32	69.46	0.46	81°	10	0.188	21000
			116.63	MDI-20	0.59	-0.10	0.40	DS20-D1666DM20-07	20.00	145.00	160.31	119.45	0.46	81°	10	0.230	7000
17.00	01C	01P	68.00	MDI-20	0.50	0.00	0.27	DS20-D1700DM20-04	20.00	96.69	112.00	71.00	0.46	81°	10	0.193	21000
			119.00	MDI-20	0.50	-0.10	0.40	DS20-D1700DM20-07	20.00	147.69	163.00	122.00	0.46	81°	10	0.236	7000
17.44	01C	01P	69.79	MDI-25	0.39	0.00	0.27	DS20-D1745DM25-04	25.00	101.92	117.23	72.61	0.46	81°	10	0.292	21000
			122.14	MDI-25	0.39	-0.10	0.40	DS20-D1745DM25-07	25.00	154.27	169.58	124.96	0.46	81°	10	0.340	7000
18.00	01C	01P	72.00	MDI-25	0.25	0.00	0.27	DS20-D1800DM25-04	25.00	104.69	120.00	75.00	0.46	81°	10	0.300	20000
			126.00	MDI-25	0.25	-0.10	0.40	DS20-D1800DM25-07	25.00	158.69	174.00	129.00	0.46	81°	10	0.353	6000
19.00	02C	02P	76.00	MDI-25	1.06	0.00	0.33	DS20-D1900DM25-04	25.00	108.62	124.00	79.00	0.55	81°	10	0.313	19000
			133.00	MDI-25	1.06	-0.10	0.40	DS20-D1900DM25-07	25.00	165.62	181.00	136.00	0.55	81°	10	0.374	6000
19.05	02C	02P	76.20	MDI-25	1.05	0.00	0.33	DS20-D1905DM25-04	25.00	108.33	123.71	79.22	0.55	81°	10	0.311	19000
			133.35	MDI-25	1.05	-0.10	0.40	DS20-D1905DM25-07	25.00	165.48	180.86	136.37	0.55	81°	10	0.373	6000
20.00	02C	02P	80.00	MDI-25	0.82	0.00	0.33	DS20-D2000DM25-04	25.00	112.62	128.00	83.00	0.55	81°	10	0.327	18000
			140.00	MDI-25	0.82	-0.10	0.40	DS20-D2000DM25-07	25.00	172.62	188.00	143.00	0.55	81°	10	0.398	6000
20.62	02C	02P	82.49	MDI-25	0.67	0.00	0.33	DS20-D2062DM25-04	25.00	114.50	129.88	85.52	0.55	81°	10	0.333	17000
			144.37	MDI-25	0.67	-0.10	0.40	DS20-D2062DM25-07	25.00	176.38	191.75	147.39	0.55	81°	10	0.412	6000
21.00	02C	02P	84.00	MDI-25	0.58	0.00	0.33	DS20-D2100DM25-04	25.00	116.62	132.00	87.00	0.55	81°	10	0.342	17000
			147.00	MDI-25	0.58	-0.10	0.40	DS20-D2100DM25-07	25.00	179.62	195.00	150.00	0.55	81°	10	0.425	5000
22.00	02C	02P	88.00	MDI-25	0.34	0.00	0.33	DS20-D2200DM25-04	25.00	120.62	136.00	91.00	0.55	81°	10	0.359	16000
			154.00	MDI-25	0.34	-0.10	0.40	DS20-D2200DM25-07	25.00	186.62	202.00	157.00	0.55	81°	10	0.454	5000
22.22	03C	03P	88.90	MDI-25	1.45	0.00	0.33	DS20-D2223DM25-04	25.00	120.87	136.33	92.10	0.66	81°	10	0.360	16000
			155.57	MDI-25	1.45	-0.10	0.40	DS20-D2223DM25-07	25.00	187.54	203.01	158.77	0.66	81°	10	0.458	5000
23.00	03C	03P	92.00	MDI-25	1.30	0.00	0.33	DS20-D2300DM25-04	25.00	125.53	141.00	96.00	0.66	81°	10	0.379	15000
			161.00	MDI-25	1.30	-0.10	0.40	DS20-D2300DM25-07	25.00	194.53	210.00	165.00	0.66	81°	10	0.488	5000
23.79	03C	03P	95.19	MDI-25	1.14	0.00	0.33	DS20-D2380DM25-04	25.00	127.04	142.50	98.39	0.66	81°	10	0.390	15000
			166.59	MDI-25	1.14	-0.10	0.40	DS20-D2380DM25-07	25.00	198.44	213.90	169.79	0.66	81°	10	0.510	5000
24.00	03C	03P	96.00	MDI-25	1.10	0.00	0.33	DS20-D2400DM25-04	25.00	129.53	145.00	100.00	0.66	81°	10	0.400	15000
			168.00	MDI-25	1.10	-0.10	0.40	DS20-D2400DM25-07	25.00	201.53	217.00	172.00	0.66	81°	10	0.523	5000
25.00	03C	03P	100.00	MDI-25	0.90	0.00	0.33	DS20-D2500DM25-04	25.00	133.53	149.00	104.00	0.66	81°	10	0.422	14000
			175.00	MDI-25	0.90	-0.10	0.40	DS20-D2500DM25-07	25.00	208.53	224.00	179.00	0.66	81°	10	0.561	4000
25.40	03C	03P	101.60	MDI-25	0.82	0.00	0.33	DS20-D2540DM25-04	25.00	133.31	148.78	104.80	0.66	81°	10	0.425	14000
			177.80	MDI-25	0.82	-0.10	0.40	DS20-D2540DM25-07	25.00	209.51	224.98	181.00	0.66	81°	10	0.571	4000
26.00	03C	03P	104.00	MDI-32	0.70	0.00	0.33	DS20-D2600DM32-04	32.00	142.53	158.00	108.00	0.66	81°	10	0.651	14000
			182.00	MDI-32	0.70	-0.10	0.40	DS20-D2600DM32-07	32.00	220.53	236.00	186.00	0.66	81°	10	0.808	4000
26.97	03C	03P	107.89	MDI-32	0.51	0.00	0.33	DS20-D2697DM32-04	32.00	145.51	160.97	111.09	0.66	81°	10	0.674	13000
			188.82	MDI-32	0.51	-0.10	0.40	DS20-D2697DM32-07	32.00	226.43	241.89	192.02	0.66	81°	10	0.849	4000
27.00	03C	03P	108.00	MDI-32	0.50	0.00	0.33	DS20-D2700DM32-04	32.00	146.53	162.00	112.00	0.66	81°	10	0.677	13000
			189.00	MDI-32	0.50	-0.10	0.40	DS20-D2700DM32-07	32.00	227.53	243.00	193.00	0.66	81°	10	0.853	4000
33.32	05C	05P	133.29	MDI-40	2.32	0.00	0.35	DS20-D3332DM40-04	40.00	179.95	195.67	137.21	1.00	81°	10	1.303	11000
			233.27	MDI-40	2.32	-0.10	0.40	DS20-D3332DM40-07	40.00	279.92	295.64	237.18	1.00	81°	10	1.634	3000


E12


C1

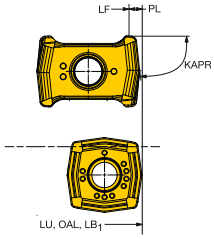
H2

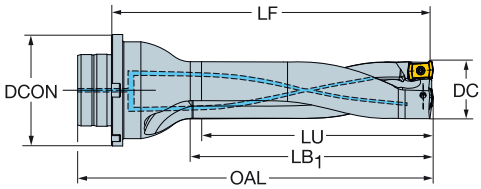
H7

CoroDrill® DS20 indexable insert drill

Modular drill interface

Internal coolant supply





Metric design

DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
									Dimensions, mm								
34.00	05C	05P	136.00	MDI-40	2.16	0.00	0.35	DS20-D3400DM40-04	40.00	183.28	199.00	140.00	1.00	81°	10	1.340	11000
			238.00	MDI-40	2.16	-0.10	0.40	DS20-D3400DM40-07	40.00	285.28	301.00	242.00	1.00	81°	10	1.691	3000
34.92	05C	05P	139.70	MDI-40	1.94	0.00	0.35	DS20-D3493DM40-04	40.00	186.22	201.94	143.61	1.00	81°	10	1.370	10000
			244.47	MDI-40	1.94	-0.10	0.40	DS20-D3493DM40-07	40.00	291.00	306.71	248.38	1.00	81°	10	1.750	3000
35.00	05C	05P	140.00	MDI-40	1.92	0.00	0.35	DS20-D3500DM40-04	40.00	187.28	203.00	144.00	1.00	81°	10	1.383	10000
			245.00	MDI-40	1.92	-0.10	0.40	DS20-D3500DM40-07	40.00	292.28	308.00	249.00	1.00	81°	10	1.766	3000
36.00	05C	05P	144.00	MDI-40	1.68	0.00	0.35	DS20-D3600DM40-04	40.00	191.28	207.00	148.00	1.00	81°	10	1.429	10000
			252.00	MDI-40	1.68	-0.10	0.40	DS20-D3600DM40-07	40.00	299.28	315.00	256.00	1.00	81°	10	1.846	3000
36.49	05C	05P	145.99	MDI-40	1.56	0.00	0.35	DS20-D3650DM40-04	40.00	192.42	208.14	149.91	1.00	81°	10	1.441	10000
			255.49	MDI-40	1.56	-0.10	0.40	DS20-D3650DM40-07	40.00	301.92	317.64	259.41	1.00	81°	10	1.876	3000
37.00	05C	05P	148.00	MDI-40	1.44	0.00	0.35	DS20-D3700DM40-04	40.00	195.28	211.00	152.00	1.00	81°	10	1.477	10000
			259.00	MDI-40	1.44	-0.10	0.40	DS20-D3700DM40-07	40.00	306.28	322.00	263.00	1.00	81°	10	1.930	3000
38.00	05C	05P	152.00	MDI-40	1.20	0.00	0.35	DS20-D3800DM40-04	40.00	199.28	215.00	156.00	1.00	81°	10	1.529	9000
			266.00	MDI-40	1.20	-0.10	0.40	DS20-D3800DM40-07	40.00	313.28	329.00	270.00	1.00	81°	10	2.019	3000
38.10	05C	05P	152.40	MDI-40	1.18	0.00	0.35	DS20-D3810DM40-04	40.00	198.69	214.41	156.31	1.00	81°	10	1.520	9000
			266.70	MDI-40	1.18	-0.10	0.40	DS20-D3810DM40-07	40.00	312.99	328.71	270.61	1.00	81°	10	2.015	3000
39.00	05C	05P	156.00	MDI-40	0.96	0.00	0.35	DS20-D3900DM40-04	40.00	203.28	219.00	160.00	1.00	81°	10	1.582	9000
			273.00	MDI-40	0.96	-0.10	0.40	DS20-D3900DM40-07	40.00	320.28	336.00	277.00	1.00	81°	10	2.113	3000
39.67	05C	05P	158.69	MDI-40	0.80	0.00	0.35	DS20-D3967DM40-04	40.00	204.87	220.58	162.61	1.00	81°	10	1.605	9000
			277.72	MDI-40	0.80	-0.10	0.40	DS20-D3967DM40-07	40.00	323.89	339.61	281.63	1.00	81°	10	2.163	3000
40.00	05C	05P	160.00	MDI-40	0.72	0.00	0.35	DS20-D4000DM40-04	40.00	206.28	222.00	164.00	1.00	81°	10	1.624	9000
			280.00	MDI-40	0.72	-0.10	0.40	DS20-D4000DM40-07	40.00	326.28	342.00	284.00	1.00	81°	10	2.196	3000

		Spare parts
DC	DC"	Insert screw
15.00-18.00	.590-.708	5513 020-27
19.00-22.00	.748-.866	5513 020-88
22.00-27.00	.875-1.062	5513 020-58
33.00-40.00	1.312-1.574	416.1-833

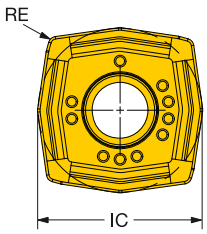
For complete list of spare parts, see www.sandvik.coromant.com

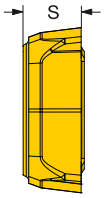
E12 C1 H2 H7

ENG

CoroDrill® DS20 insert for drilling

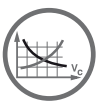
Central insert





			P	M	K	N		S		H	Dimensions, mm, inch		
	INSUC	Ordering code	1344	1144	1344	H13A	1344	1344	H13A	1344	S	RE	IC
01C	C	DS20-0104-C-L5	★	★		★	☆	★	☆	★	2.30	0.35	6.0
											.091	.014	.237
01C	C	DS20-0104-C-M7	★		★					☆	2.30	0.35	6.0
											.091	.014	.237
02C	C	DS20-0205-C-L5	★	★		★	☆	★	☆	★	2.60	0.35	7.3
											.102	.014	.289
02C	C	DS20-0205-C-M7	★		★					☆	2.60	0.35	7.3
											.102	.014	.289
03C	C	DS20-0306-C-L5	★	★		★	☆	★	☆	★	3.00	0.35	8.9
											.118	.014	.350
03C	C	DS20-0306-C-M7	★		★					☆	3.00	0.35	8.9
											.118	.014	.350
05C	C	DS20-0508-C-L5	★	★		★	☆	★	☆	★	3.50	0.35	13.4
											.138	.014	.526
05C	C	DS20-0508-C-M7	★		★					☆	3.50	0.35	13.4
											.138	.014	.526

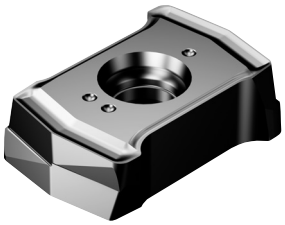

E2


E14

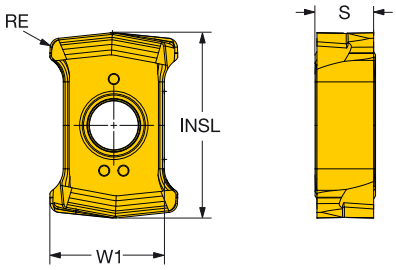
H2

CoroDrill® DS20 insert for drilling

Peripheral insert



DS20..P-L5W



			P			M			K			N		S			H		Dimensions, mm, inch			
	INSUC	Ordering code	4324	4334	4344	2044	4334	4344	4324	4334	4344	4344	H13A	2044	4344	H13A	4334	4344	S	RE	W1	INSL
01P	P	DS20-0104-P-H5W		★	☆	★	☆	☆											2.73	0.40	5.0	8.5
																			.107	.016	.197	.335
01P	P	DS20-0104-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				2.73	0.40	5.0	8.5
																			.107	.016	.197	.335
01P	P	DS20-0104-P-L6W			★			★			★	★			★			★	2.73	0.40	5.0	8.5
																			.107	.016	.197	.335
01P	P	DS20-0104-P-M7W	☆	★	☆				☆	★	☆						☆	★	2.73	0.40	5.0	8.5
																			.107	.016	.197	.335
01P	P	DS20-0104-P-S5W						★				☆	★		★	☆			2.73	0.40	5.0	8.5
																			.107	.016	.197	.335
02P	P	DS20-0205-P-H5W		★	☆	★	☆	☆											3.10	0.50	6.1	9.8
																			.122	.020	.240	.386
02P	P	DS20-0205-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				3.10	0.50	6.1	9.8
																			.122	.020	.240	.386
02P	P	DS20-0205-P-L6W			★			★			★	★			★			★	3.10	0.50	6.1	9.8
																			.122	.020	.240	.386
02P	P	DS20-0205-P-M7W	☆	★	☆				☆	★	☆						☆	★	3.10	0.50	6.1	9.8
																			.122	.020	.240	.386
02P	P	DS20-0205-P-S5W						★				☆	★		★	☆			3.10	0.50	6.1	9.8
																			.122	.020	.240	.386
03P	P	DS20-0306-P-H5W		★	☆	★	☆	☆											3.53	0.60	7.3	11.3
																			.139	.024	.289	.445
03P	P	DS20-0306-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				3.53	0.60	7.3	11.3
																			.139	.024	.289	.445
03P	P	DS20-0306-P-L6W			★			★			★	★			★			★	3.53	0.60	7.3	11.3
																			.139	.024	.289	.445
03P	P	DS20-0306-P-M7W	☆	★	☆				☆	★	☆						☆	★	3.53	0.60	7.3	11.3
																			.139	.024	.289	.445
03P	P	DS20-0306-P-S5W						★				☆	★		★	☆			3.53	0.60	7.3	11.3
																			.139	.024	.289	.445
05P	P	DS20-0508-P-H5W		★	☆	★	☆	☆											4.75	0.80	11.2	15.2
																			.187	.031	.443	.598
05P	P	DS20-0508-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				4.75	0.80	11.2	15.2
																			.187	.031	.443	.598
05P	P	DS20-0508-P-L6W			★			★			★	★			★			★	4.75	0.80	11.2	15.2
																			.187	.031	.443	.598
05P	P	DS20-0508-P-M7W	☆	★	☆				☆	★	☆						☆	★	4.75	0.80	11.2	15.2
																			.187	.031	.443	.598
05P	P	DS20-0508-P-S5W						★				☆	★		★	☆			4.75	0.80	11.2	15.2
																			.187	.031	.443	.598

E2 E14 H2

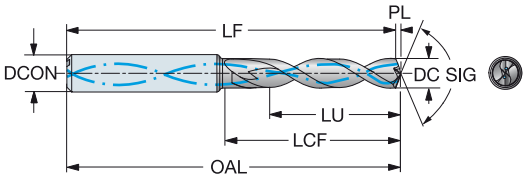
ENG

CoroDrill® 860 solid carbide drill

For nickel-based alloys and titanium-based alloys

Internal coolant supply

TCHA H9
SIG 140°



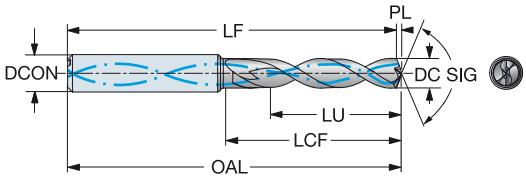
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
							1210	Dimensions, mm, inch												
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-SM	★	6.0	.236	62	2.441	61.5	2.419	20	.787	0.6	.022	20	290	DIN 6537 K
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-SM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.6	.022	20	290	DIN 6537 L
3.10	.122	9.9	.390	3	6	860.1-0310-009A1-SM	★	6.0	.236	62	2.441	61.4	2.419	20	.787	0.6	.022	20	290	DIN 6537 K
3.17	.125	16.4	.646	5	6	860.1-0317-016A1-SM	★	6.0	.236	66	2.598	65.4	2.576	28	1.102	0.6	.023	20	290	DIN 6537 L
3.18	.125	10.1	.398	3	6	860.1-0318-010A1-SM	★	6.0	.236	62	2.441	61.4	2.418	20	.787	0.6	.023	20	290	DIN 6537 K
3.20	.126	10.2	.402	3	6	860.1-0320-010A1-SM	★	6.0	.236	62	2.441	61.4	2.418	20	.787	0.6	.023	20	290	DIN 6537 K
3.20	.126	16.6	.654	5	6	860.1-0320-016A1-SM	★	6.0	.236	66	2.598	65.4	2.576	28	1.102	0.6	.023	20	290	DIN 6537 L
3.30	.130	10.5	.413	3	6	860.1-0330-010A1-SM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.30	.130	17.1	.673	5	6	860.1-0330-017A1-SM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.40	.134	10.8	.425	3	6	860.1-0340-010A1-SM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-SM	★	6.0	.236	62	2.441	61.4	2.416	20	.787	0.6	.025	20	290	DIN 6537 K
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-SM	★	6.0	.236	66	2.598	65.4	2.573	28	1.102	0.6	.025	20	290	DIN 6537 L
3.57	.141	11.4	.449	3	6	860.1-0357-011A1-SM	★	6.0	.236	62	2.441	61.4	2.415	20	.787	0.7	.026	20	290	DIN 6537 K
3.60	.142	11.5	.453	3	6	860.1-0360-011A1-SM	★	6.0	.236	62	2.441	61.3	2.415	20	.787	0.7	.026	20	290	DIN 6537 K
3.70	.146	11.8	.465	3	6	860.1-0370-011A1-SM	★	6.0	.236	62	2.441	61.3	2.415	20	.787	0.7	.026	20	290	DIN 6537 K
3.70	.146	19.2	.756	5	6	860.1-0370-019A1-SM	★	6.0	.236	66	2.598	65.3	2.572	28	1.102	0.7	.026	20	290	DIN 6537 L
3.80	.150	11.7	.461	3	6	860.1-0380-011A1-SM	★	6.0	.236	66	2.598	65.3	2.571	20	.787	0.7	.027	20	290	DIN 6537 K
3.90	.154	11.6	.457	2	6	860.1-0390-011A1-SM	★	6.0	.236	66	2.598	65.3	2.570	20	.787	0.7	.028	20	290	DIN 6537 K
3.90	.154	19.6	.772	5	6	860.1-0390-019A1-SM	★	6.0	.236	74	2.913	73.3	2.885	28	1.102	0.7	.028	20	290	DIN 6537 L
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-SM	★	6.0	.236	66	2.598	65.3	2.570	24	.945	0.7	.029	20	290	DIN 6537 K
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-SM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.029	20	290	DIN 6537 L
4.10	.161	13.0	.512	3	6	860.1-0410-013A1-SM	★	6.0	.236	62	2.441	65.3	2.569	24	.945	0.8	.030	20	290	DIN 6537 K
4.15	.163	21.5	.846	5	6	860.1-0415-021A1-SM	★	6.0	.236	74	2.913	73.2	2.883	36	1.417	0.8	.030	20	290	DIN 6537 L
4.20	.165	13.4	.528	3	6	860.1-0420-013A1-SM	★	6.0	.236	66	2.598	65.2	2.569	24	.945	0.8	.030	20	290	DIN 6537 K
4.20	.165	21.8	.858	5	6	860.1-0420-021A1-SM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.8	.030	20	290	DIN 6537 L
4.30	.169	13.7	.539	3	6	860.1-0430-013A1-SM	★	6.0	.236	66	2.598	65.2	2.568	24	.945	0.8	.031	20	290	DIN 6537 K
4.37	.172	13.9	.547	3	6	860.1-0437-013A1-SM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031	20	290	DIN 6537 K
4.40	.173	22.8	.898	5	6	860.1-0440-022A1-SM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.50	.177	14.3	.563	3	6	860.1-0450-014A1-SM	★	6.0	.236	66	2.598	65.2	2.566	24	.945	0.8	.032	20	290	DIN 6537 K
4.50	.177	23.3	.917	5	6	860.1-0450-023A1-SM	★	6.0	.236	74	2.913	73.2	2.881	36	1.417	0.8	.032	20	290	DIN 6537 L
4.60	.181	14.6	.575	3	6	860.1-0460-014A1-SM	★	6.0	.236	66	2.598	65.2	2.565	24	.945	0.8	.033	20	290	DIN 6537 K
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-SM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.033	20	290	DIN 6537 L
4.70	.185	15.0	.591	3	6	860.1-0470-014A1-SM	★	6.0	.236	66	2.598	65.1	2.565	24	.945	0.9	.034	20	290	DIN 6537 K
4.70	.185	24.4	.961	5	6	860.1-0470-024A1-SM	★	6.0	.236	74	2.913	73.1	2.880	36	1.417	0.9	.034	20	290	DIN 6537 L
4.76	.187	13.6	.535	2	6	860.1-0476-013A1-SM	★	6.0	.236	66	2.598	65.1	2.564	24	.945	0.9	.034	20	290	DIN 6537 K
4.76	.187	24.7	.972	5	6	860.1-0476-024A1-SM	★	6.0	.236	82	3.228	81.1	3.194	36	1.417	0.9	.034	20	290	DIN 6537 L
4.80	.189	15.3	.602	3	6	860.1-0480-015A1-SM	★	6.0	.236	66	2.598	65.1	2.564	28	1.102	0.9	.034	20	290	DIN 6537 K
4.80	.189	24.9	.980	5	6	860.1-0480-024A1-SM	★	6.0	.236	82	3.228	81.2	3.197	36	1.417	0.9	.034	20	290	DIN 6537 L
4.90	.193	15.6	.614	3	6	860.1-0490-015A1-SM	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K
4.90	.193	25.4	1.000	5	6	860.1-0490-025A1-SM	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
5.00	.197	15.9	.626	3	6	860.1-0500-015A1-SM	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.036	20	290	DIN 6537 K
5.00	.197	25.9	1.020	5	6	860.1-0500-025A1-SM	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.9	.036	20	290	DIN 6537 L
5.10	.201	16.2	.638	3	6	860.1-0510-016A1-SM	★	6.0	.236	66	2.598	65.1	2.562	28	1.102	0.9	.037	20	290	DIN 6537 K
5.10	.201	26.4	1.039	5	6	860.1-0510-026A1-SM	★	6.0	.236	82	3.228	81.1	3.192	44	1.732	0.9	.037	20	290	DIN 6537 L
5.16	.203	16.4	.646	3	6	860.1-0516-016A1-SM	★	6.0	.236	66	2.598	65.1	2.561	28	1.102	0.9	.037	20	290	DIN 6537 K
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-SM	★	6.0	.236	66	2.598	65.1	2.561	28	1.102	1.0	.037	20	290	DIN 6537 K
5.25	.207	16.7	.657	3	6	860.1-0525-016A1-SM	★	6.0	.236	66	2.598	65.0	2.561	28	1.102	1.0	.038	20	290	DIN 6537 K
5.30	.209	16.9	.665	3	6	860.1-0530-016A1-SM	★	6.0	.236	66	2.598	65.0	2.561	28	1.102	1.0	.038	20	290	DIN 6537 K
5.30	.209	27.5	1.083	5	6	860.1-0530-027A1-SM	★	6.0	.236	82	3.228	81.0	3.191	44	1.732	1.0	.038	20	290	DIN 6537 L
5.40	.213	17.2	.677	3	6	860.1-0540-017A1-SM	★	6.0	.236	66	2.598	65.0	2.560	28	1.102	1.0	.039	20	290	DIN 6537 K
5.50	.217	17.5	.689	3	6	860.1-0550-017A1-SM	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039	20	290	DIN 6537 K
5.50	.217	28.5	1.122	5	6	860.1-0550-028A1-SM	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039	20	290	DIN 6537 L

CoroDrill® 860 solid carbide drill

For nickel-based alloys and titanium-based alloys

Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S 1210	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
5.55	.219	17.6	.693	3	6	860.1-0555-017A1-SM	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.040	20	290	DIN 6537 K
5.56	.219	17.6	.693	3	6	860.1-0556-017A1-SM	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.040	20	290	DIN 6537 K
5.56	.219	28.8	1.134	5	6	860.1-0556-028A1-SM	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.040	20	290	DIN 6537 L
5.60	.220	17.6	.693	3	6	860.1-0560-017A1-SM	★	6.0	.236	66	2.598	65.0	2.558	28	1.102	1.0	.040	20	290	DIN 6537 K
5.60	.220	29.0	1.142	5	6	860.1-0560-029A1-SM	★	6.0	.236	82	3.228	81.0	3.188	44	1.732	1.0	.040	20	290	DIN 6537 L
5.70	.224	17.6	.693	3	6	860.1-0570-017A1-SM	★	6.0	.236	66	2.598	65.0	2.557	28	1.102	1.0	.041	20	290	DIN 6537 K
5.70	.224	29.5	1.161	5	6	860.1-0570-029A1-SM	★	6.0	.236	82	3.228	81.0	3.187	44	1.732	1.0	.041	20	290	DIN 6537 L
5.80	.228	17.7	.697	3	6	860.1-0580-017A1-SM	★	6.0	.236	66	2.598	64.9	2.557	28	1.102	1.1	.042	20	290	DIN 6537 K
5.80	.228	30.1	1.185	5	6	860.1-0580-030A1-SM	★	6.0	.236	82	3.228	80.9	3.187	60	2.362	1.1	.042	20	290	DIN 6537 L
5.95	.234	17.7	.697	2	6	860.1-0595-017A1-SM	★	6.0	.236	66	2.598	64.9	2.556	28	1.102	1.1	.043	20	290	DIN 6537 K
6.00	.236	19.1	.752	3	6	860.1-0600-019A1-SM	★	6.0	.236	66	2.598	64.9	2.556	34	1.339	1.1	.043	20	290	DIN 6537 K
6.00	.236	31.1	1.224	5	6	860.1-0600-031A1-SM	★	6.0	.236	82	3.228	80.9	3.185	44	1.732	1.1	.043	20	290	DIN 6537 L
6.10	.240	19.4	.764	3	8	860.1-0610-019A1-SM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.044	20	290	DIN 6537 K
6.10	.240	31.6	1.244	5	8	860.1-0610-031A1-SM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.1	.044	20	290	DIN 6537 L
6.20	.244	19.7	.776	3	8	860.1-0620-019A1-SM	★	8.0	.315	79	3.110	77.9	3.066	34	1.339	1.1	.044	20	290	DIN 6537 K
6.20	.244	32.1	1.264	5	8	860.1-0620-032A1-SM	★	8.0	.315	91	3.583	89.9	3.538	53	2.087	1.1	.044	20	290	DIN 6537 L
6.35	.250	20.2	.795	3	8	860.1-0635-020A1-SM	★	8.0	.315	79	3.110	77.8	3.065	34	1.339	1.2	.046	20	290	DIN 6537 K
6.35	.250	32.9	1.295	5	8	860.1-0635-032A1-SM	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.2	.046	20	290	DIN 6537 L
6.40	.252	20.4	.803	3	8	860.1-0640-020A1-SM	★	8.0	.315	79	3.110	77.8	3.065	34	1.339	1.2	.046	20	290	DIN 6537 K
6.40	.252	33.2	1.307	5	8	860.1-0640-033A1-SM	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.2	.046	20	290	DIN 6537 L
6.50	.256	20.7	.815	3	8	860.1-0650-020A1-SM	★	8.0	.315	79	3.110	77.8	3.064	34	1.339	1.2	.046	20	290	DIN 6537 K
6.50	.256	33.7	1.327	5	8	860.1-0650-033A1-SM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.2	.046	20	290	DIN 6537 L
6.60	.260	21.0	.827	3	8	860.1-0660-021A1-SM	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.047	20	290	DIN 6537 K
6.60	.260	34.2	1.346	5	8	860.1-0660-034A1-SM	★	8.0	.315	91	3.583	89.8	3.535	44	1.732	1.2	.047	20	290	DIN 6537 L
6.70	.264	21.3	.839	3	8	860.1-0670-021A1-SM	★	8.0	.315	79	3.110	77.8	3.062	34	1.339	1.2	.048	20	290	DIN 6537 K
6.70	.264	34.7	1.366	5	8	860.1-0670-034A1-SM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.048	20	290	DIN 6537 L
6.80	.268	21.6	.850	3	8	860.1-0680-021A1-SM	★	8.0	.315	79	3.110	77.8	3.061	34	1.339	1.2	.049	20	290	DIN 6537 K
6.80	.268	35.2	1.386	5	8	860.1-0680-035A1-SM	★	8.0	.315	91	3.583	89.8	3.534	53	2.087	1.2	.049	20	290	DIN 6537 L
6.90	.272	21.6	.850	3	8	860.1-0690-021A1-SM	★	8.0	.315	79	3.110	77.7	3.061	34	1.339	1.3	.050	20	290	DIN 6537 K
6.90	.272	35.8	1.409	5	8	860.1-0690-035A1-SM	★	8.0	.315	91	3.583	89.7	3.533	53	2.087	1.3	.050	20	290	DIN 6537 L
7.00	.276	21.6	.850	3	8	860.1-0700-021A1-SM	★	8.0	.315	79	3.110	77.7	3.060	34	1.339	1.3	.050	20	290	DIN 6537 K
7.00	.276	36.3	1.429	5	8	860.1-0700-036A1-SM	★	8.0	.315	91	3.583	89.7	3.533	53	2.087	1.3	.050	20	290	DIN 6537 L
7.10	.280	22.6	.890	3	8	860.1-0710-022A1-SM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
7.10	.280	36.8	1.449	5	8	860.1-0710-036A1-SM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
7.14	.281	22.7	.894	3	8	860.1-0714-022A1-SM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
7.14	.281	37.0	1.457	5	8	860.1-0714-036A1-SM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
7.20	.283	22.9	.902	3	8	860.1-0720-022A1-SM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.052	20	290	DIN 6537 K
7.20	.283	37.3	1.469	5	8	860.1-0720-037A1-SM	★	8.0	.315	91	3.583	89.7	3.531	53	2.087	1.3	.052	20	290	DIN 6537 L
7.30	.287	23.2	.913	3	8	860.1-0730-023A1-SM	★	8.0	.315	79	3.110	77.7	3.058	41	1.614	1.3	.052	20	290	DIN 6537 K
7.30	.287	37.8	1.488	5	8	860.1-0730-037A1-SM	★	8.0	.315	91	3.583	89.7	3.530	53	2.087	1.3	.052	20	290	DIN 6537 L
7.40	.291	23.5	.925	3	8	860.1-0740-023A1-SM	★	8.0	.315	79	3.110	77.7	3.057	41	1.614	1.4	.053	20	290	DIN 6537 K
7.40	.291	38.3	1.508	5	8	860.1-0740-038A1-SM	★	8.0	.315	91	3.583	89.7	3.530	53	2.087	1.4	.053	20	290	DIN 6537 L
7.50	.295	23.9	.941	3	8	860.1-0750-023A1-SM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.054	20	290	DIN 6537 K
7.50	.295	38.9	1.532	5	8	860.1-0750-038A1-SM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.4	.054	20	290	DIN 6537 L
7.70	.303	24.5	.965	3	8	860.1-0770-024A1-SM	★	8.0	.315	89	3.504	77.6	3.055	41	1.614	1.4	.055	20	290	DIN 6537 K
7.80	.307	24.8	.976	3	8	860.1-0780-024A1-SM	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.056	20	290	DIN 6537 K
7.94	.313	25.3	.996	3	8	860.1-0794-025A1-SM	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.057	20	290	DIN 6537 K
8.00	.315	25.5	1.004	3	8	860.1-0800-025A1-SM	★	8.0	.315	79	3.110	77.5	3.053	41	1.614	1.5	.057	20	290	DIN 6537 K
8.00	.315	40.9	1.610	5	8	860.1-0800-040A1-SM	★	8.0	.315	79	3.110	89.6	3.528	53	2.087	1.5	.057	20	290	DIN 6537 L
8.10	.319	25.8	1.016	3	10	860.1-0810-025A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.5	.058	20	290	DIN 6537 K
8.10	.319	42.0	1.654	5	10	860.1-0810-041A1-SM	★	10.0	.394	103	4.055	101.5	3.997	61	2.402	1.5	.058	20	290	DIN 6537 L

E46 H2 H7 H6

SANDVIK Coromant

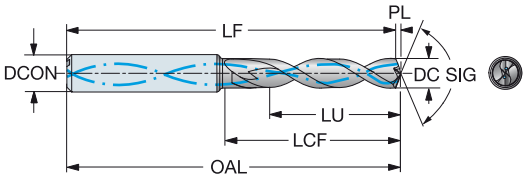
ENG

CoroDrill® 860 solid carbide drill

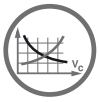
For nickel-based alloys and titanium-based alloys

Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S	1210	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
							Dimensions, mm, inch														
8.20	.323	26.1	1.028	3	10	860.1-0820-026A1-SM	★		10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
8.30	.327	26.4	1.039	3	10	860.1-0830-026A1-SM	★		10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.059	20	290	DIN 6537 K
8.33	.328	26.5	1.043	3	10	860.1-0833-026A1-SM	★		10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.060	20	290	DIN 6537 K
8.40	.331	26.7	1.051	3	10	860.1-0840-026A1-SM	★		10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.060	20	290	DIN 6537 K
8.40	.331	43.5	1.713	5	10	860.1-0840-043A1-SM	★		10.0	.394	103	4.055	101.5	3.995	61	2.402	1.5	.060	20	290	DIN 6537 L
8.45	.333	26.9	1.059	3	10	860.1-0845-026A1-SM	★		10.0	.394	89	3.504	87.5	3.443	47	1.850	1.5	.061	20	290	DIN 6537 K
8.50	.335	27.0	1.063	3	10	860.1-0850-027A1-SM	★		10.0	.394	89	3.504	87.5	3.443	47	1.850	1.6	.061	20	290	DIN 6537 K
8.50	.335	44.0	1.732	5	10	860.1-0850-044A1-SM	★		10.0	.394	103	4.055	101.5	3.994	53	2.087	1.6	.061	20	290	DIN 6537 L
8.60	.339	27.4	1.079	3	10	860.1-0860-027A1-SM	★		10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062	20	290	DIN 6537 K
8.60	.339	44.6	1.756	5	10	860.1-0860-044A1-SM	★		10.0	.394	103	4.055	101.4	3.993	61	2.402	1.6	.062	20	290	DIN 6537 L
8.65	.341	27.5	1.083	3	10	860.1-0865-027A1-SM	★		10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062	20	290	DIN 6537 K
8.70	.343	27.7	1.091	3	10	860.1-0870-027A1-SM	★		10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062	20	290	DIN 6537 K
8.73	.344	27.8	1.094	3	10	860.1-0873-027A1-SM	★		10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
8.73	.344	45.2	1.780	5	10	860.1-0873-045A1-SM	★		10.0	.394	103	4.055	101.4	3.993	61	2.402	1.6	.063	20	290	DIN 6537 L
8.80	.346	28.0	1.102	3	10	860.1-0880-028A1-SM	★		10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
8.85	.348	28.2	1.110	3	10	860.1-0885-028A1-SM	★		10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.00	.354	28.6	1.126	3	10	860.1-0900-028A1-SM	★		10.0	.394	89	3.504	87.4	3.439	47	1.850	1.6	.065	20	290	DIN 6537 K
9.00	.354	46.2	1.819	5	10	860.1-0900-046A1-SM	★		10.0	.394	103	4.055	101.4	3.991	61	2.402	1.6	.065	20	290	DIN 6537 L
9.20	.362	29.3	1.154	3	10	860.1-0920-029A1-SM	★		10.0	.394	89	3.504	87.3	3.438	47	1.850	1.7	.066	20	290	DIN 6537 K
9.30	.366	29.6	1.165	3	10	860.1-0930-029A1-SM	★		10.0	.394	89	3.504	87.3	3.437	47	1.850	1.7	.067	20	290	DIN 6537 K
9.30	.366	46.3	1.823	4	10	860.1-0930-046A1-SM	★		10.0	.394	103	4.055	101.3	3.989	61	2.402	1.7	.067	20	290	DIN 6537 L
9.40	.370	29.9	1.177	3	10	860.1-0940-029A1-SM	★		10.0	.394	89	3.504	87.3	3.437	47	1.850	1.7	.067	20	290	DIN 6537 K
9.50	.374	30.2	1.189	3	10	860.1-0950-030A1-SM	★		10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068	20	290	DIN 6537 K
9.52	.375	30.3	1.193	3	10	860.1-0952-030A1-SM	★		10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068	20	290	DIN 6537 K
9.53	.375	30.3	1.193	3	10	860.1-0953-030A1-SM	★		10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068	20	290	DIN 6537 K
9.60	.378	30.5	1.201	3	10	860.1-0960-030A1-SM	★		10.0	.394	89	3.504	87.3	3.435	47	1.850	1.8	.069	20	290	DIN 6537 K
9.70	.382	30.9	1.217	3	10	860.1-0970-030A1-SM	★		10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.070	20	290	DIN 6537 K
9.80	.386	31.2	1.228	3	10	860.1-0980-031A1-SM	★		10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.070	20	290	DIN 6537 K
9.80	.386	46.4	1.827	4	10	860.1-0980-046A1-SM	★		10.0	.394	103	4.055	101.2	3.985	61	2.402	1.8	.070	20	290	DIN 6537 L
9.90	.390	46.5	1.831	4	10	860.1-0990-046A1-SM	★		10.0	.394	103	4.055	101.2	3.984	61	2.402	1.8	.071	20	290	DIN 6537 L
9.92	.391	31.6	1.244	3	10	860.1-0992-031A1-SM	★		10.0	.394	89	3.504	87.2	3.433	47	1.850	1.8	.071	20	290	DIN 6537 K
10.00	.394	31.8	1.252	3	10	860.1-1000-031A1-SM	★		10.0	.394	89	3.504	87.2	3.432	47	1.850	1.8	.072	20	290	DIN 6537 K
10.00	.394	46.5	1.831	4	10	860.1-1000-046A1-SM	★		10.0	.394	103	4.055	101.2	3.983	61	2.402	1.8	.072	20	290	DIN 6537 L
10.10	.398	32.1	1.264	3	12	860.1-1010-032A1-SM	★		12.0	.472	102	4.016	100.2	3.943	47	1.850	1.8	.072	20	290	DIN 6537 K
10.20	.402	32.5	1.280	3	12	860.1-1020-032A1-SM	★		12.0	.472	102	4.016	100.1	3.943	55	2.165	1.9	.073	20	290	DIN 6537 K
10.30	.406	32.8	1.291	3	12	860.1-1030-032A1-SM	★		12.0	.472	102	4.016	100.1	3.942	55	2.165	1.9	.074	20	290	DIN 6537 K
10.30	.406	53.4	2.102	5	12	860.1-1030-053A1-SM	★		12.0	.472	118	4.646	116.1	4.572	71	2.795	1.9	.074	20	290	DIN 6537 L
10.32	.406	32.8	1.291	3	12	860.1-1032-032A1-SM	★		12.0	.472	102	4.016	100.1	3.942	55	2.165	1.9	.074	20	290	DIN 6537 K
10.50	.413	33.4	1.315	3	12	860.1-1050-033A1-SM	★		12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
10.50	.413	54.2	2.134	5	12	860.1-1050-054A1-SM	★		12.0	.472	118	4.646	116.1	4.570	71	2.795	1.9	.075	20	290	DIN 6537 L
10.80	.425	34.4	1.354	3	12	860.1-1080-034A1-SM	★		12.0	.472	102	4.016	100.0	3.938	55	2.165	2.0	.078	20	290	DIN 6537 K
11.00	.433	35.0	1.378	3	12	860.1-1100-035A1-SM	★		12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079	20	290	DIN 6537 K
11.00	.433	54.2	2.134	4	12	860.1-1100-054A1-SM	★		12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079	20	290	DIN 6537 L
11.11	.437	35.4	1.394	3	12	860.1-1111-035A1-SM	★		12.0	.472	102	4.016	100.0	3.936	55	2.165	2.0	.080	20	290	DIN 6537 K
11.20	.441	35.6	1.402	3	12	860.1-1120-035A1-SM	★		12.0	.472	102	4.016	100.0	3.935	55	2.165	2.0	.080	20	290	DIN 6537 K
11.50	.453	36.6	1.441	3	12	860.1-1150-036A1-SM	★		12.0	.472	102	4.016	99.9	3.933	55	2.165	2.1	.082	20	290	DIN 6537 K
11.80	.465	37.5	1.476	3	12	860.1-1180-037A1-SM	★		12.0	.472	102	4.016	99.9	3.931	55	2.165	2.2	.085	20	290	DIN 6537 K
12.00	.472	38.2	1.504	3	12	860.1-1200-038A1-SM	★		12.0	.472	102	4.016	99.8	3.930	55	2.165	2.2	.086	20	290	DIN 6537 K
12.00	.472	54.3	2.138	4	12	860.1-1200-054A1-SM	★		12.0	.472	118	4.646	115.8	4.560	61	2.402	2.2	.086	20	290	DIN 6537 L

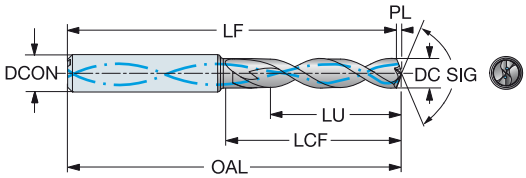


CoroDrill® 860 solid carbide drill

For nickel-based alloys and titanium-based alloys

Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S 1210	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
12.10	.476	38.5	1.516	3	14	**860.1-1210-038A1-SM**	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.2	.087	20	290	DIN 6537 K
12.20	.480	38.8	1.528	3	14	**860.1-1220-038A1-SM**	★	14.0	.551	107	4.213	104.8	4.125	55	2.165	2.2	.087	20	290	DIN 6537 K
12.40	.488	39.5	1.555	3	14	**860.1-1240-039A1-SM**	★	14.0	.551	107	4.213	104.7	4.124	60	2.362	2.3	.089	20	290	DIN 6537 K
12.50	.492	39.8	1.567	3	14	**860.1-1250-039A1-SM**	★	14.0	.551	107	4.213	104.7	4.123	60	2.362	2.3	.089	20	290	DIN 6537 K
12.70	.500	40.4	1.591	3	14	**860.1-1270-040A1-SM**	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.091	20	290	DIN 6537 K
12.70	.500	57.6	2.268	4	14	**860.1-1270-057A1-SM**	★	14.0	.551	124	4.882	121.8	4.795	71	2.795	2.3	.091	20	290	DIN 6537 L
12.90	.508	40.6	1.598	3	14	**860.1-1290-040A1-SM**	★	14.0	.551	107	4.213	104.7	4.120	60	2.362	2.4	.093	20	290	DIN 6537 K
13.00	.512	40.5	1.594	3	14	**860.1-1300-040A1-SM**	★	14.0	.551	107	4.213	104.6	4.119	60	2.362	2.4	.093	20	290	DIN 6537 K
13.25	.522	40.5	1.594	3	14	**860.1-1325-040A1-SM**	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.4	.095	20	290	DIN 6537 K
13.50	.531	40.6	1.598	3	14	**860.1-1350-040A1-SM**	★	14.0	.551	107	4.213	104.5	4.116	60	2.362	2.5	.097	20	290	DIN 6537 K
13.70	.539	40.6	1.598	2	14	**860.1-1370-040A1-SM**	★	14.0	.551	107	4.213	104.5	4.115	60	2.362	2.5	.098	20	290	DIN 6537 K
13.70	.539	57.6	2.268	4	14	**860.1-1370-057A1-SM**	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.5	.098	20	290	DIN 6537 L
13.75	.541	40.6	1.598	2	14	**860.1-1375-040A1-SM**	★	14.0	.551	107	4.213	104.5	4.114	60	2.362	2.5	.098	20	290	DIN 6537 K
14.00	.551	40.6	1.598	2	14	**860.1-1400-040A1-SM**	★	14.0	.551	107	4.213	104.5	4.112	60	2.362	2.6	.100	20	290	DIN 6537 K
15.50	.610	43.6	1.717	2	16	**860.1-1550-043A1-SM**	★	16.0	.630	115	4.528	112.2	4.417	65	2.559	2.8	.111	20	290	DIN 6537 K
15.87	.625	50.5	1.988	3	16	**860.1-1587-061A1-SM**	★	16.0	.630	133	5.236	130.4	5.134	83	3.268	2.9	.114	20	290	DIN 6537 L

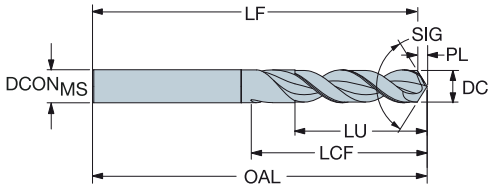
E46 H2 H7 H6

ENG

CoroDrill® 863 solid carbide drill

For composite materials

SIG 90°



DC	LU	ULDR	CZC_{MS}	Ordering code	O1AD	Dimensions, mm, inch DCON	OAL	LF	PL	BSG
3.30	17.9	5	6	863.1-0330-017A0-O	★	6.0	66	64.6	1.4	COROMANT
.130	.705	5	6			.236	2.598	2.543	.056	
4.85	26.3	5	6	863.1-0485-024A0-O	★	6.0	82	79.9	2.1	COROMANT
.191	1.035	5	6			.236	3.228	3.146	.082	
6.37	34.6	5	8	863.1-0637-032A0-O	★	8.0	91	88.3	2.7	COROMANT
.251	1.362	5	8			.315	3.583	3.475	.107	
7.96	43.2	5	8	863.1-0796-039A0-O	★	8.0	91	87.6	3.4	COROMANT
.313	1.701	5	8			.315	3.583	3.448	.135	
9.55	51.9	5	10	863.1-0955-048A0-O	★	10.0	103	98.9	4.1	COROMANT
.376	2.043	5	10			.394	4.055	3.894	.161	

E46

H2

H7


H6

CoroDrill® DS20

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD Min.	4-5xD Rec.	4-5xD Max.	6-7xD Min.	6-7xD Rec.	6-7xD Max.	Drill diameter mm
P											
	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324 4334 4344	230 210 190	340 285 225	400 325 245	230 210 190	305 255 205	360 295 220	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324 4334 4344	230 200 170	320 270 210	370 305 235	230 200 170	290 245 190	335 275 210	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324 4334 4344	190 155 120	265 215 165	305 250 190	190 155 120	240 195 150	275 225 170	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324 4334 4344	170 140 105	250 205 155	290 240 185	170 140 105	225 185 140	260 215 165	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324 4334 4344	140 135 125	260 220 175	325 265 200	140 135 125	235 200 160	295 240 180	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.1.Z.AN	Low alloy steel Annealed	175	4324 4334 4344	180 150 115	260 215 165	305 250 190	180 150 115	235 195 150	275 225 170	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.2.Z.AN	Low alloy steel Annealed	240	4324 4334 4344	180 150 115	250 200 175	290 225 205	180 150 115	225 180 160	260 205 185	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324 4334 4344	90 85 75	190 155 125	245 195 150	90 85 75	170 140 115	220 175 135	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324 4334 4344	110 105 100	210 175 140	265 210 160	110 105 100	190 160 125	240 190 145	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P3.0.Z.AN	High alloy steel Annealed	200	4324 4334 4344	160 130 100	245 200 150	290 240 180	160 130 100	220 180 135	260 215 160	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

CoroDrill® DS20

Metric values

Drill length 4xD					Drill length 5xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
-	0.05-0.12	0.06-0.14	0.06-0.16	-	-	0.05-0.1	0.06-0.12	0.06-0.14	-
-	0.05-0.14	0.06-0.16	0.06-0.18	-	-	0.05-0.12	0.06-0.14	0.06-0.15	-
-	0.05-0.18	0.06-0.2	0.06-0.22	-	-	0.05-0.15	0.06-0.17	0.06-0.19	-
-	0.07-0.22	0.08-0.24	0.08-0.26	-	-	0.07-0.19	0.08-0.2	0.08-0.22	-
-	0.07-0.24	0.08-0.26	0.08-0.28	-	-	0.07-0.2	0.08-0.22	0.08-0.24	-
-	0.09-0.24	0.1-0.26	0.1-0.28	-	-	0.09-0.2	0.1-0.22	0.1-0.24	-
-	0.09-0.24	0.1-0.26	0.1-0.28	-	-	0.09-0.2	0.1-0.22	0.1-0.24	-
-	0.05-0.12	0.06-0.14	0.06-0.16	-	-	0.05-0.1	0.06-0.12	0.06-0.14	-
-	0.05-0.14	0.06-0.16	0.06-0.18	-	-	0.05-0.12	0.06-0.14	0.06-0.15	-
-	0.05-0.18	0.06-0.2	0.06-0.22	-	-	0.05-0.15	0.06-0.17	0.06-0.19	-
-	0.07-0.22	0.08-0.24	0.08-0.26	-	-	0.07-0.19	0.08-0.2	0.08-0.22	-
-	0.07-0.24	0.08-0.26	0.08-0.28	-	-	0.07-0.2	0.08-0.22	0.08-0.24	-
-	0.09-0.24	0.1-0.26	0.1-0.28	-	-	0.09-0.2	0.1-0.22	0.1-0.24	-
-	0.09-0.24	0.1-0.26	0.1-0.28	-	-	0.09-0.2	0.1-0.22	0.1-0.24	-
-	0.04-0.12	0.04-0.12	0.04-0.12	-	-	0.04-0.1	0.04-0.1	0.04-0.1	-
-	0.04-0.13	0.04-0.13	0.04-0.13	-	-	0.04-0.11	0.04-0.11	0.04-0.11	-
-	0.04-0.14	0.04-0.14	0.04-0.14	-	-	0.04-0.12	0.04-0.12	0.04-0.12	-
-	0.05-0.15	0.05-0.15	0.05-0.15	-	-	0.05-0.13	0.05-0.13	0.05-0.13	-
-	0.05-0.16	0.05-0.16	0.05-0.16	-	-	0.05-0.14	0.05-0.14	0.05-0.14	-
-	0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-
-	0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-
-	-	0.06-0.14	0.06-0.16	-	-	-	0.06-0.12	0.06-0.14	-
-	-	0.06-0.16	0.06-0.18	-	-	-	0.06-0.14	0.06-0.15	-
-	-	0.06-0.2	0.06-0.22	-	-	-	0.06-0.17	0.06-0.19	-
-	-	0.08-0.24	0.08-0.26	-	-	-	0.08-0.2	0.08-0.22	-
-	-	0.08-0.26	0.08-0.28	-	-	-	0.08-0.22	0.08-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.06-0.14	0.06-0.16	-	-	-	0.06-0.12	0.06-0.14	-
-	-	0.06-0.16	0.06-0.18	-	-	-	0.06-0.14	0.06-0.15	-
-	-	0.06-0.2	0.06-0.22	-	-	-	0.06-0.17	0.06-0.19	-
-	-	0.08-0.24	0.08-0.26	-	-	-	0.08-0.2	0.08-0.22	-
-	-	0.08-0.26	0.08-0.28	-	-	-	0.08-0.22	0.08-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.06-0.14	0.06-0.16	-	-	-	0.06-0.12	0.06-0.14	-
-	-	0.06-0.16	0.06-0.18	-	-	-	0.06-0.14	0.06-0.15	-
-	-	0.06-0.2	0.06-0.22	-	-	-	0.06-0.17	0.06-0.19	-
-	-	0.08-0.24	0.08-0.26	-	-	-	0.08-0.2	0.08-0.22	-
-	-	0.08-0.26	0.08-0.28	-	-	-	0.08-0.22	0.08-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.06-0.16	0.06-0.18	-	-	-	0.06-0.14	0.06-0.15	-
-	-	0.06-0.18	0.06-0.2	-	-	-	0.06-0.15	0.06-0.17	-
-	-	0.06-0.22	0.06-0.24	-	-	-	0.06-0.19	0.06-0.2	-
-	-	0.08-0.26	0.08-0.28	-	-	-	0.08-0.22	0.08-0.24	-
-	-	0.08-0.28	0.08-0.3	-	-	-	0.08-0.24	0.08-0.26	-
-	-	0.1-0.28	0.1-0.3	-	-	-	0.1-0.24	0.1-0.26	-
-	-	0.1-0.28	0.1-0.3	-	-	-	0.1-0.24	0.1-0.26	-
-	-	0.06-0.14	0.06-0.16	-	-	-	0.06-0.12	0.06-0.14	-
-	-	0.06-0.16	0.06-0.18	-	-	-	0.06-0.14	0.06-0.15	-
-	-	0.06-0.2	0.06-0.22	-	-	-	0.06-0.17	0.06-0.19	-
-	-	0.08-0.24	0.08-0.26	-	-	-	0.08-0.2	0.08-0.22	-
-	-	0.08-0.26	0.08-0.28	-	-	-	0.08-0.22	0.08-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-

CoroDrill® DS20

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD			6-7xD			Drill diameter mm
P	P3.0.Z.HT	High alloy steel Hardened and tempered	380	4324 4334 4344	80 75 70	165 140 110	210 175 130	80 75 70	150 125 100	190 160 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P5.0.Z.AN	Ferritic/martensitic stainless steel Annealed	200	4334 4344 2044	115 115 115	185 155 150	225 175 165	115 115 115	165 140 135	205 160 150	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P5.0.Z.HT	Ferritic/martensitic stainless steel Hardened and tempered	330	4334 4344 2044	75 70 70	135 115 115	170 140 140	75 70 70	120 105 105	155 125 125	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
M	M1.0.Z.AQ	Austenic stainless steel Annealed/quenched	200	4334 4344 2044	115 115 115	185 165 155	225 190 180	115 115 115	165 150 140	205 170 160	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M1.1.Z.AQ	Austenitic stainless steel Machinability improved	200	4334 4344 2044	115 115 115	195 175 170	240 210 200	115 115 115	175 160 155	215 190 180	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M2.0.Z.AQ	Super austenitic (Ni>20%) stainless steel Annealed/quenched	200	4334 4344 2044	80 80 80	125 110 110	150 125 125	80 80 80	115 100 100	135 115 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M3.1.Z.AQ	Duplex stainless steel >60% ferrite (N<0.10%)	230	4334 4344 2044	85 85 85	125 115 110	145 130 125	85 85 85	115 105 100	130 115 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M3.2.Z.AQ	Duplex stainless steel <60% ferrite (N≥0.10%)	260	4334 4344 2044	75 75 75	105 100 100	120 115 115	75 75 75	95 90 90	110 105 105	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
S	S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS	Heat resistant super alloys Ni based	350	4334 4344 2044	20 20 20	40 40 40	50 50 50	20 20 20	35 35 35	45 45 45	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	S4.2.Z.AN S4.3.Z.AG	Heat resistant super alloys Ti-based	330	H13A 4344 2044	40 40 40	90 90 90	120 120 120	40 40 40	80 80 80	110 110 110	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

ENG

CoroDrill® DS20

Metric values

		Drill length 4xD					Drill length 5xD		
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range									
-	-	0.06-0.14	0.06-0.16	-	-	-	0.06-0.12	0.06-0.14	-
-	-	0.06-0.16	0.06-0.18	-	-	-	0.06-0.14	0.06-0.15	-
-	-	0.06-0.2	0.06-0.22	-	-	-	0.06-0.17	0.06-0.19	-
-	-	0.08-0.24	0.08-0.26	-	-	-	0.08-0.2	0.08-0.22	-
-	-	0.08-0.26	0.08-0.28	-	-	-	0.08-0.22	0.08-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
-	-	0.1-0.26	0.1-0.28	-	-	-	0.1-0.22	0.1-0.24	-
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
0.04-0.08	0.04-0.08	0.04-0.08	-	-	0.04-0.07	0.04-0.07	0.04-0.07	-	-
0.04-0.09	0.04-0.09	0.04-0.09	-	-	0.04-0.08	0.04-0.08	0.04-0.08	-	-
0.04-0.1	0.04-0.1	0.04-0.1	-	-	0.04-0.09	0.04-0.09	0.04-0.09	-	-
0.05-0.11	0.05-0.11	0.05-0.11	-	-	0.05-0.1	0.05-0.1	0.05-0.1	-	-
0.05-0.12	0.05-0.12	0.05-0.12	-	-	0.05-0.11	0.05-0.11	0.05-0.11	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-
0.06-0.14	0.06-0.14	0.06-0.14	-	-	0.06-0.12	0.06-0.12	0.06-0.12	-	-
0.06-0.15	0.06-0.15	0.06-0.15	-	-	0.06-0.13	0.06-0.13	0.06-0.13	-	-
0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
0.08-0.17	0.08-0.17	0.08-0.17	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-
0.08-0.18	0.08-0.18	0.08-0.18	-	-	0.08-0.15	0.08-0.15	0.08-0.15	-	-
0.1-0.18	0.1-0.18	0.1-0.18	-	-	0.1-0.15	0.1-0.15	0.1-0.15	-	-
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

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD			6-7xD			Drill diameter mm
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324 4334 4344	140 110 180	210 170 165	245 200 155	140 110 180	190 155 150	220 180 140	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324 4334 4344	210 170 130	285 235 180	325 270 205	210 170 130	255 210 160	295 245 185	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324 4334 4344	125 100 75	205 160 125	245 195 150	125 100 75	185 145 115	220 175 135	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K3.1.C.UT	Nodular cast iron Ferritic	155	4324 4334 4344	125 100 80	190 155 120	225 185 145	125 100 80	170 140 110	205 165 130	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K3.3.C.UT	Nodular cast iron Pearlitic	265	4324 4334 4344	110 90 70	175 145 110	210 175 130	110 90 70	160 130 100	190 160 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K4.2.C.UT	Compacted graphite iron High tensile strength	230	4324 4334 4344	130 110 85	210 170 125	250 200 150	130 110 85	190 155 115	225 180 135	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
H	H1.3.Z.HA	Extra hard steel Hardened and tempered	60 (HRC)	4324 4334 4344	30 30 30	65 65 65	85 85 85	30 30 30	60 60 60	75 75 75	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

CoroDrill® DS20

Metric values

Drill length 4xD					Drill length 5xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range									
-	0.08-0.15	0.08-0.15	0.08-0.2	-	-	0.08-0.13	0.08-0.13	0.08-0.17	-
-	0.08-0.18	0.08-0.18	0.08-0.23	-	-	0.08-0.15	0.08-0.15	0.08-0.2	-
-	0.08-0.21	0.08-0.21	0.08-0.26	-	-	0.08-0.18	0.08-0.18	0.08-0.22	-
-	0.1-0.24	0.1-0.24	0.1-0.29	-	-	0.1-0.2	0.1-0.2	0.1-0.25	-
-	0.1-0.27	0.1-0.27	0.1-0.32	-	-	0.1-0.23	0.1-0.23	0.1-0.27	-
-	0.12-0.27	0.12-0.27	0.12-0.32	-	-	0.12-0.23	0.12-0.23	0.12-0.27	-
-	0.12-0.27	0.12-0.27	0.12-0.32	-	-	0.12-0.23	0.12-0.23	0.12-0.27	-
-	0.08-0.15	0.08-0.15	0.08-0.2	-	-	0.08-0.13	0.08-0.13	0.08-0.17	-
-	0.08-0.18	0.08-0.18	0.08-0.23	-	-	0.08-0.15	0.08-0.15	0.08-0.2	-
-	0.08-0.21	0.08-0.21	0.08-0.26	-	-	0.08-0.18	0.08-0.18	0.08-0.22	-
-	0.1-0.24	0.1-0.24	0.1-0.29	-	-	0.1-0.2	0.1-0.2	0.1-0.25	-
-	0.1-0.27	0.1-0.27	0.1-0.32	-	-	0.1-0.23	0.1-0.23	0.1-0.27	-
-	0.12-0.27	0.12-0.27	0.12-0.32	-	-	0.12-0.23	0.12-0.23	0.12-0.27	-
-	0.12-0.27	0.12-0.27	0.12-0.32	-	-	0.12-0.23	0.12-0.23	0.12-0.27	-
-	0.08-0.13	0.08-0.13	0.08-0.18	-	-	0.08-0.11	0.08-0.11	0.08-0.15	-
-	0.08-0.16	0.08-0.16	0.08-0.21	-	-	0.08-0.14	0.08-0.14	0.08-0.18	-
-	0.08-0.19	0.08-0.19	0.08-0.24	-	-	0.08-0.16	0.08-0.16	0.08-0.2	-
-	0.1-0.22	0.1-0.22	0.1-0.27	-	-	0.1-0.19	0.1-0.19	0.1-0.23	-
-	0.1-0.25	0.1-0.25	0.1-0.3	-	-	0.1-0.21	0.1-0.21	0.1-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.08-0.13	0.08-0.13	0.08-0.18	-	-	0.08-0.11	0.08-0.11	0.08-0.15	-
-	0.08-0.16	0.08-0.16	0.08-0.21	-	-	0.08-0.14	0.08-0.14	0.08-0.18	-
-	0.08-0.19	0.08-0.19	0.08-0.24	-	-	0.08-0.16	0.08-0.16	0.08-0.2	-
-	0.1-0.22	0.1-0.22	0.1-0.27	-	-	0.1-0.19	0.1-0.19	0.1-0.23	-
-	0.1-0.25	0.1-0.25	0.1-0.3	-	-	0.1-0.21	0.1-0.21	0.1-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.08-0.13	0.08-0.13	0.08-0.18	-	-	0.08-0.11	0.08-0.11	0.08-0.15	-
-	0.08-0.16	0.08-0.16	0.08-0.21	-	-	0.08-0.14	0.08-0.14	0.08-0.18	-
-	0.08-0.19	0.08-0.19	0.08-0.24	-	-	0.08-0.16	0.08-0.16	0.08-0.2	-
-	0.1-0.22	0.1-0.22	0.1-0.27	-	-	0.1-0.19	0.1-0.19	0.1-0.23	-
-	0.1-0.25	0.1-0.25	0.1-0.3	-	-	0.1-0.21	0.1-0.21	0.1-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.08-0.13	0.08-0.13	0.08-0.18	-	-	0.08-0.11	0.08-0.11	0.08-0.15	-
-	0.08-0.16	0.08-0.16	0.08-0.21	-	-	0.08-0.14	0.08-0.14	0.08-0.18	-
-	0.08-0.19	0.08-0.19	0.08-0.24	-	-	0.08-0.16	0.08-0.16	0.08-0.2	-
-	0.1-0.22	0.1-0.22	0.1-0.27	-	-	0.1-0.19	0.1-0.19	0.1-0.23	-
-	0.1-0.25	0.1-0.25	0.1-0.3	-	-	0.1-0.21	0.1-0.21	0.1-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.12-0.25	0.12-0.25	0.12-0.3	-	-	0.12-0.21	0.12-0.21	0.12-0.26	-
-	0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-
-	0.06-0.14	0.06-0.14	0.06-0.14	-	-	0.06-0.12	0.06-0.12	0.06-0.12	-
-	0.06-0.15	0.06-0.15	0.06-0.15	-	-	0.06-0.13	0.06-0.13	0.06-0.13	-
-	0.08-0.16	0.08-0.16	0.08-0.16	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-
-	0.08-0.18	0.08-0.18	0.08-0.18	-	-	0.08-0.15	0.08-0.15	0.08-0.15	-
-	0.1-0.18	0.1-0.18	0.1-0.18	-	-	0.1-0.15	0.1-0.15	0.1-0.15	-
-	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

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD			6-7xD			Drill diameter mm
N	N1.2.Z.AG	Aluminium based alloys AlSi alloys, Si ≤ 1%	100	H13A 4344	300 300	365 365	400 400	300 300	330 330	360 360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N1.3.C.UT	Aluminium based alloys AlSi cast alloys (1%< Si <13%)	75	H13A 4344	250 250	350 350	400 400	250 250	315 315	360 360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N1.3.C.AG	Aluminium based alloys AlSi cast and aged alloys (1%< Si <13%)	90	H13A 4344	250 250	315 315	350 350	250 250	285 285	315 315	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N3.3.U.UT	Copper based alloys Free cutting copper based alloys	110	H13A 4344	250 250	350 350	400 400	250 250	315 315	360 360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N3.2.C.UT	Copper based alloys Leaded brass & bronzes (Pb ≤ 1%)	90	H13A 4344	180 180	220 220	240 240	180 180	200 200	215 215	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

ENG

CoroDrill® DS20

Metric values

Drill length 4xD					Drill length 5xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range									
0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-
0.06-0.2	0.06-0.2	0.06-0.2	-	-	0.06-0.17	0.06-0.17	0.06-0.17	-	-
0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-
0.08-0.25	0.08-0.25	0.08-0.25	-	-	0.08-0.21	0.08-0.21	0.08-0.21	-	-
0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-
0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-
0.06-0.14	0.06-0.14	0.06-0.14	-	-	0.06-0.12	0.06-0.12	0.06-0.12	-	-
0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-
0.08-0.2	0.08-0.2	0.08-0.2	-	-	0.08-0.17	0.08-0.17	0.08-0.17	-	-
0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-
0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-
0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-
0.06-0.14	0.06-0.14	0.06-0.14	-	-	0.06-0.12	0.06-0.12	0.06-0.12	-	-
0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-
0.08-0.2	0.08-0.2	0.08-0.2	-	-	0.08-0.17	0.08-0.17	0.08-0.17	-	-
0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-
0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-
0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-
0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-
0.06-0.2	0.06-0.2	0.06-0.2	-	-	0.06-0.17	0.06-0.17	0.06-0.17	-	-
0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-
0.08-0.25	0.08-0.25	0.08-0.25	-	-	0.08-0.21	0.08-0.21	0.08-0.21	-	-
0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-
0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-
0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-
0.06-0.2	0.06-0.2	0.06-0.2	-	-	0.06-0.17	0.06-0.17	0.06-0.17	-	-
0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-
0.08-0.25	0.08-0.25	0.08-0.25	-	-	0.08-0.21	0.08-0.21	0.08-0.21	-	-
0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-
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

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD Min.	4-5xD Rec.	4-5xD Max.	6-7xD Min.	6-7xD Rec.	6-7xD Max.	Drill diameter mm
P											
	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324 4334 4344	230 210 190	340 285 225	400 325 245	230 210 190	305 255 205	360 295 220	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324 4334 4344	230 200 170	320 270 210	370 305 235	230 200 170	290 245 190	335 275 210	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324 4334 4344	190 155 120	265 215 165	305 250 190	190 155 120	240 195 150	275 225 170	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324 4334 4344	170 140 105	250 205 155	290 240 185	170 140 105	225 185 140	260 215 165	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324 4334 4344	140 135 125	260 220 175	325 265 200	140 135 125	235 200 160	295 240 180	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.1.Z.AN	Low alloy steel Annealed	175	4324 4334 4344	180 150 115	260 215 165	305 250 190	180 150 115	235 195 150	275 225 170	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.2.Z.AN	Low alloy steel Annealed	240	4324 4334 4344	180 150 115	250 200 175	290 225 205	180 150 115	225 180 160	260 205 185	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324 4334 4344	90 85 75	190 155 125	245 195 150	90 85 75	170 140 115	220 175 135	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324 4334 4344	110 105 100	210 175 140	265 210 160	110 105 100	190 160 125	240 190 145	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P3.0.Z.AN	High alloy steel Annealed	200	4324 4334 4344	160 130 100	245 200 150	290 240 180	160 130 100	220 180 135	260 215 160	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

CoroDrill® DS20

Metric values

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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
-	0.05-0.08	0.06-0.09	0.06-0.1	-	-	0.05-0.07	0.06-0.08	0.06-0.09	-
-	0.05-0.09	0.06-0.1	0.06-0.12	-	-	0.05-0.08	0.06-0.09	0.06-0.1	-
-	0.05-0.12	0.06-0.13	0.06-0.14	-	-	0.05-0.1	0.06-0.11	0.06-0.12	-
-	0.07-0.14	0.08-0.16	0.08-0.17	-	-	0.07-0.12	0.08-0.13	0.08-0.14	-
-	0.07-0.16	0.08-0.17	0.08-0.18	-	-	0.07-0.13	0.08-0.14	0.08-0.15	-
-	0.09-0.16	0.1-0.17	0.1-0.18	-	-	0.09-0.13	0.1-0.14	0.1-0.15	-
-	0.09-0.16	0.1-0.17	0.1-0.18	-	-	0.09-0.13	0.1-0.14	0.1-0.15	-
-	0.05-0.08	0.06-0.09	0.06-0.1	-	-	0.05-0.07	0.06-0.08	0.06-0.09	-
-	0.05-0.09	0.06-0.1	0.06-0.12	-	-	0.05-0.08	0.06-0.09	0.06-0.1	-
-	0.05-0.12	0.06-0.13	0.06-0.14	-	-	0.05-0.1	0.06-0.11	0.06-0.12	-
-	0.07-0.14	0.08-0.16	0.08-0.17	-	-	0.07-0.12	0.08-0.13	0.08-0.14	-
-	0.07-0.16	0.08-0.17	0.08-0.18	-	-	0.07-0.13	0.08-0.14	0.08-0.15	-
-	0.09-0.16	0.1-0.17	0.1-0.18	-	-	0.09-0.13	0.1-0.14	0.1-0.15	-
-	0.09-0.16	0.1-0.17	0.1-0.18	-	-	0.09-0.13	0.1-0.14	0.1-0.15	-
-	0.04-0.08	0.04-0.08	0.04-0.08	-	-	0.04-0.07	0.04-0.07	0.04-0.07	-
-	0.04-0.08	0.04-0.08	0.04-0.08	-	-	0.04-0.07	0.04-0.07	0.04-0.07	-
-	0.04-0.09	0.04-0.09	0.04-0.09	-	-	0.04-0.08	0.04-0.08	0.04-0.08	-
-	0.05-0.1	0.05-0.1	0.05-0.1	-	-	0.05-0.08	0.05-0.08	0.05-0.08	-
-	0.05-0.1	0.05-0.1	0.05-0.1	-	-	0.05-0.09	0.05-0.09	0.05-0.09	-
-	0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-
-	0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-
-	-	0.06-0.09	0.06-0.1	-	-	-	0.06-0.08	0.06-0.09	-
-	-	0.06-0.1	0.06-0.12	-	-	-	0.06-0.09	0.06-0.1	-
-	-	0.06-0.13	0.06-0.14	-	-	-	0.06-0.11	0.06-0.12	-
-	-	0.08-0.16	0.08-0.17	-	-	-	0.08-0.13	0.08-0.14	-
-	-	0.08-0.17	0.08-0.18	-	-	-	0.08-0.14	0.08-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.06-0.09	0.06-0.1	-	-	-	0.06-0.08	0.06-0.09	-
-	-	0.06-0.1	0.06-0.12	-	-	-	0.06-0.09	0.06-0.1	-
-	-	0.06-0.13	0.06-0.14	-	-	-	0.06-0.11	0.06-0.12	-
-	-	0.08-0.16	0.08-0.17	-	-	-	0.08-0.13	0.08-0.14	-
-	-	0.08-0.17	0.08-0.18	-	-	-	0.08-0.14	0.08-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.06-0.09	0.06-0.1	-	-	-	0.06-0.08	0.06-0.09	-
-	-	0.06-0.1	0.06-0.12	-	-	-	0.06-0.09	0.06-0.1	-
-	-	0.06-0.13	0.06-0.14	-	-	-	0.06-0.11	0.06-0.12	-
-	-	0.08-0.16	0.08-0.17	-	-	-	0.08-0.13	0.08-0.14	-
-	-	0.08-0.17	0.08-0.18	-	-	-	0.08-0.14	0.08-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.06-0.1	0.06-0.12	-	-	-	0.06-0.09	0.06-0.1	-
-	-	0.06-0.12	0.06-0.13	-	-	-	0.06-0.1	0.06-0.11	-
-	-	0.06-0.14	0.06-0.16	-	-	-	0.06-0.12	0.06-0.13	-
-	-	0.08-0.17	0.08-0.18	-	-	-	0.08-0.14	0.08-0.15	-
-	-	0.08-0.18	0.08-0.2	-	-	-	0.08-0.15	0.08-0.17	-
-	-	0.1-0.18	0.1-0.2	-	-	-	0.1-0.15	0.1-0.17	-
-	-	0.1-0.18	0.1-0.2	-	-	-	0.1-0.15	0.1-0.17	-
-	-	0.06-0.09	0.06-0.1	-	-	-	0.06-0.08	0.06-0.09	-
-	-	0.06-0.1	0.06-0.12	-	-	-	0.06-0.09	0.06-0.1	-
-	-	0.06-0.13	0.06-0.14	-	-	-	0.06-0.11	0.06-0.12	-
-	-	0.08-0.16	0.08-0.17	-	-	-	0.08-0.13	0.08-0.14	-
-	-	0.08-0.17	0.08-0.18	-	-	-	0.08-0.14	0.08-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-

CoroDrill® DS20

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD			6-7xD			Drill diameter mm
P	P3.0.Z.HT	High alloy steel Hardened and tempered	380	4324 4334 4344	80 75 70	165 140 110	210 175 130	80 75 70	150 125 100	190 160 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P5.0.Z.AN	Ferritic/martensitic stainless steel Annealed	200	4334 4344 2044	115 115 115	185 155 150	225 175 165	115 115 115	165 140 135	205 160 150	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	P5.0.Z.HT	Ferritic/martensitic stainless steel Hardened and tempered	330	4334 4344 2044	75 70 70	135 115 115	170 140 140	75 70 70	120 105 105	155 125 125	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
M	M1.0.Z.AQ	Austenic stainless steel Annealed/quenched	200	4334 4344 2044	115 115 115	185 165 155	225 190 180	115 115 115	165 150 140	205 170 160	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M1.1.Z.AQ	Austenitic stainless steel Machinability improved	200	4334 4344 2044	115 115 115	195 175 170	240 210 200	115 115 115	175 160 155	215 190 180	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M2.0.Z.AQ	Super austenitic (Ni>20%) stainless steel Annealed/quenched	200	4334 4344 2044	80 80 80	125 110 110	150 125 125	80 80 80	115 100 100	135 115 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M3.1.Z.AQ	Duplex stainless steel >60% ferrite (N<0.10%)	230	4334 4344 2044	85 85 85	125 115 110	145 130 125	85 85 85	115 105 100	130 115 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	M3.2.Z.AQ	Duplex stainless steel <60% ferrite (N≥0.10%)	260	4334 4344 2044	75 75 75	105 100 100	120 115 115	75 75 75	95 90 90	110 105 105	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
S	S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS	Heat resistant super alloys Ni based	350	4334 4344 2044	20 20 20	40 40 40	50 50 50	20 20 20	35 35 35	45 45 45	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	S4.2.Z.AN S4.3.Z.AG	Heat resistant super alloys Ti-based	330	H13A 4344 2044	40 40 40	90 90 90	120 120 120	40 40 40	80 80 80	110 110 110	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

ENG

CoroDrill® DS20

Metric values

Drill length 6xD					Drill length 7xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range									
-	-	0.06-0.09	0.06-0.1	-	-	-	0.06-0.08	0.06-0.09	-
-	-	0.06-0.1	0.06-0.12	-	-	-	0.06-0.09	0.06-0.1	-
-	-	0.06-0.13	0.06-0.14	-	-	-	0.06-0.11	0.06-0.12	-
-	-	0.08-0.16	0.08-0.17	-	-	-	0.08-0.13	0.08-0.14	-
-	-	0.08-0.17	0.08-0.18	-	-	-	0.08-0.14	0.08-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
-	-	0.1-0.17	0.1-0.18	-	-	-	0.1-0.14	0.1-0.15	-
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
0.04-0.06	0.04-0.06	0.04-0.06	-	-	0.04-0.05	0.04-0.05	0.04-0.05	-	-
0.04-0.07	0.04-0.07	0.04-0.07	-	-	0.04-0.06	0.04-0.06	0.04-0.06	-	-
0.04-0.08	0.04-0.08	0.04-0.08	-	-	0.04-0.07	0.04-0.07	0.04-0.07	-	-
0.05-0.09	0.05-0.09	0.05-0.09	-	-	0.05-0.07	0.05-0.07	0.05-0.07	-	-
0.05-0.1	0.05-0.1	0.05-0.1	-	-	0.05-0.08	0.05-0.08	0.05-0.08	-	-
0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-
0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-
0.06-0.11	0.06-0.11	0.06-0.11	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-
0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-
0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-

CoroDrill® DS20

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD			6-7xD			Drill diameter mm
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324 4334 4344	140 110 180	210 170 165	245 200 155	140 110 180	190 155 150	220 180 140	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324 4334 4344	210 170 130	285 235 180	325 270 205	210 170 130	255 210 160	295 245 185	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324 4334 4344	125 100 75	205 160 125	245 195 150	125 100 75	185 145 115	220 175 135	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K3.1.C.UT	Nodular cast iron Ferritic	155	4324 4334 4344	125 100 80	190 155 120	225 185 145	125 100 80	170 140 110	205 165 130	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K3.3.C.UT	Nodular cast iron Pearlitic	265	4324 4334 4344	110 90 70	175 145 110	210 175 130	110 90 70	160 130 100	190 160 115	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	K4.2.C.UT	Compacted graphite iron High tensile strength	230	4324 4334 4344	130 110 85	210 170 125	250 200 150	130 110 85	190 155 115	225 180 135	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
H	H1.3.Z.HA	Extra hard steel Hardened and tempered	60 (HRC)	4324 4334 4344	30 30 30	65 65 65	85 85 85	30 30 30	60 60 60	75 75 75	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

ENG

CoroDrill® DS20

Metric values

Drill length 6xD					Drill length 7xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range									
-	0.08-0.1	0.08-0.1	0.08-0.13	-	-	0.08-0.08	0.08-0.08	0.08-0.11	-
-	0.08-0.12	0.08-0.12	0.08-0.15	-	-	0.08-0.1	0.08-0.1	0.08-0.13	-
-	0.08-0.14	0.08-0.14	0.08-0.17	-	-	0.08-0.12	0.08-0.12	0.08-0.14	-
-	0.1-0.16	0.1-0.16	0.1-0.19	-	-	0.1-0.13	0.1-0.13	0.1-0.16	-
-	0.1-0.18	0.1-0.18	0.1-0.21	-	-	0.1-0.15	0.1-0.15	0.1-0.18	-
-	0.12-0.18	0.12-0.18	0.12-0.21	-	-	0.12-0.15	0.12-0.15	0.12-0.18	-
-	0.12-0.18	0.12-0.18	0.12-0.21	-	-	0.12-0.15	0.12-0.15	0.12-0.18	-
-	0.08-0.1	0.08-0.1	0.08-0.13	-	-	0.08-0.08	0.08-0.08	0.08-0.11	-
-	0.08-0.12	0.08-0.12	0.08-0.15	-	-	0.08-0.1	0.08-0.1	0.08-0.13	-
-	0.08-0.14	0.08-0.14	0.08-0.17	-	-	0.08-0.12	0.08-0.12	0.08-0.14	-
-	0.1-0.16	0.1-0.16	0.1-0.19	-	-	0.1-0.13	0.1-0.13	0.1-0.16	-
-	0.1-0.18	0.1-0.18	0.1-0.21	-	-	0.1-0.15	0.1-0.15	0.1-0.18	-
-	0.12-0.18	0.12-0.18	0.12-0.21	-	-	0.12-0.15	0.12-0.15	0.12-0.18	-
-	0.12-0.18	0.12-0.18	0.12-0.21	-	-	0.12-0.15	0.12-0.15	0.12-0.18	-
-	0.08-0.08	0.08-0.08	0.08-0.12	-	-	0.08-0.07	0.08-0.07	0.08-0.1	-
-	0.08-0.1	0.08-0.1	0.08-0.14	-	-	0.08-0.09	0.08-0.09	0.08-0.12	-
-	0.08-0.12	0.08-0.12	0.08-0.16	-	-	0.08-0.1	0.08-0.1	0.08-0.13	-
-	0.1-0.14	0.1-0.14	0.1-0.18	-	-	0.1-0.12	0.1-0.12	0.1-0.15	-
-	0.1-0.16	0.1-0.16	0.1-0.2	-	-	0.1-0.14	0.1-0.14	0.1-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.08-0.08	0.08-0.08	0.08-0.12	-	-	0.08-0.07	0.08-0.07	0.08-0.1	-
-	0.08-0.1	0.08-0.1	0.08-0.14	-	-	0.08-0.09	0.08-0.09	0.08-0.12	-
-	0.08-0.12	0.08-0.12	0.08-0.16	-	-	0.08-0.1	0.08-0.1	0.08-0.13	-
-	0.1-0.14	0.1-0.14	0.1-0.18	-	-	0.1-0.12	0.1-0.12	0.1-0.15	-
-	0.1-0.16	0.1-0.16	0.1-0.2	-	-	0.1-0.14	0.1-0.14	0.1-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.08-0.08	0.08-0.08	0.08-0.12	-	-	0.08-0.07	0.08-0.07	0.08-0.1	-
-	0.08-0.1	0.08-0.1	0.08-0.14	-	-	0.08-0.09	0.08-0.09	0.08-0.12	-
-	0.08-0.12	0.08-0.12	0.08-0.16	-	-	0.08-0.1	0.08-0.1	0.08-0.13	-
-	0.1-0.14	0.1-0.14	0.1-0.18	-	-	0.1-0.12	0.1-0.12	0.1-0.15	-
-	0.1-0.16	0.1-0.16	0.1-0.2	-	-	0.1-0.14	0.1-0.14	0.1-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.08-0.08	0.08-0.08	0.08-0.12	-	-	0.08-0.07	0.08-0.07	0.08-0.1	-
-	0.08-0.1	0.08-0.1	0.08-0.14	-	-	0.08-0.09	0.08-0.09	0.08-0.12	-
-	0.08-0.12	0.08-0.12	0.08-0.16	-	-	0.08-0.1	0.08-0.1	0.08-0.13	-
-	0.1-0.14	0.1-0.14	0.1-0.18	-	-	0.1-0.12	0.1-0.12	0.1-0.15	-
-	0.1-0.16	0.1-0.16	0.1-0.2	-	-	0.1-0.14	0.1-0.14	0.1-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.12-0.16	0.12-0.16	0.12-0.2	-	-	0.12-0.14	0.12-0.14	0.12-0.17	-
-	0.06-0.08	0.06-0.08	0.06-0.08	-	-	0.06-0.07	0.06-0.07	0.06-0.07	-
-	0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-
-	0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-
-	0.08-0.1	0.08-0.1	0.08-0.1	-	-	0.08-0.09	0.08-0.09	0.08-0.09	-
-	0.08-0.12	0.08-0.12	0.08-0.12	-	-	0.08-0.1	0.08-0.1	0.08-0.1	-
-	0.1-0.12	0.1-0.12	0.1-0.12	-	-	0.1-0.1	0.1-0.1	0.1-0.1	-
-	0.1-0.12	0.1-0.12	0.1-0.12	-	-	0.1-0.1	0.1-0.1	0.1-0.1	-

CoroDrill® DS20

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed (v_c) m/min 4-5xD			6-7xD			Drill diameter mm
N	N1.2.Z.AG	Aluminium based alloys AlSi alloys, Si ≤ 1%	100	H13A 4344	300 300	365 365	400 400	300 300	330 330	360 360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N1.3.C.UT	Aluminium based alloys AlSi cast alloys (1%< Si <13%)	75	H13A 4344	250 250	350 350	400 400	250 250	315 315	360 360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N1.3.C.AG	Aluminium based alloys AlSi cast and aged alloys (1%< Si <13%)	90	H13A 4344	250 250	315 315	350 350	250 250	285 285	315 315	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N3.3.U.UT	Copper based alloys Free cutting copper based alloys	110	H13A 4344	250 250	350 350	400 400	250 250	315 315	360 360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00
	N3.2.C.UT	Copper based alloys Leaded brass & bronzes (Pb ≤ 1%)	90	H13A 4344	180 180	220 220	240 240	180 180	200 200	215 215	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00

ENG

CoroDrill® DS20

Metric values

Drill length 6xD					Drill length 7xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range									
0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-
0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
0.08-0.16	0.08-0.16	0.08-0.16	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-
0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-
0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-
0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-
0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-
0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-
0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-
0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-
0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-
0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-
0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-
0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-
0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
0.08-0.16	0.08-0.16	0.08-0.16	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-
0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-
0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-
0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-
0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
0.08-0.16	0.08-0.16	0.08-0.16	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-
0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-
0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-

CoroDrill® DS20

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed v_c, ft/min						Drill diameter
					4-5xD			6-7xD			inch
					Min.	Rec.	Max.	Min.	Rec.	Max.	
P	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324 4334 4344	755 690 625	1115 935 740	1310 1065 805	755 690 625	1005 840 665	1180 960 725	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324 4334 4344	755 655 560	1055 880 695	1215 1000 770	755 655 560	950 790 625	1095 900 695	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324 4334 4344	625 510 395	870 710 545	1000 820 625	625 510 395	785 640 490	900 740 565	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324 4334 4344	560 460 345	815 670 515	950 785 605	560 460 345	735 605 465	855 705 545	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324 4334 4344	460 445 410	855 720 570	1065 870 655	460 445 410	770 650 515	960 785 590	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.1.Z.AN	Low alloy steel Annealed	175	4324 4334 4344	590 490 375	855 705 540	1000 820 625	590 490 375	770 635 485	900 740 565	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.2.Z.AN	Low alloy steel Annealed	240	4324 4334 4344	590 490 375	825 655 565	950 740 670	590 490 375	745 590 510	855 665 605	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324 4334 4344	295 280 245	625 515 405	805 640 490	295 280 245	565 465 365	725 575 440	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324 4334 4344	360 345 330	690 570 455	870 690 525	360 345 330	620 515 410	785 620 475	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P3.0.Z.AN	High alloy steel Annealed	200	4324 4334 4344	525 425 330	800 660 500	950 785 590	525 425 330	720 595 450	855 705 530	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559

ENG

CoroDrill® DS20

Inch values

Drill length 4xD					Drill length 5xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range					Recommended start value at middle of feed range				
f_n inch/rev	f_n inch/rev	f_n inch/rev	f_n inch/rev	f_n inch/rev	f_n inch/rev	f_n inch/rev	f_n inch/rev	f_n inch/rev	f_n inch/rev
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
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
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
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
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
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
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
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
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
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
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
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
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
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
-	0.002-0.005	0.002-0.006	0.002-0.006	-	-	0.002-0.004	0.002-0.005	0.002-0.005	-
-	0.002-0.006	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-
-	0.002-0.007	0.002-0.008	0.002-0.009	-	-	0.002-0.006	0.002-0.007	0.002-0.007	-
-	0.003-0.009	0.003-0.009	0.003-0.01	-	-	0.003-0.007	0.003-0.008	0.003-0.009	-
-	0.003-0.009	0.003-0.01	0.003-0.011	-	-	0.003-0.008	0.003-0.009	0.003-0.009	-
-	0.004-0.009	0.004-0.01	0.004-0.011	-	-	0.004-0.008	0.004-0.009	0.004-0.009	-
-	0.004-0.009	0.004-0.01	0.004-0.011	-	-	0.004-0.008	0.004-0.009	0.004-0.009	-
-	0.002-0.005	0.002-0.006	0.002-0.006	-	-	0.002-0.004	0.002-0.005	0.002-0.005	-
-	0.002-0.006	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-
-	0.002-0.007	0.002-0.008	0.002-0.009	-	-	0.002-0.006	0.002-0.007	0.002-0.007	-
-	0.003-0.009	0.003-0.009	0.003-0.01	-	-	0.003-0.007	0.003-0.008	0.003-0.009	-
-	0.003-0.009	0.003-0.01	0.003-0.011	-	-	0.003-0.008	0.003-0.009	0.003-0.009	-
-	0.004-0.009	0.004-0.01	0.004-0.011	-	-	0.004-0.008	0.004-0.009	0.004-0.009	-
-	0.004-0.009	0.004-0.01	0.004-0.011	-	-	0.004-0.008	0.004-0.009	0.004-0.009	-
-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-
-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-
-	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	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-
-	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	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-
-	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	0.002-0.006	-	-	-	0.002-0.005	0.002-0.005	-
-	-	0.002-0.006	0.002-0.007	-	-	-	0.002-0.005	0.002-0.006	-
-	-	0.002-0.008	0.002-0.009	-	-	-	0.002-0.007	0.002-0.007	-
-	-	0.003-0.009	0.003-0.01	-	-	-	0.003-0.008	0.003-0.009	-
-	-	0.003-0.01	0.003-0.011	-	-	-	0.003-0.009	0.003-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.002-0.006	0.002-0.006	-	-	-	0.002-0.005	0.002-0.005	-
-	-	0.002-0.006	0.002-0.007	-	-	-	0.002-0.005	0.002-0.006	-
-	-	0.002-0.008	0.002-0.009	-	-	-	0.002-0.007	0.002-0.007	-
-	-	0.003-0.009	0.003-0.01	-	-	-	0.003-0.008	0.003-0.009	-
-	-	0.003-0.01	0.003-0.011	-	-	-	0.003-0.009	0.003-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.002-0.006	0.002-0.006	-	-	-	0.002-0.005	0.002-0.005	-
-	-	0.002-0.006	0.002-0.007	-	-	-	0.002-0.005	0.002-0.006	-
-	-	0.002-0.008	0.002-0.009	-	-	-	0.002-0.007	0.002-0.007	-
-	-	0.003-0.009	0.003-0.01	-	-	-	0.003-0.008	0.003-0.009	-
-	-	0.003-0.01	0.003-0.011	-	-	-	0.003-0.009	0.003-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.002-0.006	0.002-0.007	-	-	-	0.002-0.005	0.002-0.006	-
-	-	0.002-0.007	0.002-0.008	-	-	-	0.002-0.006	0.002-0.007	-
-	-	0.002-0.009	0.002-0.009	-	-	-	0.002-0.007	0.002-0.008	-
-	-	0.003-0.01	0.003-0.011	-	-	-	0.003-0.009	0.003-0.009	-
-	-	0.003-0.011	0.003-0.012	-	-	-	0.003-0.009	0.003-0.01	-
-	-	0.004-0.011	0.004-0.012	-	-	-	0.004-0.009	0.004-0.01	-
-	-	0.004-0.011	0.004-0.012	-	-	-	0.004-0.009	0.004-0.01	-
-	-	0.002-0.006	0.002-0.006	-	-	-	0.002-0.005	0.002-0.005	-
-	-	0.002-0.006	0.002-0.007	-	-	-	0.002-0.005	0.002-0.006	-
-	-	0.002-0.008	0.002-0.009	-	-	-	0.002-0.007	0.002-0.007	-
-	-	0.003-0.009	0.003-0.01	-	-	-	0.003-0.008	0.003-0.009	-
-	-	0.003-0.01	0.003-0.011	-	-	-	0.003-0.009	0.003-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-

CoroDrill® DS20

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed v_c, ft/min						Drill diameter
						4-5xD			6-7xD		inch
P	P3.0.Z.HT	High alloy steel	380	4324	260	540	690	260	485	620	0.591-0.709
		Hardened and tempered		4334	245	460	575	245	415	520	0.709-0.866
				4344	230	355	425	230	320	385	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	P5.0.Z.AN	Ferritic/martensitic stainless steel	200	4334	375	610	740	375	550	665	0.591-0.709
				4344	375	505	575	375	455	520	0.709-0.866
		Annealed		2044	375	480	540	375	430	485	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	P5.0.Z.HT	Ferritic/martensitic stainless steel	330	4334	245	450	560	245	405	505	0.591-0.709
				4344	230	380	460	230	340	415	0.709-0.866
		Hardened and tempered		2044	230	380	460	230	340	415	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
M	M1.0.Z.AQ	Austenitic stainless steel	200	4334	375	610	740	375	550	665	0.591-0.709
				4344	375	540	625	375	485	565	0.709-0.866
		Annealed/quenched		2044	375	515	590	375	465	530	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M1.1.Z.AQ	Austenitic Stainless steel	200	4334	375	640	785	375	575	705	0.591-0.709
				4344	375	580	690	375	520	620	0.709-0.866
		Machinability improved		2044	375	555	655	375	500	590	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M2.0.Z.AQ	Super austenitic (Ni>20%) stainless steel	200	4334	260	410	490	260	370	440	0.591-0.709
				4344	260	360	410	260	325	370	0.709-0.866
				2044	260	360	410	260	325	370	0.866-1.063
		Annealed/quenched									1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M3.1.Z.AQ	Duplex stainless steel	230	4334	280	405	475	280	365	430	0.591-0.709
		>60% ferrite (N<0.10%)		4344	280	375	425	280	340	385	0.709-0.866
				2044	280	365	410	280	330	370	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M3.2.Z.AQ	Duplex stainless steel	260	4334	245	345	395	245	310	355	0.591-0.709
		<60% ferrite (N≥0.10%)		4344	245	330	375	245	295	340	0.709-0.866
				2044	245	330	375	245	295	340	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
S	S2.0.Z.AN	Heat resistant super alloys	350	4334	65	130	165	65	115	150	0.591-0.709
	S2.0.Z.AG	Ni based		4344	65	130	165	65	115	150	0.709-0.866
	S2.0.Z.NS			2044	65	130	165	65	115	150	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	S4.2.Z.AN	Heat resistant super alloys	330	H13A	130	300	395	130	270	355	0.591-0.709
	S4.3.Z.AG	Ti-based		4344	130	300	395	130	270	355	0.709-0.866
				2044	130	300	395	130	270	355	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559

ENG

CoroDrill® DS20

Inch values

Drill length 4xD					Drill length 5xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range					Recommended start value at middle of feed range				
-	-	0.002-0.006	0.002-0.006	-	-	-	0.002-0.005	0.002-0.005	-
-	-	0.002-0.006	0.002-0.007	-	-	-	0.002-0.005	0.002-0.006	-
-	-	0.002-0.008	0.002-0.009	-	-	-	0.002-0.007	0.002-0.007	-
-	-	0.003-0.009	0.003-0.01	-	-	-	0.003-0.008	0.003-0.009	-
-	-	0.003-0.01	0.003-0.011	-	-	-	0.003-0.009	0.003-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
-	-	0.004-0.01	0.004-0.011	-	-	-	0.004-0.009	0.004-0.009	-
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
0.002-0.003	0.002-0.003	0.002-0.003	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
0.002-0.004	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	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.003-0.007	0.003-0.007	0.003-0.007	-	-	0.003-0.006	0.003-0.006	0.003-0.006	-	-
0.003-0.007	0.003-0.007	0.003-0.007	-	-	0.003-0.006	0.003-0.006	0.003-0.006	-	-
0.004-0.007	0.004-0.007	0.004-0.007	-	-	0.004-0.006	0.004-0.006	0.004-0.006	-	-
0.004-0.007	0.004-0.007	0.004-0.007	-	-	0.004-0.006	0.004-0.006	0.004-0.006	-	-

CoroDrill® DS20

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed v_c, ft/min						Drill diameter
						4-5xD			6-7xD		inch
K	K1.1.C.NS	Malleable cast iron	200	4324	460	685	805	460	615	725	0.591-0.709
		Low tensile strength		4334	360	550	655	360	495	590	0.709-0.866
				4344	590	540	510	590	485	460	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	K2.1.C.UT	Grey cast iron	180	4324	690	935	1065	690	840	960	0.591-0.709
		Low tensile strength		4334	560	770	885	560	695	795	0.709-0.866
				4344	425	585	670	425	525	605	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	K2.2.C.UT	Grey cast iron	245	4324	410	665	805	410	600	725	0.591-0.709
		High tensile strength		4334	330	530	640	330	475	575	0.709-0.866
				4344	245	405	490	245	365	440	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	K3.1.C.UT	Nodular cast iron	155	4324	410	625	740	410	565	665	0.591-0.709
		Ferritic		4334	330	510	605	330	460	545	0.709-0.866
				4344	260	400	475	260	360	430	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	K3.3.C.UT	Nodular cast iron	265	4324	360	575	690	360	520	620	0.591-0.709
		Ferritic		4334	295	475	575	295	430	520	0.709-0.866
				4344	230	355	425	230	320	385	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	K4.2.C.UT	Compacted graphite iron	230	4324	425	680	820	425	610	740	0.591-0.709
		High tensile strength		4334	360	550	655	360	495	590	0.709-0.866
				4344	280	415	490	280	375	440	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
H	H1.3.Z.HA	Extra hard steel	60 (HRC)	4324	100	215	280	100	195	250	0.591-0.709
		Hardened and tempered		4334	100	215	280	100	195	250	0.709-0.866
				4344	100	215	280	100	195	250	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559

CoroDrill® DS20

Inch values

Drill length 4xD					Drill length 5xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range					Recommended start value at middle of feed range				
-	0.003-0.006	0.003-0.006	0.003-0.008	-	-	0.003-0.005	0.003-0.005	0.003-0.007	-
-	0.003-0.007	0.003-0.007	0.003-0.009	-	-	0.003-0.006	0.003-0.006	0.003-0.008	-
-	0.003-0.008	0.003-0.008	0.003-0.01	-	-	0.003-0.007	0.003-0.007	0.003-0.009	-
-	0.004-0.009	0.004-0.009	0.004-0.011	-	-	0.004-0.008	0.004-0.008	0.004-0.01	-
-	0.004-0.011	0.004-0.011	0.004-0.013	-	-	0.004-0.009	0.004-0.009	0.004-0.011	-
-	0.005-0.011	0.005-0.011	0.005-0.013	-	-	0.005-0.009	0.005-0.009	0.005-0.011	-
-	0.005-0.011	0.005-0.011	0.005-0.013	-	-	0.005-0.009	0.005-0.009	0.005-0.011	-
-	0.003-0.006	0.003-0.006	0.003-0.008	-	-	0.003-0.005	0.003-0.005	0.003-0.007	-
-	0.003-0.007	0.003-0.007	0.003-0.009	-	-	0.003-0.006	0.003-0.006	0.003-0.008	-
-	0.003-0.008	0.003-0.008	0.003-0.01	-	-	0.003-0.007	0.003-0.007	0.003-0.009	-
-	0.004-0.009	0.004-0.009	0.004-0.011	-	-	0.004-0.008	0.004-0.008	0.004-0.01	-
-	0.004-0.011	0.004-0.011	0.004-0.013	-	-	0.004-0.009	0.004-0.009	0.004-0.011	-
-	0.005-0.011	0.005-0.011	0.005-0.013	-	-	0.005-0.009	0.005-0.009	0.005-0.011	-
-	0.005-0.011	0.005-0.011	0.005-0.013	-	-	0.005-0.009	0.005-0.009	0.005-0.011	-
-	0.003-0.005	0.003-0.005	0.003-0.007	-	-	0.003-0.004	0.003-0.004	0.003-0.006	-
-	0.003-0.006	0.003-0.006	0.003-0.008	-	-	0.003-0.005	0.003-0.005	0.003-0.007	-
-	0.003-0.007	0.003-0.007	0.003-0.009	-	-	0.003-0.006	0.003-0.006	0.003-0.008	-
-	0.004-0.009	0.004-0.009	0.004-0.011	-	-	0.004-0.007	0.004-0.007	0.004-0.009	-
-	0.004-0.01	0.004-0.01	0.004-0.012	-	-	0.004-0.008	0.004-0.008	0.004-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.003-0.005	0.003-0.005	0.003-0.007	-	-	0.003-0.004	0.003-0.004	0.003-0.006	-
-	0.003-0.006	0.003-0.006	0.003-0.008	-	-	0.003-0.005	0.003-0.005	0.003-0.007	-
-	0.003-0.007	0.003-0.007	0.003-0.009	-	-	0.003-0.006	0.003-0.006	0.003-0.008	-
-	0.004-0.009	0.004-0.009	0.004-0.011	-	-	0.004-0.007	0.004-0.007	0.004-0.009	-
-	0.004-0.01	0.004-0.01	0.004-0.012	-	-	0.004-0.008	0.004-0.008	0.004-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.003-0.005	0.003-0.005	0.003-0.007	-	-	0.003-0.004	0.003-0.004	0.003-0.006	-
-	0.003-0.006	0.003-0.006	0.003-0.008	-	-	0.003-0.005	0.003-0.005	0.003-0.007	-
-	0.003-0.007	0.003-0.007	0.003-0.009	-	-	0.003-0.006	0.003-0.006	0.003-0.008	-
-	0.004-0.009	0.004-0.009	0.004-0.011	-	-	0.004-0.007	0.004-0.007	0.004-0.009	-
-	0.004-0.01	0.004-0.01	0.004-0.012	-	-	0.004-0.008	0.004-0.008	0.004-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.003-0.005	0.003-0.005	0.003-0.007	-	-	0.003-0.004	0.003-0.004	0.003-0.006	-
-	0.003-0.006	0.003-0.006	0.003-0.008	-	-	0.003-0.005	0.003-0.005	0.003-0.007	-
-	0.003-0.007	0.003-0.007	0.003-0.009	-	-	0.003-0.006	0.003-0.006	0.003-0.008	-
-	0.004-0.009	0.004-0.009	0.004-0.011	-	-	0.004-0.007	0.004-0.007	0.004-0.009	-
-	0.004-0.01	0.004-0.01	0.004-0.012	-	-	0.004-0.008	0.004-0.008	0.004-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.005-0.01	0.005-0.01	0.005-0.012	-	-	0.005-0.008	0.005-0.008	0.005-0.01	-
-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-
-	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-
-	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-
-	0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-
-	0.003-0.007	0.003-0.007	0.003-0.007	-	-	0.003-0.006	0.003-0.006	0.003-0.006	-
-	0.004-0.007	0.004-0.007	0.004-0.007	-	-	0.004-0.006	0.004-0.006	0.004-0.006	-
-	0.004-0.007	0.004-0.007	0.004-0.007	-	-	0.004-0.006	0.004-0.006	0.004-0.006	-

CoroDrill® DS20

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed v_c, ft/min						Drill diameter
						4-5xD			6-7xD		inch
N	N1.2.Z.AG	Aluminium based alloys	100	H13A	985	1195	1310	985	1075	1180	0.591-0.709
		AlSi alloys, Si ≤ 1%		4344	985	1195	1310	985	1075	1180	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N1.3.C.UT	Aluminium based alloys	75	H13A	820	1140	1310	820	1025	1180	0.591-0.709
		AlSi alloys, Si ≤ 1%		4344	820	1140	1310	820	1025	1180	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N1.3.C.AG	Aluminium based alloys	90	H13A	820	1035	1150	820	930	1035	0.591-0.709
		AlSi cast and aged alloys (1%< Si <13%)		4344	820	1035	1150	820	930	1035	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N3.3.U.UT	Copper based alloys	110	H13A	820	1140	1310	820	1025	1180	0.591-0.709
		Free cutting copper based alloys		4344	820	1140	1310	820	1025	1180	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N3.2.C.UT	Copper based alloys	90	H13A	590	715	785	590	645	705	0.591-0.709
		Leaded brass & bronzes (Pb ≤ 1%)		4344	590	715	785	590	645	705	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559

ENG

CoroDrill® DS20

Inch values

Drill length 4xD					Drill length 5xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range					Recommended start value at middle of feed range				
0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-
0.002-0.008	0.002-0.008	0.002-0.008	-	-	0.002-0.007	0.002-0.007	0.002-0.007	-	-
0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-
0.003-0.01	0.003-0.01	0.003-0.01	-	-	0.003-0.008	0.003-0.008	0.003-0.008	-	-
0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-
0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-
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	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-
0.003-0.008	0.003-0.008	0.003-0.008	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-
0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-
0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-
0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-
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	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-
0.003-0.008	0.003-0.008	0.003-0.008	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-
0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-
0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-
0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-
0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-
0.002-0.008	0.002-0.008	0.002-0.008	-	-	0.002-0.007	0.002-0.007	0.002-0.007	-	-
0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-
0.003-0.01	0.003-0.01	0.003-0.01	-	-	0.003-0.008	0.003-0.008	0.003-0.008	-	-
0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-
0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-
0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-
0.002-0.008	0.002-0.008	0.002-0.008	-	-	0.002-0.007	0.002-0.007	0.002-0.007	-	-
0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-
0.003-0.01	0.003-0.01	0.003-0.01	-	-	0.003-0.008	0.003-0.008	0.003-0.008	-	-
0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-
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

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed v_c, ft/min						Drill diameter
					4-5xD			6-7xD			inch
					Min.	Rec.	Max.	Min.	Rec.	Max.	
P	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324 4334 4344	755 690 625	1115 935 740	1310 1065 805	755 690 625	1005 840 665	1180 960 725	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324 4334 4344	755 655 560	1055 880 695	1215 1000 770	755 655 560	950 790 625	1095 900 695	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324 4334 4344	625 510 395	870 710 545	1000 820 625	625 510 395	785 640 490	900 740 565	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324 4334 4344	560 460 345	815 670 515	950 785 605	560 460 345	735 605 465	855 705 545	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324 4334 4344	460 445 410	855 720 570	1065 870 655	460 445 410	770 650 515	960 785 590	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.1.Z.AN	Low alloy steel Annealed	175	4324 4334 4344	590 490 375	855 705 540	1000 820 625	590 490 375	770 635 485	900 740 565	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.2.Z.AN	Low alloy steel Annealed	240	4324 4334 4344	590 490 375	825 655 565	950 740 670	590 490 375	745 590 510	855 665 605	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324 4334 4344	295 280 245	625 515 405	805 640 490	295 280 245	565 465 365	725 575 440	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324 4334 4344	360 345 330	690 570 455	870 690 525	360 345 330	620 515 410	785 620 475	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	P3.0.Z.AN	High alloy steel Annealed	200	4324 4334 4344	525 425 330	800 660 500	950 785 590	525 425 330	720 595 450	855 705 530	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559

CoroDrill® DS20

Inch values

Drill length 6xD					Drill length 7xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range					Recommended start value at middle of feed range				
fn inch/rev	fn inch/rev	fn inch/rev	fn inch/rev	fn inch/rev	fn inch/rev	fn inch/rev	fn inch/rev	fn inch/rev	fn inch/rev
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
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
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
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
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
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
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
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
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
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
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
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
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
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
-	0.002-0.003	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	0.002-0.004	0.002-0.004	0.002-0.005	-	-	0.002-0.003	0.002-0.003	0.002-0.004	-
-	0.002-0.005	0.002-0.005	0.002-0.006	-	-	0.002-0.004	0.002-0.004	0.002-0.005	-
-	0.003-0.006	0.003-0.006	0.003-0.007	-	-	0.003-0.005	0.003-0.005	0.003-0.006	-
-	0.003-0.006	0.003-0.007	0.003-0.007	-	-	0.003-0.005	0.003-0.006	0.003-0.006	-
-	0.004-0.006	0.004-0.007	0.004-0.007	-	-	0.004-0.005	0.004-0.006	0.004-0.006	-
-	0.004-0.006	0.004-0.007	0.004-0.007	-	-	0.004-0.005	0.004-0.006	0.004-0.006	-
-	0.002-0.003	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	0.002-0.004	0.002-0.004	0.002-0.005	-	-	0.002-0.003	0.002-0.003	0.002-0.004	-
-	0.002-0.005	0.002-0.005	0.002-0.006	-	-	0.002-0.004	0.002-0.004	0.002-0.005	-
-	0.003-0.006	0.003-0.006	0.003-0.007	-	-	0.003-0.005	0.003-0.005	0.003-0.006	-
-	0.003-0.006	0.003-0.007	0.003-0.007	-	-	0.003-0.005	0.003-0.006	0.003-0.006	-
-	0.004-0.006	0.004-0.007	0.004-0.007	-	-	0.004-0.005	0.004-0.006	0.004-0.006	-
-	0.004-0.006	0.004-0.007	0.004-0.007	-	-	0.004-0.005	0.004-0.006	0.004-0.006	-
-	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	0.002-0.003	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	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	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	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	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	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	0.002-0.004	-	-	-	0.002-0.003	0.002-0.003	-
-	-	0.002-0.004	0.002-0.005	-	-	-	0.002-0.003	0.002-0.004	-
-	-	0.002-0.005	0.002-0.006	-	-	-	0.002-0.004	0.002-0.005	-
-	-	0.003-0.006	0.003-0.007	-	-	-	0.003-0.005	0.003-0.006	-
-	-	0.003-0.007	0.003-0.007	-	-	-	0.003-0.006	0.003-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.002-0.004	0.002-0.004	-	-	-	0.002-0.003	0.002-0.003	-
-	-	0.002-0.004	0.002-0.005	-	-	-	0.002-0.003	0.002-0.004	-
-	-	0.002-0.005	0.002-0.006	-	-	-	0.002-0.004	0.002-0.005	-
-	-	0.003-0.006	0.003-0.007	-	-	-	0.003-0.005	0.003-0.006	-
-	-	0.003-0.007	0.003-0.007	-	-	-	0.003-0.006	0.003-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.002-0.004	0.002-0.004	-	-	-	0.002-0.003	0.002-0.003	-
-	-	0.002-0.004	0.002-0.005	-	-	-	0.002-0.003	0.002-0.004	-
-	-	0.002-0.005	0.002-0.006	-	-	-	0.002-0.004	0.002-0.005	-
-	-	0.003-0.006	0.003-0.007	-	-	-	0.003-0.005	0.003-0.006	-
-	-	0.003-0.007	0.003-0.007	-	-	-	0.003-0.006	0.003-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.002-0.004	0.002-0.005	-	-	-	0.002-0.003	0.002-0.004	-
-	-	0.002-0.005	0.002-0.005	-	-	-	0.002-0.004	0.002-0.004	-
-	-	0.002-0.006	0.002-0.006	-	-	-	0.002-0.005	0.002-0.005	-
-	-	0.003-0.007	0.003-0.007	-	-	-	0.003-0.006	0.003-0.006	-
-	-	0.003-0.007	0.003-0.008	-	-	-	0.003-0.006	0.003-0.006	-
-	-	0.004-0.007	0.004-0.008	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.004-0.007	0.004-0.008	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.002-0.004	0.002-0.004	-	-	-	0.002-0.003	0.002-0.003	-
-	-	0.002-0.004	0.002-0.005	-	-	-	0.002-0.003	0.002-0.004	-
-	-	0.002-0.005	0.002-0.006	-	-	-	0.002-0.004	0.002-0.005	-
-	-	0.003-0.006	0.003-0.007	-	-	-	0.003-0.005	0.003-0.006	-
-	-	0.003-0.007	0.003-0.007	-	-	-	0.003-0.006	0.003-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-

CoroDrill® DS20

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed v_c, ft/min						Drill diameter
						4-5xD			6-7xD		inch
P	P3.0.Z.HT	High alloy steel	380	4324	260	540	690	260	485	620	0.591-0.709
		Hardened and tempered		4334	245	460	575	245	415	520	0.709-0.866
				4344	230	355	425	230	320	385	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	P5.0.Z.AN	Ferritic/martensitic stainless steel	200	4334	375	610	740	375	550	665	0.591-0.709
				4344	375	505	575	375	455	520	0.709-0.866
		Annealed		2044	375	480	540	375	430	485	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	P5.0.Z.HT	Ferritic/martensitic stainless steel	330	4334	245	450	560	245	405	505	0.591-0.709
				4344	230	380	460	230	340	415	0.709-0.866
		Hardened and tempered		2044	230	380	460	230	340	415	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
M	M1.0.Z.AQ	Austenitic stainless steel	200	4334	375	610	740	375	550	665	0.591-0.709
				4344	375	540	625	375	485	565	0.709-0.866
		Annealed/quenched		2044	375	515	590	375	465	530	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M1.1.Z.AQ	Austenitic Stainless steel	200	4334	375	640	785	375	575	705	0.591-0.709
				4344	375	580	690	375	520	620	0.709-0.866
		Machinability improved		2044	375	555	655	375	500	590	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M2.0.Z.AQ	Super austenitic (Ni>20%) stainless steel	200	4334	260	410	490	260	370	440	0.591-0.709
				4344	260	360	410	260	325	370	0.709-0.866
				2044	260	360	410	260	325	370	0.866-1.063
		Annealed/quenched									1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M3.1.Z.AQ	Duplex stainless steel	230	4334	280	405	475	280	365	430	0.591-0.709
		>60% ferrite (N<0.10%)		4344	280	375	425	280	340	385	0.709-0.866
				2044	280	365	410	280	330	370	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	M3.2.Z.AQ	Duplex stainless steel	260	4334	245	345	395	245	310	355	0.591-0.709
		<60% ferrite (N≥0.10%)		4344	245	330	375	245	295	340	0.709-0.866
				2044	245	330	375	245	295	340	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
S	S2.0.Z.AN	Heat resistant super alloys	350	4334	65	130	165	65	115	150	0.591-0.709
	S2.0.Z.AG	Ni based		4344	65	130	165	65	115	150	0.709-0.866
	S2.0.Z.NS			2044	65	130	165	65	115	150	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	S4.2.Z.AN	Heat resistant super alloys	330	H13A	130	300	395	130	270	355	0.591-0.709
	S4.3.Z.AG	Ti-based		4344	130	300	395	130	270	355	0.709-0.866
				2044	130	300	395	130	270	355	0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559

CoroDrill® DS20

Inch values

Drill length 6xD					Drill length 7xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range					Recommended start value at middle of feed range				
-	-	0.002-0.004	0.002-0.004	-	-	-	0.002-0.003	0.002-0.003	-
-	-	0.002-0.004	0.002-0.005	-	-	-	0.002-0.003	0.002-0.004	-
-	-	0.002-0.005	0.002-0.006	-	-	-	0.002-0.004	0.002-0.005	-
-	-	0.003-0.006	0.003-0.007	-	-	-	0.003-0.005	0.003-0.006	-
-	-	0.003-0.007	0.003-0.007	-	-	-	0.003-0.006	0.003-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
-	-	0.004-0.007	0.004-0.007	-	-	-	0.004-0.006	0.004-0.006	-
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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
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	0.002-0.003	0.002-0.003	-	-	0.002-0.002	0.002-0.002	0.002-0.002	-	-
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	0.002-0.003	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
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	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
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	0.002-0.004	0.002-0.004	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.003-0.005	0.003-0.005	0.003-0.005	-	-	0.003-0.004	0.003-0.004	0.003-0.004	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-

CoroDrill® DS20

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed v_c, ft/min						Drill diameter
						4-5xD			6-7xD		inch
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324 4334 4344	460 360 590	685 550 540	805 655 510	460 360 590	615 495 485	725 590 460	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324 4334 4344	690 560 425	935 770 585	1065 885 670	690 560 425	840 695 525	960 795 605	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324 4334 4344	410 330 245	665 530 405	805 640 490	410 330 245	600 475 365	725 575 440	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	K3.1.C.UT	Nodular cast iron Ferritic	155	4324 4334 4344	410 330 260	625 510 400	740 605 475	410 330 260	565 460 360	665 545 430	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	K3.3.C.UT	Nodular cast iron Ferritic	265	4324 4334 4344	360 295 230	575 475 355	690 575 425	360 295 230	520 430 320	620 520 385	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
	K4.2.C.UT	Compacted graphite iron High tensile strength	230	4324 4334 4344	425 360 280	680 550 415	820 655 490	425 360 280	610 495 375	740 590 440	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559
H	H1.3.Z.HA	Extra hard steel Hardened and tempered	60 (HRC)	4324 4334 4344	100 100 100	215 215 215	280 280 280	100 100 100	195 195 195	250 250 250	0.591-0.709 0.709-0.866 0.866-1.063 1.063-1.299 1.299-1.575 1.575-2.047 2.047-2.559

ENG

CoroDrill® DS20

Inch values

		Drill length 6xD					Drill length 7xD		
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
	Recommended start value at middle of feed range					Recommended start value at middle of feed range			
-	0.003-0.004	0.003-0.004	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.004	-
-	0.003-0.005	0.003-0.005	0.003-0.006	-	-	0.003-0.004	0.003-0.004	0.003-0.005	-
-	0.003-0.005	0.003-0.005	0.003-0.007	-	-	0.003-0.005	0.003-0.005	0.003-0.006	-
-	0.004-0.006	0.004-0.006	0.004-0.007	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.004-0.007	0.004-0.007	0.004-0.008	-	-	0.004-0.006	0.004-0.006	0.004-0.007	-
-	0.005-0.007	0.005-0.007	0.005-0.008	-	-	0.005-0.006	0.005-0.006	0.005-0.007	-
-	0.005-0.007	0.005-0.007	0.005-0.008	-	-	0.005-0.006	0.005-0.006	0.005-0.007	-
-	0.003-0.004	0.003-0.004	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.004	-
-	0.003-0.005	0.003-0.005	0.003-0.006	-	-	0.003-0.004	0.003-0.004	0.003-0.005	-
-	0.003-0.005	0.003-0.005	0.003-0.007	-	-	0.003-0.005	0.003-0.005	0.003-0.006	-
-	0.004-0.006	0.004-0.006	0.004-0.007	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.004-0.007	0.004-0.007	0.004-0.008	-	-	0.004-0.006	0.004-0.006	0.004-0.007	-
-	0.005-0.007	0.005-0.007	0.005-0.008	-	-	0.005-0.006	0.005-0.006	0.005-0.007	-
-	0.005-0.007	0.005-0.007	0.005-0.008	-	-	0.005-0.006	0.005-0.006	0.005-0.007	-
-	0.003-0.003	0.003-0.003	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.004	-
-	0.003-0.004	0.003-0.004	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.005	-
-	0.003-0.005	0.003-0.005	0.003-0.006	-	-	0.003-0.004	0.003-0.004	0.003-0.005	-
-	0.004-0.006	0.004-0.006	0.004-0.007	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.004-0.006	0.004-0.006	0.004-0.008	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.003-0.003	0.003-0.003	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.004	-
-	0.003-0.004	0.003-0.004	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.005	-
-	0.003-0.005	0.003-0.005	0.003-0.006	-	-	0.003-0.004	0.003-0.004	0.003-0.005	-
-	0.004-0.006	0.004-0.006	0.004-0.007	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.004-0.006	0.004-0.006	0.004-0.008	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.003-0.003	0.003-0.003	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.004	-
-	0.003-0.004	0.003-0.004	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.005	-
-	0.003-0.005	0.003-0.005	0.003-0.006	-	-	0.003-0.004	0.003-0.004	0.003-0.005	-
-	0.004-0.006	0.004-0.006	0.004-0.007	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.004-0.006	0.004-0.006	0.004-0.008	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.003-0.003	0.003-0.003	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.004	-
-	0.003-0.004	0.003-0.004	0.003-0.005	-	-	0.003-0.003	0.003-0.003	0.003-0.005	-
-	0.003-0.005	0.003-0.005	0.003-0.006	-	-	0.003-0.004	0.003-0.004	0.003-0.005	-
-	0.004-0.006	0.004-0.006	0.004-0.007	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.004-0.006	0.004-0.006	0.004-0.008	-	-	0.004-0.005	0.004-0.005	0.004-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.005-0.006	0.005-0.006	0.005-0.008	-	-	0.005-0.005	0.005-0.005	0.005-0.006	-
-	0.002-0.003	0.002-0.003	0.002-0.003	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-
-	0.003-0.004	0.003-0.004	0.003-0.004	-	-	0.003-0.003	0.003-0.003	0.003-0.003	-
-	0.003-0.005	0.003-0.005	0.003-0.005	-	-	0.003-0.004	0.003-0.004	0.003-0.004	-
-	0.004-0.005	0.004-0.005	0.004-0.005	-	-	0.004-0.004	0.004-0.004	0.004-0.004	-
-	0.004-0.005	0.004-0.005	0.004-0.005	-	-	0.004-0.004	0.004-0.004	0.004-0.004	-

CoroDrill® DS20

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed V_c, ft/min						Drill diameter
					4-5xD			6-7xD			inch
N	N1.2.Z.AG	Aluminium based alloys	100	H13A	985	1195	1310	985	1075	1180	0.591-0.709
		AlSi alloys, Si ≤ 1%		4344	985	1195	1310	985	1075	1180	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N1.3.C.UT	Aluminium based alloys	75	H13A	820	1140	1310	820	1025	1180	0.591-0.709
		AlSi alloys, Si ≤ 1%		4344	820	1140	1310	820	1025	1180	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N1.3.C.AG	Aluminium based alloys	90	H13A	820	1035	1150	820	930	1035	0.591-0.709
		AlSi cast and aged alloys (1%< Si <13%)		4344	820	1035	1150	820	930	1035	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N3.3.U.UT	Copper based alloys	110	H13A	820	1140	1310	820	1025	1180	0.591-0.709
		Free cutting copper based alloys		4344	820	1140	1310	820	1025	1180	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559
	N3.2.C.UT	Copper based alloys	90	H13A	590	715	785	590	645	705	0.591-0.709
		Leaded brass & bronzes (Pb ≤ 1%)		4344	590	715	785	590	645	705	0.709-0.866
											0.866-1.063
											1.063-1.299
											1.299-1.575
											1.575-2.047
											2.047-2.559

CoroDrill® DS20

Inch values

Drill length 6xD					Drill length 7xD				
-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
Recommended start value at middle of feed range					Recommended start value at middle of feed range				
0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
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	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.003-0.005	0.003-0.005	0.003-0.005	-	-	0.003-0.004	0.003-0.004	0.003-0.004	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
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	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.003-0.005	0.003-0.005	0.003-0.005	-	-	0.003-0.004	0.003-0.004	0.003-0.004	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-
0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-

CoroDrill® 860 solid carbide drill

Metric values

ISO	CMC No.	Material	Hardness Brinell HB	Cutting speed (v_c), m/min	Drill diameter, mm 3.00–6.00	6.01–10.00	10.01–14.00	14.01–20.00
					Feed f_n mm/r [3]			
S	S1.0.U.AN	Heat resistans super alloys	200	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S1.0.U.AG		280	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.AN	Nickel based alloys	250	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.AG		350	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.UT		275	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S2.0.Z.NS		320	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.Z.AN	Cobalt based alloys	200	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.Z.AG		300	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S3.0.C.NS		320	15≥25	0.06-0.12	0.08-0.14	0.10-0.14	0.12-0.16
	S4.1.Z.UT	Titanium alloys	200	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.2.Z.AN		320	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.3.Z.AN		330	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.3.Z.AG		375	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.4.Z.AN		330	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30
	S4.4.Z.AG		410	40≥60	0.06-0.12	0.08-0.20	0.14-0.28	0.16-0.30

CoroDrill® 863 solid carbide drill

Metric values

ISO	Material	Cutting speed (v_c), m/min		Drill diameter, mm 3	6	8	10
				Feed f_n mm/r [3]			
O	Thermoset Resin	Min.	65	0.05	0.05	0.05	0.05
		Rec.	125	0.07	0.07	0.075	0.075
		Max.	200	0.12	0.12	0.15	0.15
	Thermoplastic Resin	Min.	50	0.05	0.05	0.10	0.10
		Rec.	75	0.10	0.10	0.15	0.15
		Max.	125	0.15	0.20	0.25	0.25
	BMI/Cyanate/Phenolic Resin	Min.	50	0.05	0.08	0.08	0.10
		Rec.	100	0.10	0.10	0.10	0.15
		Max.	150	0.12	0.20	0.20	0.25

Rotating tool adaptors

Machine side interface Coromant Capto®

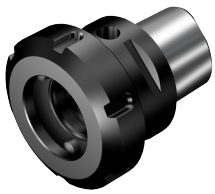
Machine side interface HSK

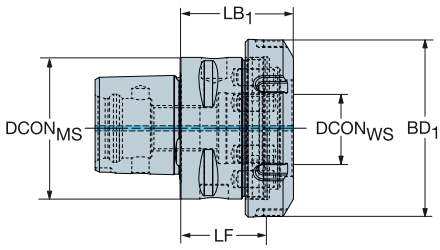
Machine side interface ISO 7388-1

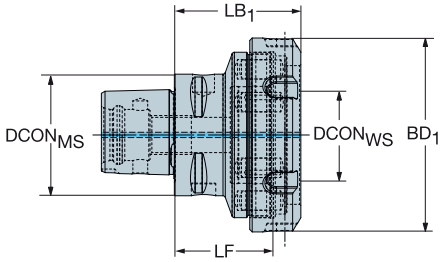
Machine side interface MAS-BT

Machine side interface CAT-V

Coromant Capto® to MDI adaptor

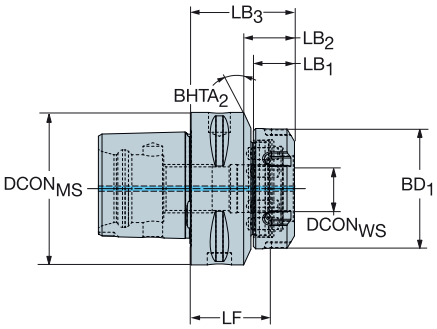






Metric bore

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BD$_1$	BAR PSI	NM	KG	RPMX
C3	MDI-20	3	1	C3-DM20-N-032	32.0	20.0	32.0	42.0	49.7	80	135.0	0.31	28000
					1.260	*.787*	*1.260*	*1.654*	*1.957*	*1160*			
C4	MDI-20	3	1	C4-DM20-N-028	40.0	20.0	28.0	38.0	49.7	80	135.0	0.40	39000
					1.575	*.787*	*1.102*	*1.496*	*1.957*	*1160*			
	MDI-25	3	1	C4-DM25-N-035	40.0	25.0	35.0	45.0	62.7	80	170.0	0.58	39000
					1.575	*.984*	*1.378*	*1.772*	*2.469*	*1160*			
	MDI-32	3	1	C4-DM32-N-042	40.0	32.0	42.0	52.0	67.7	80	200.0	0.71	39000
					1.575	*1.260*	*1.654*	*2.047*	*2.665*	*1160*			
C5	MDI-25	3	1	C5-DM25-N-030	50.0	25.0	30.0	40.0	62.7	80	170.0	0.67	55000
					1.969	*.984*	*1.181*	*1.575*	*2.469*	*1160*			
	MDI-32	3	1	C5-DM32-N-035	50.0	32.0	35.0	45.0	67.7	80	200.0	0.77	28000
					1.969	*1.260*	*1.378*	*1.772*	*2.665*	*1160*			
	MDI-40	3	1	C5-DM40-N-040	50.0	40.0	40.0	52.0	79.7	80	230.0	1.00	55000
					1.969	*1.575*	*1.575*	*2.047*	*3.138*	*1160*			
C6	MDI-32	3	1	C6-DM32-N-030	63.0	32.0	30.0	40.0	67.7	80	200.0	0.99	20000
					2.480	*1.260*	*1.181*	*1.575*	*2.665*	*1160*			
	MDI-40	3	1	C6-DM40-N-040	63.0	40.0	40.0	52.0	79.7	80	230.0	1.34	20000
					2.480	*1.575*	*1.575*	*2.047*	*3.138*	*1160*			



Metric bore

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BAR PSI	NM	KG	RPMX
C5	MDI-20	3	1	C5-DM20-N-028	50.0	20.0	28.0	18.0	38.0	49.7	80	135.0	0.57	28000
					1.969	*.787*	*1.102*	*.709*	*1.496*	*1.957*	*1160*			
C6	MDI-20	3	1	C6-DM20-N-033	63.0	20.0	33.0	18.0	43.0	49.7	80	135.0	0.96	20000
					2.480	*.787*	*1.299*	*.709*	*1.693*	*1.957*	*1160*			
	MDI-25	3	1	C6-DM25-N-030	63.0	25.0	30.0	18.0	40.0	62.7	80	170.0	1.00	20000
					2.480	*.984*	*1.181*	*.709*	*1.575*	*2.469*	*1160*			
C8	MDI-32	3	1	C8-DM32-N-040	80.0	32.0	40.0	18.0	50.0	67.7	80	200.0	2.01	14000
					3.150	*1.260*	*1.575*	*.709*	*1.969*	*2.665*	*1160*			
	MDI-40	3	1	C8-DM40-N-040	80.0	40.0	40.0	22.0	52.0	79.7	80	230.0	2.09	14000
					3.150	*1.575*	*1.575*	*.866*	*2.047*	*3.138*	*1160*			

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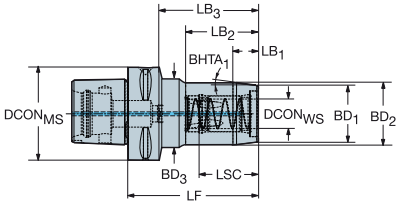
G1 H2 H7

Coromant Capto® to CoroChuck™ 930

Slender design

DSGN 10



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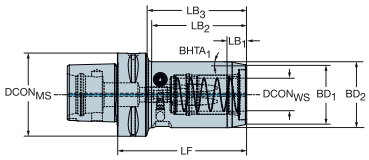

Metric bore

						Dimensions, mm, inch												BAR PSI	NM	KG	
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	BD_4	$BHTA_1$				RPMX
C3	6	3	1	6	**930-C3-S-06-064**	32.0	6.0	37	64.0	11.3	33.2	64.0	22.0	26.0	32.0		10°	80	8.0	0.32	55000
						1.260	*.236*	*1.457*	*2.520*	*.445*	*1.307*	*2.520*	*.866*	*1.024*	*1.260*			*1160*			
	8	3	1	6	**930-C3-S-08-065**	32.0	8.0	37	65.0	11.3	35.3	65.0	24.0	28.0	32.0		10°	80	8.0	0.34	55000
						1.260	*.315*	*1.457*	*2.559*	*.445*	*1.390*	*2.559*	*.945*	*1.102*	*1.260*			*1160*			
	10	3	1	6	**930-C3-S-10-070**	32.0	10.0	41	70.0	11.3	39.6	70.0	26.0	30.0	32.0		10°	80	8.0	0.38	55000
						1.260	*.394*	*1.614*	*2.756*	*.445*	*1.559*	*2.756*	*1.024*	*1.181*	*1.260*			*1160*			
C4	6	3	1	6	**930-C4-S-06-066**	40.0	6.0	37	66.0	11.3	30.2	66.0	22.0	26.0	40.0		10°	80	8.0	0.48	39000
						1.575	*.236*	*1.457*	*2.598*	*.445*	*1.189*	*2.598*	*.866*	*1.024*	*1.575*			*1160*			
	8	3	1	6	**930-C4-S-08-066**	40.0	8.0	37	66.0	11.3	30.2	66.0	24.0	28.0	40.0		10°	80	8.0	0.50	39000
						1.575	*.315*	*1.457*	*2.598*	*.445*	*1.189*	*2.598*	*.945*	*1.102*	*1.575*			*1160*			
	10	3	1	6	**930-C4-S-10-072**	40.0	10.0	41	72.0	11.3	34.2	72.0	26.0	30.0	40.0		10°	80	8.0	0.55	39000
						1.575	*.394*	*1.614*	*2.835*	*.445*	*1.346*	*2.835*	*1.024*	*1.181*	*1.575*			*1160*			
C5	6	3	1	6	**930-C5-S-06-068**	50.0	6.0	37	68.0	11.3	30.2	68.0	22.0	26.0	50.0		10°	80	8.0	0.75	28000
						1.969	*.236*	*1.457*	*2.677*	*.445*	*1.189*	*2.677*	*.866*	*1.024*	*1.969*			*1160*			
	8	3	1	6	**930-C5-S-08-070**	50.0	8.0	37	70.0	11.3	32.2	70.0	24.0	28.0	50.0		10°	80	8.0	0.77	28000
						1.969	*.315*	*1.457*	*2.756*	*.445*	*1.268*	*2.756*	*.945*	*1.102*	*1.969*			*1160*			
	10	3	1	6	**930-C5-S-10-072**	50.0	10.0	41	72.0	11.3	34.2	72.0	26.0	30.0	50.0		10°	80	8.0	0.80	20000
						1.969	*.394*	*1.614*	*2.835*	*.445*	*1.346*	*2.835*	*1.024*	*1.181*	*1.969*			*1160*			
C6	6	3	1	10	**930-C6-S-06-074**	63.0	6.0	37	74.0	11.3	30.2	48.1	22.0	26.0	50.0	63	10°	80	8.0	1.15	20000
						2.480	*.236*	*1.457*	*2.913*	*.445*	*1.189*	*1.894*	*.866*	*1.024*	*1.969*	*2.480*		*1160*			
	8	3	1	10	**930-C6-S-08-076**	63.0	8.0	37	76.0	11.3	32.2	50.1	24.0	28.0	50.0	63	10°	80	8.0	1.17	20000
						2.480	*.315*	*1.457*	*2.992*	*.445*	*1.268*	*1.972*	*.945*	*1.102*	*1.969*	*2.480*		*1160*			
	10	3	1	10	**930-C6-S-10-078**	63.0	10.0	41	78.0	11.3	34.2	52.1	26.0	30.0	50.0	63	10°	80	8.0	1.20	20000
						2.480	*.394*	*1.614*	*3.071*	*.445*	*1.346*	*2.051*	*1.024*	*1.181*	*1.969*	*2.480*		*1160*			

Inch bore

					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	LB_3	BD_1	BD_2	BD_4	$BHTA_1$	$BHTA_3$				RPMX
C6	1	3	1	**930-C6-S-A25-098**	63.0	25.4	57	98.0	12.9	72.1	76.0	45.0	50.0	63	11°	59°	80	8.0	1.60	20000
					2.480	*1.000*	*2.244*	*3.858*	*.508*	*2.839*	*2.992*	*1.772*	*1.969*	*2.480*			*1160*			

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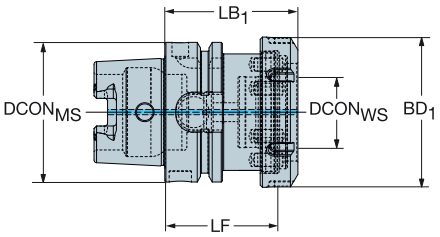
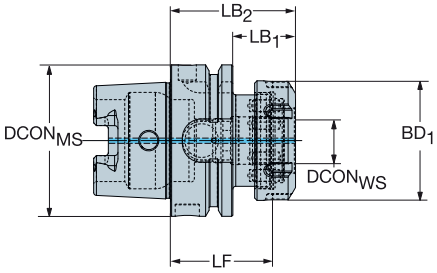
G1 H2 H7

HSK to MDI adaptor

Machine side interface HSK A/C/T





Metric bore

					Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR PSI	NM	KG	RPMX
63.0	MDI-20	1	1	**HT06-DM20-N-042**	63.0	20.0	42.0	26.0	52.0	49.7	63.0	80	135.0	0.86	20000
					2.480	*.787*	*1.654*	*1.026*	*2.047*	*1.957*	*2.480*	*1160*			
	MDI-25	1	1	**HT06-DM25-N-050**	63.0	25.0	50.0	34.0	60.0	62.7	63.0	80	170.0	1.10	20000
					2.480	*.984*	*1.969*	*1.341*	*2.362*	*2.469*	*2.480*	*1160*			
	MDI-32	1	1	**HT06-DM32-N-050**	63.0	32.0	50.0	60.0		67.7		80	200.0	1.18	20000
					2.480	*1.260*	*1.969*	*2.362*		*2.665*		*1160*			

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

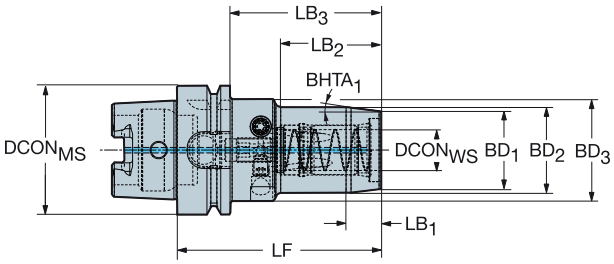
G1 H2 H7

ENG

HSK to CoroChuck™ 930

Slender design

Machine side interface HSK A/C



Metric bore

					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	KG	RPMX
63.0	6	1	1	**930-HA06-S-06-074**	63.0	6.0	37	74.0	11.3	30.2	48.0	22.0	26.0	40.0	63.0	10°	80	0.90	20000
					2.480	*.236*	*1.457*	*2.913*	*.445*	*1.189*	*1.890*	*.866*	*1.024*	*1.575*	*2.480*		*1160*		
	8	1	1	**930-HA06-S-08-074**	63.0	8.0	37	74.0	11.3	30.2	48.0	24.0	28.0	40.0	63.0	10°	80	0.91	20000
					2.480	*.315*	*1.457*	*2.913*	*.445*	*1.189*	*1.890*	*.945*	*1.102*	*1.575*	*2.480*		*1160*		
	10	1	1	**930-HA06-S-10-080**	63.0	10.0	41	80.0	11.3	34.2	54.0	26.0	30.0	40.0	63.0	10°	80	0.99	20000
					2.480	*.394*	*1.614*	*3.150*	*.445*	*1.346*	*2.126*	*1.024*	*1.181*	*1.575*	*2.480*		*1160*		

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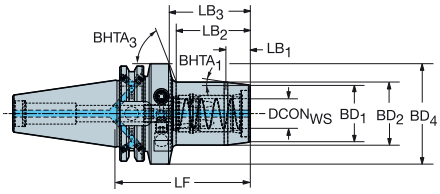
G1 H2 H7

ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB

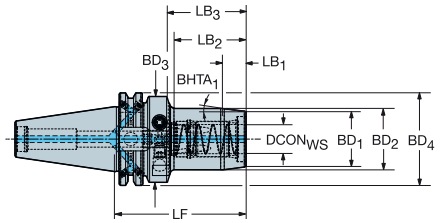
Metric bore



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	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	BAR PSI	NM	KG	RPMX
40.0	6	7	1	10	**930-I40-S-06-068**	6.0	M16	37	68.0	11.3	30.2	48.9	22.0	26.0	40.0	63	10°	80	8.0	1.06	18000
						.236		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.866*	*1.024*	*1.575*	*2.500*		*1160*			
	8	7	1	10	**930-I40-S-08-068**	8.0	M16	37	68.0	11.3	30.2	48.9	24.0	28.0	40.0	63	10°	80	8.0	1.07	18000
						.315		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.945*	*1.102*	*1.575*	*2.500*		*1160*			
	10	7	1	10	**930-I40-S-10-072**	10.0	M16	41	72.0	11.3	34.2	52.9	26.0	30.0	40.0	63	10°	80	8.0	1.11	18000
						.394		*1.614*	*2.835*	*.445*	*1.346*	*2.083*	*1.024*	*1.181*	*1.575*	*2.500*		*1160*			

Metric bore



BIG-PLUS

						Dimensions, mm, inch														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{WS}$	CRKS	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	7	1	10	**930-IB40-S-06-068**	6.0	M16	37	68.0	11.3	30.2	48.9	22.0	26.0	40.0	63	10°	80	8.0	1.08	18000
						.236		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.866*	*1.024*	*1.575*	*2.500*		*1160*			
	8	7	1	10	**930-IB40-S-08-068**	8.0	M16	37	68.0	11.3	30.2	48.9	24.0	28.0	40.0	63	10°	80	8.0	1.10	18000
						.315		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.945*	*1.102*	*1.575*	*2.500*		*1160*			
	10	7	1	10	**930-IB40-S-10-072**	10.0	M16	41	72.0	11.3	34.2	52.9	26.0	30.0	40.0	63	10°	80	8.0	1.13	18000
						.394		*1.614*	*2.835*	*.445*	*1.346*	*2.083*	*1.024*	*1.181*	*1.575*	*2.500*		*1160*			

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

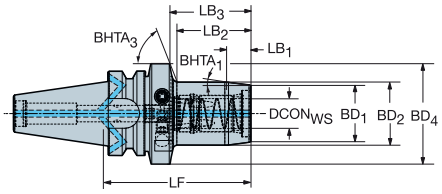
G1 H2 H7

ENG

MAS-BT 403 to CoroChuck™ 930

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

Metric bore



Slender design

					Dimensions, mm, inch												BAR PSI	KG	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BD_4	$BHTA_1$			RPMX
40.0	6	7	1	**930-B40-S-06-075**	6.0	M16	37	75.0	11.3	30.2	48.0	22.0	26.0	40.0	63.0	10°	80	1.21	18000
					.236		*1.457*	*2.953*	*.445*	*1.189*	*1.890*	*.866*	*1.024*	*1.575*	*2.480*		*1160*		
	8	7	1	**930-B40-S-08-075**	8.0	M16	37	75.0	11.3	30.2	48.0	24.0	28.0	40.0	63.0	10°	80	1.23	18000
					.315		*1.457*	*2.953*	*.445*	*1.189*	*1.890*	*.945*	*1.102*	*1.575*	*2.480*		*1160*		
	10	7	1	**930-B40-S-10-080**	10.0	M16	41	80.0	11.3	34.2	53.0	26.0	30.0	40.0	63.0	10°	80	1.27	18000
					.394		*1.614*	*3.150*	*.445*	*1.346*	*2.087*	*1.024*	*1.181*	*1.575*	*2.480*		*1160*		

BIG-PLUS

					Dimensions, mm, inch												BAR PSI	KG	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BD_4	$BHTA_1$			RPMX
40.0	6	7	1	**930-BB40-S-06-075**	6.0	M16	37	75.0	11.3	30.2	48.0	22.0	26.0	40.0	63.0	10°	80	1.23	18000
					.236		*1.457*	*2.953*	*.445*	*1.189*	*1.890*	*.866*	*1.024*	*1.575*	*2.480*		*1160*		
	8	7	1	**930-BB40-S-08-075**	8.0	M16	37	75.0	11.3	30.2	48.0	24.0	28.0	40.0	63.0	10°	80	1.25	18000
					.315		*1.457*	*2.953*	*.445*	*1.189*	*1.890*	*.945*	*1.102*	*1.575*	*2.480*		*1160*		
	10	7	1	**930-BB40-S-10-080**	10.0	M16	41	80.0	11.3	34.2	53.0	26.0	30.0	40.0	63.0	10°	80	1.29	18000
					.394		*1.614*	*3.150*	*.445*	*1.346*	*2.087*	*1.024*	*1.181*	*1.575*	*2.480*		*1160*		

BIG-PLUS® SYSTEM licensed by BIG Daishowa

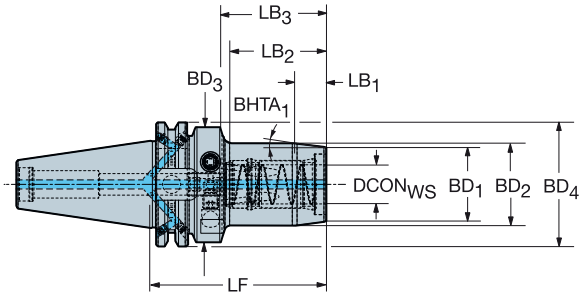
For spare parts, visit www.sandvik.coromant.com

G1 H2 H7

CAT-V to CoroChuck™ 930

Slender design

Machine side interface ASME B5.50-2009

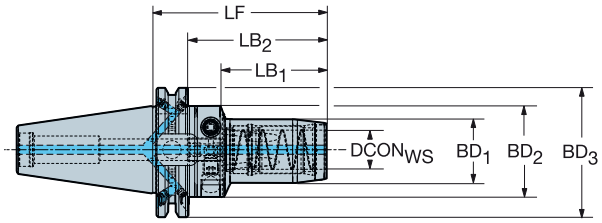


Metric bore

					Dimensions, mm, inch														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	BAR PSI	KG	RPMX
40.0	6	7	1	930-V40-S-06-068	6.0	5/8"-11	37	68.0	11.3	30.2	48.9	22.0	26.0	40.0	63.5	10°	80	1.06	18000
					.236		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.866*	*1.024*	*1.575*	*2.500*		*1160*		
	8	7	1	930-V40-S-08-068	8.0	5/8"-11	37	68.0	11.3	30.2	48.9	24.0	28.0	40.0	63.5	10°	80	1.08	18000
					.315		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.945*	*1.102*	*1.575*	*2.500*		*1160*		
	10	7	1	930-V40-S-10-072	10.0	5/8"-11	41	72.0	11.3	34.2	52.9	26.0	30.0	40.0	63.5	10°	80	1.11	18000
					.394		*1.614*	*2.835*	*.445*	*1.346*	*2.083*	*1.024*	*1.181*	*1.575*	*2.500*		*1160*		

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

Machine side interface ASME B5.50-2009



BIG-PLUS

					Dimensions, mm, inch														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	BAR PSI	KG	RPMX
40.0	6	7	1	930-VB40-S-06-068	6.0	5/8"-11	37	68.0	11.3	30.2	48.9	22.0	26.0	40.0	63.5	10°	80	1.09	18000
					.236		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.866*	*1.024*	*1.575*	*2.500*		*1160*		
	8	7	1	930-VB40-S-08-068	8.0	5/8"-11	37	68.0	11.3	30.2	48.9	24.0	28.0	40.0	63.5	10°	80	1.11	18000
					.315		*1.457*	*2.677*	*.445*	*1.189*	*1.925*	*.945*	*1.102*	*1.575*	*2.500*		*1160*		
	10	7	1	930-VB40-S-10-072	10.0	5/8"-11	41	72.0	11.3	34.2	52.9	26.0	30.0	40.0	63.5	10°	80	1.14	18000
					.394		*1.614*	*2.835*	*.445*	*1.346*	*2.083*	*1.024*	*1.181*	*1.575*	*2.500*		*1160*		

G1 H2 H7

Accessories

Torque wrenches

Torque wrench	
ER-TK-01M	10-50 Nm
ER-TK-02M	60-300 Nm

	ER size	MDI
5680 103-05	ER 32	20
5680 103-06	ER 40	25
5680 103-07		32
5680 103-08		40

CoroChuck™ 970

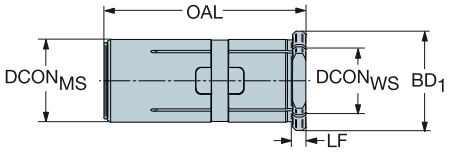
	ER size
391.530-970-11	ER 11
391.530-970-20	ER 20
391.530-970-25	ER 25
391.530-970-32	ER 32
391.530-970-40	ER 40

ENG

Cylindrical sleeves

Collet with mechanical locking interface

393.CLF
A393.CLF



Metric bore

Application	Ordering code	Dimensions, mm DCONWS	DCONMS	BD1	LF	OAL	Accessories Anchor screw	Assembly tool
CoroChuck® 930 HD32	393.CLF-321660	16	32	37	4	65	5519 140-02	5680 140-02
	393.CLF-322060	20	32	37	4	65		
	393.CLF-322560	25	32	37	4	65		
CoroChuck® 930 HD/S25	393.CLF-251256	12	25	30	4	61	5519 140-02	5680 140-02
	393.CLF-251656	16	25	30	4	61		
	393.CLF-252056	20	25	30	4	61		
CoroChuck® 930 HD/S20	393.CLF-201052	10	20	25	4	55	5519 140-01	5680 140-01
	393.CLF-201252	12	20	25	4	55		
	393.CLF-201652	16	20	25	4	55		

Inch bore

Application	Ordering code	Dimensions, inch DCONWS	DCONMS	BD1	LF	OAL	Accessories Anchor screw	Assembly tool
CoroChuck® 930 HD32	A393.CLF-321060	5/8	1.260	1.417	.157	2.559	5519 140-02	5680 140-02
	A393.CLF-321260	3/4	1.260	1.417	.157	2.559		
	A393.CLF-321660	1	1.260	1.417	.157	2.559		
CoroChuck® 930 HD/S25	A393.CLF-250856	1/2	.984	1.181	.157	2.401	5519 140-02	5680 140-02
	A393.CLF-251056	5/8	.984	1.181	.157	2.401		
	A393.CLF-251256	3/4	.984	1.181	.157	2.401		
CoroChuck® 930 HD/S20	A393.CLF-200652	3/8	.787	.984	.157	2.165	5519 140-01	5680 140-01
	A393.CLF-200852	1/2	.787	.984	.157	2.165		
	A393.CLF-201052	5/8	.787	.984	.157	2.165		

Anchor screw and assembly tool to be ordered separately.

General information

To make life easier, a new standard has been developed

B

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?

C

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
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
$CICT_E$	Cutting item count - end position
$CICT_P$	Cutting item count - peripheral position
$CICT_S$	Cutting item count - side position
$CICT_T$	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

D

E

F

G

H

ENG

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
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
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
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
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	Theoretical radius value required for programming purpose
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
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
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count (ZEFP)
ZWX	Maximum number of Wiper inserts

Safety information

Safety information in connection with grinding of cemented carbide

Material compositon

Tool holders
Tool holders mainly contain iron (FE), and low alloy elements such as chromium, nickel, manganese, molybdenum and silicon.
Indexable inserts/cutting tools/round tools
Substances in cemented carbide products contain mostly wolfram carbide and cobalt. They may also contain carbides and carbonitrides of the following elements: titanium, tantalum, niobium, chromium, molybdenum and vanadium.

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

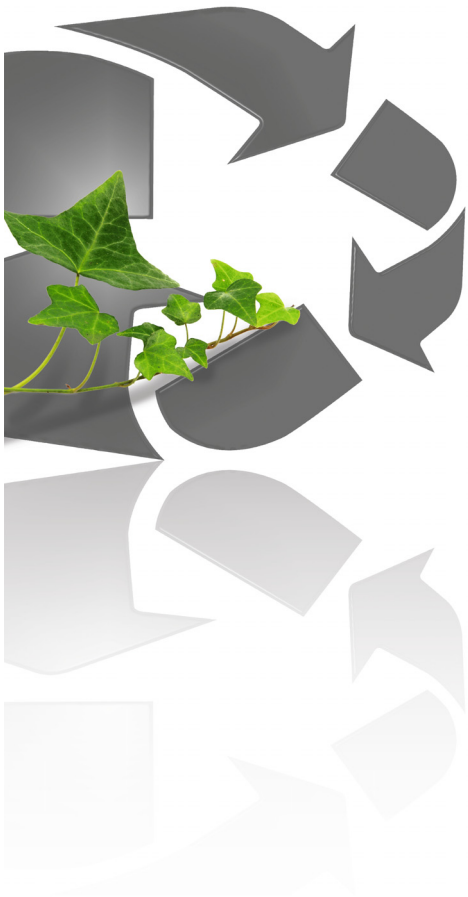
Preventive measures

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

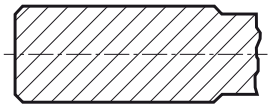
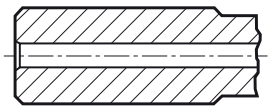
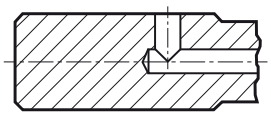
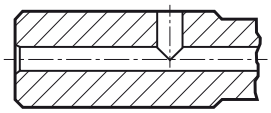
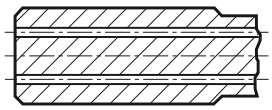
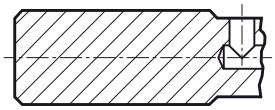
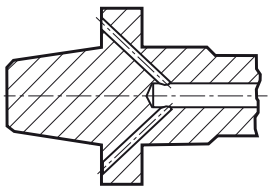
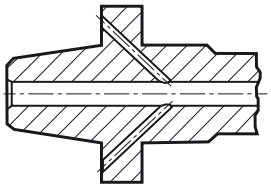
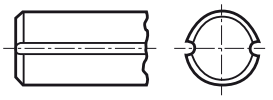
- A worldwide ISO and OHAS certified recycling system.
- Open to all Sandvik Coromant customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.

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

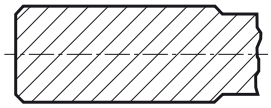
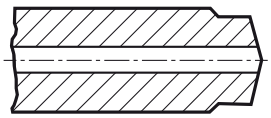
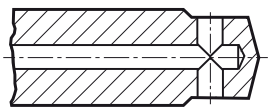
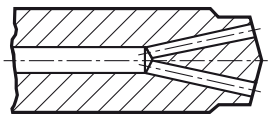
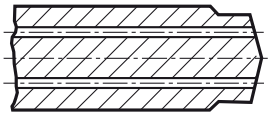
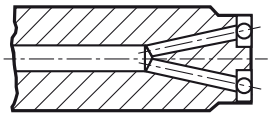
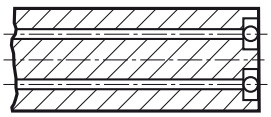
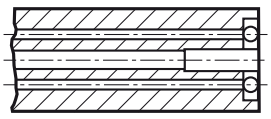
CNSC

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	

General turning inserts

Inserts, metric

C	N	M	G	12	04	08	–			–	PF
1	2	3	4	5	6	7		8	9		12

Inserts, inch

C	N	M	G	4	3	2	–			–	PF
1	2	3	4	5	6	7		8	9		12

Inserts, advanced cutting materials, metric

C	N	M	G	12	04	08	–	T	010	20
1	2	3	4	5	6	7		8	10	11

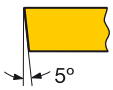
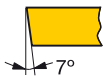
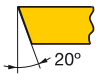
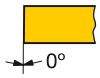
Inserts, advanced cutting materials, inch

C	N	G	A	4	3	2	–	T	03	20
1	2	3	4	5	6	7		8	10	11

1 Insert shape

C		D	
K		R	
S		T	
V		W	

2 Insert clearance angle

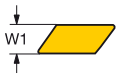
B		C	
E		N	
P		O	Specific description

3 Tolerances, metric

Class	S	IC / W1
G	±0.13	±0.025
M	±0.13	±0.05 – ±0.15[1)]
U	±0.13	±0.08 – ±0.25[1)]
E	±0.025	±0.025

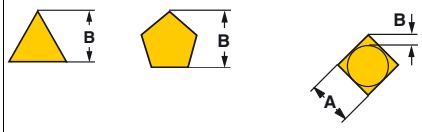
[1)]Varies depending on the size of IC. See below.

Inscribed circle IC mm	Tolerance class M	U
3.97 5.0 5.56 6.0 6.35 8.0 9.525 10.0	±0.05	±0.08
12.0 12.7	±0.08	±0.13
15.875 16.0 19.05 20.0	±0.10	±0.18
25.0 25.4	±0.13	±0.25
31.75 32.0	±0.15	±0.25



For positive inserts iC is valid for a sharp corner. See cutting edge condition F. (Picture 8).

3 Tolerances, inch



A: Theoretical diameter of the insert inscribed circle.

T: Thickness of the insert.
B: See figures.

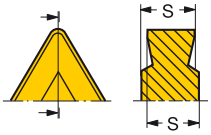
Tolerances in inch

Clas	B:	A:	T:
A	±.0002	±.001	±.001
B	.0002	.001	.005
C	.0005	.001	.001
D	.0005	.001	.005
E	.001	.001	.001
F	.0002	.0005	.001
G	.001	.001	.005
H	.0005	.0005	.001
J	.0002	.002-.005	.001
K	.0005	.002-.005	.001
L	.001	.002-.005	.001
M	.002-.005	.002-.005	.005
U	.005-.012	.005-.010	.005
N	.002-.010	.002-.004	.001

ENG

General turning inserts

6 Insert thickness, S mm



01	S = 1.59
T1	S = 1.98
02	S = 2.38
03	S= 3.18
T3	S = 3.97
04	S = 4.76
05	S = 5.56
06	S = 6.35
07	S = 7.94
09	S = 9.52
10	S = 10.00
12	S = 12.00

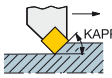
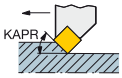
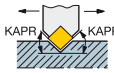
7 Nose radius, RE mm

00* = 0
01 = 0.1
02 = 0.2
04 = 0.4
05 = 0.5
08 = 0.8
10 = 1.0
12 = 1.2
15 = 1.5
16 = 1.6
24 = 2.4
32 = 3.2

8 Cutting edge condition

F		Sharp cutting edge
A		ER treated cutting edge (ANSI)
E		ER treated cutting edge
T		Negative land
K		Double negative lands
S		Negative land and ER treated cutting edge

9 Hand of tool

R		Feed
L	Feed 	
N	Feed 	Feed

12 Manufacturer's option

The ISO code consists of nine symbols including 8 and 9 which are used only when required. In addition the manufacturer may add further three symbols e. g.

- WF = Wiper – finishing
- WMX = Wiper, medium machining
- PF = ISO P – finishing
- PR = ISO P – roughing
- HGR = Chip breaker for removal of hardened layer

7 * Code on round inserts

Code 00 or M0 in position 7 is used on round inserts in the metric code. M0 shows that the diameter of the insert has a metric even dimension. In the inch code for round inserts, position 7 isn't used at all. It's blank.