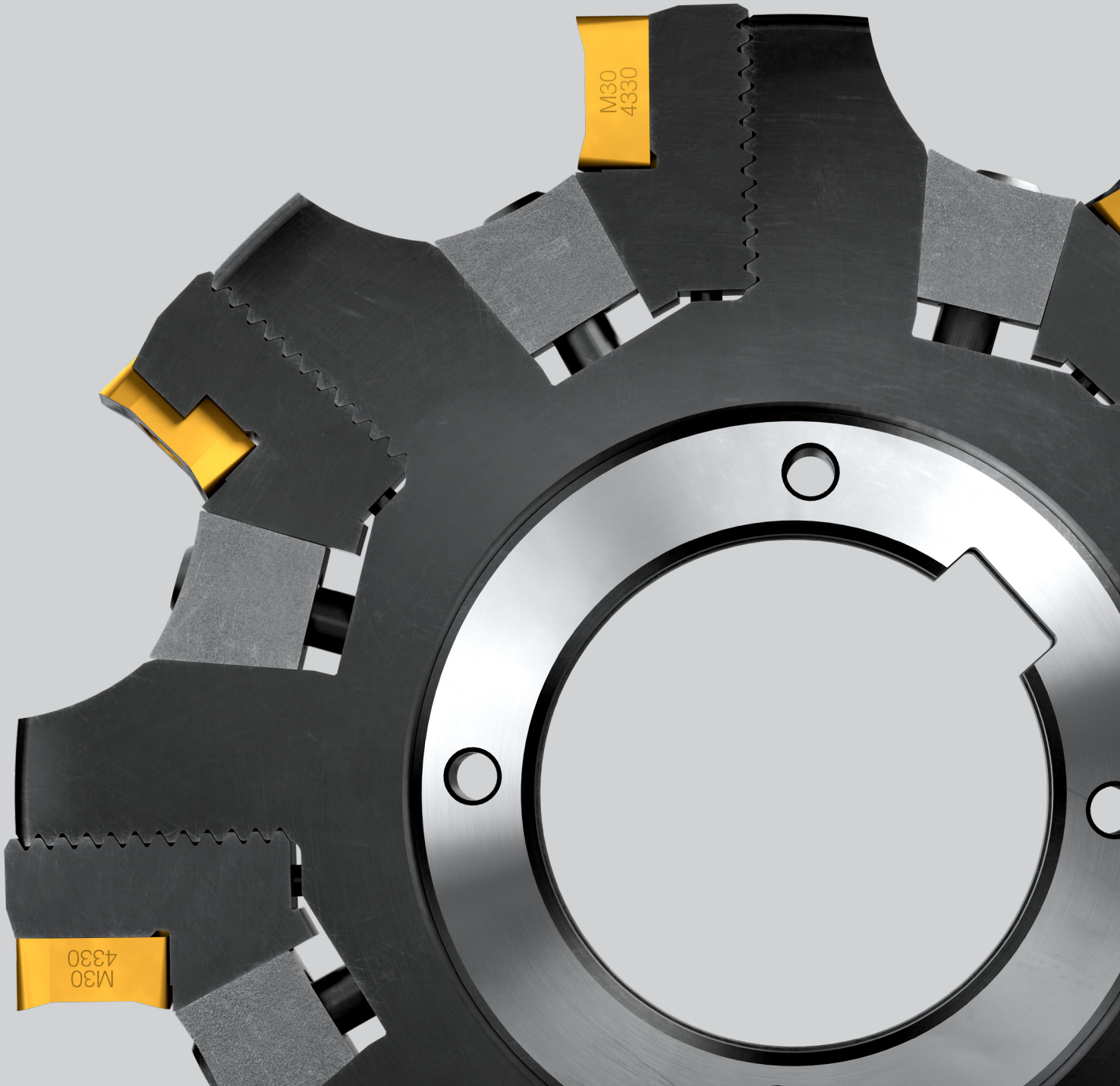
SANDVIK Coromant

2018.2

Supplement

– TO TURNING TOOLS AND ROTATING TOOLS CATALOGUES

GENERAL TURNING
PARTING AND GROOVING
MILLING
DRILLING
TAPPING
BORING
ROTATING TOOL ADAPTORS
ACCESSORIES



General turning

CB7125 and CB7135

Hard part turning

Grades developed for medium to heavy interrupted cuts in hard part turning.

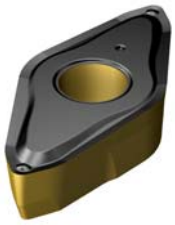
See chapter A

CoroTurn® Prime

Insert for turning, -L4 geometry

- Designed for finishing operations in unstable set-ups and for slender components
- Available in grades GC4325 (ISO P), GC1115 (ISO M and S) and H13A (Titanium) for B-type inserts

See page 8

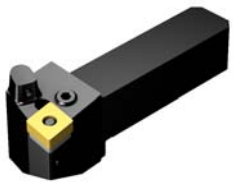


T-Max® P

QS™ shank tool for turning

QS™ shanks for T-max® P, offering both over and under coolant as well as improved possibilities to connect coolant compared to our existing HP tools.

See page 19



Parting and grooving

CoroCut® QF

Face grooving

Concept dedicated for face grooving, offering superior process security and stable insert clamping interface. The strong design ensures high blade stiffness.

- Two additional geometries: -GF geometry for grooving and -RM geometry for profiling

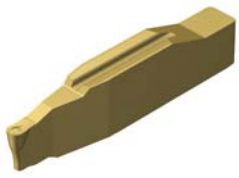
See page 30

CoroCut® 1-2

Seal fin grooving

- 1.5 mm (.059 inch) insert width, for machining of smaller seal fin features
- New CoroTurn® SL70 heads to complement the existing modular assortment

See page 41



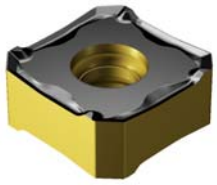
Milling

GC4330 and GC4340

Steel grades

A new substrate, Inveio® coating and an improved post treatment technology provide increased tool life and improved process security.

See chapter C



CoroMill® 331

High quality disc milling

Cutter bodies with internal coolant, shortened arbor length, light cutting geometry for ISO P and ISO K, dedicated geometries for ISO M and ISO S and new surface treatment on wedge.

- Internal coolant assortment extended with more couplings
- Extension of light-cutting geometries for ISO P, K, M and S

See page 51

CoroMill® Plura

ISO S milling in aerospace applications

- Carbide for frame applications
- Ceramic for engine applications

See page 67

CoroMill® 316

ISO S milling in aerospace applications

- Carbide for frame applications
- Ceramic for engine applications

See page 68

Drilling

CoroDrill® 400 and CoroDrill® 430

ISO N

CoroDrill 400 straight flute drill and CoroDrill 430 3-flute drill optimized for ISO N.
New grades:

- N1BU: Tungsten Carbide
- N1DU: Veined PCD

See page 80

CoroDrill® 452

Drilling composites

Range extension for composite drilling and aerospace.

See page 82

CoroDrill® 870

New grades

- Zertivo® coating for all geometries
- Increased tool life and wear predictability

See page 84

Tapping

CoroTap™

ISO N

- All thread forms, optimized for aluminium.

See chapter E

Boring

CoroBore® BR20

Extension of insert carriers

- TC insert carriers and kits for CoroBore® BR20 and CoroBore® BR20 with Silent Tools™ damping, KAPR 90°
- CNMU, non-ISO, insert carriers and kits for CoroBore® BR20-, KAPR 90°
- SPMT insert carriers for CoroBore® BR20 with Silent Tools™ damping, KAPR 84°

See page 126

CoroBore® BR30

Multi-edge solution for cavity boring

- A multi-edge rough boring solution for all industry segments, but optimized for cavities and flow bores within the oil and gas industry
- Can be ordered as a complete tool assembly including kits and adaptors

See page 131

CoroBore® XL

Smaller insert size

- Cartridge (SP12, KAPR 84°)
- Lightweight kits (SP12, KAPR 84° and CC12, KAPR 90°)
- Lightweight bridge kits (SP12, KAPR 84°) to be used with 40S face mill adaptor
- Smaller insert size to secure a stable machining process for aluminium bridges

See page 132

CoroBore® 826 HP

Cartridge sets

Two cartridge sets to increase the diameter range of each tool body/kit.

See page 134

Rotating tools and accessories

Coromant Capto®

Face mill adaptors

Face mill adaptors with coolant through arbor

See page 136

Coromant Capto® and HSK

ER collet chuck

ER collet chuck extension: Coromant Capto® short versions and HSK63 to ER20

See chapter G

CoroChuck™ 970

New collet size

Adaptors and collets size ER32 for CoroChuck® 970

See chapter G and H

DIN 2080 to Coromant Capto® adaptor

Quick change adaptors

Rotating quick change adaptors with DIN 2080 machine side interface

See page 143

Coromant EH to CoroMill® 327 adaptor

New adaptor

Adaptor with Coromant EH interface in the backend and CoroMill® 327 interface in the front

See page 144

Sleeves

Extension of sizes

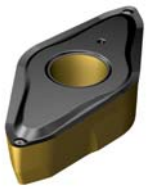
CF cylindrical sleeve in more sizes and with improved, more precise coolant flow

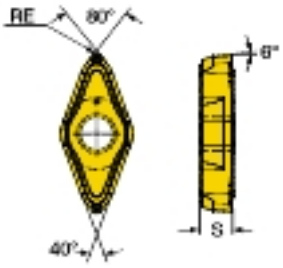
See page 146

ENG

General turning

CoroTurn® Prime insert for turning





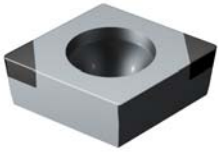
Metric version

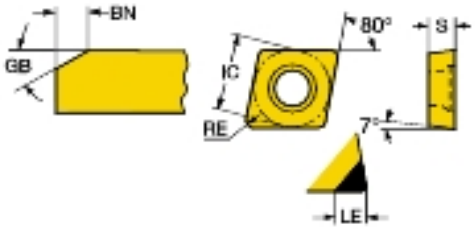
		SSC	S	RE	ISO CODE	P 4325	P H13A	M 1115	M H13A	S 1115	S H13A
Medium	L4	CP-B	5.00	0.79	CP-B1108-L4	★	☆	★	☆	★	☆
	L4W	CP-B	5.00	0.79	CP-B1108-L4W	★	☆	★	☆	★	☆

25 150

CoroTurn® 107 insert for turning

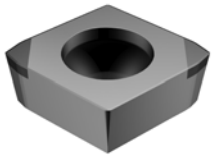
C-style insert (Rhombic 80°)

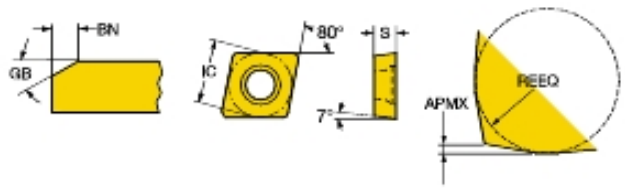




Advanced cutting materials

	IC	LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	06	1/4	2.6	2.38	0.2	20°	0.10	CCGW060202T01020F	★		CCGW2(1.5)0T0320F
			.102	*.094*	*.008*	*20°*	*.004*			
			2.6	2.38	0.4	20°	0.10	CCGW060204S01020F	★		CCGW2(1.5)1S0320F
			.102	*.094*	*.016*	*20°*	*.004*			
			2.6	2.38	0.4	30°	0.15	CCGW060204S01530F		★	CCGW2(1.5)1S0530F
			.102	*.094*	*.016*	*30°*	*.006*			
	09	3/8	2.6	3.97	0.4	20°	0.10	CCGW09T304S01020F	★		CCGW3(2.5)1S0320F
			.102	*.156*	*.016*	*20°*	*.004*			
			2.6	3.97	0.4	30°	0.15	CCGW09T304S01530F		★	CCGW3(2.5)1S0530F
			.102	*.156*	*.016*	*30°*	*.006*			
			2.5	3.97	0.8	20°	0.10	CCGW09T308S01020F	★		CCGW3(2.5)2S0320F
			.098	*.156*	*.031*	*20°*	*.004*			
			2.5	3.97	0.8	30°	0.15	CCGW09T308S01530F		★	CCGW3(2.5)2S0530F
			.098	*.156*	*.031*	*30°*	*.006*			
			2.5	3.97	0.8	30°	0.20	CCGW09T308S02030F	★		CCGW3(2.5)2S0830F
			.098	*.156*	*.031*	*30°*	*.008*			
			2.4	3.97	1.2	20°	0.10	CCGW09T312S01020F	★		CCGW3(2.5)3S0320F
			.094	*.156*	*.047*	*20°*	*.004*			
			2.6	3.97	0.4	20°	0.15	CCGW09T304S01520FWH	★		CCGW3(2.5)1S0520FWH
			.102	*.156*	*.016*	*20°*	*.006*			
			2.5	3.97	0.8	20°	0.15	CCGW09T308S01520FWH	★		CCGW3(2.5)2S0520FWH
			.098	*.156*	*.031*	*20°*	*.006*			





Advanced cutting materials - Xcel geometry

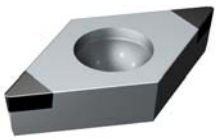
	IC	LE	S	REEQ	APMX	GB	BN	ISO CODE	H 7125
Finishing	09	3/8	2.3	3.97	1.9	0.2	15°	0.15	CCGX09T3L020-15FXA	★
			.091	*.156*	*.075*	*.008*	*15°*	*.006*		

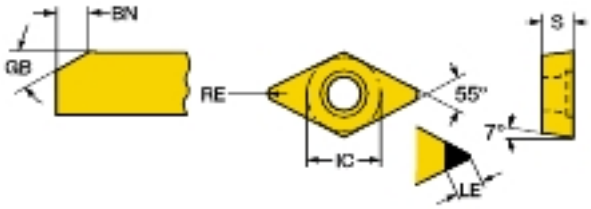
25 150 156

CoroTurn® 107 insert for turning

D-style insert (Rhombic 55°)

Advanced cutting materials





			LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	07	1/4	2.5	2.38	0.2	20°	0.10	DCGW070202T01020F	★		DCGW2(1.5)0T0320F
			.098	*.094*	*.008*	*20°*	*.004*				
			2.9	2.38	0.4	20°	0.10	DCGW070204S01020F	★		DCGW2(1.5)1S0320F
			.114	*.094*	*.016*	*20°*	*.004*				
			2.9	2.38	0.4	30°	0.15	DCGW070204S01530F		★	DCGW2(1.5)1S0530F
			.114	*.094*	*.016*	*30°*	*.006*				
			2.5	2.38	0.8	20°	0.10	DCGW070208S01020F	★		DCGW2(1.5)2S0320F
			.098	*.094*	*.031*	*20°*	*.004*				
	11	3/8	2.9	3.97	0.4	20°	0.10	DCGW11T304S01020F	★		DCGW3(2.5)1S0320F
			.114	*.156*	*.016*	*20°*	*.004*				
			2.9	3.97	0.4	30°	0.15	DCGW11T304S01530F		★	DCGW3(2.5)1S0530F
			.114	*.156*	*.016*	*30°*	*.006*				
			2.5	3.97	0.8	20°	0.10	DCGW11T308S01020F	★		DCGW3(2.5)2S0320F
			.098	*.156*	*.031*	*20°*	*.004*				
			3.1	3.97	0.8	30°	0.15	DCGW11T308S01530F		★	DCGW3(2.5)2S0530F
			.122	*.156*	*.031*	*30°*	*.006*				
			2.5	3.97	0.8	30°	0.20	DCGW11T308S02030F	★		DCGW3(2.5)2S0830F
			.098	*.156*	*.031*	*30°*	*.008*				
			2.1	3.97	1.2	20°	0.10	DCGW11T312S01020F	★		DCGW3(2.5)3S0320F
			.083	*.156*	*.047*	*20°*	*.004*				

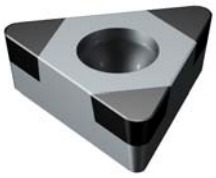
25 150 156

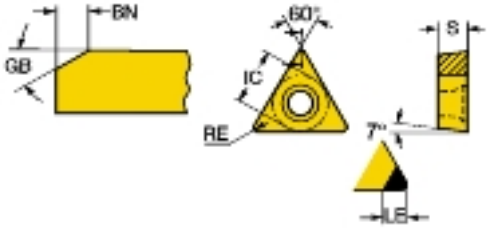
ENG

CoroTurn® 107 insert for turning

T-style insert (Triangular)

Advanced cutting materials





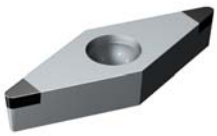
		IC	LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	09	7/32	2.5	2.38	0.2	20°	0.10	TCGW090202T01020F	★		TCGW1.8(1.5)0T0320F
			.098	*.094*	*.008*	*20°*	*.004*				
			2.8	2.38	0.4	20°	0.10	TCGW090204S01020F	★		TCGW1.8(1.5)1S0320F
			.110	*.094*	*.016*	*20°*	*.004*				
			2.8	2.38	0.4	30°	0.15	TCGW090204S01530F		★	TCGW1.8(1.5)1S0530F
			.110	*.094*	*.016*	*30°*	*.006*				
	11	1/4	2.8	3.18	0.4	20°	0.10	TCGW110304S01020F	★		TCGW221S0320F
			.110	*.125*	*.016*	*20°*	*.004*				
			2.8	3.18	0.4	30°	0.15	TCGW110304S01530F		★	TCGW221S0530F
			.110	*.125*	*.016*	*30°*	*.006*				
			2.5	3.18	0.8	20°	0.10	TCGW110308S01020F	★		TCGW222S0320F
			.098	*.125*	*.031*	*20°*	*.004*				

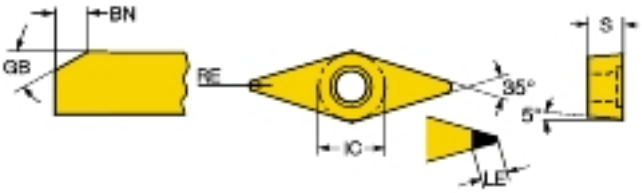
25 150 156

CoroTurn® 107 insert for turning

V-style insert (Rhombic 35°)

Advanced cutting materials



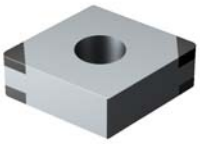


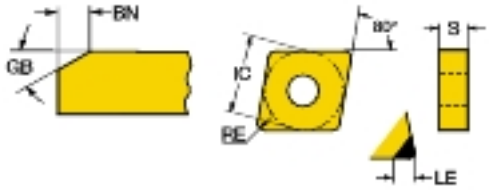
			LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	11	1/4	2.5	3.18	0.4	20°	0.10	VBGW110304S01020F	★		VBGW221T0320F
			.098	*.125*	*.016*	*20°*	*.004*				
			2.5	3.18	0.4	30°	0.15	VBGW110304S01530F		★	VBGW221T0530F
			.098	*.125*	*.016*	*30°*	*.006*				
	16	3/8	2.5	4.76	0.4	20°	0.10	VBGW160404S01020F	★		VBGW331S0320F
			.098	*.187*	*.016*	*20°*	*.004*				
			2.5	4.76	0.4	30°	0.15	VBGW160404S01530F		★	VBGW331S0530F
			.098	*.187*	*.016*	*30°*	*.006*				
			2.5	4.76	0.8	20°	0.10	VBGW160408S01020F	★		VBGW332S0320F
			.098	*.187*	*.031*	*20°*	*.004*				
			2.5	4.76	0.8	30°	0.15	VBGW160408S01530F		★	VBGW332S0530F
			.098	*.187*	*.031*	*30°*	*.006*				

25 150 156

T-Max® P insert for turning

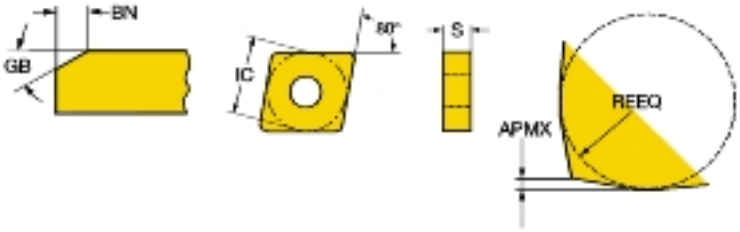
C-style insert (Rhombic 80°)





Advanced cutting materials

			LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	12	1/2	2.6	4.76	0.4	25°	0.15	CNGA120404S01525H	★		CNGA431S0525H
			.102	.187	.016	25°	.006				
			2.6	4.76	0.4	30°	0.15	CNGA120404S01530F		★	CNGA431S0530F
			.102	.187	.016	30°	.006				
			2.5	4.76	0.8	25°	0.15	CNGA120408S01525H	★		CNGA432S0525H
			.098	.187	.031	25°	.006				
			2.5	4.76	0.8	30°	0.15	CNGA120408S01530F		★	CNGA432S0530F
			.098	.187	.031	30°	.006				
			2.5	4.76	0.8	35°	0.20	CNGA120408S02035F	★		CNGA432S0835H
			.098	.187	.031	35°	.008				
			2.4	4.76	1.2	25°	0.15	CNGA120412S01525H	★		CNGA433S0525H
			.094	.187	.047	25°	.006				
			2.9	4.76	1.2	30°	0.15	CNGA120412S01530F		★	CNGA433S0530F
			.113	.187	.047	30°	.006				
			2.4	4.76	1.2	35°	0.20	CNGA120412S02035F	★		CNGA433S0835H
			.094	.187	.047	35°	.008				
			2.8	4.76	1.6	25°	0.10	CNGA120416S01025H	★		CNGA434S0325H
			.110	.187	.063	25°	.004				
			2.8	4.76	1.6	35°	0.20	CNGA120416S02035F	★		CNGA434S0835H
			.110	.187	.063	35°	.008				
			2.5	4.76	0.8	20°	0.15	CNGA120408S01520HWG	★		CNGA432S0520HWG
			.098	.187	.031	20°	.006				
			2.6	4.76	0.4	20°	0.15	CNGA120404S01520HWH	★		CNGA431S0520HWH
			.102	.187	.016	20°	.006				
			2.5	4.76	0.8	20°	0.15	CNGA120408S01520FWH		★	CNGA432S0520FWH
			.098	.187	.031	20°	.006				
			2.5	4.76	1.2	20°	0.15	CNGA120408S01520HWH	★		CNGA432S0520HWH
			.098	.187	.047	20°	.006				
			2.4	4.76	1.2	20°	0.15	CNGA120412S01520HWH	★		CNGA433S0520HWH
			.094	.187	.047	20°	.006				
Roughing	12	1/2	3.5	4.76	0.8	30°	0.12	CNGM120408F-HGR	★		CNGM432-HGR
			.138	.187	.031	30°	.005				
			3.5	4.76	1.2	30°	0.12	CNGM120412F-HGR	★		CNGA433-HGR
			.138	.187	.047	30°	.005				



Advanced cutting materials - Xcel geometry

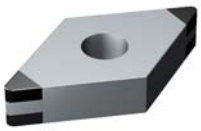
			LE	S	REEQ	APMX	GB	BN	ISO CODE	H 7125
Finishing	12	1/2	3.3	4.76	2.3	0.3	15°	0.15	CNGX1204L025-18HXA	★
			.128	.187	.091	.010	15°	.006		

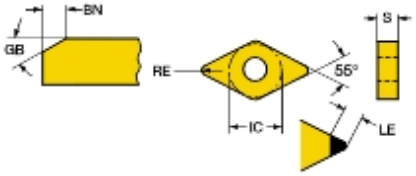
25 150 156

T-Max® P insert for turning

D-style insert (Rhombic 55°)

Advanced cutting materials





	IC	LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	3/8	2.9	4.76	0.4	25°	0.15	DNGA110404S01525H	★		DNGA331S0525H
		.114	.187	.016	25°	.006				
		2.9	4.76	0.4	30°	0.15	DNGA110404S01530F		★	DNGA331S0530F
		.114	.187	.016	30°	.006				
		2.5	4.76	0.8	25°	0.15	DNGA110408S01525H	★		DNGA332S0525H
		.098	.187	.031	25°	.006				
		2.5	4.76	0.8	30°	0.15	DNGA110408S01530F		★	DNGA332S0530F
		.098	.187	.031	30°	.006				
	1/2	2.9	4.76	0.4	25°	0.15	DNGA150404S01525H	★		DNGA431S0525H
		.114	.187	.016	25°	.006				
		2.5	4.76	0.8	25°	0.15	DNGA150408S01525H	★		DNGA432S0525H
		.098	.187	.031	25°	.006				
		2.5	4.76	0.8	30°	0.15	DNGA150408S01530F		★	DNGA432S0530F
		.098	.187	.031	30°	.006				
		2.5	4.76	0.8	35°	0.20	DNGA150408S02035F	★		DNGA432S0835H
		.098	.187	.031	35°	.008				
		3.2	4.76	1.2	25°	0.15	DNGA150412S01525H	★		DNGA433S0525H
		.125	.187	.047	25°	.006				
		3.2	4.76	1.2	30°	0.15	DNGA150412S01530F		★	DNGA433S0530F
		.125	.187	.047	30°	.006				
		3.2	4.76	1.2	35°	0.20	DNGA150412S02035F	★		DNGA433S0835H
		.125	.187	.047	35°	.008				
		2.5	4.76	1.6	25°	0.15	DNGA150416S01525H	★		DNGA434S0525H
		.098	.187	.063	25°	.006				
		2.5	4.76	0.8	20°	0.15	DNGA150408S01520HWH	★		DNGA432S0520HWH
		.098	.187	.031	20°	.006				
Roughing	1/2	3.5	4.76	0.8	30°	0.12	DNGM150408F-HGR	★		DNGM432-HGR
		.138	.187	.031	30°	.005				
		3.5	4.76	1.2	30°	0.12	DNGM150412F-HGR	★		DNGM433-HGR
		.138	.187	.047	30°	.005				

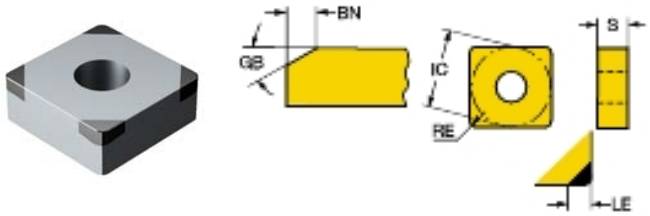
25 150 156

ENG

T-Max® P insert for turning

S-style insert (Square)

Advanced cutting materials



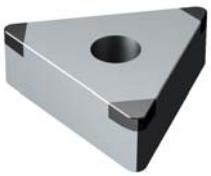
	IC	LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	12	1/2	2.5	4.76	0.8	30°	0.15	SNGA120408S01530F		★	SNGA432S0530F
			.098	.187	.031	30°	.006				
			2.8	4.76	1.2	30°	0.15	SNGA120412S01530F		★	SNGA433S0530F
			.110	.187	.047	30°	.006				
			2.8	4.76	1.6	25°	0.10	SNGA120416S01025F	★	☆	SNGA434S0325F
			.110	.187	.063	25°	.004				
			2.9	4.76	2.0	25°	0.10	SNGA120420S01025F	★		SNGA435S0325F
			.114	.187	.079	25°	.004				
			2.8	4.76	2.4	25°	0.10	SNGA120424S01025F	★	☆	SNGA436S0325F
			.110	.187	.094	25°	.004				

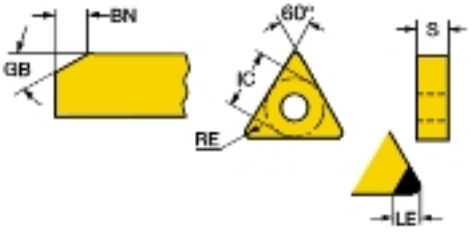
25 150 156

T-Max® P insert for turning

T-style insert (Triangular)

Advanced cutting materials





			LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	16	3/8	2.5	4.76	0.8	30°	0.15	TNGA160408S01530F		★	TNGA332S0530F
			.098	.187	.031	30°	.006				
			3.1	4.76	1.2	25°	0.10	TNGA160412S01025F	★		TNGA333S0325H
			.122	.187	.047	25°	.004				
			3.1	4.76	1.2	30°	0.15	TNGA160412S01530F		★	TNGA333S0530F
			.122	.187	.047	30°	.006				
			2.8	4.76	1.6	25°	0.10	TNGA160416S01025F	★	☆	TNGA334S0325H
			.110	.187	.063	25°	.004				
			3.9	4.76	2.0	25°	0.10	TNGA160420S01025F	★	☆	TNGA335S0325H
			.154	.187	.079	25°	.004				
			3.6	4.76	2.4	25°	0.10	TNGA160424S01025F	★	☆	TNGA336S0325H
			.142	.187	.094	25°	.004				

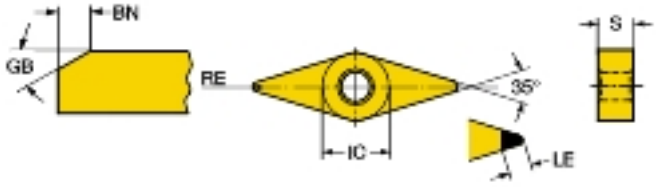
25 150 156

ENG

T-Max® P insert for turning

V-style insert (Rhombic 35°)

Advanced cutting materials



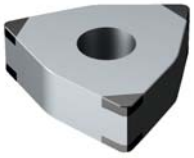
			LE	S	RE	GB	BN	ISO CODE	H 7125	ANSI CODE
Finishing	16	3/8	2.5	4.76	0.4	25°	0.15	VNGA160404S01525H	★	VNGA331S0525H
			.098	.187	.016	25°	.006			
			2.5	4.76	0.8	25°	0.15	VNGA160408S01525H	★	VNGA332S0525H
			.098	.187	.031	25°	.006			

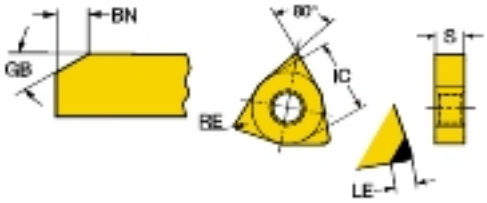
25 150 156

T-Max® P insert for turning

W-style insert (Trigon 80°)

Advanced cutting materials





			LE	S	RE	GB	BN	ISO CODE	H 7125	H 7135	ANSI CODE
Finishing	08	1/2	2.5	4.76	0.8	25°	0.15	WNGA080408S01525H	★		WNGA332S0525H
			.098	.187	.031	25°	.006				
			2.5	4.76	0.8	30°	0.15	WNGA080408S01530F		★	WNGA332S0530F
			.098	.187	.031	30°	.006				
			2.4	4.76	1.2	25°	0.15	WNGA080412S01525H	★		WNGA333S0525H
			.095	.187	.047	25°	.006				
			2.9	4.76	1.2	30°	0.15	WNGA080412S01530F		★	WNGA333S0530F
			.113	.187	.047	30°	.006				

25 150 156

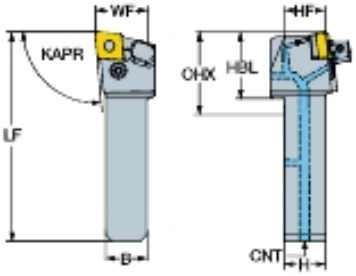
ENG

T-Max® P QS shank tool for turning

Lever clamp design

Precision coolant supply

KAPR 95.0°
PSIR -5.0°



Metric version

						Dimensions, mm, inch										
		CZC_{MS}	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR PSI	NM	KG	MIID
12	1/2	20 x 20	52.0	3	**QS-PCLNL 2020-12C**	20.0	20.0	32.0	101.0	25.0	20.0	G 1/8-28	150	5.0	0.31	CNMG 12 04 08
		2.047				*.787*	*.787*	*1.260*	*3.976*	*.984*	*.787*	*G 1/8-28*	*2175*			
		20 x 20	52.0	3	**QS-PCLNR 2020-12C**	20.0	20.0	32.0	101.0	25.0	20.0	G 1/8-28	150	5.0	0.31	CNMG 12 04 08
		2.047				*.787*	*.787*	*1.260*	*3.976*	*.984*	*.787*	*G 1/8-28*	*2175*			
		25 x 25	57.0	3	**QS-PCLNL 2525-12C**	25.0	25.0	32.0	116.0	32.0	25.0	G 1/8-28	150	5.0	0.54	CNMG 12 04 08
		2.244				*.984*	*.984*	*1.260*	*4.567*	*1.260*	*.984*	*G 1/8-28*	*2175*			
		25 x 25	57.0	3	**QS-PCLNR 2525-12C**	25.0	25.0	32.0	116.0	32.0	25.0	G 1/8-28	150	5.0	0.54	CNMG 12 04 08
		2.244				*.984*	*.984*	*1.260*	*4.567*	*1.260*	*.984*	*G 1/8-28*	*2175*			

Inch version

						Dimensions, mm, inch										
		CZC_{MS}	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR PSI	NM	KG	MIID
12	1/2	3/4 x 3/4	51.1	3	**QS-PCLNL 12 4C**	19.1	19.1	32.0	101.0	25.4	19.1	G 1/8-28	150	5.0	0.29	CNMG 12 04 08
		2.010				*.750*	*.750*	*1.260*	*3.976*	*1.000*	*.750*	*G 1/8-28*	*2175*			
		3/4 x 3/4	51.1	3	**QS-PCLNR 12 4C**	19.1	19.1	32.0	101.0	25.4	19.1	G 1/8-28	150	5.0	0.29	CNMG 12 04 08
		2.010				*.750*	*.750*	*1.260*	*3.976*	*1.000*	*.750*	*G 1/8-28*	*2175*			
		1 x 1	52.0	3	**QS-PCLNL 16 4C**	25.4	25.4	32.0	101.0	25.0	20.0	G 1/8-28	150	5.0	0.55	CNMG 12 04 08
		2.047				*1.000*	*1.000*	*1.260*	*3.976*	*.984*	*.787*	*G 1/8-28*	*2175*			
		1 x 1	57.4	3	**QS-PCLNR 16 4C**	25.4	25.4	32.0	116.0	31.8	25.4	G 1/8-28	150	5.0	0.55	CNMG 12 04 08
		2.260				*1.000*	*1.000*	*1.260*	*4.567*	*1.250*	*1.000*	*G 1/8-28*	*2175*			

R = Right hand, L = Left hand

Spare parts							
Lever	Screw	Shim	Shim pin	Nozzle	Screw	Screw	Screw
174.3-841M	174.3-821	171.31-850M	174.3-861	5691 026-13	5512 104-01	3214 013-01	3214 012-01

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

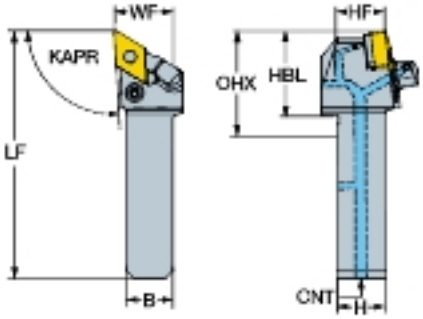
ISO 13399 150 CN8C CXSO 155

T-Max® P QS shank tool for turning

Lever clamp design

Precision coolant supply

KAPR 93.0°
PSIR -3.0°



Metric version

							Dimensions, mm, inch										
	IC	CZC_{MS}	RMPX	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR PSI	NM	KG	MIID
15	1/2	20 x 20	27°	56.0	3	QS-PDJNL 2020-15C	20.0	20.0	36.0	105.0	25.0	20.0	G 1/8-28	150	5.0	0.30	DNMG 15 06 08
				2.205			*.787*	*.787*	*1.417*	*4.134*	*.984*	*.787*	*G 1/8-28*	*2175*			
		20 x 20	27°	56.0	3	QS-PDJNR 2020-15C	20.0	20.0	36.0	105.0	25.0	20.0	G 1/8-28	150	5.0	0.30	DNMG 15 06 08
				2.205			*.787*	*.787*	*1.417*	*4.134*	*.984*	*.787*	*G 1/8-28*	*2175*			
		25 x 25	27°	61.0	3	QS-PDJNL 2525-15C	25.0	25.0	36.0	120.0	32.0	25.0	G 1/8-28	150	5.0	0.51	DNMG 15 06 08
				2.402			*.984*	*.984*	*1.417*	*4.724*	*1.260*	*.984*	*G 1/8-28*	*2175*			
		25 x 25	27°	61.0	3	QS-PDJNR 2525-15C	25.0	25.0	36.0	120.0	32.0	25.0	G 1/8-28	150	5.0	0.51	DNMG 15 06 08
				2.402			*.984*	*.984*	*1.417*	*4.724*	*1.260*	*.984*	*G 1/8-28*	*2175*			

Inch version

							Dimensions, mm, inch										
	IC	CZC_{MS}	RMPX	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR PSI	NM	KG	MIID
15	1/2	3/4 x 3/4	27°	55.1	3	QS-PDJNL 12 4C	19.1	19.1	36.0	105.0	25.4	19.1	G 1/8-28	150	5.0	0.27	DNMG 15 04 08
				2.167			*.750*	*.750*	*1.417*	*4.134*	*1.000*	*.750*	*G 1/8-28*	*2175*			
		3/4 x 3/4	27°	55.1	3	QS-PDJNR 12 4C	19.1	19.1	36.0	105.0	25.4	19.1	G 1/8-28	150	5.0	0.27	DNMG 15 04 08
				2.167			*.750*	*.750*	*1.417*	*4.134*	*1.000*	*.750*	*G 1/8-28*	*2175*			
		1 x 1	27°	61.4	3	QS-PDJNL 16 4C	25.4	25.4	36.0	120.0	31.8	25.4	G 1/8-28	150	5.0	0.53	DNMG 15 04 08
				2.417			*1.000*	*1.000*	*1.417*	*4.724*	*1.250*	*1.000*	*G 1/8-28*	*2175*			
		1 x 1	27°	61.4	3	QS-PDJNR 16 4C	25.4	25.4	36.0	120.0	31.8	25.4	G 1/8-28	150	5.0	0.53	DNMG 15 04 08
				2.417			*1.000*	*1.000*	*1.417*	*4.724*	*1.250*	*1.000*	*G 1/8-28*	*2175*			

R = Right hand, L = Left hand

Spare parts							
Lever	Screw	Shim	Shim pin	Nozzle	Screw	Screw	Screw
174.3-847M	174.3-830	171.35-851M	174.3-861	5691 026-13	5512 104-01	3214 013-01	3214 012-01

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

ISO 13399 150 CN8C CXSC 155

SANDVIK Coromant

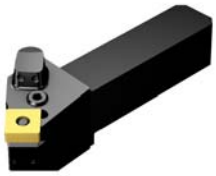
ENG

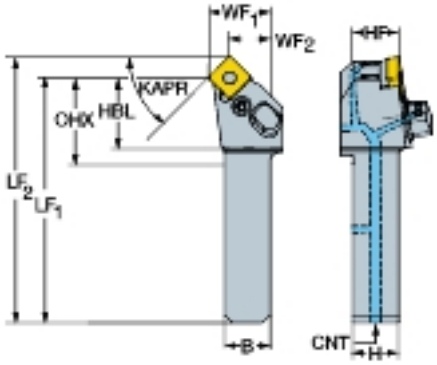
T-Max® P QS shank tool for turning

Lever clamp design

Precision coolant supply

KAPR 45.0°
PSIR 45.0°





Metric version

						Dimensions, mm, inch									BAR PSI	NM	KG	
		CZC_{MS}	OHX	CNSC	**Ordering code**	B	H	HBL	LF_1	LF_2	WF_1	WF_2	HF	CNT				MIID
12	1/2	20 x 20	52.7	3	**QS-PSSNL 2020-12C**	20.0	20.0	32.7	101.7	110.0	25.0	16.7	20.0	G 1/8-28	150	5.0	0.33	SNMG 12 04 08
			2.075			*.787*	*.787*	*1.287*	*4.004*	*4.331*	*.984*	*.657*	*.787*	*G 1/8-28*	*2175*			
		20 x 20	52.7	3	**QS-PSSNR 2020-12C**	20.0	20.0	32.7	101.7	110.0	25.0	16.7	20.0	G 1/8-28	150	5.0	0.33	SNMG 12 04 08
			2.075			*.787*	*.787*	*1.287*	*4.004*	*4.331*	*.984*	*.657*	*.787*	*G 1/8-28*	*2175*			
		25 x 25	56.7	3	**QS-PSSNL 2525-12C**	25.0	25.0	31.7	115.7	124.0	32.0	23.7	25.0	G 1/8-28	150	5.0	0.54	SNMG 12 04 08
			2.232			*.984*	*.984*	*1.248*	*4.555*	*4.882*	*1.260*	*.933*	*.984*	*G 1/8-28*	*2175*			
		25 x 25	56.7	3	**QS-PSSNR 2525-12C**	25.0	25.0	31.7	115.7	124.0	32.0	23.7	25.0	G 1/8-28	150	5.0	0.54	SNMG 12 04 08
			2.232			*.984*	*.984*	*1.248*	*4.555*	*4.882*	*1.260*	*.933*	*.984*	*G 1/8-28*	*2175*			

Inch version

						Dimensions, mm, inch									BAR PSI	NM	KG	
		CZC_{MS}	OHX	CNSC	**Ordering code**	B	H	HBL	LF_1	LF_2	WF_1	WF_2	HF	CNT				MIID
12	1/2	3/4 x 3/4	51.3	3	**QS-PSSNL 12 4C**	19.1	19.1	32.2	101.2	109.5	25.4	17.1	19.1	G 1/8-28	150	5.0	0.26	SNMG 12 04 08
			2.018			*.750*	*.750*	*1.268*	*3.984*	*4.311*	*1.000*	*.673*	*.750*	*G 1/8-28*	*2175*			
		3/4 x 3/4	51.3	3	**QS-PSSNR 12 4C**	19.1	19.1	32.2	101.2	109.5	25.4	17.1	19.1	G 1/8-28	150	5.0	0.26	SNMG 12 04 08
			2.018			*.750*	*.750*	*1.268*	*3.984*	*4.311*	*1.000*	*.673*	*.750*	*G 1/8-28*	*2175*			
		1 x 1	57.6	3	**QS-PSSNL 16 4C**	25.4	25.4	32.2	116.2	124.5	31.8	23.5	25.4	G 1/8-28	150	5.0	0.56	SNMG 12 04 08
			2.268			*1.000*	*1.000*	*1.268*	*4.575*	*4.902*	*1.250*	*.925*	*1.000*	*G 1/8-28*	*2175*			
		1 x 1	57.6	3	**QS-PSSNR 16 4C**	25.4	25.4	32.2	116.2	124.5	31.8	23.5	25.4	G 1/8-28	150	5.0	0.56	SNMG 12 04 08
			2.268			*1.000*	*1.000*	*1.268*	*4.575*	*4.902*	*1.250*	*.925*	*1.000*	*G 1/8-28*	*2175*			

R = Right hand, L = Left hand

Spare parts							
Lever	Screw	Shim	Shim pin	Nozzle	Screw	Screw	Screw
174.3-841M	174.3-821	174.3-851M	174.3-861	5691 026-13	5512 104-01	3214 013-01	3214 012-01

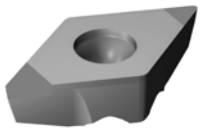
For complete list of spare parts, see www.sandvik.coromant.com

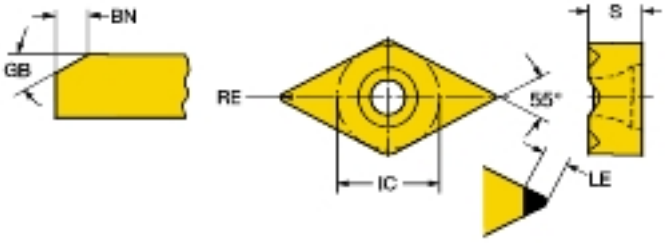
ISO 13399 150 CN8C CXSO 155

CoroTurn® TR insert for turning

D-style insert (Rhombic 55°)

Advanced cutting materials





									H
		IC	LE	S	RE	GB	BN	ISO CODE	7125
Finishing	13	11	2.5	5.53	0.80	20°	0.10	TR-DC1308S01020F	★
			.098	*.218*	*.031*	*20°*	*.004*		

25

150

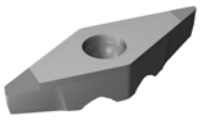
SANDVIK Coromant

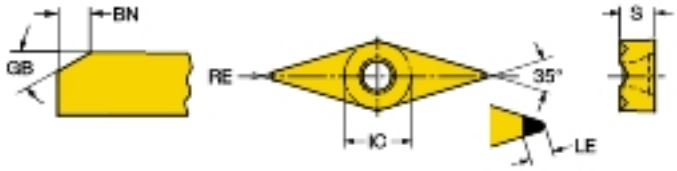
ENG

CoroTurn® TR insert for turning

V-style insert (Rhombic 35°)

Advanced cutting materials





									H
			LE	S	RE	GB	BN	ISO CODE	7125
Finishing	13	8	3.1	4.53	0.40	20°	0.10	TR-VB1304S01020F	★
			.122	*.178*	*.016*	*20°*	*.004*		

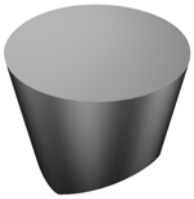
25

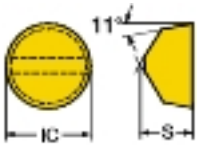
150

T-Max® insert for turning

D-style insert (Rhombic 55°)

Advanced cutting materials





		IC	S	RE	ISO CODE	S 6160	ANSI CODE
Medium	E	06 1/4	4.76 *.187*	3.18 *.125*	RPGX060400E	★	RPGX23A

25 150

ENG

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			
					h_{ex}, mm ≈ feed f_n, mm/r			
	CMC				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			
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	455-305-215			
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	425-290-205			
		Low-alloy steel (alloying elements ≤5%)						
P2.1.Z.AN	02.1	Non-hardened	1700	180	460-305-215			
P2.1.Z.AN	02.12	Ball bearing steel	1800	210	395-265-190			
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	205-145-110			
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	205-145-110			
		High-alloy steel (alloying elements >5%)						
P3.0.Z.AN	03.11	Annealed	1950	200	300-205-150			
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	135-95-75			
		Steel castings						
P1.5.C.UT	06.1	Unalloyed	1550	180	240-180-130			
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	210-140-100			
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	200-165-125			

ISO M		Stainless steel	Specific cutting force k_{c1}	Hardness Brinell				
					GC1115			
					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			
		Ferritic/martensitic						
		Bars/forged						
P5.0.Z.AN	05.11	Non-hardened	1800	200	335-255-200			
P5.0.Z.PH	05.12	PH-hardened	2850	330	185-150-120			
P5.0.Z.HT	05.13	Hardened	2350	330	200-160-140			
		Austenitic						
		Bars/forged						
M1.0.Z.AQ	05.21	Austenitic	1800	180	265-215-165			
M1.0.Z.PH	05.22	PH-hardened	2850	330	185-150-120			
M2.0.Z.AQ	05.23	Super austenitic	2250	200	220-190-155			
		Austenitic-ferritic (Duplex)						
		Bars/forged						
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	250-205-155			
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	230-170-130			
		Ferritic/martensitic						
		Cast						
P5.0.C.UT	15.11	Non-hardened	1700	200	320-265-205			
	15.12	PH-hardened	2450	330	160-130-95			
P5.0.C.HT	15.13	Hardened	2150	330	175-145-110			
		Austenitic						
		Cast						
M1.0.C.UT	15.21	Austenitic	1700	180	280-225-170			
	15.22	PH-hardened	2450	330	160-130-95			
M2.0.C.AQ	15.23	Super austenitic	2150	200	210-180-150			
		Austenitic-ferritic (Duplex)						
		Cast						
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	230-170-120			
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	205-155-110			

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO S		Heat resistant material	Specific cutting force k_{c1}	Hardness Brinell			
					GC1125	H13A	
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.1-0.2-0.5	0.1-0.3-0.5	
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	75-60-45	80-65-50	
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	55-45-35	60-50-40	
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	45-35-25	50-40-30	
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	35-25-15	40-30-20	
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	23-17-12	25-20-15	
		Cobalt alloys					
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	45-35-25	50-40-30	
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	35-25-15	40-30-20	
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	23-17-12	25-20-15	
		Titanium alloys[2]		**Rm**[3]			
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	1300	400	-	50-40-30	
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	1400	950	-	40-30-20	
S4.3.Z.AG	23.22	α+β alloys in aged conditions. β alloys. Annealed or aged	1400	1050	-	25-20-15	

ISO H		Hardened material	Specific cutting force k_{c1}	Hardness			
					CB7125	CB7135	
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.03-0.25.-0.41	0.05-0.16-0.31	
MC No.	No.	Material	N/mm²		Cutting speed (v_c), m/min		
		Extra hard steel					
H1.3.Z.HA	04.1	Hardened and tempered	4300	*60HRC*	200-175-135	145-140-110	

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.

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			
					h_{ex}, inch ≈ feed, f_n inch/rev. at 0° to -5° lead			
	CMC				.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			
P1.2.Z.AN	01.2	C = 0.25–0.55%	233,000	150	1250-800-590			
P1.3.Z.AN	01.3	C = 0.55–0.80%	247,000	170	1200-760-560			
		Low-alloy steel						
		(alloying elements ≤5%)						
P2.1.Z.AN	02.1	Non-hardened	249,500	180	980-600-445			
P2.1.Z.AN	02.12	Ball bearing steel	259,500	210	820-500-365			
P2.5.Z.HT	02.2	Hardened and tempered	268,000	275	600-385-280			
P2.5.Z.HT	02.2	Hardened and tempered	298,000	350	485-310-225			
		High-alloy steel						
		(alloying elements >5%)						
P3.0.Z.AN	03.11	Annealed	282,000	200	780-500-345			
P3.0.Z.HT	03.21	Hardened tool steel	435,500	325	360-225-165			
		Steel castings						
P1.5.C.UT	06.1	Unalloyed	225,000	180	600-450-335			
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230,500	200	540-320-235			
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	300,500	225	470-305-220			

ISO M		Stainless steel	Specific cutting force k_{c1}	Hardness Brinell				
					GC1115			
					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			
		Ferritic/martensitic						
		Bars/forged						
P5.0.Z.AN	05.11	Non-hardened	262,000	200	1100-840-650			
P5.0.Z.PH	05.12	PH-hardened	411,500	330	610-490-390			
P5.0.Z.HT	05.13	Hardened	340,000	330	650-530-460			
		Austenitic						
		Bars/forged						
M1.0.Z.AQ	05.21	Austenitic	259,000	180	870-700-530			
M1.0.Z.PH	05.22	PH-hardened	414,000	330	610-490-390			
M2.0.Z.AQ	05.23	Super austenitic	328,000	200	730-630-510			
		Austenitic-ferritic (Duplex)						
		Bars/forged						
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	286,500	230	830-660-510			
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	740-550-430			
		Ferritic/martensitic						
		Cast						
P5.0.C.UT	15.11	Non-hardened	246,500	200	1050-860-660			
	15.12	PH-hardened	354,500	330	530-430-310			
P5.0.C.HT	15.13	Hardened	311,000	330	570-470-350			
		Austenitic						
		Cast						
M1.0.C.UT	15.21	Austenitic	248,000	180	910-730-560			
	15.22	PH-hardened	356,000	330	530-430-310			
M2.0.C.AQ	15.23	Super austenitic	310,500	200	690-590-490			
		Austenitic-ferritic (Duplex)						
		Cast						
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	258,000	230	750-550-390			
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,000	260	670-510-350			

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO S		Heat resistant material	Specific cutting force k_{c1}	Hardness Brinell			
					GC1125	H13A	
					h_{ex}, inch ≈ feed, f_n inch/rev. at 0° to -5° lead		
	CMC				.004-.012-.020	.004-.012-.020	
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	245-195-145	260-210-160	
S1.0.U.AG	20.12	Aged or solution treated and aged	359,000	280	180-145-115	195-165-130	
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	383,000	250	150-115-80	165-130-95	
S2.0.Z.AG	20.22	Aged or solution treated and aged	420,500	350	115-80-50	130-95-65	
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	75-55-39	80-65-50	
		Cobalt alloys					
S3.0.Z.AN	20.31	Annealed or solution treated	391,500	200	150-115-80	165-130-95	
S3.0.Z.AG	20.32	Solution treated and aged	432,000	300	115-80-50	130-95-65	
S3.0.C.NS	20.33	Cast or cast and aged	450,500	320	75-55-39	80-65-50	
		Titanium alloys[2]		**Rm[3]**			
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	188,500	400	-	590-485-410	
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	203,000	950	-	245-200-165	
S4.3.Z.AG	23.22	α+β alloys in aged conditions. β alloys. Annealed or aged	203,000	1050	-	235-175-150	

ISO H		Hardened material	Specific cutting force k_{c1}	Hardness			
					CB7125	CB7135	
					h_{ex}, inch ≈ feed, f_n inch/rev. at 0° to -5° lead		
	CMC				.001-.020-.030	.005-.016-.031	
MC No.	No.	Material	lbs/in²		Cutting speed v_c, ft/min		
		Extra hard steel					
H1.3.Z.HA	04.1	Hardened and tempered	625,500	*60HRC*	640-580-445	480-450-360	

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.

ENG

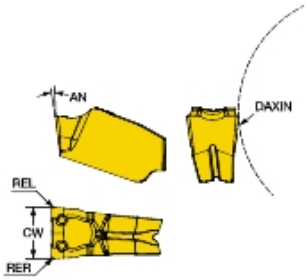
Parting and grooving

CoroCut® QF

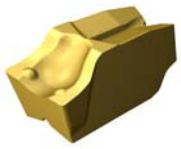
CoroCut® 1-2

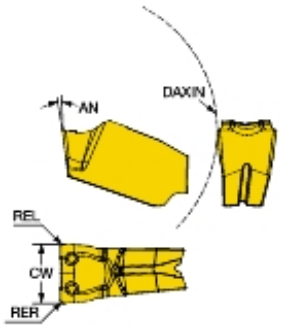
Cutting data

CoroCut® QF insert for face grooving



SSC	CW	REL	RER	DAXIN	Ordering code	P	M		K	N			S			Dimensions, mm, inch				
						1125	1105	1125	1125	1105	1125	H10F	1105	1125	H10F	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
QFT-G	3.00	0.20	0.20	30.0	QFT-G-0300-02-GF	★	☆	★	★	☆	☆	★	★	☆	☆	7°	-0.020	0.020	-0.050	0.050
	.118	*.008*	*.008*	*1.181*													*-.0008*	*.0008*	*-.0020*	*.0020*
QFT-H	4.00	0.20	0.20	30.0	QFT-H-0400-02-GF	★	☆	★	★	☆	☆	★	★	☆	☆	7°	-0.020	0.020	-0.050	0.050
	.157	*.008*	*.008*	*1.181*													*-.0008*	*.0008*	*-.0020*	*.0020*





SSC	CW	REL	RER	DAXIN	Ordering code	P	M		K	N			S			Dimensions, mm, inch				
						1125	1105	1125	1125	1105	1125	H10F	1105	1125	H10F	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
QFU-G	3.00	0.20	0.20	30.0	QFU-G-0300-02-GF	★	☆	★	★	☆	☆	★	★	☆	☆	7°	-0.020	0.020	-0.050	0.050
	.118	*.008*	*.008*	*1.181*													*-.0008*	*.0008*	*-.0020*	*.0020*
QFU-H	4.00	0.20	0.20	30.0	QFU-H-0400-02-GF	★	☆	★	★	☆	☆	★	★	☆	☆	7°	-0.020	0.020	-0.050	0.050
	.157	*.008*	*.008*	*1.181*													*-.0008*	*.0008*	*-.0020*	*.0020*

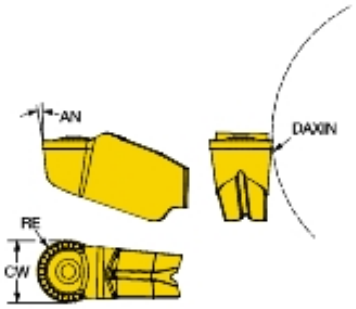
SSC = To correspond with SSC on holder.

33 39 43 150

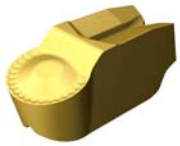
SANDVIK Coromant

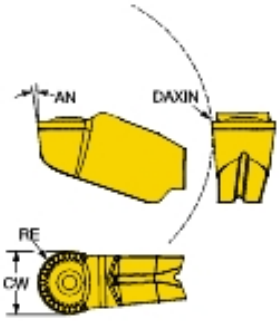
ENG

CoroCut® QF insert for face grooving



SSC	CW	RE	DAXIN	Ordering code	P		M			K		N		S			Dimensions, mm, inch		
					1125	1135	1105	1125	1135	1125	1135	1105	1125	1105	1125	1135	AN	CWTOLL	CWTOLU
QFT-G	3.00	1.50	30.0	QFT-G-0300-RM	★	☆	☆	☆	★	★	☆	★	☆	★	☆	☆	7°	-0.050	0.050
	.118	*.059*	*1.181*															*-.0020*	*.0020*
QFT-H	4.00	2.00	30.0	QFT-H-0400-RM	★	☆	☆	☆	★	★	☆	★	☆	★	☆	☆	7°	-0.050	0.050
	.157	*.079*	*1.181*															*-.0020*	*.0020*



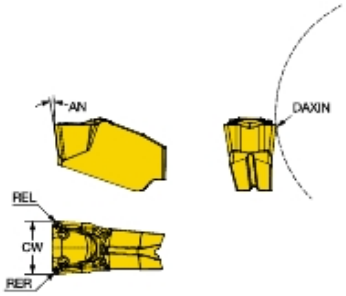


SSC	CW	RE	DAXIN	Ordering code	P		M			K		N		S			Dimensions, mm, inch		
					1125	1135	1105	1125	1135	1125	1135	1105	1125	1105	1125	1135	AN	CWTOLL	CWTOLU
QFU-G	3.00	1.50	30.0	QFU-G-0300-RM	★	☆	☆	☆	★	★	☆	★	☆	★	☆	☆	7°	-0.050	0.050
	.118	*.059*	*1.181*															*-.0020*	*.0020*
QFU-H	4.00	2.00	30.0	QFU-H-0400-RM	★	☆	☆	☆	★	★	☆	★	☆	★	☆	☆	7°	-0.050	0.050
	.157	*.079*	*1.181*															*-.0020*	*.0020*

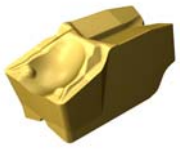
SSC = To correspond with SSC on holder.

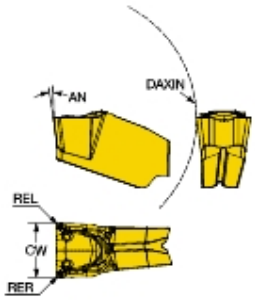
33 39 43 150

CoroCut® QF insert for face grooving



SSC	CW	REL	RER	DAXIN	Ordering code	P				M				K		N				S				Dimensions, mm, inch				
						1105	1125	1135	1145	1105	1125	1135	1145	1125	1135	1105	1125	1135	1105	1105	1125	1135	1145	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
QFT-G	3.00	0.30	0.30	30.0	QFT-G-0300-03-TF	☆	★	☆	☆	☆	☆	★	☆	★	☆	★	☆	☆	★	☆	☆	☆	☆	7°	-0.050	0.050	-0.050	0.050
	.118	*.012*	*.012*	*1.181*																					*-.0020*	*.0020*	*-.0020*	*.0020*
QFT-H	4.00	0.30	0.30	30.0	QFT-H-0400-03-TF	☆	★	☆	☆	☆	☆	★	☆	★	☆	★	☆	☆	★	☆	☆	☆	☆	7°	-0.050	0.050	-0.050	0.050
	.157	*.012*	*.012*	*1.181*																					*-.0020*	*.0020*	*-.0020*	*.0020*





SSC	CW	REL	RER	DAXIN	Ordering code	P				M				K		N				S				Dimensions, mm, inch				
						1105	1125	1135	1145	1105	1125	1135	1145	1125	1135	1105	1125	1135	1105	1105	1125	1135	1145	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
QFU-G	3.00	0.30	0.30	30.0	QFU-G-0300-03-TF	☆	★	☆	☆	☆	☆	★	☆	★	☆	★	☆	☆	★	☆	☆	☆	☆	7°	-0.050	0.050	-0.050	0.050
	.118	*.012*	*.012*	*1.181*																					*-.0020*	*.0020*	*-.0020*	*.0020*
QFU-H	4.00	0.30	0.30	30.0	QFU-H-0400-03-TF	☆	★	☆	☆	☆	☆	★	☆	★	☆	★	☆	☆	★	☆	☆	☆	☆	7°	-0.050	0.050	-0.050	0.050
	.157	*.012*	*.012*	*1.181*																					*-.0020*	*.0020*	*-.0020*	*.0020*

SSC = To correspond with SSC on holder.

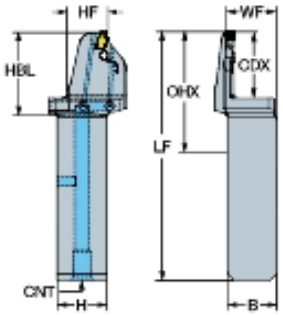
33 39 43 150

ENG

CoroCut® QF QS shank tool for face grooving

Spring clamp design

Precision coolant supply



Metric version

SSC	CZC$_{MS}$	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, mm B	H	HBL	LF	WF	HF	CNT	BAR	KG	MIID
QFT-G	25 x 25	20.0	30.0	42.0	29.6	3	QFT-RFG20C2525-030B	25.0	25.0	29.6	113.6	25.5	25.0	G 1/8-28	150	0.50	QFT-G-0300-03-TF
	25 x 25	25.0	35.0	52.0	34.6	3	QFT-RFG25C2525-035B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.48	QFT-G-0300-03-TF
	25 x 25	25.0	45.0	60.0	34.6	3	QFT-RFG25C2525-045B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.48	QFT-G-0300-03-TF
	25 x 25	25.0	55.0	70.0	34.6	3	QFT-RFG25C2525-055B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.48	QFT-G-0300-03-TF
	25 x 25	30.0	70.0	100.0	39.6	3	QFT-RFG30C2525-070B	25.0	25.0	39.6	123.6	25.5	25.0	G 1/8-28	150	0.48	QFT-G-0300-03-TF
	25 x 25	30.0	100.0	156.0	39.6	3	QFT-RFG30C2525-100B	25.0	25.0	39.6	123.6	25.5	25.0	G 1/8-28	150	0.48	QFT-G-0300-03-TF
	25 x 25	30.0	150.0	310.0	39.6	3	QFT-RFG30C2525-150B	25.0	25.0	39.6	123.6	25.5	25.0	G 1/8-28	150	0.50	QFT-G-0300-03-TF
QFT-H	25 x 25	22.0	30.0	45.0	31.6	3	QFT-RFH22C2525-030B	25.0	25.0	31.6	115.6	25.5	25.0	G 1/8-28	150	0.48	QFT-H-0400-03-TF
	25 x 25	22.0	35.0	55.0	31.6	3	QFT-RFH22C2525-035B	25.0	25.0	31.6	115.6	25.5	25.0	G 1/8-28	150	0.48	QFT-H-0400-03-TF
	25 x 25	25.0	35.0	55.0	34.6	3	QFT-RFH25C2525-035B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.49	QFT-H-0400-03-TF
	25 x 25	26.0	45.0	75.0	35.6	3	QFT-RFH26C2525-045B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.49	QFT-H-0400-03-TF
	25 x 25	26.0	65.0	108.0	35.6	3	QFT-RFH26C2525-065B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFT-H-0400-03-TF
	25 x 25	26.0	100.0	160.0	35.6	3	QFT-RFH26C2525-100B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFT-H-0400-03-TF
	25 x 25	26.0	150.0	310.0	35.6	3	QFT-RFH26C2525-150B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFT-H-0400-03-TF
	25 x 25	26.0	300.0	510.0	35.6	3	QFT-RFH26C2525-300B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.49	QFT-H-0400-03-TF
	25 x 25	26.0	500.0	2000.0	35.6	3	QFT-RFH26C2525-500B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFT-H-0400-03-TF
	25 x 25	32.0	45.0	75.0	41.6	3	QFT-RFH32C2525-045B	25.0	25.0	41.6	125.6	25.5	25.0	G 1/8-28	150	0.49	QFT-H-0400-03-TF
	25 x 25	32.0	65.0	108.0	41.6	3	QFT-RFH32C2525-065B	25.0	25.0	41.6	125.6	25.5	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF
	25 x 25	38.0	100.0	160.0	47.6	3	QFT-RFH38C2525-100B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF
	25 x 25	38.0	150.0	310.0	47.6	3	QFT-RFH38C2525-150B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF
	25 x 25	38.0	300.0	510.0	47.6	3	QFT-RFH38C2525-300B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF
	25 x 25	38.0	500.0	2000.0	47.6	3	QFT-RFH38C2525-500B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF

Inch version

SSC	CZC$_{MS}$	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, inch B	H	HBL	LF	WF	HF	CNT	PSI	LBS	MIID
QFT-G	1 x 1	.800	1.181	1.654	1.178	3	QFT-RFG080C16-030B	1.000	1.000	1.178	4.485	1.024	.984	G 1/8-28	2175	1.091	QFT-G-0300-03-TF
	1 x 1	1.000	1.378	2.047	1.378	3	QFT-RFG100C16-035B	1.000	1.000	1.378	4.685	1.024	1.000	G 1/8-28	2175	1.078	QFT-G-0300-03-TF
	1 x 1	1.000	1.772	2.362	1.378	3	QFT-RFG100C16-045B	1.000	1.000	1.378	4.685	1.024	1.000	G 1/8-28	2175	1.091	QFT-G-0300-03-TF
	1 x 1	1.000	2.165	2.992	1.378	3	QFT-RFG100C16-055B	1.000	1.000	1.378	4.685	1.024	.984	G 1/8-28	2175	1.091	QFT-G-0300-03-TF
	1 x 1	1.200	2.756	4.173	1.575	3	QFT-RFG120C16-070B	1.000	1.000	1.578	4.882	1.024	1.000	G 1/8-28	2175	1.091	QFT-G-0300-03-TF
	1 x 1	1.200	3.937	6.142	1.575	3	QFT-RFG120C16-100B	1.000	1.000	1.578	4.882	1.024	1.000	G 1/8-28	2175	1.091	QFT-G-0300-03-TF
	1 x 1	1.200	5.906	12.205	1.575	3	QFT-RFG120C16-150B	1.000	1.000	1.578	4.882	1.024	1.000	G 1/8-28	2175	1.078	QFT-G-0300-03-TF
QFT-H	1 x 1	.900	1.181	1.772	1.278	3	QFT-RFH090C16-030B	1.000	1.000	1.278	4.585	1.024	1.000	G 1/8-28	2175	1.230	QFT-H-0400-03-TF
	1 x 1	1.000	1.378	2.047	1.378	3	QFT-RFH100C16-035B	1.000	1.000	1.378	4.685	1.024	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.250	1.772	2.953	1.628	3	QFT-RFH125C16-045B	1.000	1.000	1.628	4.935	1.024	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.250	2.559	4.252	1.628	3	QFT-RFH125C16-065B	1.000	1.000	1.628	4.935	1.024	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.500	3.937	6.299	1.878	3	QFT-RFH150C16-100B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.500	5.906	12.205	1.878	3	QFT-RFH150C16-150B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.500	11.811	20.079	1.878	3	QFT-RFH150C16-300B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.140	QFT-H-0400-03-TF
	1 x 1	1.500	19.685	78.740	1.878	3	QFT-RFH150C16-500B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF

SSC = To correspond with SSC on insert.

B curve - Clockwise spindle rotation

Spare parts	
Plug	Plug
3214 013-01	3214 012-01

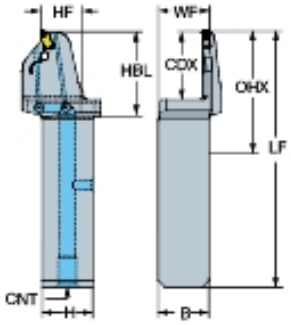
For complete list of spare parts, see www.sandvik.coromant.com

30 150 155

CoroCut® QF QS shank tool for face grooving

Spring clamp design

Precision coolant supply



Metric version

SSC	CZC$_{MS}$	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, mm B	H	HBL	LF	WF	HF	CNT	BAR	KG	MIID
QFU-G	25 x 25	20.0	30.0	42.0	29.6	3	QFU-LFG20C2525-030B	25.0	25.0	29.6	113.6	25.5	25.0	G 1/8-28	150	0.48	QFU-G-0300-03-TF
	25 x 25	25.0	35.0	52.0	34.6	3	QFU-LFG25C2525-035B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.50	QFU-G-0300-03-TF
	25 x 25	25.0	45.0	60.0	34.6	3	QFU-LFG25C2525-045B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.48	QFU-G-0300-03-TF
	25 x 25	25.0	55.0	70.0	34.6	3	QFU-LFG25C2525-055B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.48	QFU-G-0300-03-TF
	25 x 25	30.0	70.0	100.0	39.6	3	QFU-LFG30C2525-070B	25.0	25.0	39.6	123.6	25.5	25.0	G 1/8-28	150	0.49	QFU-G-0300-03-TF
	25 x 25	30.0	100.0	156.0	39.6	3	QFU-LFG30C2525-100B	25.0	25.0	39.6	123.6	25.5	25.0	G 1/8-28	150	0.49	QFU-G-0300-03-TF
	25 x 25	30.0	150.0	310.0	39.6	3	QFU-LFG30C2525-150B	25.0	25.0	39.6	123.6	25.5	25.0	G 1/8-28	150	0.48	QFU-G-0300-03-TF
QFU-H	25 x 25	22.0	30.0	45.0	31.6	3	QFU-LFH22C2525-030B	25.0	25.0	31.6	115.6	25.5	25.0	G 1/8-28	150	0.49	QFU-H-0400-03-TF
	25 x 25	22.0	35.0	55.0	31.6	3	QFU-LFH22C2525-035B	25.0	25.0	31.6	115.6	25.5	25.0	G 1/8-28	150	0.56	QFU-H-0400-03-TF
	25 x 25	25.0	35.0	55.0	34.6	3	QFU-LFH25C2525-035B	25.0	25.0	34.6	118.6	25.5	25.0	G 1/8-28	150	0.49	QFU-H-0400-03-TF
	25 x 25	26.0	45.0	75.0	35.6	3	QFU-LFH26C2525-045B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFU-H-0400-03-TF
	25 x 25	26.0	65.0	108.0	35.6	3	QFU-LFH26C2525-065B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFU-H-0400-03-TF
	25 x 25	26.0	100.0	160.0	35.6	3	QFU-LFH26C2525-100B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFU-H-0400-03-TF
	25 x 25	26.0	150.0	310.0	35.6	3	QFU-LFH26C2525-150B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.49	QFU-H-0400-03-TF
	25 x 25	26.0	300.0	510.0	35.6	3	QFU-LFH26C2525-300B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFU-H-0400-03-TF
	25 x 25	26.0	500.0	2000.0	35.6	3	QFU-LFH26C2525-500B	25.0	25.0	35.6	119.6	25.5	25.0	G 1/8-28	150	0.48	QFU-H-0400-03-TF
	25 x 25	32.0	45.0	75.0	41.6	3	QFU-LFH32C2525-045B	25.0	25.0	41.6	125.6	25.5	25.0	G 1/8-28	150	0.49	QFU-H-0400-03-TF
	25 x 25	32.0	65.0	108.0	41.6	3	QFU-LFH32C2525-065B	25.0	25.0	41.6	125.6	25.5	25.0	G 1/8-28	150	0.52	QFU-H-0400-03-TF
	25 x 25	38.0	100.0	160.0	47.6	3	QFU-LFH38C2525-100B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.56	QFU-H-0400-03-TF
	25 x 25	38.0	150.0	310.0	47.6	3	QFU-LFH38C2525-150B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.50	QFU-H-0400-03-TF
	25 x 25	38.0	300.0	510.0	47.6	3	QFU-LFH38C2525-300B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.56	QFU-H-0400-03-TF
	25 x 25	38.0	500.0	2000.0	47.6	3	QFU-LFH38C2525-500B	25.0	25.0	47.6	131.6	25.5	25.0	G 1/8-28	150	0.56	QFU-H-0400-03-TF

Inch version

SSC	CZC$_{MS}$	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, inch B	H	HBL	LF	WF	HF	CNT	PSI	LBS	MIID
QFU-G	1 x 1	.800	1.181	1.654	1.178	3	QFU-LFG080C16-030B	1.000	1.000	1.178	4.485	1.024	1.000	G 1/8-28	2175	1.091	QFU-G-0300-03-TF
	1 x 1	1.000	1.378	2.047	1.378	3	QFU-LFG100C16-035B	1.000	1.000	1.378	4.685	1.024	1.000	G 1/8-28	2175	1.091	QFU-G-0300-03-TF
	1 x 1	1.000	1.772	2.362	1.378	3	QFU-LFG100C16-045B	1.000	1.000	1.378	4.685	1.024	1.000	G 1/8-28	2175	1.091	QFU-G-0300-03-TF
	1 x 1	1.000	2.165	2.992	1.378	3	QFU-LFG100C16-055B	1.000	1.000	1.378	4.685	1.024	1.000	G 1/8-28	2175	1.089	QFU-G-0300-03-TF
	1 x 1	1.200	2.756	4.173	1.575	3	QFU-LFG120C16-070B	1.000	1.000	1.575	5.197	1.024	1.000	G 1/8-28	2175	1.091	QFU-G-0300-03-TF
	1 x 1	1.200	3.937	6.142	1.575	3	QFU-LFG120C16-100B	1.000	1.000	1.575	5.197	1.024	1.000	G 1/8-28	2175	1.091	QFU-G-0300-03-TF
	1 x 1	1.200	5.906	12.205	1.575	3	QFU-LFG120C16-150B	1.000	1.000	1.575	4.882	1.024	1.000	G 1/8-28	2175	.880	QFU-G-0300-03-TF
QFU-H	1 x 1	.900	1.181	1.772	1.278	3	QFU-LFH090C16-030B	1.000	1.000	1.278	4.585	1.024	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.000	1.378	2.165	1.378	3	QFU-LFH100C16-035B	1.000	1.000	1.378	4.685	1.024	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.250	1.772	2.953	1.628	3	QFU-LFH125C16-045B	1.000	1.000	1.628	4.935	1.024	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.250	2.559	4.252	1.628	3	QFU-LFH125C16-065B	1.000	1.000	1.628	4.935	1.024	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.500	3.937	6.299	1.878	3	QFU-LFH150C16-100B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.122	QFU-H-0400-03-TF
	1 x 1	1.500	5.906	12.205	1.878	3	QFU-LFH150C16-150B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.500	11.811	20.079	1.878	3	QFU-LFH150C16-300B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.500	19.685	78.740	1.878	3	QFU-LFH150C16-500B	1.000	1.000	1.878	5.197	1.024	1.000	G 1/8-28	2175	1.122	QFU-H-0400-03-TF

SSC = To correspond with SSC on insert.

B Curve - Counter clockwise spindle rotation

Spare parts	
Plug	Plug
3214 013-01	3214 012-01

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


30

150

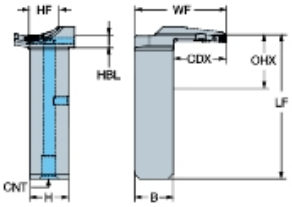
155

ENG

CoroCut® QF QS shank tool for face grooving

Spring clamp design

Precision coolant supply



Metric version

SSC	CZC_{MS}	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, mm B	H	HBL	LF	WF	HF	CNT	BAR	KG	MIID
QFT-H	25 x 25	22.0	30.0	45.0	8.0	3	**QFT-LGH22C2525-030B**	25.0	25.0	8.0	92.0	49.1	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF
	25 x 25	25.0	35.0	55.0	8.0	3	**QFT-LGH25C2525-035B**	25.0	25.0	8.0	92.0	52.1	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF
	25 x 25	32.0	45.0	75.0	8.0	3	**QFT-LGH32C2525-045B**	25.0	25.0	8.0	92.0	59.1	25.0	G 1/8-28	150	0.51	QFT-H-0400-03-TF
	25 x 25	32.0	65.0	108.0	8.0	3	**QFT-LGH32C2525-065B**	25.0	25.0	8.0	92.0	59.1	25.0	G 1/8-28	150	0.51	QFT-H-0400-03-TF
	25 x 25	38.0	100.0	160.0	8.0	3	**QFT-LGH38C2525-100B**	25.0	25.0	8.0	92.0	65.1	25.0	G 1/8-28	150	0.53	QFT-H-0400-03-TF
	25 x 25	38.0	150.0	310.0	8.0	3	**QFT-LGH38C2525-150B**	25.0	25.0	8.0	92.0	65.1	25.0	G 1/8-28	150	0.50	QFT-H-0400-03-TF

Inch version

SSC	CZC_{MS}	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, inch B	H	HBL	LF	WF	HF	CNT	PSI	LBS	MIID
QFT-H	1 x 1	.900	1.181	1.772	.315	3	**QFT-LGH090C16-030B**	1.000	1.000	.315	3.622	1.983	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.000	1.378	2.047	.315	3	**QFT-LGH100C16-035B**	1.000	1.000	.315	3.622	2.083	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.250	1.772	2.953	.315	3	**QFT-LGH125C16-045B**	1.000	1.000	.315	3.622	2.333	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.250	2.559	4.252	.315	3	**QFT-LGH125C16-065B**	1.000	1.000	.315	3.622	2.333	1.000	G 1/8-28	2175	1.100	QFT-H-0400-03-TF
	1 x 1	1.500	3.937	6.299	.315	3	**QFT-LGH150C16-100B**	1.000	1.000	.315	3.622	2.583	1.000	G 1/8-28	2175	1.144	QFT-H-0400-03-TF
	1 x 1	1.500	5.906	12.205	.315	3	**QFT-LGH150C16-150B**	1.000	1.000	.315	3.622	2.583	1.000	G 1/8-28	2175	1.210	QFT-H-0400-03-TF

SSC = To correspond with SSC on insert.

B Curve - Counter clockwise spindle rotation

Spare parts	
Plug	Plug
3214 013-01	3214 012-01

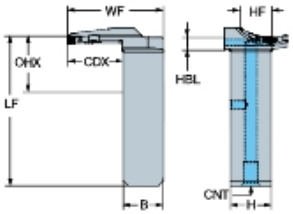
For complete list of spare parts, see www.sandvik.coromant.com

30 150 155

CoroCut® QF QS shank tool for face grooving

Spring clamp design

Precision coolant supply



Metric version

SSC	CZC_{MS}	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, mm B	H	HBL	LF	WF	HF	CNT	BAR	KG	MIID
QFU-H	25 x 25	22.0	30.0	45.0	8.0	3	**QFU-RGH22C2525-030B**	25.0	25.0	8.0	92.0	25.5	25.0	G 1/8-28	150	0.50	QFU-H-0400-03-TF
	25 x 25	25.0	35.0	55.0	8.0	3	**QFU-RGH25C2525-035B**	25.0	25.0	8.0	92.0	52.1	25.0	G 1/8-28	150	0.51	QFU-H-0400-03-TF
	25 x 25	32.0	45.0	75.0	8.0	3	**QFU-RGH32C2525-045B**	25.0	25.0	8.0	92.0	59.1	25.0	G 1/8-28	150	0.51	QFU-H-0400-03-TF
	25 x 25	32.0	65.0	108.0	8.0	3	**QFU-RGH32C2525-065B**	25.0	25.0	8.0	92.0	59.1	25.0	G 1/8-28	150	0.50	QFU-H-0400-03-TF
	25 x 25	38.0	100.0	160.0	8.0	3	**QFU-RGH38C2525-100B**	25.0	25.0	8.0	92.0	65.1	25.0	G 1/8-28	150	0.52	QFU-H-0400-03-TF
	25 x 25	38.0	150.0	310.0	8.0	3	**QFU-RGH38C2525-150B**	25.0	25.0	8.0	92.0	65.1	25.0	G 1/8-28	150	0.52	QFU-H-0400-03-TF

Inch version

SSC	CZC_{MS}	CDX	DAXIN	DAXX	OHX	CNSC	Ordering code	Dimensions, inch B	H	HBL	LF	WF	HF	CNT	PSI	LBS	MIID
QFU-H	1 x 1	.900	1.181	1.772	.315	3	**QFU-RGH090C16-030B**	1.000	1.000	.315	3.622	1.983	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.000	1.378	2.047	.315	3	**QFU-RGH100C16-035B**	1.000	1.000	.315	3.622	2.083	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.250	1.772	2.953	.315	3	**QFU-RGH125C16-045B**	1.000	1.000	.315	3.622	2.333	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.250	2.559	4.252	.315	3	**QFU-RGH125C16-065B**	1.000	1.000	.315	3.622	2.333	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF
	1 x 1	1.500	3.937	6.299	.315	3	**QFU-RGH150C16-100B**	1.000	1.000	.315	3.622	2.583	1.000	G 1/8-28	2175	1.230	QFU-H-0400-03-TF
	1 x 1	1.500	5.906	12.205	.315	3	**QFU-RGH150C16-150B**	1.000	1.000	.315	3.622	2.583	1.000	G 1/8-28	2175	1.100	QFU-H-0400-03-TF

SSC = To correspond with SSC on insert.

B Curve - Counter clockwise spindle rotation

Spare parts	
Plug	Plug
3214 013-01	3214 012-01

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

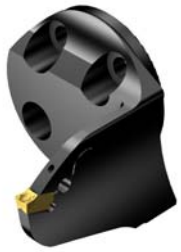
30 150 155

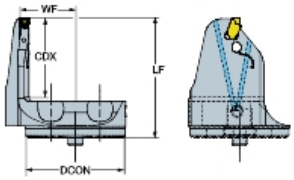
ENG

CoroCut® QF head for face grooving

Spring clamp design

Precision coolant supply





SSC	CZC_{MS}	CDX	DAXIN	DAXX	CNSC	Ordering code	Dimensions, mm, inch DCON	LF	WF	BAR PSI	KG	MIID
QFT-G	40	20.0	30.0	42.0	1	SL-QFT-RG20C40-030B	40	36.0	22.0	150	0.42	QFT-G-0300-03-TF
		.787	*1.181*	*1.654*			*1.575*	*1.417*	*.866*	*2175*		
	40	25.0	35.0	52.0	1	SL-QFT-RG25C40-035B	40	41.0	22.0	150	0.15	QFT-G-0300-03-TF
		.984	*1.378*	*2.047*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	45.0	60.0	1	SL-QFT-RG25C40-045B	40	41.0	22.0	150	0.15	QFT-G-0300-03-TF
		.984	*1.772*	*2.362*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	55.0	76.0	1	SL-QFT-RG25C40-055B	40	41.0	22.0	150	0.15	QFT-G-0300-03-TF
		.984	*2.165*	*2.992*			*1.575*	*1.614*	*.866*	*2175*		
	40	30.0	70.0	106.0	1	SL-QFT-RG30C40-070B	40	46.0	22.0	150	0.15	QFT-G-0300-03-TF
		1.181	*2.756*	*4.173*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	100.0	156.0	1	SL-QFT-RG30C40-100B	40	46.0	22.0	150	0.15	QFT-G-0300-03-TF
		1.181	*3.937*	*6.142*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	150.0	310.0	1	SL-QFT-RG30C40-150B	40	46.0	22.0	150	0.15	QFT-G-0300-03-TF
		1.181	*5.906*	*12.205*			*1.575*	*1.811*	*.866*	*2175*		
QFT-H	40	22.0	30.0	45.0	1	SL-QFT-RH22C40-030B	40	38.0	22.5	150	0.22	QFT-H-0400-03-TF
		.866	*1.181*	*1.772*			*1.575*	*1.496*	*.886*	*2175*		
	40	25.0	35.0	55.0	1	SL-QFT-RH25C40-035B	40	41.0	22.5	150	0.22	QFT-H-0400-03-TF
		.984	*1.378*	*2.165*			*1.575*	*1.614*	*.886*	*2175*		
	40	32.0	45.0	75.0	1	SL-QFT-RH32C40-045B	40	48.0	22.5	150	0.16	QFT-H-0400-03-TF
		1.260	*1.772*	*2.953*			*1.575*	*1.890*	*.886*	*2175*		
	40	32.0	65.0	108.0	1	SL-QFT-RH32C40-065B	40	48.0	22.5	150	0.22	QFT-H-0400-03-TF
		1.260	*2.559*	*4.252*			*1.575*	*1.890*	*.886*	*2175*		
	40	38.0	100.0	160.0	1	SL-QFT-RH38C40-100B	40	54.0	22.5	150	0.18	QFT-H-0400-03-TF
		1.496	*3.937*	*6.299*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	150.0	310.0	1	SL-QFT-RH38C40-150B	40	54.0	22.5	150	0.17	QFT-H-0400-03-TF
		1.496	*5.906*	*12.205*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	300.0	510.0	1	SL-QFT-RH38C40-300B	40	54.0	22.5	150	0.17	QFT-H-0400-03-TF
		1.496	*11.811*	*20.079*			*1.575*	*2.126*	*.886*	*2175*		

SSC = To correspond with SSC on insert.

B curve - Clockwise spindle rotation

Spare parts
Locating tube
5638 031-01

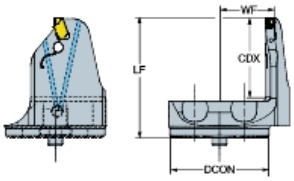
For complete list of spare parts, see www.sandvik.coromant.com

30 150 155

CoroCut® QF head for face grooving

Spring clamp design

Precision coolant supply



SSC	CZC_{MS}	CDX	DAXIN	DAXX	CNSC	Ordering code	Dimensions, mm, inch DCON	LF	WF	BAR PSI	KG	MID
QFU-G	40	20.0	30.0	42.0	1	SL-QFU-LG20C40-030B	40	36.0	22.0	150	0.15	QFU-G-0300-03-TF
		.787	*1.181*	*1.654*			*1.575*	*1.417*	*.866*	*2175*		
	40	25.0	35.0	52.0	1	SL-QFU-LG25C40-035B	40	41.0	22.0	150	0.15	QFU-G-0300-03-TF
		.984	*1.378*	*2.047*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	45.0	60.0	1	SL-QFU-LG25C40-045B	40	41.0	22.0	150	0.15	QFU-G-0300-03-TF
		.984	*1.772*	*2.362*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	55.0	76.0	1	SL-QFU-LG25C40-055B	40	41.0	22.0	150	0.15	QFU-G-0300-03-TF
		.984	*2.165*	*2.992*			*1.575*	*1.614*	*.866*	*2175*		
	40	30.0	70.0	106.0	1	SL-QFU-LG30C40-070B	40	46.0	22.0	150	0.15	QFU-G-0300-03-TF
		1.181	*2.756*	*4.173*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	100.0	156.0	1	SL-QFU-LG30C40-100B	40	46.0	22.0	150	0.15	QFU-G-0300-03-TF
		1.181	*3.937*	*6.142*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	150.0	310.0	1	SL-QFU-LG30C40-150B	40	46.0	22.0	150	0.15	QFU-G-0300-03-TF
		1.181	*5.906*	*12.205*			*1.575*	*1.811*	*.866*	*2175*		
QFU-H	40	22.0	30.0	45.0	1	SL-QFU-LH22C40-030B	40	38.0	22.5	150	0.22	QFU-H-0400-03-TF
		.866	*1.181*	*1.772*			*1.575*	*1.496*	*.886*	*2175*		
	40	25.0	35.0	55.0	1	SL-QFU-LH25C40-035B	40	41.0	22.5	150	0.22	QFU-H-0400-03-TF
		.984	*1.378*	*2.165*			*1.575*	*1.614*	*.886*	*2175*		
	40	32.0	45.0	75.0	1	SL-QFU-LH32C40-045B	40	48.0	22.5	150	0.22	QFU-H-0400-03-TF
		1.260	*1.772*	*2.953*			*1.575*	*1.890*	*.886*	*2175*		
	40	32.0	65.0	108.0	1	SL-QFU-LH32C40-065B	40	48.0	22.5	150	0.22	QFU-H-0400-03-TF
		1.260	*2.559*	*4.252*			*1.575*	*1.890*	*.886*	*2175*		
	40	38.0	100.0	160.0	1	SL-QFU-LH38C40-100B	40	54.0	22.5	150	0.17	QFU-H-0400-03-TF
		1.496	*3.937*	*6.299*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	150.0	310.0	1	SL-QFU-LH38C40-150B	40	54.0	22.5	150	0.17	QFU-H-0400-03-TF
		1.496	*5.906*	*12.205*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	300.0	510.0	1	SL-QFU-LH38C40-300B	40	54.0	22.5	150	0.22	QFU-H-0400-03-TF
		1.496	*11.811*	*20.079*			*1.575*	*2.126*	*.886*	*2175*		

SSC = To correspond with SSC on insert.

B Curve - Counter clockwise spindle rotation

Spare parts	
Locating tube	
5638 031-01	

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

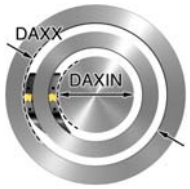
30 150 155

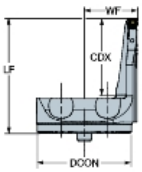
ENG

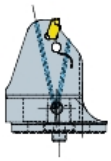
CoroCut® QF head for face grooving

Spring clamp design

Precision coolant supply







							Dimensions, mm, inch					
SSC	CZC_{MS}	CDX	DAXIN	DAXX	CNSC	**Ordering code**	DCON	LF	WF	BAR PSI	KG	MIID
QFT-G	32	20.0	30.0	42.0	1	**SL-QFT-LG20C32-030A**	32	36.0	18.0	150	0.11	QFT-G-0300-03-TF
		.787	*1.181*	*1.654*			*1.260*	*1.417*	*.709*	*2175*		
	32	25.0	35.0	52.0	1	**SL-QFT-LG25C32-035A**	32	41.0	18.0	150	0.10	QFT-G-0300-03-TF
		.984	*1.378*	*2.047*			*1.260*	*1.614*	*.709*	*2175*		
	32	25.0	45.0	60.0	1	**SL-QFT-LG25C32-045A**	32	41.0	18.0	150	0.11	QFT-G-0300-03-TF
		.984	*1.772*	*2.362*			*1.260*	*1.614*	*.709*	*2175*		
	40	25.0	38.0	52.0	1	**SL-QFT-LG25C40-038A**	40	41.0	22.0	150	0.14	QFT-G-0300-03-TF
		.984	*1.496*	*2.047*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	45.0	60.0	1	**SL-QFT-LG25C40-045A**	40	41.0	22.0	150	0.17	QFT-G-0300-03-TF
		.984	*1.772*	*2.362*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	55.0	76.0	1	**SL-QFT-LG25C40-055A**	40	41.0	22.0	150	0.14	QFT-G-0300-03-TF
		.984	*2.165*	*2.992*			*1.575*	*1.614*	*.866*	*2175*		
	40	30.0	70.0	106.0	1	**SL-QFT-LG30C40-070A**	40	46.0	22.0	150	0.15	QFT-G-0300-03-TF
		1.181	*2.756*	*4.173*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	100.0	156.0	1	**SL-QFT-LG30C40-100A**	40	46.0	22.0	150	0.15	QFT-G-0300-03-TF
		1.181	*3.937*	*6.142*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	150.0	310.0	1	**SL-QFT-LG30C40-150A**	40	46.0	22.0	150	0.15	QFT-G-0300-03-TF
		1.181	*5.906*	*12.205*			*1.575*	*1.811*	*.866*	*2175*		
QFT-H	32	22.0	30.0	45.0	1	**SL-QFT-LH22C32-030A**	32	38.0	18.5	150	0.11	QFT-H-0400-03-TF
		.866	*1.181*	*1.772*			*1.260*	*1.496*	*.728*	*2175*		
	32	25.0	35.0	55.0	1	**SL-QFT-LH25C32-035A**	32	41.0	18.5	150	0.11	QFT-H-0400-03-TF
		.984	*1.378*	*2.165*			*1.260*	*1.614*	*.728*	*2175*		
	40	25.0	36.0	55.0	1	**SL-QFT-LH25C40-036A**	40	41.0	22.5	150	0.15	QFT-H-0400-03-TF
		.984	*1.417*	*2.165*			*1.575*	*1.614*	*.886*	*2175*		
	40	32.0	45.0	75.0	1	**SL-QFT-LH32C40-045A**	40	48.0	22.5	150	0.15	QFT-H-0400-03-TF
		1.260	*1.772*	*2.953*			*1.575*	*1.890*	*.886*	*2175*		
	40	32.0	65.0	108.0	1	**SL-QFT-LH32C40-065A**	40	48.0	22.5	150	0.16	QFT-H-0400-03-TF
		1.260	*2.559*	*4.252*			*1.575*	*1.890*	*.886*	*2175*		
	40	38.0	100.0	160.0	1	**SL-QFT-LH38C40-100A**	40	54.0	22.5	150	0.22	QFT-H-0400-03-TF
		1.496	*3.937*	*6.299*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	150.0	310.0	1	**SL-QFT-LH38C40-150A**	40	54.0	22.5	150	0.22	QFT-H-0400-03-TF
		1.496	*5.906*	*12.205*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	300.0	510.0	1	**SL-QFT-LH38C40-300A**	40	54.0	22.5	150	0.22	QFT-H-0400-03-TF
		1.496	*11.811*	*20.079*			*1.575*	*2.126*	*.886*	*2175*		

SSC = To correspond with SSC on insert.

A Curve - Clockwise spindle rotation

Spare parts
Locating tube
5638 031-01

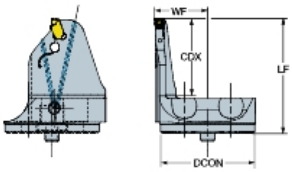
For complete list of spare parts, see www.sandvik.coromant.com

30 150 155

CoroCut® QF head for face grooving

Spring clamp design

Precision coolant supply



SSC	CZC_{MS}	CDX	DAXIN	DAXX	CNSC	Ordering code	Dimensions, mm, inch DCON	LF	WF	BAR PSI	KG	MIID
QFU-G	32	20.0	30.0	42.0	1	SL-QFU-RG20C32-030A	32	36.0	18.0	150	0.10	QFU-G-0300-03-TF
		.787	*1.181*	*1.654*			*1.260*	*1.417*	*.709*	*2175*		
	32	25.0	35.0	52.0	1	SL-QFU-RG25C32-035A	32	41.0	18.0	150	0.21	QFU-G-0300-03-TF
		.984	*1.378*	*2.047*			*1.260*	*1.614*	*.709*	*2175*		
	32	25.0	45.0	60.0	1	SL-QFU-RG25C32-045A	32	41.0	18.0	150	0.11	QFU-G-0300-03-TF
		.984	*1.772*	*2.362*			*1.260*	*1.614*	*.709*	*2175*		
	40	25.0	38.0	52.0	1	SL-QFU-RG25C40-038A	40	41.0	22.0	150	0.22	QFU-G-0300-03-TF
		.984	*1.496*	*2.047*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	45.0	60.0	1	SL-QFU-RG25C40-045A	40	41.0	22.0	150	0.14	QFU-G-0300-03-TF
		.984	*1.772*	*2.362*			*1.575*	*1.614*	*.866*	*2175*		
	40	25.0	55.0	76.0	1	SL-QFU-RG25C40-055A	40	41.0	22.0	150	0.14	QFU-G-0300-03-TF
		.984	*2.165*	*2.992*			*1.575*	*1.614*	*.866*	*2175*		
	40	30.0	70.0	106.0	1	SL-QFU-RG30C40-070A	40	46.0	22.0	150	0.14	QFU-G-0300-03-TF
		1.181	*2.756*	*4.173*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	100.0	156.0	1	SL-QFU-RG30C40-100A	40	46.0	22.0	150	0.15	QFU-G-0300-03-TF
		1.181	*3.937*	*6.142*			*1.575*	*1.811*	*.866*	*2175*		
	40	30.0	150.0	310.0	1	SL-QFU-RG30C40-150A	40	46.0	22.0	150	0.15	QFU-G-0300-03-TF
		1.181	*5.906*	*12.205*			*1.575*	*1.811*	*.866*	*2175*		
QFU-H	32	22.0	30.0	45.0	1	SL-QFU-RH22C32-030A	32	38.0	18.5	150	0.12	QFU-H-0400-03-TF
		.866	*1.181*	*1.772*			*1.260*	*1.496*	*.728*	*2175*		
	32	25.0	35.0	52.0	1	SL-QFU-RH25C32-035A	32	41.0	18.5	150	0.11	QFU-H-0400-03-TF
		.984	*1.378*	*2.047*			*1.260*	*1.614*	*.728*	*2175*		
	40	25.0	36.0	55.0	1	SL-QFU-RH25C40-036A	40	41.0	22.5	150	0.15	QFU-H-0400-03-TF
		.984	*1.417*	*2.165*			*1.575*	*1.614*	*.886*	*2175*		
	40	32.0	45.0	75.0	1	SL-QFU-RH32C40-045A	40	48.0	22.5	150	0.15	QFU-H-0400-03-TF
		1.260	*1.772*	*2.953*			*1.575*	*1.890*	*.886*	*2175*		
	40	32.0	65.0	108.0	1	SL-QFU-RH32C40-065A	40	48.0	22.5	150	0.16	QFU-H-0400-03-TF
		1.260	*2.559*	*4.252*			*1.575*	*1.890*	*.886*	*2175*		
	40	38.0	100.0	160.0	1	SL-QFU-RH38C40-100A	40	54.0	22.5	150	0.17	QFU-H-0400-03-TF
		1.496	*3.937*	*6.299*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	150.0	310.0	1	SL-QFU-RH38C40-150A	40	54.0	22.5	150	0.17	QFU-H-0400-03-TF
		1.496	*5.906*	*12.205*			*1.575*	*2.126*	*.886*	*2175*		
	40	38.0	300.0	510.0	1	SL-QFU-RH38C40-300A	40	54.0	22.5	150	0.17	QFU-H-0400-03-TF
		1.496	*11.811*	*20.079*			*1.575*	*2.126*	*.886*	*2175*		

SSC = To correspond with SSC on insert.

A Curve - Counter clockwise spindle rotation

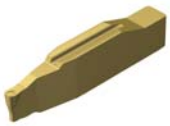
Spare parts
Locating tube
5638 031-01

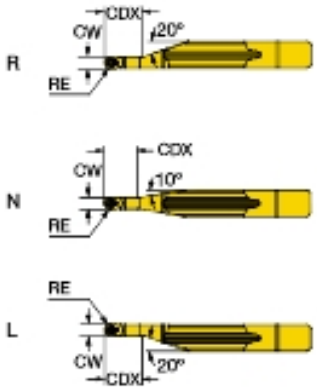
For complete list of spare parts, see www.sandvik.coromant.com

30 150 155

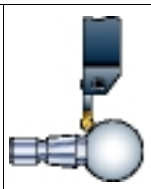
CoroCut® 1-2 insert for profiling

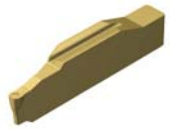
Profiling hardened materials and heat resistant super alloys

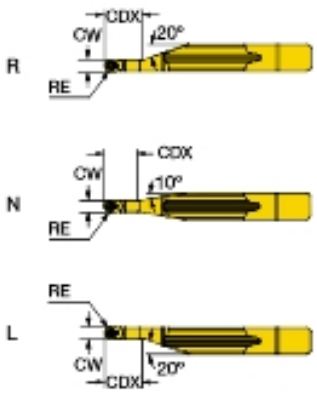




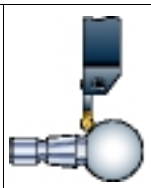
CoroCut® 1-edge

		SSC	CW	RE	CDX	APMX	Ordering code	P	M			K	N		S			Dimensions, mm, inch				
								1125	1105	1125	S05F	1125	1105	1125	1105	1125	S05F	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		HN	1.50	0.75	4.0	0.5	N123H1-0150-RO	★	☆	★	☆	★	★	☆	★	☆	☆	7°	-0.020	0.020	-0.010	0.010
			.059	.030	.157	.020													-.0008	.0008	-.0004	.0004





CoroCut® 1-edge

		SSC	CW	RE	CDX	APMX	Ordering code	P	M			K	N		S			Dimensions, mm, inch				
								1125	1105	1125	S05F	1125	1105	1125	1105	1125	S05F	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		HL	1.50	0.75	4.0	0.5	L123H1-0150-RO	★	☆	★	☆	★	★	☆	★	☆	☆	7°	-0.020	0.020	-0.010	0.010
			.059	.030	.157	.020													-.0008	.0008	-.0004	.0004
		HR	1.50	0.75	4.0	0.5	R123H1-0150-RO	★	☆	★	☆	★	★	☆	★	☆	☆	7°	-0.020	0.020	-0.010	0.010
			.059	.030	.157	.020													-.0008	.0008	-.0004	.0004

SSC = To correspond with SSC on holder.

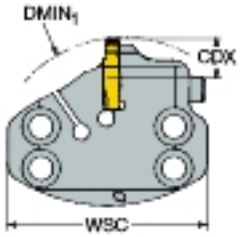
N = Neutral, R = Right hand, L = Left hand

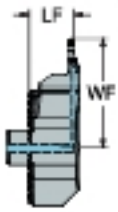
43 150

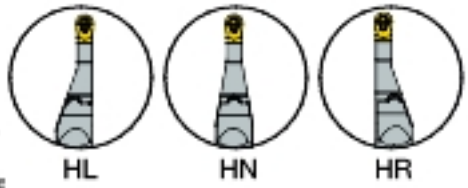
CoroCut® 1-2 head for profiling

Screw clamp design

CoroTurn® SL70 - Internal coolant supply







						Dimensions, mm, inch						
SSC	CZC_{MS}	CDX	$DMIN_1$	CNSC	**Ordering code**	LF	WF	WSC	BAR PSI	NM	KG	MIID
HL	70	11.0	100.0	1	**SL70-L123H11LC-HP**	15.5	38.4	70.0	80	3.1	0.31	L123H1-0150-RO
		.433	*3.937*			*.610*	*1.512*	*2.756*	*1160*			
	70	11.0	100.0	1	**SL70-R123H11LC-HP**	17.4	38.4	70.0	80	3.1	0.31	L123H1-0150-RO
		.433	*3.937*			*.685*	*1.512*	*2.756*	*1160*			
HN	70	11.0	100.0	1	**SL70-L123H11NC-HP**	16.5	38.4	70.0	80	3.1	0.31	N123H1-0150-RO
		.433	*3.937*			*.648*	*1.512*	*2.756*	*1160*			
	70	11.0	100.0	1	**SL70-R123H11NC-HP**	16.5	38.4	70.0	80	3.1	0.31	N123H1-0150-RO
		.433	*3.937*			*.648*	*1.512*	*2.756*	*1160*			
HR	70	11.0	100.0	1	**SL70-L123H11RC-HP**	17.4	38.4	70.0	80	3.1	0.31	R123H1-0150-RO
		.433	*3.937*			*.685*	*1.512*	*2.756*	*1160*			
	70	11.0	100.0	1	**SL70-R123H11RC-HP**	15.5	38.4	70.0	80	3.1	0.31	R123H1-0150-RO
		.433	*3.937*			*.610*	*1.512*	*2.756*	*1160*			

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

Spare parts		
Screw	Nozzle	Guide bush
3212 010-313	5691 026-23	5552 058-04

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

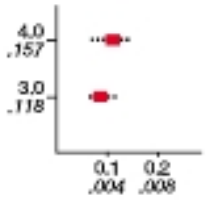
150 155

CoroCut® QF

Face grooving

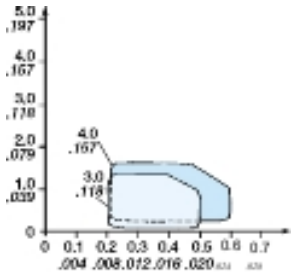
-RM

Grooving feed
Insert width (CW), mm, inch



Feed (f_n), mm/r, inch/r

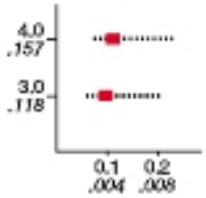
Turning feed
Cutting depth (a_p), mm, inch



Excellent for profiling in all materials
Outstanding chip control even at low feeds and small depths of cut.
Good surface finish.

-GF

Grooving feed
Insert width (CW), mm, inch



Feed (f_n), mm/r, inch/r

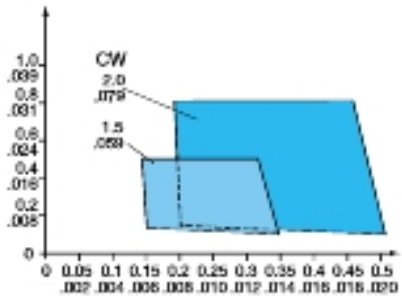
For precision grooves
Good accuracy and repeatability due to tight tolerances on inserts.
Low cutting forces and good surface finishing due to sharp cutting edge.

CoroCut® 1-2

Profiling

-RO

Turning feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

Excellent for profiling in stainless steel, HRSA and other sticky materials
HRSA and other sticky materials.
Outstanding chip control at low feeds and small depths of cut.
Good surface finish. Sharp cutting edge.
Available as CoroCut 2-edge inserts.

= Recommended starting value.

ENG

Milling

Face milling tools

Shoulder milling tools

Disc milling tools

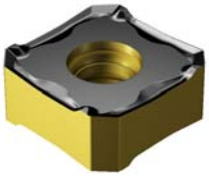
Profile milling tools

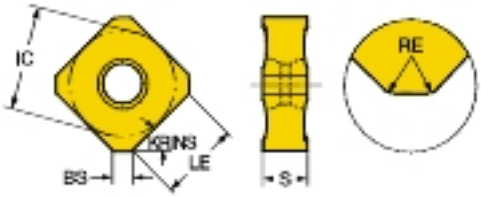
Solid milling tools

Cutting data

CoroMill® 345 insert for milling

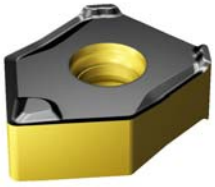
KRINS 45°

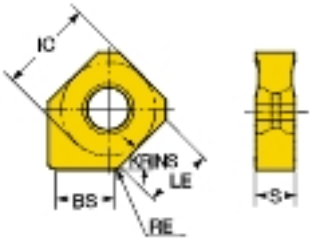




		RE		Ordering code	P 4330	P 4340	M 4340	K 4330	K 4340	Dimensions, mm, inch IC	LE	S	BS	BSR
Light	PL	13	0.80	345R-1305E-PL	★	☆	☆	☆	☆	13.0	8.8	5.05	2.0	107.0
			.031							.512	.346	.199	.079	4.213
			0.80	345R-1305M-PL	★	☆	☆	☆	☆	13.0	8.8	5.05	2.0	107.0
			.031							.512	.346	.199	.079	4.213
Medium	PM	13	0.80	345L-1305M-PM	★	☆	☆	☆	☆	13.0	8.8	5.05	2.0	107.0
			.031							.512	.346	.199	.079	4.213
			0.80	345R-1305M-PM	★	☆	☆	☆	☆	13.0	8.8	5.05	2.0	107.0
			.031							.512	.346	.199	.079	4.213
Heavy	PH	13	0.80	345R-1305M-PH	★	☆		☆	☆	13.0	8.8	5.05	2.0	107.0
			.031							.512	.346	.199	.079	4.213
	KH	13	0.80	345R-1305M-KH	☆			☆		13.0	8.8	5.05	2.0	107.0
			.031							.512	.346	.199	.079	4.213

KRINS 45°





		RE		Ordering code	P 4330	K 4330	Dimensions, mm, inch IC	LE	S	BS	BSR
Light	PW5	13	1.00	345N-1305E-PW5	★	☆	13.0	8.8	5.05	5.0	500.0
			.039				.512	.346	.199	.197	19.685
	PW8	13	1.00	345N-1305E-PW8	★	☆	13.0	8.8	5.05	8.0	500.0
			.039				.512	.346	.199	.315	19.685

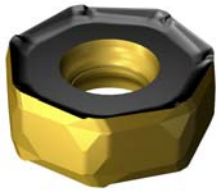
70 150

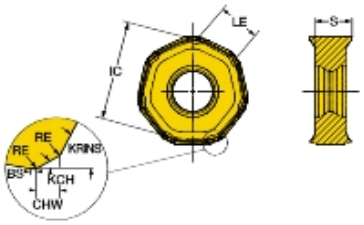
SANDVIK Coromant

ENG

CoroMill® 745 insert for milling

KRINS 42°





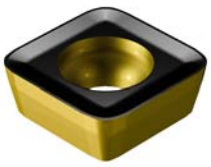
			RE	KCH	CHW	Ordering code	P 4330	P 4340	M 4340	K 4330	K 4340	IC	LE	S	BS	BSR
Medium	M30	21	1.00	17°	1.3	745R-2109E-M30	★	☆		☆	☆	21.0	8.9	9.00	0.3	25.0
			.039		.051							.827	.350	.354	.012	.984
	M31	21	1.00			745R-2109E-M31	★	☆	☆	☆	☆	21.0	7.1	9.00	1.9	150.0
			.039									.827	.280	.354	.075	5.906
	M50	21	1.00	17°	1.3	745L-2109E-M50	★			☆		21.0	8.5	9.00	0.3	25.0
			.039		.051							.827	.335	.354	.013	.984
			1.00	17°	1.3	745R-2109E-M50	★	☆		☆	☆	21.0	8.9	9.00	0.3	25.0
			.039		.051							.827	.350	.354	.012	.984
Heavy	H50	21	1.00	17°	1.3	745R-2109E-H50	★	☆		☆	☆	21.0	8.9	9.00	0.3	25.0
			.039		.051							.827	.350	.354	.012	.984

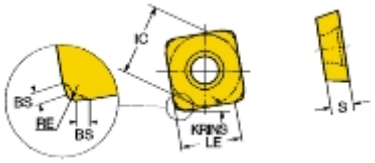
745R-2109E-M31 not recommended for CoroMill 745 high feed cutter with 25° entering angle.

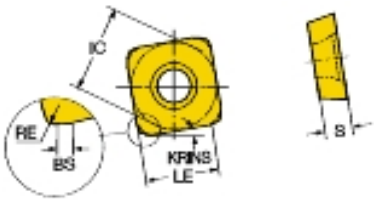
CoroMill® 210 insert for milling

KRINS 10°
R210..E-PM

10°
R210..M-PM





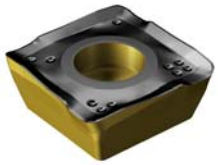


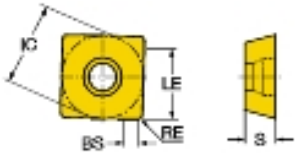
			RE	Ordering code	P 4330	P 4340	M 4340	K 4330	K 4340	IC	LE	S	BS	BSR
Medium	PM	09	1.40	R210-09 04 14E-PM	★	☆	☆	☆	☆	9.5	5.7	4.50	0.7	50.0
			.055							.374	.227	.177	.026	1.969
		14	1.40	R210-14 05 14E-PM	★	☆	☆	☆	☆	14.6	10.8	5.26	0.7	50.0
			.055							.575	.426	.207	.028	1.969
		09	1.00	R210-09 04 12M-PM	★	☆	☆	☆	☆	9.4	6.2	4.00	0.8	
			.039							.370	.244	.157	.030	
		14	1.00	R210-14 05 12M-PM	★	☆	☆	☆	☆	14.5	11.3	4.76	0.8	
			.039							.571	.445	.187	.030	

70 150

CoroMill® 490 insert for milling

KRINS 90°





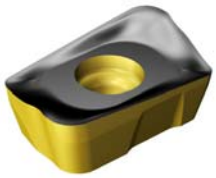
		RE	Ordering code	P 4330	P 4340	M 4340	K 4330	K 4340	IC	LE	S	BS
Light	PL	08 0.40	490R-08T304M-PL	★	☆	☆	☆	☆	8.5	5.6	3.30	1.5
		.016							.335	.220	.130	.059
		0.80	490R-08T308M-PL	★	☆	☆	☆	☆	8.5	5.6	3.30	1.2
		.031							.335	.220	.130	.047
		14 0.80	490R-140408M-PL	★	☆	☆	☆	☆	13.8	10.3	3.90	2.0
		.031							.543	.406	.154	.079
Medium	PM	08 0.80	490R-08T308M-PM	★	☆	☆	☆	☆	8.5	5.6	3.30	1.2
		.031							.335	.220	.130	.047
		1.20	490R-08T312M-PM	★	☆	☆	☆	☆	8.5	5.6	3.30	0.9
		.047							.335	.220	.130	.033
		1.60	490R-08T316M-PM	★	☆	☆	☆	☆	8.5	5.6	3.30	0.6
		.063							.335	.220	.130	.024
		14 0.80	490L-140408M-PM	★			☆		13.8	10.3	3.90	2.0
		.031							.543	.406	.154	.079
		0.80	490R-140408M-PM	★	☆	☆	☆	☆	13.8	10.3	3.90	2.0
		.031							.543	.406	.154	.079
		1.20	490R-140412M-PM	★	☆	☆	☆	☆	13.8	10.3	3.90	2.0
		.047							.543	.406	.154	.079
		1.60	490R-140416M-PM	★	☆	☆	☆	☆	13.8	10.3	3.90	1.2
		.063							.543	.406	.154	.047
		2.00	490R-140420M-PM	★	☆	☆	☆	☆	13.8	10.3	3.90	0.9
		.079							.543	.406	.154	.035
Heavy	PH	08 0.80	490R-08T308M-PH	☆	★	☆	☆	☆	8.5	5.6	3.30	1.2
		.031							.335	.220	.130	.047
		1.60	490R-08T316M-PH	☆	★	☆	☆	☆	8.5	5.6	3.30	0.6
		.063							.335	.220	.130	.024
		14 0.80	490R-140408M-PH	☆	★	☆	☆	☆	13.8	10.3	3.90	2.0
		.031							.543	.406	.154	.079
		2.00	490R-140420M-PH	☆	★	☆	☆	☆	13.8	10.3	3.90	0.9
		.079							.543	.406	.154	.035

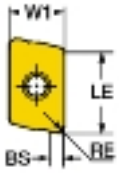
70 150

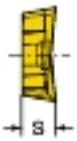
ENG

CoroMill® 390 insert for milling

KRINS 90°





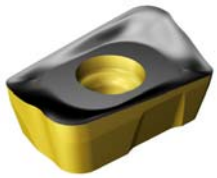


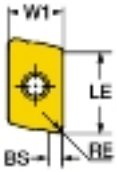
		RE	Ordering code	P 4330	P 4340	M 4340	K 4330	K 4340	Dimensions, mm, inch W1	LE	S	BS
Light	PL	17	R390-17 04 08E-PL		★	☆		☆	9.6	15.7	4.76	1.5
		.031							.378	.618	.187	.059
		18	R390-18 06 08H-PL	★	☆	☆	☆	☆	11.0	15.4	6.33	1.0
		.031							.433	.606	.249	.039
		1.20	R390-18 06 12H-PL	★	☆	☆	☆	☆	11.0	15.4	6.33	1.0
		.047							.433	.606	.249	.039
		1.60	R390-18 06 16H-PL		★	☆		☆	11.0	15.4	6.33	1.0
		.063							.433	.606	.249	.039
		11	R390-11 T3 08M-PL	★	☆	☆	☆	☆	6.8	10.0	3.59	1.2
		.031							.268	.394	.141	.047
		17	R390-17 04 08M-PL	★	☆	☆	☆	☆	9.6	15.7	4.76	1.5
		.031							.378	.618	.187	.059
Medium	PM	07	390R-070202M-PM		★	☆		☆	4.0	5.9	2.40	0.7
		.008							.160	.232	.094	.028
		0.40	390R-070204M-PM	★	☆	☆	☆	☆	4.0	5.9	2.40	0.7
		.016							.160	.232	.094	.028
		0.80	390R-070208M-PM	★	☆	☆	☆	☆	4.0	5.9	2.40	0.7
		.031							.160	.232	.094	.028
		1.20	390R-070212M-PM		★	☆		☆	4.0	5.9	2.40	0.7
		.047							.160	.232	.094	.028
		1.60	390R-070216M-PM		★	☆		☆	4.0	5.9	2.40	0.2
		.063							.160	.232	.094	.008
		11	R390-11 T3 02E-PM		★	☆		☆	6.8	10.0	3.59	0.7
		.008							.268	.394	.141	.028
		1.20	R390-11 T3 12E-PM		★	☆		☆	6.8	10.0	3.59	0.8
		.047							.268	.394	.141	.031
		1.60	R390-11 T3 16E-PM		★	☆		☆	6.8	10.0	3.59	0.4
		.063							.268	.394	.141	.016
		2.00	R390-11 T3 20E-PM		★	☆		☆	6.8	10.0	3.59	
		.079							.268	.394	.141	
		2.40	R390-11 T3 24E-PM		★	☆		☆	6.8	10.0	3.59	
		.094							.268	.394	.141	
		3.10	R390-11 T3 31E-PM		★	☆		☆	6.8	10.0	3.59	
		.122							.268	.394	.141	
		17	R390-17 04 04E-PM		★	☆		☆	9.6	15.7	4.76	1.0
		.016							.378	.618	.187	.039
		1.20	R390-17 04 12E-PM		★	☆		☆	9.6	15.7	4.76	1.1
		.047							.378	.618	.187	.043
		1.60	R390-17 04 16E-PM		★	☆		☆	9.6	15.7	4.76	0.7
		.063							.378	.618	.187	.028
		2.00	R390-17 04 20E-PM		★	☆		☆	9.6	15.7	4.76	0.3
		.079							.378	.618	.187	.012

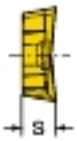
70 150

CoroMill® 390 insert for milling

KRINS 90°







		RE	Ordering code	P 4330	P 4340	M 4340	K 4330	K 4340	Dimensions, mm, inch W1	LE	S	BS
Medium	07	2.40	R390-17 04 24E-PM		★	☆		☆	9.6	15.7	4.76	
		.094							.378	.618	.187	
		3.10	R390-17 04 31E-PM		★	☆		☆	9.6	15.7	4.76	
		.122							.378	.618	.187	
		4.00	R390-17 04 40E-PM		★	☆		☆	9.6	15.7	4.76	
		.157							.378	.618	.187	
		5.00	R390-17 04 50E-PM		★	☆		☆	9.6	15.7	4.76	
		.197							.378	.618	.187	
		6.00	R390-17 04 60E-PM		★	☆		☆	9.6	15.7	4.76	
		.236							.378	.618	.187	
		6.35	R390-17 04 64E-PM		★	☆		☆	9.6	15.7	4.76	
		.250							.378	.618	.187	
		11 0.40	R390-11 T3 04M-PM		★	☆		☆	6.8	10.0	3.59	0.9
		.016							.268	.394	.141	.035
		0.80	R390-11 T3 08M-PM	★	☆	☆	☆	☆	6.8	10.0	3.59	1.2
		.031							.268	.394	.141	.047
		1.60	R390-11 T3 16M-PM		★	☆		☆	6.8	10.0	3.59	0.4
		.063							.268	.394	.141	.016
		3.10	R390-11 T3 31M-PM		★	☆		☆	6.8	10.0	3.59	
		.122							.268	.394	.141	
		17 0.40	R390-17 04 04M-PM		★	☆		☆	9.6	15.7	4.76	1.0
		.016							.378	.618	.187	.039
		0.80	R390-17 04 08M-PM	★	☆	☆	☆	☆	9.6	15.7	4.76	1.5
		.031							.378	.618	.187	.059
		1.60	R390-17 04 16M-PM		★	☆		☆	9.6	15.7	4.76	0.7
		.063							.378	.618	.187	.028
		3.10	R390-17 04 31M-PM		★	☆		☆	9.6	15.7	4.76	
		.122							.378	.618	.187	
		18 0.80	R390-18 06 08M-PM	★	☆	☆	☆	☆	11.0	15.4	6.33	1.1
		.031							.433	.606	.249	.043
		1.20	R390-18 06 12M-PM	★	☆	☆	☆	☆	11.0	15.4	6.33	1.1
		.047							.433	.606	.249	.043
		1.60	R390-18 06 16M-PM	★	☆	☆	☆	☆	11.0	15.4	6.33	1.1
		.063							.433	.606	.249	.043
		2.00	R390-18 06 20M-PM	★	☆	☆	☆	☆	11.0	15.4	6.33	0.5
		.079							.433	.606	.249	.020
		3.10	R390-18 06 31M-PM	★	☆	☆	☆	☆	11.0	15.4	6.33	0.5
		.122							.433	.606	.249	.020
	PMR	18 1.20	R390-18 06 12M-PMR	★	☆	☆	☆	☆	11.0	15.4	6.33	0.3
		.047							.433	.606	.249	.010
Heavy	PH	11 1.00	R390-11 T3 10M-PH	☆	★	☆	☆	☆	6.8	10.0	3.59	1.0
		.039							.268	.394	.141	.040
		17 0.80	R390-17 04 08M-PH		★	☆		☆	9.6	15.7	4.76	1.5
		.031							.378	.618	.187	.059
		1.60	R390-17 04 16M-PH	☆	★	☆	☆	☆	9.6	15.7	4.76	1.5
		.063							.378	.618	.187	.059

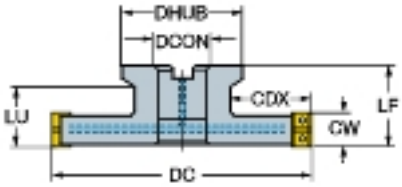
70 150

ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462:2011
KAPR 90°



Metric version

									Dimensions, mm								
CW	CWX	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	DCON	ISO	LF	LU	DHUB	BAR	KG	RPMX	CICT	MIID
6.0	8.0	80	20.0	27	6.0	1	3	R331.32C-080Q27CM	27.0	A	50.00	26	51.0	80	0.51	19300	6	N331.1A-04
		100	22.0	27	6.0	1	4	R331.32C-100Q27CM	27.0	A	50.00		51.0	80	0.75	17100	8	N331.1A-04
		125	29.5	32	6.0	1	5	R331.32C-125Q32CM	32.0	B	50.00		61.0	80	0.92	15100	10	N331.1A-04
		160	41.0	40	6.0	1	6	R331.32C-160Q40CM	40.0	B	50.00		73.0	80	1.38	13200	12	N331.1A-04
8.0	10.0	80	20.0	27	8.0	1	3	R331.32C-080Q27DM	27.0	A	50.00	26	51.0	80	0.54	15000	6	N331.1A-05
		100	22.0	27	8.0	1	4	R331.32C-100Q27DM	27.0	A	50.00		51.0	80	1.01	13200	8	N331.1A-05
		125	29.5	32	8.0	1	5	R331.32C-125Q32DM	32.0	B	50.00		61.0	80	1.09	11700	10	N331.1A-05
		160	41.0	40	8.0	1	6	R331.32C-160Q40DM	40	B	50.00		73.0	80	1.53	10200	12	N331.1A-05
10.0	12.0	80	20.0	27	10.0	1	3	R331.32C-080Q27EM	27.0	A	50.00	26	51.0	80	0.70	18100	6	N331.1A-08
		100	22.0	27	10.0	1	4	R331.32C-100Q27EM	27.0	A	50.00		51.0	80	1.10	15900	8	N331.1A-08
		125	29.5	32	10.0	1	5	R331.32C-125Q32EM	32.0	B	50.00		61.0	80	1.30	14100	10	N331.1A-08
		160	41.0	40	10.0	1	6	R331.32C-160Q40EM	40.0	B	50.00		73.0	80	1.98	12400	12	N331.1A-08
12.0	15.0	80	20.0	27	12.0	1	3	R331.32C-080Q27FM	27.0	A	50.00	26	51.0	80	0.62	18100	6	N331.1A-08
		100	22.0	27	12.0	1	4	R331.32C-100Q27FM	27.0	A	50.00		51.0	80	0.92	15900	8	N331.1A-08
		125	29.5	32	12.0	1	5	R331.32C-125Q32FM	32.0	B	50.00		61.0	80	1.21	14100	10	N331.1A-08
		160	41.0	40	12.0	1	6	R331.32C-160Q40FM	40.0	B	50.00		73.0	80	1.94	12400	12	N331.1A-08
15.0	17.5	100	25.5	27	15.0	1	3	R331.32C-100Q27KM	27.0	A	50.00	26	51.0	80	0.98	14000	6	N331.1A-11
		125	29.5	32	15.0	1	4	R331.32C-125Q32KM	32.0	B	50.00		61.0	80	1.23	12400	8	N331.1A-11
		160	41.0	40	15.0	1	5	R331.32C-160Q40KM	40.0	B	50.00		73.0	80	2.17	10800	10	N331.1A-11
17.5	20.5	125	29.5	32	17.5	1	4	R331.32C-125Q32LM	32.0	B	50.00		61.0	80	1.42	12400	8	N331.1A-11
		160	41.0	40	17.5	1	5	R331.32C-160Q40LM	40.0	B	50.00		73.0	80	2.35	10800	10	N331.1A-11
20.5	23.5	160	41.0	40	20.5	1	5	R331.32C-160Q40QM	40.0	B	50.00		73.0	80	2.63	9000	10	N331.1A-14
23.5	26.5	160	41.0	40	23.5	1	5	R331.32C-160Q40RM	40.0	B	50.00		73.0	80	3.00	9000	10	N331.1A-14

		Spare parts				
CW	DC	Cassette right	Cassette left	Insert screw	Wedge	Screw
6.0	80.00-160.00	5321 240-15	5321 240-16	5513 020-19	5431 105-07	5516 014-06
8.0	80.00	5321 240-13	5321 240-14	5513 020-34	5431 105-06	5516 014-05
8.0	100.00-160.00	5321 240-13	5321 240-14	5513 020-34	5431 105-06	5516 014-04
10.0	80.00	5321 240-01	5321 240-02	5513 020-24	5431 105-01	269-832
10.0	100.00	5321 240-01	5321 240-02	5513 020-24	5431 105-01	5516 010-02
10.0	125.00-160.00	5321 240-01	5321 240-02	5513 020-24	5431 105-01	339-831
12.0	80.00	5321 240-03	5321 240-04	5513 020-24	5431 105-02	269-832
12.0	100.00	5321 240-03	5321 240-04	5513 020-24	5431 105-02	5516 010-02
12.0	125.00-160.00	5321 240-03	5321 240-04	5513 020-24	5431 105-02	339-831
15.0	100.00-160.00	5321 240-07	5321 240-08	5513 020-29	5431 105-04	339-831
17.5	125.00-160.00	5321 240-07	5321 240-08	5513 020-29	5431 105-04	339-831
20.5	160.00	5321 240-09	5321 240-10	5513 020-29	5431 105-05	339-831
23.5	160.00	5321 240-09	5321 240-10	5513 020-29	5431 105-05	339-831

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

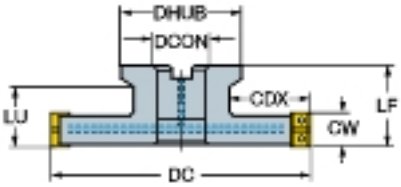
	Accessories
CZC_{MS}	Coolant screw
27	5512 087-02
32	5512 098-04
40	5512 098-03

62 150 155

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462:2011
KAPR 90°



Inch version

CW	CWX	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, inch DCON	ISO	LF	LU	DHUB	PSI	LBS	RPMX	CICT	MIID
.236	.315	3.150	.787	1	.236	1	3	R331.32C-080R25CM	1.000	A	2.000	1.024	2.008	1160	1.16	19300	6	N331.1A-04
		4.000	.866	1	.236	1	4	R331.32C-101R25CM	1.000	A	2.000		2.008	1160	1.85	17100	8	N331.1A-04
		5.000	1.201	1 1/4	.236	1	5	R331.32C-127R32CM	1.250	B	2.000		2.402	1160	1.98	15100	10	N331.1A-04
		6.000	1.465	1 1/2	.236	1	6	R331.32C-152R38CM	1.500	B	2.000		2.992	1160	3.10	13200	12	N331.1A-04
.315	.394	3.150	.787	1	.315	1	3	R331.32C-080R25DM	1.000	A	2.000	1.024	2.008	1160	1.21	15000	6	N331.1A-05
		4.000	.866	1	.315	1	4	R331.32C-101R25DM	1.000	A	2.000		2.008	1160	1.91	13200	8	N331.1A-05
		5.000	1.201	1 1/4	.315	1	5	R331.32C-127R32DM	1.250	B	2.000		2.402	1160	2.42	11700	10	N331.1A-05
		6.000	1.465	1 1/2	.315	1	6	R331.32C-152R38DM	1.500	B	2.000		2.992	1160	3.10	10200	12	N331.1A-05
.394	.472	3.150	.787	1	.394	1	3	R331.32C-080R25EM	1.000	A	2.000	1.024	2.008	1160	1.21	18100	6	N331.1A-08
		4.000	.866	1	.394	1	4	R331.32C-101R25EM	1.000	A	2.000		2.008	1160	1.91	15900	8	N331.1A-08
		5.000	1.201	1 1/4	.394	1	5	R331.32C-127R32EM	1.250	B	2.000		2.402	1160	2.86	14100	10	N331.1A-08
		6.000	1.465	1 1/2	.394	1	6	R331.32C-152R38EM	1.500	B	2.000		2.992	1160	3.91	12400	12	N331.1A-08
.472	.591	3.150	.787	1	.472	1	3	R331.32C-080R25FM	1.000	A	2.000	1.024	2.008	1160	1.32	18100	6	N331.1A-08
		4.000	.866	1	.472	1	4	R331.32C-101R25FM	1.000	A	2.000		2.008	1160	2.11	15900	8	N331.1A-08
		5.000	1.201	1 1/4	.472	1	5	R331.32C-127R32FM	1.250	B	2.000		2.402	1160	2.70	14100	10	N331.1A-08
		6.000	1.465	1 1/2	.472	1	6	R331.32C-152R38FM	1.500	B	2.000		2.992	1160	3.97	12400	12	N331.1A-08
.591	.689	4.000	1.024	1	.591	1	3	R331.32C-101R25KM	1.000	A	2.000	1.024	2.008	1160	2.23	14000	6	N331.1A-11
		5.000	1.201	1 1/4	.591	1	4	R331.32C-127R32KM	1.250	B	2.000		2.402	1160	2.90	12400	8	N331.1A-11
		6.000	1.465	1 1/2	.591	1	5	R331.32C-152R38KM	1.500	B	2.000		2.992	1160	4.26	10800	10	N331.1A-11
.689	.807	5.000	1.201	1 1/4	.689	1	4	R331.32C-127R32LM	1.250	B	2.000		2.402	1160	3.08	12400	8	N331.1A-11
		6.000	1.465	1 1/2	.689	1	5	R331.32C-152R38LM	1.500	B	2.000		2.992	1160	4.84	10800	10	N331.1A-11
.807	.925	6.000	1.465	1 1/2	.807	1	5	R331.32C-152R38QM	1.500	B	2.000		2.992	1160	5.50	9000	10	N331.1A-14
.925	1.043	6.000	1.465	1 1/2	.925	1	5	R331.32C-152R38RM	1.500	B	2.000		2.992	1160	6.60	9000	10	N331.1A-14

		Spare parts				
CW	DC	Cassette right	Cassette left	Insert screw	Wedge	Screw
.236	3.150 - 6.000	5321 240-15	5321 240-16	5513 020-19	5431 105-07	5516 014-06
.315	3.150	5321 240-13	5321 240-14	5513 020-34	5431 105-06	5516 014-05
.315	4.000 - 6.000	5321 240-13	5321 240-14	5513 020-34	5431 105-06	5516 014-04
.394	3.150	5321 240-01	5321 240-02	5513 020-24	5431 105-01	269-832
.394	4.000	5321 240-01	5321 240-02	5513 020-24	5431 105-01	5516 010-02
.394	5.000 - 6.000	5321 240-01	5321 240-02	5513 020-24	5431 105-01	339-831
.472	3.150	5321 240-03	5321 240-04	5513 020-24	5431 105-02	269-832
.472	4.000	5321 240-03	5321 240-04	5513 020-24	5431 105-02	5516 010-02
.472	5.000 - 6.000	5321 240-03	5321 240-04	5513 020-24	5431 105-02	339-831
.591	4.000 - 6.000	5321 240-07	5321 240-08	5513 020-29	5431 105-04	339-831
.689	5.000 - 6.000	5321 240-07	5321 240-08	5513 020-29	5431 105-04	339-831
.807	6.000	5321 240-09	5321 240-10	5513 020-29	5431 105-05	339-831
.925	6.000	5321 240-09	5321 240-10	5513 020-29	5431 105-05	339-831

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

	Accessories
CZC_{MS}	Coolant screw
1	5512 088-02
1.25	5512 099-05
1.5	5512 099-03

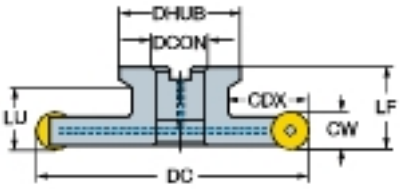
62 150 155

ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462:2011



Metric version

CW	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, mm DCON	ISO	LF	LU	DHUB	BAR	KG	RPMX	CICT	MIID
10.0	82	21.6	27	10.0	1	6	R331.32C-082Q27EMQ	27.0	A	50.00	26	51.0	80	0.59	19500	6	RCKT 10 T3 M0
	102	23.0	27	10.0	1	8	R331.32C-102Q27EMQ	27.0	A	50.00		51.0	80	0.95	15900	8	RCKT 10 T3 M0
	127	30.5	32	10.0	1	10	R331.32C-127Q32EMQ	32.0	B	50.00		61.0	80	1.20	14100	10	RCKT 10 T3 M0
	162	42.0	40	10.0	1	12	R331.32C-162Q40EMQ	40.0	B	50.00		73.0	80	1.85	12400	12	RCKT 10 T3 M0
12.0	82	21.0	27	12.0	1	6	R331.32C-082Q27FMQ	27.0	A	50.00	26	51.0	80	0.66	18100	6	RCKT 12 04 M0
	102	23.0	27	12.0	1	8	R331.32C-102Q27FMQ	27.0	A	50.00		51.0	80	1.00	15900	8	RCKT 12 04 M0
	127	30.5	32	12.0	1	10	R331.32C-127Q32FMQ	32.0	B	50.00		61.0	80	1.29	14100	10	RCKT 12 04 M0
	162	42.0	40	12.0	1	12	R331.32C-162Q40FMQ	40.0	B	50.00		73.0	80	2.03	12400	12	RCKT 12 04 M0
16.0	102	26.5	27	16.0	1	6	R331.32C-102Q27KMQ	27.0	A	50.00	26	51.0	80	0.90	14000	6	RCKT 16 06 M0
	127	30.5	32	16.0	1	8	R331.32C-127Q32KMQ	32.0	B	50.00		61.0	80	1.38	12400	8	RCKT 16 06 M0
	162	42.0	40	16.0	1	10	R331.32C-162Q40KMQ	40.0	B	50.00		73.0	80	2.22	10800	10	RCKT 16 06 M0

		Spare parts			
CW	DC	Cassette neutral	Insert screw	Wedge	Screw
10.0	82.00	5521 250-02	5513 020-09	5431 105-01	269-832
10.0	102.00	5521 250-02	5513 020-09	5431 105-01	5516 010-02
10.0	127.00-162.00	5521 250-02	5513 020-09	5431 105-01	339-831
12.0	82.00	5521 250-03	5513 020-09	5431 105-02	269-832
12.0	102.00	5521 250-03	5513 020-09	5431 105-02	5516 010-02
12.0	127.00-162.00	5521 250-03	5513 020-09	5431 105-02	339-831
16.0	102.00-162.00	5521 250-05	5513 020-07	5431 105-04	339-831

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

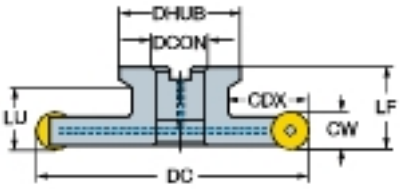
	Accessories
CZC_{MS}	Coolant screw
27	5512 087-02
32	5512 098-04
40	5512 098-03

62 150 155

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462:2011



Inch version

CW	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, inch DCON	ISO	LF	LU	DHUB	PSI	LBS	RPMX	CICT	MIID
.375	3.228	.827	1	.375	1	6	R331.32C-082R25EMQ	1.000	A	2.000	1.024	2.008	1160	1.32	18100	6	RCKT 09 T3 00
	4.079	.925	1	.375	1	8	R331.32C-103R25EMQ	1.000	A	2.000		2.008	1160	2.20	15900	8	RCKT 09 T3 00
	5.079	1.200	1 1/4	.375	1	10	R331.32C-129R32EMQ	1.250	B	2.000		2.402	1160	2.64	14100	10	RCKT 09 T3 00
	6.079	1.504	1 1/2	.375	1	12	R331.32C-154R38EMQ	1.500	B	2.000		2.874	1160	3.96	12400	12	RCKT 09 T3 00
.500	3.228	.827	1	.500	1	6	R331.32C-082R25FMQ	1.000	A	2.000	1.024	2.008	1160	1.54	18100	6	RCKT 13 04 00
	4.079	.925	1	.500	1	8	R331.32C-103R25FMQ	1.000	A	2.000		2.008	1160	2.20	15900	8	RCKT 13 04 00
	5.079	1.200	1 1/4	.500	1	10	R331.32C-129R32FMQ	1.250	B	2.000		2.402	1160	2.86	14100	10	RCKT 13 04 00
	6.079	1.504	1 1/2	.500	1	12	R331.32C-154R38FMQ	1.500	B	2.000		2.874	1160	4.40	12400	12	RCKT 13 04 00
.630	4.079	1.051	1	.630	1	6	R331.32C-103R25KMQ	1.000	A	2.000	1.024	2.008	1160	1.98	14000	6	RCKT 16 06 M0
	5.079	1.200	1 1/4	.630	1	8	R331.32C-129R32KMQ	1.250	B	2.000		2.402	1160	3.08	12400	8	RCKT 16 06 M0
	6.079	1.504	1 1/2	.630	1	10	R331.32C-154R38KMQ	1.500	B	2.000		2.874	1160	4.62	10800	10	RCKT 16 06 M0

		Spare parts			
CW	DC	Cassette neutral	Insert screw	Wedge	Screw
.375	3.228	5521 250-01	5513 020-30	5431 105-01	269-832
.375	4.079	5521 250-01	5513 020-30	5431 105-01	5516 010-02
.375	5.079 - 6.079	5521 250-01	5513 020-30	5431 105-01	339-831
.500	3.228	5521 250-04	5513 020-09	5431 105-02	269-832
.500	4.079	5521 250-04	5513 020-09	5431 105-02	5516 010-02
.500	5.079 - 6.079	5521 250-04	5513 020-09	5431 105-02	339-831
.630	4.079 - 6.079	5521 250-05	5513 020-07	5431 105-04	339-831

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

	Accessories
CZC_{MS}	Coolant screw
1	5512 088-02
1.25	5512 099-05
1.5	5512 099-03

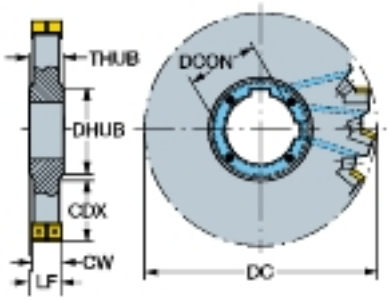
62 150 155

ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



Metric version

CW	CWX	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, mm DCON	LF	DRVCT	DHUB	THUB	BAR	KG	RPMX	CICT	MIID
6.0	8.0	80	19.5	27	6.0	1	3	N331.32C-080S27CM	27.0	10.00	1	39.0	14.0	80	0.37	19300	6	N331.1A-04
		100	25.5	32	6.0	1	4	N331.32C-100S32CM	32.0	10.00	1	47.0	14.0	80	0.62	17100	8	N331.1A-04
		125	34.0	40	6.0	1	5	N331.32C-125S40CM	40.0	10.00	2	55.0	14.0	80	0.77	15100	10	N331.1A-04
		160	51.5	40	6.0	1	6	N331.32C-160S40CM	40.0	10.00	2	55.0	14.0	80	1.02	13200	12	N331.1A-04
8.0	10.0	80	19.5	27	8.0	1	3	N331.32C-080S27DM	27.0	12.00	1	39.0	16.0	80	0.46	15000	6	N331.1A-05
		100	25.5	32	8.0	1	4	N331.32C-100S32DM	32.0	12.00	1	47.0	16.0	80	0.71	13200	8	N331.1A-05
		125	34.0	40	8.0	1	5	N331.32C-125S40DM	40.0	12.00	2	55.0	16.0	80	0.82	11700	10	N331.1A-05
		160	51.5	40	8.0	1	6	N331.32C-160S40DM	40.0	12.00	2	55.0	16.0	80	1.24	10200	12	N331.1A-05
10.0	12.0	80	19.5	27	10.0	1	3	N331.32C-080S27EM	27.0	13.00	1	39.0	16.0	80	0.42	18100	6	N331.1A-08
		100	25.5	32	10.0	1	4	N331.32C-100S32EM	32.0	13.00	1	47.0	16.0	80	0.78	15900	8	N331.1A-08
		125	34.0	40	10.0	1	5	N331.32C-125S40EM	40.0	13.00	2	55.0	16.0	80	0.93	14100	10	N331.1A-08
		160	51.5	40	10.0	1	6	N331.32C-160S40EM	40.0	13.00	2	55.0	16.0	80	1.46	12400	12	N331.1A-08
12.0	15.0	80	19.5	27	12.0	1	3	N331.32C-080S27FM	27.0	14.00	1	39.0	16.0	80	0.58	18100	6	N331.1A-08
		100	25.5	32	12.0	1	4	N331.32C-100S32FM	32.0	14.00	1	47.0	16.0	80	0.80	15900	8	N331.1A-08
		125	34.0	40	12.0	1	5	N331.32C-125S40FM	40.0	14.00	2	55.0	16.0	80	1.04	14100	10	N331.1A-08
		160	51.5	40	12.0	1	6	N331.32C-160S40FM	40.0	14.00	2	55.0	16.0	80	1.68	12400	12	N331.1A-08
15.0	17.5	100	25.5	32	15.0	1	3	N331.32C-100S32KM	32.0	16.75	1	47.0	18.5	80	0.97	14000	6	N331.1A-11
		125	34.0	40	15.0	1	4	N331.32C-125S40KM	40.0	16.75	1	55.0	18.5	80	1.23	12400	8	N331.1A-11
		160	51.5	40	15.0	1	5	N331.32C-160S40KM	40.0	16.75	2	55.0	18.5	80	2.01	10800	10	N331.1A-11
17.5	20.5	125	34.0	40	17.5	1	4	N331.32C-125S40LM	40.0	19.50	1	55.0	21.5	80	1.41	12400	8	N331.1A-11
		160	51.5	40	17.5	1	5	N331.32C-160S40LM	40.0	19.50	2	55.0	21.5	80	2.20	10800	10	N331.1A-11
20.5	23.5	160	51.5	40	20.5	1	5	N331.32C-160S40QM	40.0	22.50	2	55.0	24.5	80	2.55	9000	10	N331.1A-14
23.5	26.5	160	51.5	40	23.5	1	5	N331.32C-160S40RM	40.0	25.50	2	55.0	27.5	80	2.78	9000	10	N331.1A-14

		Spare parts		
CW	DC	Insert screw	Wedge	Screw
6.0	80-160	5513 020-19	5431 105-07	5516 014-06
8.0	80-160	5513 020-34	5431 105-06	5516 014-05
10.0	80-160	5513 020-24	5431 105-01	269-832
12.0	80-160	5513 020-24	5431 105-02	269-832
15.0	100-160	5513 020-29	5431 105-04	5516 010-02
17.5	125-160	5513 020-29	5431 105-04	5516 010-02
20.5	160	5513 020-29	5431 105-05	5516 010-02
23.5	160	5513 020-29	5431 105-05	5516 010-02

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

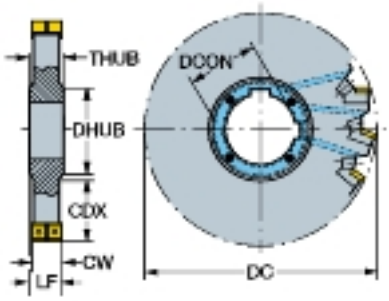
CZC_{MS}	Coolant screw set	Spacing ring set
27	5512 076-101	5549 091-032
32	5512 076-102	5549 091-042
40	5512 076-103	5549 091-052

62 150 155

CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



Inch version

CW	CWX	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, inch DCON	LF	DRVCT	DHUB	THUB	PSI	LBS	RPMX	CICT	MIID
.236	.315	3.150	.768	1	.236	1	3	N331.32C-080T25CM	1.000	.394	1	1.535	.551	1160	1.04	19300	6	N331.1A-04
		4.000	1.043	1 1/4	.236	1	4	N331.32C-101T32CM	1.250	.394	1	1.811	.551	1160	1.43	17100	8	N331.1A-04
		5.000	1.437	1 1/2	.236	1	5	N331.32C-127T38CM	1.500	.394	2	2.047	.551	1160	1.57	15100	10	N331.1A-04
		6.000	1.929	1 1/2	.236	1	6	N331.32C-152T38CM	1.500	.394	2	2.047	.551	1160	2.09	13200	12	N331.1A-04
.315	.394	3.150	.768	1	.315	1	3	N331.32C-080T25DM	1.000	.472	1	1.535	.630	1160	1.10	15000	6	N331.1A-05
		4.000	1.043	1 1/4	.315	1	4	N331.32C-101T32DM	1.250	.472	1	1.811	.630	1160	1.52	13200	8	N331.1A-05
		5.000	1.437	1 1/2	.315	1	5	N331.32C-127T38DM	1.500	.472	2	2.047	.630	1160	1.85	11700	10	N331.1A-05
		6.000	1.929	1 1/2	.315	1	6	N331.32C-152T38DM	1.500	.472	2	2.047	.630	1160	2.42	10200	12	N331.1A-05
.394	.472	3.150	.768	1	.394	1	3	N331.32C-080T25EM	1.000	.512	1	1.535	.630	1160	1.15	18100	6	N331.1A-08
		4.000	1.043	1 1/4	.394	1	4	N331.32C-101T32EM	1.250	.512	1	1.811	.630	1160	1.74	15900	8	N331.1A-08
		5.000	1.437	1 1/2	.394	1	5	N331.32C-127T38EM	1.500	.512	2	2.047	.630	1160	2.09	14100	10	N331.1A-08
		6.000	1.929	1 1/2	.394	1	6	N331.32C-152T38EM	1.500	.512	2	2.047	.630	1160	2.90	12400	12	N331.1A-08
.472	.591	3.150	.768	1	.472	1	3	N331.32C-080T25FM	1.000	.551	1	1.535	.630	1160	1.23	18100	6	N331.1A-08
		4.000	1.043	1 1/4	.472	1	4	N331.32C-101T32FM	1.250	.551	1	1.811	.630	1160	1.88	15900	8	N331.1A-08
		5.000	1.437	1 1/2	.472	1	5	N331.32C-127T38FM	1.500	.551	2	2.047	.630	1160	2.49	14100	10	N331.1A-08
		6.000	1.929	1 1/2	.472	1	6	N331.32C-152T38FM	1.500	.551	2	2.047	.630	1160	3.26	12400	12	N331.1A-08
.591	.689	4.000	1.043	1 1/4	.591	1	3	N331.32C-101T32KM	1.250	.659	1	1.811	.728	1160	2.17	14000	6	N331.1A-11
		5.000	1.437	1 1/2	.591	1	4	N331.32C-127T38KM	1.500	.659	1	2.047	.728	1160	2.82	12400	8	N331.1A-11
		6.000	1.929	1 1/2	.591	1	5	N331.32C-152T38KM	1.500	.659	2	2.047	.728	1160	3.89	10800	10	N331.1A-11
.689	.807	5.000	1.437	1 1/2	.689	1	4	N331.32C-127T38LM	1.500	.768	1	2.047	.847	1160	3.04	12400	8	N331.1A-11
		6.000	1.929	1 1/2	.689	1	5	N331.32C-152T38LM	1.500	.768	2	2.047	.847	1160	4.33	10800	10	N331.1A-11
.807	.925	6.000	1.929	1 1/2	.807	1	5	N331.32C-152T38QM	1.500	.886	2	2.047	.965	1160	4.24	9200	10	N331.1A-14
.925	1.043	6.000	1.929	1 1/2	.925	1	5	N331.32C-152T38RM	1.500	1.004	2	2.047	1.083	1160	5.50	9200	10	N331.1A-14

		Spare parts		
CW	DC"	Insert screw	Wedge	Screw
.236	3.150-6.000	5513 020-19	5431 105-07	5516 014-06
.315	3.150-6.000	5513 020-34	5431 105-06	5516 014-05
.394	3.150-6.000	5513 020-24	5431 105-01	269-832
.472	3.150-6.000	5513 020-24	5431 105-02	269-832
.591	4.000-6.000	5513 020-29	5431 105-04	5516 010-02
.689	5.000-6.000	5513 020-29	5431 105-04	5516 010-02
.807	6.000	5513 020-29	5431 105-05	5516 010-02
.925	6.000	5513 020-29	5431 105-05	5516 010-02

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

CZC_{MS}	Coolant screw set	Spacing ring set
25	5512 077-201	5549 091-512
32	-	5549 091-522
38	5512 077-202	5549 091-532

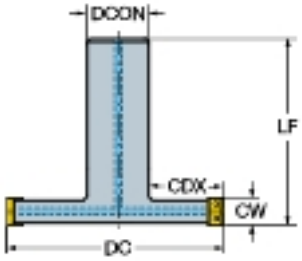
62 150 155

ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



Metric version

CW	CWX	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, mm DCON	LF	BAR	KG	RPMX	CICT	MIID
6.0	8.0	80	23.0	32	6.0	1	3	R331.32C-080A32CM	32.0	115.00	80	1.09	19300	6	N331.1A-04
		100	28.0	40	6.0	1	4	R331.32C-100A40CM	40.0	125.00	80	1.98	17100	8	N331.1A-04
8.0	10.0	80	23.0	32	8.0	1	3	R331.32C-080A32DM	32.0	115.00	80	1.15	15000	6	N331.1A-05
		100	28.0	40	8.0	1	4	R331.32C-100A40DM	40.0	125.00	80	2.04	13200	8	N331.1A-05
10.0	12.0	80	23.0	32	10.0	1	3	R331.32C-080A32EM	32.0	115.00	80	1.04	18100	6	N331.1A-08
		100	28.0	40	10.0	1	4	R331.32C-100A40EM	40.0	125.00	80	2.08	15900	8	N331.1A-08

		Spare parts		
CW	DC	Insert screw	Wedge	Screw
6.0	80-100	5513 020-19	5431 105-07	5516 014-06
8.0	80-100	5513 020-34	5431 105-06	5516 014-05
10.0	80-100	5513 020-24	5431 105-01	269-832

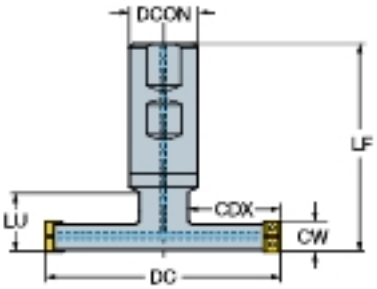
For complete list of spare parts, see www.sandvik.coromant.com

62 150 155

CoroMill® 331 adjustable full side and face disc milling cutter

Weldon - Internal coolant supply

KAPR 90°



Inch version

CW	CWX	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, inch DCON	LF	PSI	LBS	RPMX	CICT	MIID
.236	.315	3.150	.787	1 1/2	.236	1	3	R331.32C-080M38CM	1.500	4.921	1160	3.09	19300	6	N331.1A-04
		4.000	.945	2	.236	1	4	R331.32C-101M51CM	2.000	5.512	1160	3.12	17100	8	N331.1A-04
.315	.394	3.150	.787	1 1/2	.315	1	3	R331.32C-080M38DM	1.500	4.921	1160	4.36	15000	6	N331.1A-05
		4.000	.945	2	.315	1	4	R331.32C-101M51DM	2.000	5.512	1160	4.13	13200	8	N331.1A-05
.394	.472	3.150	.787	1 1/2	.394	1	3	R331.32C-080M38EM	1.500	4.921	1160	3.13	18100	6	N331.1A-08
		4.000	.945	2	.394	1	4	R331.32C-101M51EM	2.000	5.512	1160	5.79	15900	8	N331.1A-08

		Spare parts		
CW	DC"	Insert screw	Wedge	Screw
.236	3.150-4.000	5513 020-19	5431 105-07	5516 014-06
.315	3.150-4.000	5513 020-34	5431 105-06	5516 014-05
.394	3.150-4.000	5513 020-24	5431 105-01	269-832

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

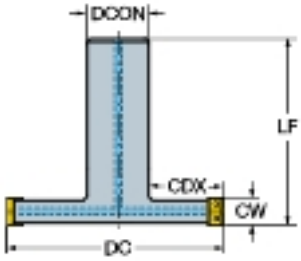
62 150 155

ENG

CoroMill® 331 full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



Metric version

CW	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, mm DCON	LF	BAR	KG	RPMX	CICT	MIID
6.0	40	11.0	16	6.0	1	2	R331.35C-040A16CM060	16.0	120.00	80	0.19	29500	4	N331.1A-04
	50	14.0	20	6.0	1	3	R331.35C-050A20CM060	20.0	130.00	80	0.33	25000	6	N331.1A-04
	63	18.0	25	6.0	1	3	R331.35C-063A25CM060	25.0	140.00	80	0.58	22000	6	N331.1A-04
	80	23.0	32	6.0	1	4	R331.35C-080A32CM060	32.0	150.00	80	1.03	19000	8	N331.1A-04
8.0	40	11.0	16	8.0	1	2	R331.35C-040A16DM080	16.0	120.00	80	0.19	22300	4	N331.1A-05
	50	14.0	20	8.0	1	3	R331.35C-050A20DM080	20.0	130.00	80	0.34	19500	6	N331.1A-05
	63	18.0	25	8.0	1	3	R331.35C-063A25DM080	25.0	140.00	80	0.60	17000	6	N331.1A-05
	80	23.0	32	8.0	1	4	R331.35C-080A32DM080	32.0	150.00	80	1.06	15000	8	N331.1A-05
10.0	40	11.0	16	10.0	1	2	R331.35C-040A16EM100	16.0	120.00	80	0.20	27000	4	N331.1A-08
	50	14.0	20	10.0	1	3	R331.35C-050A20EM100	20.0	130.00	80	0.42	23500	6	N331.1A-08
	63	18.0	25	10.0	1	3	R331.35C-063A25EM100	25.0	140.00	80	0.62	21000	6	N331.1A-08
	80	23.0	32	10.0	1	4	R331.35C-080A32EM100	32.0	150.00	80	1.11	18000	8	N331.1A-08

		Spare parts
CW	DC	Insert screw
6.0	40.00-80.00	5513 020-19
8.0	40.00-80.00	5513 020-34
10.0	40.00-80.00	5513 020-24

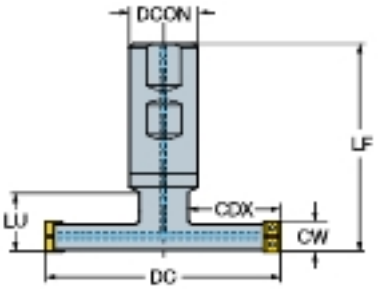
For complete list of spare parts, see www.sandvik.coromant.com

62 150 155

CoroMill® 331 full side and face disc milling cutter

Weldon - Internal coolant supply

KAPR 90°



Inch version

CW	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, inch DCON	LF	LU	PSI	LBS	RPMX	CICT	MIID
.250	1.500	.409	1	.250	1	2	R331.35C-038M25CMA04	1.000	4.140	1.500	1160	0.69	30000	4	N331.1A-04
	2.000	.583	1	.250	1	3	R331.35C-051M25CMA04	1.000	4.140	1.500	1160	0.81	25000	6	N331.1A-04
	2.500	.732	1 1/4	.250	1	3	R331.35C-063M32CMA04	1.250	4.140	1.500	1160	1.32	22000	6	N331.1A-04
	3.000	.850	1 1/4	.250	1	4	R331.35C-076M32CMA04	1.250	4.140	1.500	1160	1.59	22000	8	N331.1A-04
.312	1.500	.409	1	.312	1	2	R331.35C-038M25DMA05	1.000	4.140	1.500	1160	0.70	30000	4	N331.1A-04
	2.000	.583	1	.312	1	3	R331.35C-051M25DMA05	1.000	4.140	1.500	1160	0.84	25000	6	N331.1A-04
	2.500	.732	1 1/4	.312	1	3	R331.35C-063M32DMA05	1.250	4.140	1.500	1160	1.37	22000	6	N331.1A-04
	3.000	.850	1 1/4	.312	1	4	R331.35C-076M32DMA05	1.250	4.140	1.500	1160	1.66	19500	8	N331.1A-04
.375	1.500	.409	1	.375	1	2	R331.35C-038M25EMA06	1.000	4.140	1.500	1160	0.70	23500	4	N331.1A-05
	2.000	.583	1	.375	1	3	R331.35C-051M25EMA06	1.000	4.140	1.500	1160	0.85	19500	6	N331.1A-05
	2.500	.732	1 1/4	.375	1	3	R331.35C-063M32EMA06	1.250	4.140	1.500	1160	1.40	17000	6	N331.1A-05
	3.000	.850	1 1/4	.375	1	4	R331.35C-076M32EMA06	1.250	4.140	1.500	1160	1.71	15000	8	N331.1A-05
.500	1.500	.409	1	.500	1	2	R331.35C-038M25EMA08	1.000	4.140	1.500	1160	0.72	28000	4	N331.1A-08
	2.000	.583	1	.500	1	3	R331.35C-051M25EMA08	1.000	4.140	1.500	1160	0.90	23500	6	N331.1A-08
	2.500	.732	1 1/4	.500	1	3	R331.35C-063M32EMA08	1.250	4.140	1.500	1160	1.50	20500	6	N331.1A-08
	3.000	.850	1 1/4	.500	1	4	R331.35C-076M32EMA08	1.250	4.140	1.500	1160	1.84	18500	8	N331.1A-08

	Spare parts
CW DC"	Insert screw
.250 1.500-2.500	5513 020-19
.312 1.500-3.000	5513 020-19
.375 1.500-3.000	5513 020-34
.500 1.500-3.000	5513 020-24

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

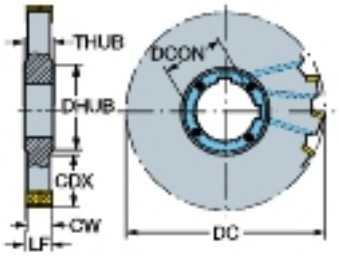
62 150 155

ENG

CoroMill® 331 full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



Metric version

CW	DC	CDX	CZC_{MS}	APMX	CNSC		Ordering code	Dimensions, mm DCON	LF	DRVCT	DHUB	THUB	BAR	KG	RPMX	CICT	MIID
6.0	100	25.5	32	6.0	4	5	N331.35C-100S32CM060	32.0	7.00	2	47.0	8.0	80	0.21	17000	10	N331.1A-04
8.0	100	25.5	32	8.0	4	5	N331.35C-100S32DM080	32.0	9.00	2	47.0	10.0	80	0.28	13000	10	N331.1A-05
	125	34.0	40	8.0	4	6	N331.35C-125S40DM080	40.0	9.00	2	55.0	10.0	80	0.47	15000	12	N331.1A-05
10.0	125	34.0	40	10.0	4	6	N331.35C-125S40EM100	40.0	11.00	2	55.0	12.0	80	0.61	11500	12	N331.1A-08

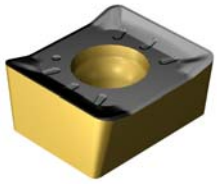
		Spare parts
CW	DC	Insert screw
6.0	100.00	5513 020-19
8.0	100.00-125.00	5513 020-34
10.0	125.00	5513 020-24

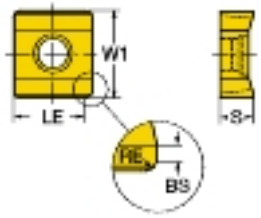
For complete list of spare parts, see www.sandvik.coromant.com

62 150 155

CoroMill® 331 insert for side and face milling

KRINS 90°





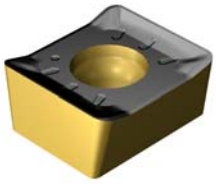
			RE	Ordering code	P			M			K				S			Dimensions, mm, inch			
					1130	4330	4340	1040	1130	2040	1020	3040	4330	4340	1130	2040	S30T	W1	LE	S	BS
Light	L30	04	0.50	N331.1A-043505E-L30				★		☆						☆	★	9.5	4.6	3.50	0.4
			.020															.374	.181	.138	.016
		05	0.80	N331.1A-054508E-L30				★		☆						☆	★	9.5	5.7	4.50	1.2
			.031															.374	.224	.177	.047
		08	0.80	N331.1A-084508E-L30				★		☆						☆	★	9.5	7.7	4.50	1.2
			.031															.374	.303	.177	.047
		11	0.80	N331.1A-115008E-L30				★		☆						☆	★	11.5	10.7	5.00	1.2
			.031															.453	.421	.197	.047
		14	0.80	N331.1A-145008E-L30				★		☆						☆	★	11.5	13.7	5.00	1.2
			.031															.453	.539	.197	.047
	L50	04	0.50	N331.1A-043505E-L50	☆			★	☆	☆					☆	☆	★	9.5	4.6	3.50	0.4
			.020															.374	.181	.138	.016
		05	0.80	N331.1A-054508E-L50	☆			★	☆	☆					☆	☆	★	9.5	5.7	4.50	1.2
			.031															.374	.224	.177	.047
		08	0.80	N331.1A-084508E-L50	☆			★	☆	☆					☆	☆	★	9.5	7.7	4.50	1.2
			.031															.374	.303	.177	.047
		11	0.80	N331.1A-115008E-L50	☆			★	☆	☆					☆	☆	★	11.5	10.7	5.00	1.2
			.031															.453	.421	.197	.047
		14	0.80	N331.1A-145008E-L50	☆			★	☆	☆					☆	☆	★	11.5	13.7	5.00	1.2
			.031															.453	.539	.197	.047
	PL	04	0.50	N331.1A-04 35 05H-PL		☆	☆						☆	☆				9.5	4.6	3.50	0.4
			.020															.374	.181	.138	.016
		05	0.80	N331.1A-05 45 08H-PL		☆	☆						☆	☆				9.5	5.7	4.50	1.2
			.031															.374	.224	.177	.047
		08	0.80	N331.1A-08 45 08H-PL		☆	☆						☆	☆				9.5	7.7	4.50	1.2
			.031															.374	.303	.177	.047
			2.00	N331.1A-08 45 20H-PL	★				☆						☆			9.5	6.5	4.50	1.2
			.079															.374	.256	.177	.047
		11	0.80	N331.1A-11 50 08H-PL		☆	☆						☆	☆				11.5	10.7	5.00	1.2
			.031															.453	.421	.197	.047
			2.00	N331.1A-11 50 20H-PL	★				☆						☆			11.5	9.5	5.00	1.2
			.079															.453	.374	.197	.047
		14	0.80	N331.1A-14 50 08H-PL		☆	☆						☆	☆				11.5	13.7	5.00	1.2
			.031															.453	.539	.197	.047
	KL	08	2.00	N331.1A-08 45 20E-KL							★							9.5	6.5	4.50	1.2
			.079															.374	.256	.177	.047
		11	2.00	N331.1A-11 50 20E-KL							★							11.5	9.5	5.00	1.2
			.079															.453	.374	.197	.047

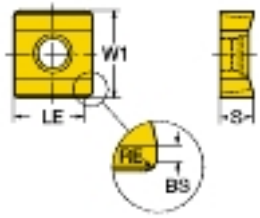
55 70 150

SANDVIK Coromant

CoroMill® 331 insert for side and face milling

KRINS 90°





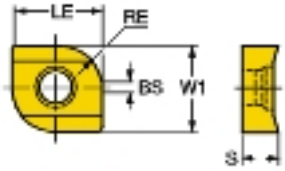
		RE	Ordering code	P 1130	P 4330	P 4340	M 1040	M 1130	M 2040	K 1020	K 3040	K 4330	K 4340	S 1130	S 2040	S 30T	Dimensions, mm, inch W1	LE	S	BS
Medium	M30	04	N331.1A-043505E-M30	★	☆					★	☆	☆					9.5	4.6	3.50	0.4
		.020															*.374*	*.181*	*.138*	*.016*
		05	N331.1A-054508E-M30	★	☆					★	☆	☆					9.5	5.7	4.50	1.2
		.031															*.374*	*.224*	*.177*	*.047*
		08	N331.1A-084508E-M30	★	☆					★	☆	☆					9.5	7.7	4.50	1.2
		.031															*.374*	*.303*	*.177*	*.047*
		11	N331.1A-115008E-M30	★	☆					★	☆	☆					11.5	10.7	5.00	1.2
		.031															*.453*	*.421*	*.197*	*.047*
		14	N331.1A-145008E-M30	★	☆					★	☆	☆					11.5	13.7	5.00	1.2
		.031															*.453*	*.539*	*.195*	*.047*
	KM	08	N331.1A-08 45 20E-KM							★	☆						9.5	6.5	4.45	1.2
		.079															*.374*	*.256*	*.175*	*.047*
		11	N331.1A-11 50 20E-KM							★	☆						11.5	9.5	4.95	1.2
		.079															*.453*	*.374*	*.195*	*.047*
	PM	04	N331.1A-04 35 05M-PM		★	☆						☆	☆				9.5	4.6	3.45	0.4
		.020															*.374*	*.181*	*.136*	*.016*
		05	N331.1A-05 45 08H-PM		★							☆					9.5	5.7	4.45	1.2
		.031															*.374*	*.224*	*.175*	*.047*
		0.80	N331.1A-05 45 08M-PM		★	☆						☆	☆				9.5	5.7	4.45	1.2
		.031															*.374*	*.224*	*.175*	*.047*
		08	N331.1A-08 45 08H-PM		★							☆					9.5	7.7	4.45	1.2
		.031															*.374*	*.303*	*.175*	*.047*
		0.80	N331.1A-08 45 08M-PM		★	☆						☆	☆				9.5	7.7	4.45	1.2
		.031															*.374*	*.303*	*.175*	*.047*
		2.00	N331.1A-08 45 20H-PM	☆	★							☆					9.5	6.5	4.45	1.2
		.079															*.374*	*.256*	*.175*	*.047*
		11	N331.1A-11 50 08H-PM		★							☆					11.5	10.7	4.95	1.2
		.031															*.453*	*.421*	*.195*	*.047*
		0.80	N331.1A-11 50 08M-PM		★	☆						☆	☆				11.5	10.7	4.95	1.2
		.031															*.453*	*.421*	*.195*	*.047*
		2.00	N331.1A-11 50 20H-PM	☆	★							☆					11.5	9.5	4.95	1.2
		.079															*.453*	*.374*	*.195*	*.047*
		14	0.80 N331.1A-14 50 08H-PM		★							☆					11.5	13.7	4.95	1.2
		.031															*.453*	*.539*	*.195*	*.047*
		0.80	N331.1A-14 50 08M-PM		★	☆						☆	☆				11.5	13.7	4.95	1.2
		.031															*.453*	*.539*	*.195*	*.047*

55 70 150

CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor made.

KRINS 90°

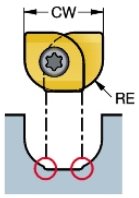


		RE	Ordering code	P 4340	K 4340	S S30T	Dimensions, mm, inch W1	LE	S	BS
Light	WL	08 1.52	L331.1A-08 45 15H-WL			★	9.5	7.7	4.45	1.2
		.060					.374	.303	.175	.047
		2.29	L331.1A-08 45 23H-WL			★	9.5	7.7	4.45	1.2
		.090					.374	.303	.175	.047
		1.52	R331.1A-08 45 15H-WL			★	9.5	7.7	4.45	1.2
		.060					.374	.303	.175	.047
		2.29	R331.1A-08 45 23H-WL			★	9.5	7.7	4.45	1.2
		.090					.374	.303	.175	.047
		11 1.52	L331.1A-11 50 15H-WL			★	11.5	10.7	4.95	1.2
		.060					.453	.421	.195	.047
		2.29	L331.1A-11 50 23H-WL			★	11.5	10.7	4.95	1.2
		.090					.453	.421	.195	.047
		1.52	R331.1A-11 50 15H-WL			★	11.5	10.7	4.95	1.2
		.060					.453	.421	.195	.047
		2.29	R331.1A-11 50 23H-WL			★	11.5	10.7	4.95	1.2
		.090					.453	.421	.195	.047
		14 3.05	L331.1A-14 50 30H-WL	☆	☆	★	11.5	13.7	4.95	1.3
		.120					.453	.539	.195	.051
		4.83	L331.1A-14 50 48H-WL	☆	☆	★	11.5	13.7	4.95	1.5
		.190					.453	.539	.195	.059
		6.35	L331.1A-14 50 63H-WL	☆	☆	★	11.5	13.7	4.95	1.6
		.250					.453	.539	.195	.063
		3.05	R331.1A-14 50 30H-WL	☆	☆	★	11.5	13.7	4.95	1.3
		.120					.453	.539	.195	.051
		4.83	R331.1A-14 50 48H-WL	☆	☆	★	11.5	13.7	4.95	1.5
		.190					.453	.539	.195	.059
		6.35	R331.1A-14 50 63H-WL	☆	☆	★	11.5	13.7	4.95	1.6
		.250					.453	.539	.195	.063

Limitations when using inserts with large corner radius

Full slot milling

Insert size	Calculated CW
04	CW = RE + 4.6
05	CW = RE + 6
08	CW = RE + 8
11	CW = RE + 11

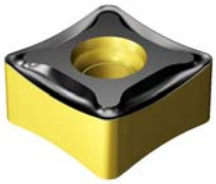


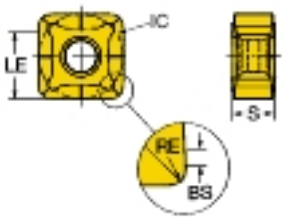
70 150

ENG

CoroMill® 331 insert for side and face milling

KRINS 88°



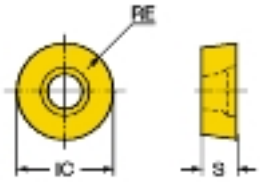


			RE	Ordering code	P 1130	P 4330	P 4340	K 4330	K 4340	Dimensions, mm, inch IC	LE	S	BS
Medium	PM	13	0.80	N331.1D-136508E-PM	☆	★	☆	☆	☆	13.4	11.4	6.55	1.2
			.031							.528	.449	.258	.047
			2.00	N331.1D-136520E-PM	☆	★	☆	☆	☆	13.4	10.2	6.55	1.2
			.079							.528	.402	.258	.047
			0.80	N331.1D-136508M-PM		★		☆		13.4	11.4	6.55	1.2
			.031							.528	.449	.258	.047

These double sided inserts need optional cassettes. See Rotating Tools catalogue for more information.

70 150

CoroMill® 200 insert for milling



Metric version

						P		M	K		Dimensions, mm, inch	
				RE	Ordering code	4330	4340	4340	4330	4340	IC	S
Medium	PM	10	.394	5.00	RCKT 10 T3 M0-PM	★	☆	☆	☆	☆	10.0	3.97
				.197							*.394*	*.156*
		12	.472	6.00	RCKT 12 04 M0-PM	★	☆	☆	☆	☆	12.0	4.76
				.236							*.472*	*.187*
		16	.630	8.00	RCKT 16 06 M0-PM	★	☆	☆	☆	☆	16.0	6.35
				.315							*.630*	*.250*
		20	.787	10.00	RCKT 20 06 M0-PM	★	☆	☆	☆	☆	20.0	6.35
				.394							*.787*	*.250*
Heavy	PH	10	.394	5.00	RCKT 10 T3 M0-PH	★	☆	☆	☆	☆	10.0	3.97
				.197							*.394*	*.156*
		12	.472	6.00	RCKT 12 04 M0-PH	★	☆	☆	☆	☆	12.0	4.76
				.236							*.472*	*.187*
		16	.630	8.00	RCKT 16 06 M0-PH	★	☆	☆	☆	☆	16.0	6.35
				.315							*.630*	*.250*
		20	.787	10.00	RCKT 20 06 M0-PH	★	☆	☆	☆	☆	20.0	6.35
				.394							*.787*	*.250*

Inch version

						P		M	K		Dimensions, mm, inch	
				RE	Ordering code	4330	4340	4340	4330	4340	IC	S
Medium	PM	09	3/8	4.76	RCKT 09 T3 00-PM	★			☆		9.5	3.97
				.187							.375	.156
		13	1/2	6.35	RCKT 13 04 00-PM	★	☆	☆	☆	☆	12.7	4.76
				.250							.500	.187
		19	3/4	9.53	RCKT 19 06 00-PM	★	☆	☆	☆	☆	19.1	6.35
				.375							.750	.250
Heavy	PH	09	3/8	4.76	RCKT 09 T3 00-PH	★	☆	☆	☆	☆	9.5	3.97
				.187							.375	.156
		13	1/2	6.35	RCKT 13 04 00-PH	★	☆	☆	☆	☆	12.7	4.76
				.250							.500	.187
		19	3/4	9.53	RCKT 19 06 00-PH	★	☆	☆	☆	☆	19.1	6.35
				.375							.750	.250

70 150

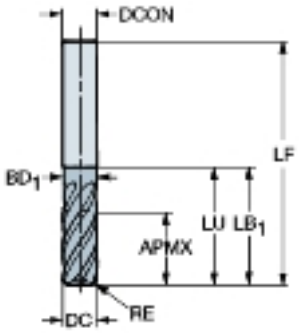
ENG

CoroMill® Plura solid ceramic end mill for high speed roughing

For nickel-based alloys

Optimized

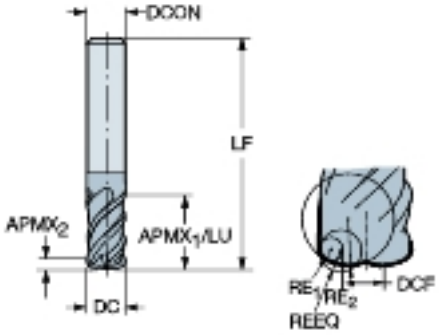
FHA 35°
BSG COROMANT
TCDC h9
TCDCON h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	S 6060	Dimensions, mm DCON	LF	DN
10.0	10	7.5	2.00	15.0	6	2F210-1000-200-SC	★	10.0	60.0	9.5
12.0	12	9.0	2.00	18.0	6	2F210-1200-200-SC	★	12.0	65.0	11.4

FHA 38°
TCDC h9
TCDCON h6



Metric version

DC	CZC$_{MS}$	APMX$_1$	APMX$_2$	RE$_1$	RE$_2$	LU	ZEFP	Ordering code	S 6060	Dimensions, mm DCON	DCF	LF	DN	REEQ	RPMX
10.0	10	7.5	0.7	1.5	5.0	15.0	4	2H310-1000-150-SC	★	10.0	3.4	60.0	9.5	1.99	35000
12.0	12	9.0	0.8	1.5	6.0	18.0	4	2H310-1200-150-SC	★	12.0	4.5	65.0	11.4	2.10	35000

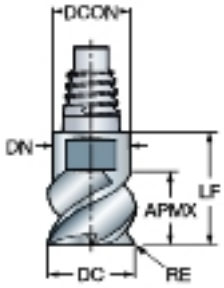
78 150

CoroMill® 316 brazed ceramic head for high speed roughing

For nickel-based alloys

Optimized

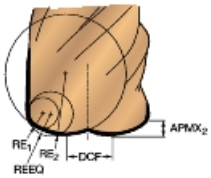
FHA 35°
BSG COROMANT
TCDC h9

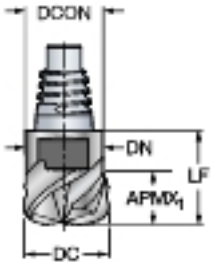


Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	S 6060	DCON	LF	DN
								Dimensions, mm		
10.0	E10	7.0	2.00	7.0	6	316-10FM635-10020D	★	9.7	13.1	9.7
12.0	E12	7.0	2.00	7.0	6	316-12FM635-12020D	★	11.7	14.2	11.7

FHA 38°
BSG COROMANT
TCDC h9





Metric version

DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	ZEFP	Ordering code	S 6060	DCON	DCF	LF	DN	REEQ	RPMX
									Dimensions, mm					
10.0	E10	7.0	0.7	1.5	5.0	4	316-10HM438-10015D	★	9.7	3.4	13.1	9.7	1.99	35000
12.0	E12	7.0	0.8	1.5	6.0	4	316-12HM438-12015D	★	11.7	4.5	14.2	11.7	2.10	35000

78 150

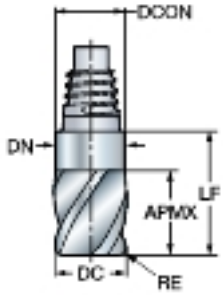
ENG

CoroMill® 316 solid carbide head for high feed side milling

For titanium alloys

Optimized

FHA	42°
BSG	COROMANT
TCDC	h10



Metric version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	S	1745	Dimensions, mm DCON	LF	DN
10.0	E10	15.0	0.50	6	316-10FL642-10005L	★		9.7	23.3	9.7
	E10	15.0	1.00	6	316-10FL642-10010L	★		9.7	23.3	9.7
	E10	15.0	2.00	6	316-10FL642-10020L	★		9.7	23.3	9.7
12.0	E12	18.0	0.50	6	316-12FL642-12005L	★		11.7	27.4	11.7
	E12	18.0	1.00	6	316-12FL642-12010L	★		11.7	27.4	11.7
	E12	18.0	2.00	6	316-12FL642-12020L	★		11.7	27.4	11.7
	E12	18.0	3.00	6	316-12FL642-12030L	★		11.7	27.4	11.7
16.0	E16	24.0	0.50	6	316-16FL642-16005L	★		15.5	35.6	15.5
	E16	24.0	1.00	6	316-16FL642-16010L	★		15.5	35.6	15.5
	E16	24.0	2.00	6	316-16FL642-16020L	★		15.5	35.6	15.5
	E16	24.0	3.00	6	316-16FL642-16030L	★		15.5	35.6	15.5
	E16	24.0	4.00	6	316-16FL642-16040L	★		15.5	35.6	15.5
20.0	E20	30.0	1.00	6	316-20FL642-20010L	★		19.3	41.7	19.3
	E20	30.0	2.00	6	316-20FL642-20020L	★		19.3	41.7	19.3
	E20	30.0	3.00	6	316-20FL642-20030L	★		19.3	41.7	19.3
	E20	30.0	4.00	6	316-20FL642-20040L	★		19.3	41.7	19.3
25.0	E25	37.5	1.00	6	316-25FL642-25010L	★		24.2	51.0	24.2
	E25	37.5	2.00	6	316-25FL642-25020L	★		24.2	51.0	24.2
	E25	37.5	3.00	6	316-25FL642-25030L	★		24.2	51.0	24.2

Inch version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	S	1745	Dimensions, inch DCON	LF	DN
.375	E10	.563	.030	6	A316-10FL642-03708L	★		.364	.890	.362
	E10	.563	.060	6	A316-10FL642-03715L	★		.364	.890	.362
.500	E12	.750	.030	6	A316-12FL642-05008L	★		.484	1.122	.500
	E12	.750	.060	6	A316-12FL642-05015L	★		.484	1.122	.500
	E12	.750	.090	6	A316-12FL642-05023L	★		.484	1.122	.500
	E12	.750	.120	6	A316-12FL642-05031L	★		.484	1.122	.500
.625	E16	.937	.030	6	A316-16FL642-06208L	★		.610	1.402	.610
	E16	.937	.060	6	A316-16FL642-06215L	★		.610	1.402	.610
	E16	.937	.090	6	A316-16FL642-06223L	★		.610	1.402	.610
	E16	.937	.120	6	A316-16FL642-06231L	★		.610	1.402	.610
.750	E20	1.125	.030	6	A316-20FL642-07508L	★		.728	1.587	.728
	E20	1.125	.060	6	A316-20FL642-07515L	★		.728	1.587	.728
	E20	1.125	.090	6	A316-20FL642-07523L	★		.728	1.587	.728
	E20	1.125	.120	6	A316-20FL642-07531L	★		.728	1.587	.728
1.000	E25	1.500	.030	6	A316-25FL642-10008L	★		.965	2.032	.965
	E25	1.500	.060	6	A316-25FL642-10015L	★		.965	2.032	.965
	E25	1.500	.090	6	A316-25FL642-10023L	★		.965	2.032	.965
	E25	1.500	.120	6	A316-25FL642-10031L	★		.965	2.032	.965

78 150

Milling with large engagement, metric values

ISO P			Specific cutting force k_{c1}	Hardness Brinell		GC4330	GC4340	GC1130
						Max chip thickness, h_{ex} mm		
						0.1-0.2-0.3	0.1-0.2-0.3	0.05-0.1-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Steel						
		Unalloyed						
P1.1.Z.AN	01.1	C = 0.1–0.25%	1500	125	0.25	490-405-330	340-280-230	375-340-280
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	0.25	360-291-245	305-250- 205	335-305-250
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	0.25	340-280-230	290-235-195	320-290-235
P1.3.Z.AN	01.4		1800	210	0.25	295-245-200	250-205-170	275-250-205
P1.3.Z.HT	01.5		2000	300	0.25	220-180-150	185-155-125	205-185-155
		Low alloyed (alloying elements ≤ 5%)						
P2.1.Z.AN	02.1	Non-hardened	1700	175	0.25	280-230-190	240-195-160	265-240-195
P2.5.Z.HT	02.2	Hardened and tempered	1900	300	0.25	185-150-125	155-130-105	170-155-130
		High alloyed (alloying elements > 5%)						
P3.0.Z.AN	03.11	Annealed	1950	200	0.25	195-160-130	165-135-110	180-165-135
P3.1.Z.AN	03.13	Hardened tool steel	2150	200	0.25	160-130-110	135-110-90	150-135-110
P3.0.Z.HT	03.21		2900	300	0.25	140-115-995	120-100-80	130-120-100
P3.0.Z.HT	03.22		3100	380	0.25	85-70-60	75-60-50	80-75-60
		Castings						
P1.5.C.UT	06.1	Unalloyed	1400	150	0.25	260-215-175	220-180-150	245-220-180
P2.6.C.UT	06.2	Low alloyed (alloying elements ≤ 5%)	1600	200	0.25	205-170-140	175-145-120	195-175-145
P3.0.C.UT	06.3	High alloyed (alloying elements > 5%)	1950	200	0.25	150-125-100	130-105-85	140-130-105

ISO M			Specific cutting force k_{c1}	Hardness Brinell		GC1040	GC2040	GC4340	GC1130
						Max chip thickness, h_{ex} mm			
						0.05-0.15-0.25	0.1-0.2-0.3	0.1-0.2-0.4	0.05-0.1-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min			
		Stainless steel							
		Ferritic/martensitic							
P5.0.Z.AN	05.11	Non-hardened	1800	200	0.21	185-140-105	240-190-155	210-170-110	255-225-180
P5.0.Z.PH	05.12	PH-hardened	2850	330	0.21	130-100-70	165-130-105	140-110-70	180-160-130
P5.0.Z.HT	05.13	Hardened	2350	330	0.21	135-100-75	175-140-110	160-125-80	185-165-135
		Austenitic							
M1.0.Z.AQ	05.21	Non-hardened	1950	200	0.21	180-135-100	200-160-130	185-150-95	250-225-180
M1.0.Z.PH	05.22	PH-hardened	2850	330	0.21	125-95-70	160-125-100	135-105-70	170-155-125
M2.0.Z.AQ	05.23	Super austenitic	2250	200		125-90-70	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	0.21	150-115-85	170-135-105	170-135-85	205-185-145
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	0.21	125-95-70	135-110-85	135-110-70	175-155-125
		Stainless steel – Cast							
		Ferritic/martensitic							
P5.0.C.UT	15.11	Non-hardened	1700	200	0.25	165-125-90	210-170-135	185-150-95	225-200-160
P5.0.C.PH	15.12	PH-hardened	2450	330	0.25	115-85-65	145-115-90	120-100-65	155-140-115
P5.0.C.HT	15.13	Hardened	2150	330	0.25	125-90-70	160-130-100	145-115-775	170-155-120
M1.0.C.UT	15.21	Non hardened	1800	200	0.25	175-130-95	190-155-125	165-130-105	235-210-170
M1.0C.PH	15.22	PH-hardened	2450	330	0.25	115-85-65	145-115-90	125-100-65	160-140-115
M2.0.C.AQ	15.23	Super austenitic	2150	200		110-85-60	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	0.25	145-105-80	160-125-100	160-125-80	195-175-140
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	0.25	115-85-65	130-100-80	125-100-65	160-145-115

ISO K			Specific cutting force k_{c1}	Hardness Brinell		GC3040	GC1020	GC4330	GC4340
						Max chip thickness, h_{ex} mm			
						0.1-0.2-0.4	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min			
		Malleable cast iron							
	07.1	Ferritic (short chipping)	790	130	0.28	240-195-135	205-170-140	215-175-145	195-160-130
K1.1.C.NS	07.2	Pearlitic (long chipping)	900	230	0.28	200-165-110	170-140-115	175-145-120	160-130-110
		Grey cast iron							
K2.1.C.UT	08.1	Low tensile strength	890	180	0.28	260-215-145	225-185-150	230-190-155	215-175-145
K2.2.C.UT	08.2	High tensile strength	1100	245	0.28	210-170-115	180-145-120	185-155-125	170-140-115
		Nodular cast iron							
K3.1.C.UT	09.1	Ferritic	900	160	0.28	165-135-90	140-115-95	145-120-100	135-110-90
K3.3.C.UT	09.2	Pearlitic	1350	250	0.28	150-125-85	130-105-90	135-110-90	125-100-85

Conditions:

Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

ENG

Milling with large engagement, metric values

ISO S			Specific cutting force k_{c1}	Hardness Brinell		S30T	GC2040	GC1130
						Max chip thickness, h_{ex} mm		
						0.1-0.15-0.2	0.1-0.15-0.25	0.1-0.15-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Heat resistant super alloys						
		Iron base						
S1.0.U.AN	20.11	Annealed or solution treated	2400	200	0.25	-	60-55-45	60-55-50
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	0.25	-	45-39-32	45-40-37
		Nickel base						
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	0.25	-	55-50-40	60-55-50
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	0.25	-	35-31-26	36-33-30
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	0.25	-	40-38-31	45-40-36
		Cobalt alloys						
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	0.25	-	23-21-17	25-22-20
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	0.25	-	17-15-12	18-16-14
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	0.25	-	15-14-11	16-14-13
		Titanium alloys[1]		Rm[2]				
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	1300	400	0.23	150-135-125	120-110-100	125-115-105
S4.2.Z.AN	23.21		1400	950	0.23	65-60-55	45-39-36	55-50-45
S4.3.Z.AG	23.22		1400	1050	0.23	50-50-45	37-33-30	45-40-36

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.

Conditions:

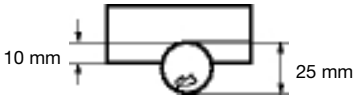
Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

Milling with small engagement, metric values

ISO P			Specific cutting force k_{c1}	Hardness Brinell		GC4330	GC4340	GC1130
						Max chip thickness, h_{ex} mm		
						0.1-0.2-0.3	0.1-0.2-0.3	0.05-0.1-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Steel						
		Unalloyed						
P1.1.Z.AN	01.1	C = 0.1–0.25%	1500	125	0.25	465-445-425	395-380-360	405-395-380
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	0.25	420-400-385	355-340-325	365-355-340
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	0.25	395-380-360	335-320-310	345-335-320
P1.3.Z.AN	01.4		1800	210	0.25	345-330-315	295-280-270	300-295-280
P1.3.Z.HT	01.5		2000	300	0.25	255-245-235	220-210-200	220-220-210
		Low-alloy (alloying elements ≤5%)						
P2.1.Z.AN	02.1	Non-hardened	1700	175	0.25	325-315-300	290-155-135	285-280-265
P2.5.Z.HT	02.2	Hardened and tempered	1900	300	0.25	215-205-195	180-175-165	185-180-175
		High-alloy (alloying elements >5%)						
P3.0.Z.AN	03.11	Annealed	1950	200	0.25	225-215-205	190-185-175	195-190-185
P3.1.Z.AN	03.13	Hardened tool steel	2150	200	0.25	185-180-170	160-150-145	160-160-150
P3.0.Z.HT	03.21		2900	300	0.25	165-155-150	140-135-125	140-140-135
P3.0.Z.HT	03.22		3100	380	0.25	100-95-95	85-85-80	90-85-85
		Castings						
P1.5.C.UT	06.1	Unalloyed	1400	150	0.25	305-290-280	255-245-235	265-255-245
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	0.25	240-230-220	205-195-190	210-205-195
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	1950	200	0.25	175-170-160	150-145-140	155-150-145

ISO M			Specific cutting force k_{c1}	Hardness Brinell		GC1040	GC2040	GC4340	GC1130
						Max chip thickness, h_{ex} mm			
						0.05 - 0.15 - 0.25	0.1-0.2-0.25	0.1-0.2-0.4	0.05- 0.1-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min			
		Stainless steel							
		Ferritic/martensitic							
P5.0.Z.AN	05.11	Non-hardened	1800	200	0.21	210-195-185	285-270-265	250-240-225	275-270-255
P5.0.Z.PH	05.12	PH-hardened	2850	330	0.21	145-140-130	195-185-180	165-160-150	195-190-180
P5.0.Z.HT	05.13	Hardened	2350	330	0.21	155-145-135	205-195-190	235-225-220	200-195-190
		Austenitic							
M1.0.Z.AQ	05.21	Non-hardened	1950	200	0.21	205-190-175	240-225-220	220-210-200	270-265-255
M1.0.Z.PH	05.22	PH-hardened	2850	330	0.21	140-135-125	190-180-175	160-150-145	190-185-175
M2.0.Z.AQ	05.23	Super austenitic	2250	200		190-180-170	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	0.21	170-160-150	200-190-185	200-190-180	225-220-210
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	0.21	140-130-125	160-155-150	160-155-145	190-185-175
		Stainless steel – Cast							
		Ferritic/martensitic							
P5.0.C.UT	15.11	Non-hardened	1700	200	0.25	185-175-165	250-240-235	225-210-200	245-240-230
P5.0C.PH	15.12	PH-hardened	2450	330	0.25	130-120-110	170-165-160	145-140-130	170-170-160
P5.0.C.HT	15.13	Hardened	2150	330	0.25	185-175-170	190-180-175	175-165-155	185-180-175
		Austenitic							
M1.0.C.UT	15.21	Austenitic	1800	200	0.25	195-180-170	230-215-210	210-200-190	260-250-240
M1.0C.PH	15.22	PH-hardened	2450	330	0.25	130-120-110	170-165-160	145-140-130	170-170-160
M2.0.C.AQ	15.23	Super austenitic	2150	200		125-120-110	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	0.25	160-150-140	190-180-175	190-180-170	215-205-195
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	0.25	130-125-115	150-145-140	150-140-135	175-170-165

ISO K			Specific cutting force k_{c1}	Hardness Brinell		GC3040	GC1020	GC4330	GC4340
						Max chip thickness, h_{ex} mm			
						0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.15-0.25	0.1-0.15-0.25
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min			
		Malleable cast iron							
	07.1	Ferritic (short chipping)	790	130	0.28	280-270-255	240-230-220	250-245-235	225-220-210
K1.1.C.NS	07.2	Pearlitic (long chipping)	900	230	0.28	230-220-210	195-190-180	205-200-190	185-185-175
		Grey cast iron							
K2.1.C.UT	08.1	Low tensile strength	890	180	0.28	305-290-280	260-250-240	270-265-255	250-240-230
K2.2.C.UT	08.2	High tensile strength	1100	245	0.28	245-235-225	205-200-190	220-120-105	220-120-105
		Nodular cast iron							
K3.1.C.UT	09.1	Ferritic	900	160	0.28	190-185-175	160-155-150	170-165-160	155-150-145
K3.3.C.UT	09.2	Pearlitic	1350	250	0.28	175-170-160	150-145-140	155-155-145	145-140-135



Conditions:

Side milling, cutter dia. 25 mm.
Working engagement 10 mm.

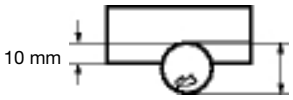
ENG

Milling with small engagement, metric values

ISO S			Specific cutting force k_{c1}	Hardness Brinell		S30T	GC2040	GC1130
						Max chip thickness, h_{ex} mm		
						0.1-0.15-0.2	0.05-0.15-0.25	0.05-0.15-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Heat resistant super alloys						
		Iron base						
S1.0.U.AN	20.11	Annealed or solution treated	2400	200	0.25	-	70-65-65	70-70-70
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	0.25	-	50-50-45	55-50-50
		Nickel base						
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	0.25	-	65-65-60	70-65-65
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	0.25	-	40-39-38	45-40-40
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	0.25	-	50-50-45	55-50-50
		Cobalt alloys						
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	0.25	-	28-27-26	30-29-28
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	0.25	-	20-19-19	21-20-20
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	0.25	-	19-18-17	20-19-18
		Titanium alloys[1]		Rm[2]				
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	1300	400	0.23	170-165-160	145-140-135	150-145-140
S4.2.Z.AN	23.21		1400	950	0.23	75-75-70	50-50-50	65-65-65
S4.3.Z.AG	23.22		1400	1050	0.23	65-60-66	45-40-40	55-50-50

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.



Conditions:
Side milling, cutter dia. 25 mm.
Working engagement 10 mm.

Milling with large engagement, inch values

ISO P			Specific cutting force k_{c1}	Hardness Brinell		GC4330	GC4340	GC1130	
						Max chip thickness, h_{ex} inch			
						.004-.008-.012	.004-.008-.012	.002-.004-.008	
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_c, ft/min			
		Steel							
		Unalloyed							
P1.1.Z.AN	01.1	C = 0.10 – 0.25%	216,500	125	0.25	1300-1050-870	1100-910-740	1250-1100-910	
P1.2.Z.AN	01.2	C = 0.25 – 0.55%	233,000	150	0.25	1150-960-780	1000-820-670	1100-1000-820	
P1.3.Z.AN	01.3	C = 0.55 – 0.80%	247,000	170	0.25	1100-900-740	940-770-630	1050-940-770	
P1.3.Z.AN	01.4		260,500	210	0.25	970-790-650	820-670-550	910-820-670	
P1.3.Z.HT	01.5		291,500	300	0.25	710-580-475	610-500-405	670-610-500	
		Low alloyed (alloying elements ≤ 5%)							
P2.1.Z.AN	02.1	Non-hardened	246,500	175	0.25	920-750-610	780-640-520	860-780-640	
P2.5.Z.HT	02.2	Hardened and tempered	278,500	300	0.25	600-490-400	510-415-340	560-510-415	
		High alloyed (alloying elements > 5%)							
P3.0.Z.AN	03.11	Annealed	282,000	200	0.25	630-510-420	540-440-360	590-540-440	
P3.1.Z.AN	03.13	Hardened tool steel	311,000	200	0.25	520-430-350	445-360-295	490-445-360	
P3.0.Z.HT	03.21		420,000	300	0.25	455-370-305	390-315-260	430-390-315	
P3.0.Z.HT	03.22		448,500	380	0.25	285-235-190	245-200-160	270-245-200	
		Castings							
P1.5.C.UT	06.1	Unalloyed	204,000	150	0.25	850-690-670	720-590-480	800-720-590	
P2.6.C.UT	06.2	Low alloyed (alloying elements ≤ 5%)	230,500	200	0.25	680-550-450	570-470-385	630-570-470	
P3.0.C.UT	06.3	High alloyed (alloying elements > 5%)	283,500	200	0.25	495-405-330	420-345-280	465-420-345	

ISO M			Specific cutting force k_{c1}	Hardness Brinell		GC1040	GC2040	GC4340	GC1130
						Max chip thickness, h_{ex} inch			
						.002-.006-.010	.004-.008-.012	.004-.008-.016	.002-.004-.008
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_c, ft/min			
		Stainless steel							
		Ferritic/martensitic							
P5.0.Z.AN	05.11	Non-hardened	262,000	200	0.21	610-450-330	780-620-495	690-550-345	830-740-590
P5.0.Z.PH	05.12	PH-hardened	411,500	330	0.21	430-315-235	540-425-340	455-365-230	590-520-415
P5.0.Z.HT	05.13	Hardened	340,000	330	0.21	445-330-245	570-450-360	520-410-260	610-540-430
		Austenitic							
M1.0.Z.AQ	05.21	Non-hardened	285,000	200	0.21	590-435-325	660-520-415	610-485-305	820-730-580
M1.0.Z.PH	05.22	PH-hardened	414,000	330	0.21	415-305-225	520-410-325	440-350-220	560-500-400
M2.0.Z.AQ	05.23	Super austenitic	328,000	200		405-300-220	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	286,500	230	0.21	495-365-270	550-435-345	550-435-275	670-600-475
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	0.21	410-305-225	440-350-280	440-350-220	570-510-405
		Stainless steel – Cast							
		Ferritic/martensitic							
P5.0.C.UT	15.11	Non-hardened	246,500	200	0.25	540-400-295	690-550-440	610-485-305	740-660-520
P5.0C.PH	15.12	PH-hardened	354,500	330	0.25	375-275-200	470-375-295	400-320-200	520-460-365
P5.0.C.HT	15.13	Hardened	311,000	330	0.25	405-300-220	520-415-330	475-375-240	560-500-395
M1.0.C.UT	15.21	Non hardened	261,000	200	0.25	560-415-310	630-500-395	580-460-290	780-690-550
M1.0C.PH	15.22	PH-hardened	356,000	330	0.25	365-270-200	470-375-300	400-320-200	520-460-365
M2.0.C.AQ	15.23	Super austenitic	310,500	200		365-270-200	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	258,000	230	0.25	470-350-255	520-410-325	520-415-260	640-570-450
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,500	260	0.25	385-285-210	415-330-265	410-325-205	530-475-375

ISO K			Specific cutting force k_{c1}	Hardness Brinell		GC3040	GC1020	GC4330	GC4340
						Max chip thickness, h_{ex} inch			
						.004-.008-.016	.004-.008-.016	.004-.008-.012	.004-.008-.012
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_c, ft/min			
		Malleable cast iron							
	07.1	Ferritic (short chipping)	115,000	130	0.28	790-640-430	670-550-445	700-570-465	630-520-425
K1.1.C.NS	07.2	Pearlitic (long chipping)	131,000	230	0.28	650-530-355	550-450-370	570-470-385	520-430-350
		Grey cast iron							
K2.1.C.UT	08.1	Low tensile strength	130,000	180	0.28	850-700-465	730-600-485	760-620-510	690-570-465
K2.2.C.UT	08.2	High tensile strength	159,500	245	0.28	680-560-375	580-475-390	610-495-405	550-455-370
		Nodular cast iron							
K3.1.C.UT	09.1	Ferritic	130,000	160	0.28	530-435-290	455-370-305	475-390-320	435-335-290
K3.3.C.UT	09.2	Pearlitic	194,500	250	0.28	495-405-270	425-350-285	440-360-295	405-330-270

4.000 inch (100mm)

5.000 inch (125mm)

Conditions:

Cutter, dia. 5.000 inch (125 mm) Working engagement 4.000 inch (100 mm)

ENG

Milling with large engagement, inch values

ISO S MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in²	Hardness Brinell HB	mc	S30T	GC2040	GC1130
						Max chip thickness, h_{ex} inch		
						.004-.006-.008	.004-.006-.010	.004-.006-.008
						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	0.25	-	190-170-140	200-180-160
S1.0.U.AG	20.12	Aged or solution treated and aged	359,000	280	0.25	-	140-125-105	150-135-120
		Nickel base						
S2.0.Z.AN	20.21	Annealed or solution treated	383,000	250	0.25	-	180-165-135	190-170-155
S2.0.Z.AG	20.22	Aged or solution treated and aged	420,500	350	0.25	-	115-100-85	120-105-95
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	0.25	-	135-125-100	150-140-120
		Cobalt alloys						
S3.0.Z.AN	20.31	Annealed or solution treated	391,500	200	0.25	-	75-65-55	80-70-65
S3.0.Z.AG	20.32	Solution treated and aged	432,000	300	0.25	-	55-50-39	55-50-45
S3.0.C.NS	20.33	Cast or cast and aged	450,500	320	0.25	-	50-45-35	50-45-40
		Titanium alloys[1]		Rm[2]				
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	188,500	400	0.23	445-380-330	400-360-325	415-375-340
S4.2.Z.AN	23.21		203,000	950	0.23	200-170-145	140-130-115	185-165-150
S4.3.Z.AG	23.22		203,000	1050	0.23	155-135-115	120-110-100	145-130-120

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.

4.000 inch (100mm)

5.000 inch (125mm)

Conditions:

Cutter, dia. 5.000 inch (125 mm) Working engagement 4.000 inch (100 mm)

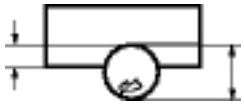
Milling with small engagement, inch values

ISO P			Specific cutting force k_{c1}	Hardness Brinell		GC4330	GC4340	GC1130
						Max chip thickness, h_{ex} inch		
						.004-.006-.012	.004-.008-.012	.002-.004-.008
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_c, ft/min		
		Steel						
		Unalloyed						
P1.1.Z.AN	01.1	C = 0.10 –0.25%	216,500	125	0.25	1500-1450-1400	1300-1250-1200	1350-1300-1250
P1.2.Z.AN	01.2	C = 0.25–0.55%	233,000	150	0.25	1350-1300-1250	1150-1100-1050	1200-1150-1100
P1.3.Z.AN	01.3	C = 0.55–0.80%	247,000	170	0.25	1300-1250-1200	1100-1050-1000	1150-1100-1050
P1.3.Z.AN	01.4		260,500	210	0.25	1150-100-1050	960-920-880	980-960-920
P1.3.Z.HT	01.5		291,500	300	0.25	840-800-760	710-680-650	730-710-680
		Low-alloy (alloying elements ≤5%)						
P2.1.Z.AN	02.1	Non-hardened	246,500	175	0.25	1100-1000-520	950-930-445	930-910-870
P2.5.Z.HT	02.2	Hardened and tempered	278,500	300	0.25	700-670-640	590-570-540	610-590-570
		High-alloy (alloying elements >5%)						
P3.0.Z.AN	03.11	Annealed	282,000	200	0.25	740-700-670	630-600-570	640-630-600
P3.1.Z.AN	03.13	Hardened tool steel	311,000	200	0.25	610-580-560	520-495-475	530-520-495
P3.0.Z.HT	03.21		420,000	300	0.25	530-510-485	455-435-415	465-455-435
P3.0.Z.HT	03.22		448,500	380	0.25	335-320-305	285-270-260	290-285-270
		Castings						
P1.5.C.UT	06.1	Unalloyed	204,000	150	0.25	990-950-910	840-810-770	860-840-810
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230,500	200	0.25	790-760-720	670-640-610	690-670-640
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	283,500	200	0.25	580-550-530	490-470-450	500-490-470

ISO M			Specific cutting force k_{c1}	Hardness Brinell		GC1040	GC2040	GC4340	GC1130
						Max chip thickness, h_{ex} inch			
						.002-.006-.010	.004-.008-.010	.004-.008-.012	.002-.004-.008
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_c, ft/min			
		Stainless steel							
		Ferritic/martensitic							
P5.0.Z.AN	05.11	Non-hardened	262,000	200	0.21	680-640-600	930-890-860	820-780-740	910-890-840
P5.0.Z.PH	05.12	PH-hardened	411,500	330	0.21	485-450-420	640-610-590	540-520-490	640-630-590
P5.0.Z.HT	05.13	Hardened	340,000	330	0.21	500-470-440	680-640-630	620-590-560	660-650-610
		Austenitic							
M1.0.Z.AQ	05.21	Non-hardened	285,000	200	0.21	660-640-580	780-740-730	740-710-375	890-870-830
M1.0.Z.PH	05.22	PH-hardened	414,000	330	0.21	465-435-405	620-590-570	520-500-475	620-600-570
M2.0.Z.AQ	05.23	Super austenitic	328,000	200		455-425-395	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	286,500	230	0.21	560-520-490	650-620-610	650-620-590	740-720-680
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	0.21	465-435-405	530-500-490	530-500-475	620-610-580
		Stainless steel – Cast							
		Ferritic/martensitic							
P5.0.C.UT	15.11	Non-hardened	246,500	200	0.25	610-570-530	830-790-770	730-690-660	810-790-750
P5.0c.PH	15.12	PH-hardened	354,500	330	0.25	420-390-365	560-530-520	475-455-430	560-550-520
P5.0.C.HT	15.13	Hardened	311,000	330	0.25	455-425-400	620-590-580	570-540-510	610-590-570
		Austenitic							
M1.0.C.UT	15.21	Austenitic	261,000	200	0.25	640-590-550	750-710-690	690-660-630	850-830-790
M1.0c.PH	15.22	PH-hardened	356,000	330	0.25	420-395-365	560-540-520	480-455-430	570-550-520
M2.0.C.AQ	15.23	Super austenitic	310,500	200		415-385-360	-	-	-
		Austenitic-ferritic (Duplex)							
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	258,000	230	0.25	530-495-460	620-590-570	620-590-560	700-680-650
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,500	260	0.25	430-405-375	495-470-460	490-465-440	580-560-540

ISO K			Specific cutting force k_{c1}	Hardness Brinell		GC3040	GC1020	GC4330	GC4340
						Max chip thickness, h_{ex} inch			
						.004-.008-.012	.004-.008-.012	.004-.006-.010	.004-.006-.010
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_c, ft/min			
		Malleable cast iron							
	07.1	Ferritic (short chipping)	115,000	130	0.28	920-880-840	780-750-710	810-800-760	740-730-690
K1.1.C.NS	07.2	Pearlitic (long chipping)	131,000	230	0.28	760-720-690	640-620-590	670-660-630	610-600-570
		Grey cast iron							
K2.1.C.UT	08.1	Low tensile strength	130,000	180	0.28	1000-950-910	850-810-780	890-870-830	810-790-760
K2.2.C.UT	08.2	High tensile strength	159,500	245	0.28	800-770-730	680-650-620	730-710-345	650-630-610
		Nodular cast iron							
K3.1.C.UT	09.1	Ferritic	130,000	160	0.28	630-600-570	530-510-485	560-540-520	510-495-475
K3.3.C.UT	09.2	Pearlitic	194,500	250	0.28	580-560-530	495-475-455	520-500-480	470-460-440

.400 inch (10 mm)



1.000 inch (25 mm)

Conditions:

Side milling, cutter dia. 1.000 inch (25 mm). Working engagement .400 inch (10 mm).

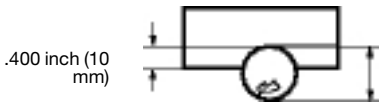
ENG

Milling with small engagement, inch values

ISO S			Specific cutting force k_{c1}	Hardness Brinell		S30T	GC2040	GC1130
						Max chip thickness, h_{ex} inch		
						.004-.006-.008	.002-.006-.010	.002-.006-.008
MC No.	CMC No.	Material	lbs/in²	HB	mc	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	0.25	-	225-215-210	235-225-220
S1.0.U.AG	20.12	Aged or solution treated and aged	359,000	280	0.25	-	165-160-150	175-170-165
		Nickel base						
S2.0.Z.AN	20.21	Annealed or solution treated	383,000	250	0.25	-	215-210-200	225-215-210
S2.0.Z.AG	20.22	Aged or solution treated and aged	420,500	350	0.25	-	135-130-125	140-135-130
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	0.25	-	165-155-150	175-165-160
		Cobalt alloys						
S3.0.Z.AN	20.31	Annealed or solution treated	391,500	200	0.25	-	90-90-85	100-95-90
S3.0.Z.AG	20.32	Solution treated and aged	432,000	300	0.25	-	65-65-60	70-65-65
S3.0.C.NS	20.33	Cast or cast and aged	450,500	320	0.25	-	60-60-55	65-60-60
		Titanium alloys[1]		**Rm**[2]				
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	188,500	400	0.23	560-540-520	480-455-445	495-470-460
S4.2.Z.AN	23.21		203,000	950	0.23	250-245-235	170-160-160	220-210-205
S4.3.Z.AG	23.22		203,000	1050	0.23	195-190-185	145-135-135	170-165-160

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.



Conditions:

Side milling, cutter dia. 1.000 inch (25 mm). Working engagement .400 inch (10 mm).

CoroMill® Plura solid ceramic end mill for high speed roughing
CoroMill® 316 brazed ceramic head for high speed roughing


						a_e = 0.4 x DC a_p = 0.5 mm Overhang 4 x d			a_e = 0.5 x DC a_p = 0.35 x DC Overhang 6 x d		
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
S	S2.0.Z.AG	20.22	Nickel based superalloys	350		B (Z6) - C (Z4)	600-1000	1968-3280	B	600-700	1968-2296

Z6 = ZEFP 6, Z4=ZEFP 4

Cutting feed recommendations

DC	**mm**	10.000	12.000
	inch	.394	.472
B	**mm/tooth**	.020	.020
B	**inch/tooth**	.0008	.0008
C	**mm/tooth**	.070	.090
C	**inch/tooth**	.0028	.0035

Maximum ramping angle

ISO	Material	Number of teeth (ZEFP) 4	6
S	Super alloys and titanium	3	3

CoroMill® 316 solid carbide head for high feed side milling


						a_e = 0.1 x DC a_p = 1.5 x DC Overhang 4 x d			a_e = 0.075 x DC a_p = 1.5 x DC Overhang 6 x d		
ISO	MC No.	Material		HB		f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min
S	S4.3.Z.AN	Titanium based alloys		320		A	100	328	A	90	295
	S4.4.Z.AN	Titanium based alloys		410		A	50	164	A	45	148

Cutting feed recommendations

DC	**mm**	9.525	10	12	12.7	15.875	16	19.05	20	25	25.4
	inch	.375	.394	.472	.500	.625	.630	.750	.787	.984	1
A	**mm/tooth**	0.057	0.057	0.066	0.066	0.076	0.076	0.095	0.095	0.123	0.123
A	**inch/tooth**	.0022	.0022	.0026	.0026	.0030	.0030	.0037	.0037	.0049	.0049

Maximum ramping angle

ISO	Material	Number of teeth (ZEFP) 4	6
S	Super alloys and titanium	3	3

ENG

Drilling

Solid drills

Exchangeable tip drills

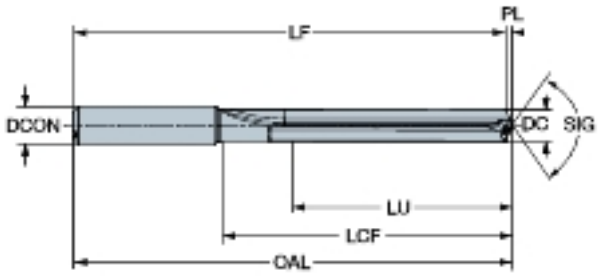
Cutting data

CoroDrill® 400 solid carbide drill

For aluminium

Internal coolant supply

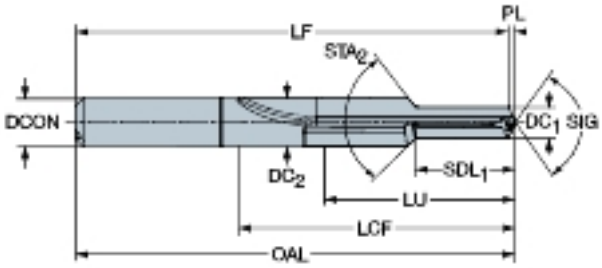
TCHA H9
SIG 135°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	N		Dimensions, mm, inch										BAR	PSI	BSG
							N1BU	N1DU	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"			
5.00	.197	30.0	1.181	6	6	**400.1-0500-030A1-NM**	★	★	6.00	.236	85	3.346	84.0	3.308	45	1.785	1.0	.038	20	290	COROMANT
7.00	.276	50.0	1.969	7	8	**400.1-0700-050A1-NM**	★	★	8.00	.315	110	4.331	108.6	4.276	68	2.695	1.4	.054	20	290	COROMANT
10.20	.402	70.0	2.756	6	12	**400.1-1020-070A1-NM**	★	★	12.00	.472	140	5.512	138.0	5.432	92	3.652	2.0	.080	20	290	COROMANT
12.50	.492	75.0	2.953	6	14	**400.1-1250-075A1-NM**	★	★	14.00	.551	150	5.906	147.5	5.807	100	3.956	2.5	.099	20	290	COROMANT

Internal coolant supply

TCHA H9
SIG 135°



DC_1	DC_1"	DC_2	DC_2"	SDL	SDL"	STA	LU	LU"	CZC_{MS}	Ordering code	N		Dimensions, mm, inch										BAR	PSI	BSG
											N1BU	N1DU	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"			
5.00	.197	8.00	.315	15.00	.590	90°	31.0	1.220	8	**400.4-0500-031A1-NM**	★	★	8.00	.315	90	3.543	89.0	3.505	50	2.002	1.0	.038	20	290	COROMANT
6.80	.268	10.00	.394	20.40	.803	90°	40.0	1.575	10	**400.4-0680-040A1-NM**	★	★	10.00	.394	105	4.134	103.7	4.081	62	2.452	1.3	.053	20	290	COROMANT
8.50	.335	12.00	.472	25.50	1.003	90°	50.0	1.969	12	**400.4-0850-050A1-NM**	★	★	12.00	.472	125	4.921	123.3	4.855	74	2.940	1.7	.067	20	290	COROMANT
10.20	.402	16.00	.630	30.60	1.204	90°	63.0	2.480	16	**400.4-1020-063A1-NM**	★	★	16.00	.630	145	5.709	143.0	5.629	91	3.605	2.0	.080	20	290	COROMANT

Drill Type 4 to use DC2 RPM, and DC1 Feed rate.

101 150

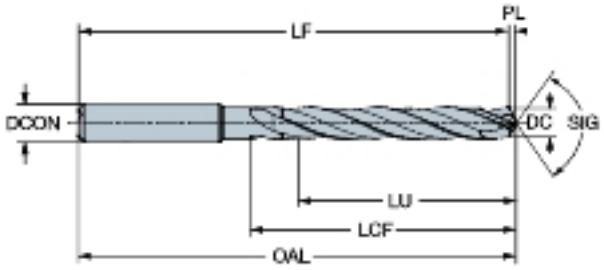
ENG

CoroDrill® 430 solid carbide drill

For aluminium

Internal coolant supply

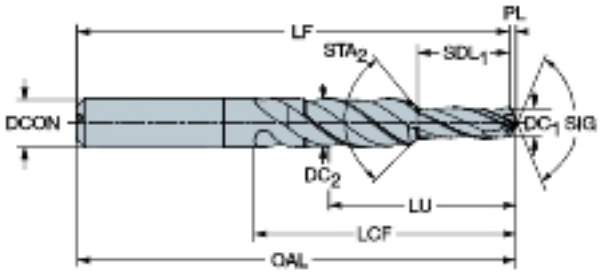
TCHA H9
SIG 135°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	N	N1BU	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
									Dimensions, mm, inch												
5.00	.197	30.0	1.181	6	6	430.1-0500-030A1-NM	★		6.00	.236	85	3.346	84.0	3.306	37	1.476	1.0	.041	20	290	COROMANT
7.00	.276	50.0	1.969	7	8	430.1-0700-050A1-NM	★		8.00	.315	110	4.331	108.6	4.274	60	2.382	1.5	.057	20	290	COROMANT
10.20	.402	70.0	2.756	6	12	430.1-1020-070A1-NM	★		12.00	.472	140	5.512	137.9	5.429	85	3.358	2.1	.083	20	290	COROMANT
12.50	.492	75.0	2.953	6	14	430.1-1250-075A1-NM	★		14.00	.551	150	5.906	147.4	5.804	93	3.693	2.6	.102	20	290	COROMANT

Internal coolant supply

TCHA H9
SIG 135°



DC_1	DC_1"	DC_2	DC_2"	SDL	SDL"	STA	LU	LU"	CZC_{MS}	Ordering code	N	N1BU	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
													Dimensions, mm, inch												
5.00	.197	8.00	.315	15.00	.590	90°	31.0	1.220	8	430.4-0500-031A1-NM	★		8.00	.315	90	3.543	89.0	3.503	39	1.535	1.0	.041	20	290	COROMANT
6.80	.268	10.00	.394	20.40	.803	90°	40.4	1.591	10	430.4-0680-040A1-NM	★		10.00	.394	105	4.134	103.6	4.078	50	1.984	1.4	.056	20	290	COROMANT
8.50	.335	12.00	.472	25.50	1.003	90°	49.5	1.949	12	430.4-0850-050A1-NM	★		12.00	.472	125	4.921	123.2	4.852	61	2.421	1.8	.069	20	290	COROMANT
10.20	.402	16.00	.630	30.60	1.204	90°	62.6	2.465	16	430.4-1020-063A1-NM	★		16.00	.630	145	5.709	142.9	5.626	78	3.094	2.1	.083	20	290	COROMANT

Drill Type 4 to use DC2 RPM, and DC1 Feed rate.

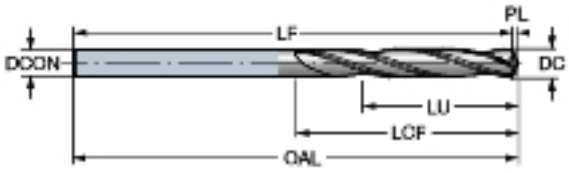
101 150

CoroDrill® 452 solid carbide drill

For handheld machines

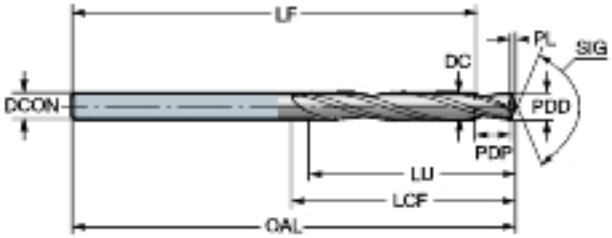
For aerospace assembly materials

TCHA H9
SIG 135°



DC	DC"	DCN	DCX	LU	LU"	ULDR	CZC_{MS}	Ordering code	M H10F	N H10F	S H10F	O H10F	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
Dimensions, mm, inch																							
3.10	.122	3.1	3.1	45.0	1.772	14	3	452.1-0310-045A0-CM	★	★	☆	★	3.10	.122	100	3.937	99.4	3.912	50	1.969	0.6	.025	COROMANT
4.10	.161	4.1	4.1	45.0	1.772	10	4	452.1-0410-045A0-CM	★	★	☆	★	4.10	.161	100	3.937	99.2	3.904	50	1.969	0.9	.033	COROMANT
5.10	.201	5.1	5.1	45.0	1.772	8	5	452.1-0510-045A0-CM	★	★	☆	★	5.10	.201	100	3.937	98.9	3.895	50	1.969	1.1	.042	COROMANT
6.10	.240	6.1	6.1	45.0	1.772	7	6	452.1-0610-045A0-CM	★	★	☆	★	6.10	.240	100	3.937	98.7	3.887	50	1.969	1.3	.050	COROMANT

TCHA H9
SIG 135°



DC	DC"	DCN	DCX	LU	LU"	ULDR	CZC_{MS}	Ordering code	M H10F	N H10F	S H10F	O H10F	DCON	DCON"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	PDD	PDD"	PDP	PDP"	BSG
Dimensions, mm, inch																											
4.10	.161	4.1	4.1	45.0	1.772	10	4	452.4-0410-045A0-CM	★	★	☆	★	4.10	.161	100	3.937	95.9	3.776	50	1.969	0.7	.027	3.30	.130	3.32	.131	COROMANT
5.10	.201	5.1	5.1	45.0	1.772	8	5	452.4-0510-045A0-CM	★	★	☆	★	5.10	.201	100	3.937	94.9	3.736	50	1.969	0.9	.034	4.20	.165	4.13	.163	COROMANT
6.10	.240	6.1	6.1	45.0	1.772	7	6	452.4-0610-045A0-CM	★	★	☆	★	6.10	.240	100	3.937	93.9	3.697	50	1.969	1.1	.043	5.20	.205	4.92	.194	COROMANT

101 150

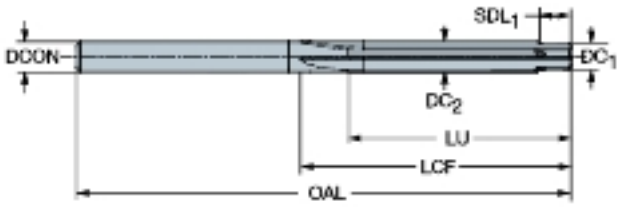
ENG

CoroDrill® 452 solid carbide reamer

For handheld machines

For aerospace assembly materials

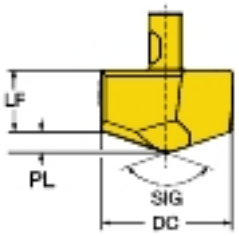
TCHA H9



									M	N	S	O	Dimensions, mm, inch			
									H10F	H10F	H10F	H10F				
DC_1	DC_1"	DC_2	DC_2"	LU	LU"	SDL	CZC_{MS}	Ordering code					OAL	OAL"	LCF	LCF"	BSG
3.10	.122	4.10	.161	45.00	1.772	3.74	4	452.R-0410-045A0-CM	★	★	☆	★	100.00	3.937	50.00	1.969	COROMANT
4.10	.161	5.10	.201	45.00	1.772	4.65	5	452.R-0510-045A0-CM	★	★	☆	★	100.00	3.937	50.00	1.969	COROMANT
5.10	.201	6.10	.240	45.00	1.772	5.57	6	452.R-0610-045A0-CM	★	★	☆	★	100.00	3.937	50.00	1.969	COROMANT
5.54	.218	6.35	.250	45.00	1.772	6.64	1/4	452.R-0635-045A0-CM	★	★	☆	★	100.00	3.937	50.00	1.969	COROMANT
7.13	.281	7.94	.313	45.00	1.772	7.53	5/16	452.R-0794-045A0-CM	★	★	☆	★	100.00	3.937	50.00	1.969	COROMANT

101 150

CoroDrill® 870 drill tip

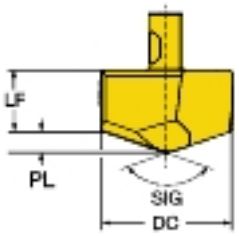


DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
10.00	.393	6	870-1000-6-PM	★	☆	☆	☆	☆	4.7	.183	1.5	.061	142°	H9
10.10	.397		870-1010-6-PM	★	☆	☆	☆	☆	4.7	.183	1.6	.061	142°	H9
10.20	.401		870-1020-6-PM	★	☆	☆	☆	☆	4.6	.182	1.6	.062	142°	H9
10.30	.405		870-1030-6-PM	★	☆	☆	☆	☆	4.6	.181	1.6	.063	142°	H9
10.40	.409		870-1040-6-PM	★	☆	☆	☆	☆	4.6	.181	1.6	.063	142°	H9
10.50	.413	7	870-1050-7-PM	★	☆	☆	☆	☆	4.6	.180	1.6	.064	142°	H9
10.60	.417		870-1060-7-PM	★	☆	☆	☆	☆	4.6	.180	1.6	.065	142°	H9
10.70	.421		870-1070-7-PM	★	☆	☆	☆	☆	4.6	.179	1.7	.065	142°	H9
10.80	.425		870-1080-7-PM	★	☆	☆	☆	☆	4.5	.178	1.7	.066	142°	H9
10.90	.429		870-1090-7-PM	★	☆	☆	☆	☆	4.5	.178	1.7	.067	142°	H9
11.00	.433	8	870-1100-8-PM	★	☆	☆	☆	☆	5.2	.206	1.7	.066	142°	H9
11.10	.437		870-1110-8-PM	★	☆	☆	☆	☆	5.2	.205	1.7	.067	142°	H9
11.11	.437		870-1111-8-PM	★	☆	☆	☆	☆	5.2	.205	1.7	.067	142°	H9
11.20	.440		870-1120-8-PM	★	☆	☆	☆	☆	5.2	.204	1.7	.067	142°	H9
11.30	.444		870-1130-8-PM	★	☆	☆	☆	☆	5.2	.204	1.7	.068	142°	H9
11.40	.448		870-1140-8-PM	★	☆	☆	☆	☆	5.2	.203	1.8	.069	142°	H9
11.50	.452	9	870-1150-9-PM	★	☆	☆	☆	☆	5.1	.202	1.8	.069	142°	H9
11.60	.456		870-1160-9-PM	★	☆	☆	☆	☆	5.1	.202	1.8	.070	142°	H9
11.70	.460		870-1170-9-PM	★	☆	☆	☆	☆	5.1	.201	1.8	.071	142°	H9
11.80	.464		870-1180-9-PM	★	☆	☆	☆	☆	5.1	.200	1.8	.071	142°	H9
11.90	.468		870-1190-9-PM	★	☆	☆	☆	☆	5.1	.200	1.8	.072	142°	H9
12.00	.472	10	870-1200-10-PM	★	☆	☆	☆	☆	5.7	.223	1.8	.072	142°	H9
12.10	.476		870-1210-10-PM	★	☆	☆	☆	☆	5.7	.222	1.9	.073	142°	H9
12.20	.480		870-1220-10-PM	★	☆	☆	☆	☆	5.6	.222	1.9	.073	142°	H9
12.30	.484		870-1230-10-PM	★	☆	☆	☆	☆	5.6	.221	1.9	.074	142°	H9
12.40	.488		870-1240-10-PM	★	☆	☆	☆	☆	5.6	.220	1.9	.075	142°	H9
12.50	.492	11	870-1250-11-PM	★	☆	☆	☆	☆	5.6	.220	1.9	.075	142°	H9
12.60	.496		870-1260-11-PM	★	☆	☆	☆	☆	5.6	.219	1.9	.076	142°	H9
12.70	.500		870-1270-11-PM	★	☆	☆	☆	☆	5.6	.219	2.0	.077	142°	H9
12.80	.503		870-1280-11-PM	★	☆	☆	☆	☆	5.5	.218	2.0	.078	142°	H9
12.90	.507		870-1290-11-PM	★	☆	☆	☆	☆	5.5	.217	2.0	.078	142°	H9
13.00	.511	12	870-1300-12-PM	★	☆	☆	☆	☆	6.0	.237	2.0	.078	142°	H9
13.10	.515		870-1310-12-PM	★	☆	☆	☆	☆	6.0	.236	2.0	.079	142°	H9
13.20	.519		870-1320-12-PM	★	☆	☆	☆	☆	6.0	.235	2.0	.080	142°	H9
13.30	.523		870-1330-12-PM	★	☆	☆	☆	☆	6.0	.235	2.0	.080	142°	H9
13.40	.527		870-1340-12-PM	★	☆	☆	☆	☆	5.9	.234	2.1	.081	142°	H9
13.50	.531	13	870-1350-13-PM	★	☆	☆	☆	☆	5.9	.233	2.1	.082	142°	H9
13.60	.535		870-1360-13-PM	★	☆	☆	☆	☆	5.9	.233	2.1	.082	142°	H9
13.70	.539		870-1370-13-PM	★	☆	☆	☆	☆	5.9	.232	2.1	.083	142°	H9
13.80	.543		870-1380-13-PM	★	☆	☆	☆	☆	5.9	.231	2.1	.084	142°	H9
13.90	.547		870-1390-13-PM	★	☆	☆	☆	☆	5.9	.231	2.1	.084	142°	H9
14.00	.551	14	870-1400-14-PM	★	☆	☆	☆	☆	6.6	.259	2.1	.084	142°	H9
14.10	.555		870-1410-14-PM	★	☆	☆	☆	☆	6.6	.258	2.2	.085	142°	H9
14.20	.559		870-1420-14-PM	★	☆	☆	☆	☆	6.5	.257	2.2	.085	142°	H9
14.29	.562		870-1429-14-PM	★	☆	☆	☆	☆	6.5	.257	2.2	.086	142°	H9
14.30	.563		870-1430-14-PM	★	☆	☆	☆	☆	6.5	.257	2.2	.086	142°	H9
14.40	.566		870-1440-14-PM	★	☆	☆	☆	☆	6.5	.256	2.2	.087	142°	H9
14.50	.570		870-1450-14-PM	★	☆	☆	☆	☆	6.5	.255	2.2	.087	142°	H9
14.60	.574		870-1460-14-PM	★	☆	☆	☆	☆	6.5	.255	2.2	.088	142°	H9
14.70	.578		870-1470-14-PM	★	☆	☆	☆	☆	6.5	.254	2.3	.089	142°	H9
14.80	.582		870-1480-14-PM	★	☆	☆	☆	☆	6.4	.253	2.3	.089	142°	H9
14.90	.586		870-1490-14-PM	★	☆	☆	☆	☆	6.4	.253	2.3	.090	142°	H9
15.00	.590	15	870-1500-15-PM	★	☆	☆	☆	☆	7.0	.276	2.3	.090	142°	H9
15.10	.594		870-1510-15-PM	★	☆	☆	☆	☆	7.0	.276	2.3	.091	142°	H9
15.20	.598		870-1520-15-PM	★	☆	☆	☆	☆	7.0	.275	2.3	.091	142°	H9
15.30	.602		870-1530-15-PM	★	☆	☆	☆	☆	7.0	.274	2.3	.092	142°	H9

102 150

ENG

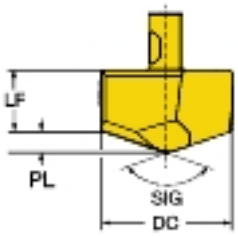
CoroDrill® 870 drill tip



DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
15.40	.606	15	870-1540-15-PM	★	☆	☆	☆	☆	7.0	.274	2.4	.093	142°	H9
15.50	.610		870-1550-15-PM	★	☆	☆	☆	☆	6.9	.273	2.4	.093	142°	H9
15.60	.614		870-1560-15-PM	★	☆	☆	☆	☆	6.9	.272	2.4	.094	142°	H9
15.70	.618		870-1570-15-PM	★	☆	☆	☆	☆	6.9	.272	2.4	.094	142°	H9
15.80	.622		870-1580-15-PM	★	☆	☆	☆	☆	6.9	.271	2.4	.095	142°	H9
15.88	.625		870-1588-15-PM	★	☆	☆	☆	☆	6.9	.270	2.4	.096	142°	H9
15.90	.626		870-1590-15-PM	★	☆	☆	☆	☆	6.9	.270	2.4	.096	142°	H9
16.00	.629	16	870-1600-16-PM	★	☆	☆	☆	☆	7.6	.298	2.4	.096	142°	H9
16.10	.633		870-1610-16-PM	★	☆	☆	☆	☆	7.6	.298	2.4	.096	142°	H9
16.13	.635		870-1613-16-PM	★	☆	☆	☆	☆	7.6	.297	2.5	.096	142°	H9
16.20	.637		870-1620-16-PM	★	☆	☆	☆	☆	7.5	.297	2.5	.097	142°	H9
16.30	.641		870-1630-16-PM	★	☆	☆	☆	☆	7.5	.296	2.5	.098	142°	H9
16.40	.645		870-1640-16-PM	★	☆	☆	☆	☆	7.5	.296	2.5	.098	142°	H9
16.50	.649		870-1650-16-PM	★	☆	☆	☆	☆	7.5	.295	2.5	.099	142°	H9
16.60	.653		870-1660-16-PM	★	☆	☆	☆	☆	7.5	.294	2.5	.100	142°	H9
16.70	.657		870-1670-16-PM	★	☆	☆	☆	☆	7.5	.294	2.5	.100	142°	H9
16.80	.661		870-1680-16-PM	★	☆	☆	☆	☆	7.4	.293	2.6	.101	142°	H9
16.90	.665		870-1690-16-PM	★	☆	☆	☆	☆	7.4	.292	2.6	.102	142°	H9
17.00	.669	17	870-1700-17-PM	★	☆	☆	☆	☆	8.0	.316	2.6	.102	142°	H9
17.10	.673		870-1710-17-PM	★	☆	☆	☆	☆	8.0	.315	2.6	.102	142°	H9
17.20	.677		870-1720-17-PM	★	☆	☆	☆	☆	8.0	.315	2.6	.103	142°	H9
17.30	.681		870-1730-17-PM	★	☆	☆	☆	☆	8.0	.314	2.6	.104	142°	H9
17.40	.685		870-1740-17-PM	★	☆	☆	☆	☆	8.0	.313	2.7	.104	142°	H9
17.46	.687		870-1746-17-PM	★	☆	☆	☆	☆	7.9	.313	2.7	.105	142°	H9
17.50	.689		870-1750-17-PM	★	☆	☆	☆	☆	7.9	.313	2.7	.105	142°	H9
17.60	.692		870-1760-17-PM	★	☆	☆	☆	☆	7.9	.312	2.7	.106	142°	H9
17.70	.696		870-1770-17-PM	★	☆	☆	☆	☆	7.9	.311	2.7	.106	142°	H9
17.80	.700		870-1780-17-PM	★	☆	☆	☆	☆	7.9	.311	2.7	.107	142°	H9
17.90	.704		870-1790-17-PM	★	☆	☆	☆	☆	7.9	.310	2.7	.107	142°	H9
18.00	.708	18	870-1800-18-PM	★	☆	☆	☆	☆	8.6	.338	2.7	.107	142°	H9
18.10	.712		870-1810-18-PM	★	☆	☆	☆	☆	8.6	.337	2.7	.108	142°	H9
18.20	.716		870-1820-18-PM	★	☆	☆	☆	☆	8.6	.337	2.8	.108	142°	H9
18.30	.720		870-1830-18-PM	★	☆	☆	☆	☆	8.5	.336	2.8	.109	142°	H9
18.40	.724		870-1840-18-PM	★	☆	☆	☆	☆	8.5	.335	2.8	.110	142°	H9
18.50	.728		870-1850-18-PM	★	☆	☆	☆	☆	8.5	.335	2.8	.110	142°	H9
18.60	.732		870-1860-18-PM	★	☆	☆	☆	☆	8.5	.334	2.8	.111	142°	H9
18.70	.736		870-1870-18-PM	★	☆	☆	☆	☆	8.5	.333	2.8	.112	142°	H9
18.80	.740		870-1880-18-PM	★	☆	☆	☆	☆	8.5	.333	2.9	.112	142°	H9
18.90	.744		870-1890-18-PM	★	☆	☆	☆	☆	8.4	.332	2.9	.113	142°	H9
19.00	.748	19	870-1900-19-PM	★	☆	☆	☆	☆	9.0	.356	2.9	.113	142°	H9
19.05	.750		870-1905-19-PM	★	☆	☆	☆	☆	9.0	.355	2.9	.113	142°	H9
19.10	.752		870-1910-19-PM	★	☆	☆	☆	☆	9.0	.355	2.9	.114	142°	H9
19.20	.755		870-1920-19-PM	★	☆	☆	☆	☆	9.0	.354	2.9	.115	142°	H9
19.25	.757		870-1925-19-PM	★	☆	☆	☆	☆	9.0	.354	2.9	.115	142°	H9
19.30	.759		870-1930-19-PM	★	☆	☆	☆	☆	9.0	.354	2.9	.115	142°	H9
19.40	.763		870-1940-19-PM	★	☆	☆	☆	☆	9.0	.353	2.9	.116	142°	H9
19.50	.767		870-1950-19-PM	★	☆	☆	☆	☆	8.9	.352	3.0	.117	142°	H9
19.60	.771		870-1960-19-PM	★	☆	☆	☆	☆	8.9	.352	3.0	.117	142°	H9
19.70	.775		870-1970-19-PM	★	☆	☆	☆	☆	8.9	.351	3.0	.118	142°	H9
19.80	.779		870-1980-19-PM	★	☆	☆	☆	☆	8.9	.350	3.0	.119	142°	H9
19.90	.783		870-1990-19-PM	★	☆	☆	☆	☆	8.9	.350	3.0	.119	142°	H9
20.00	.787	20	870-2000-20-PM	★	☆	☆	☆	☆	9.5	.373	3.0	.119	142°	H9
20.10	.791		870-2010-20-PM	★	☆	☆	☆	☆	9.5	.372	3.0	.120	142°	H9
20.20	.795		870-2020-20-PM	★	☆	☆	☆	☆	9.4	.372	3.1	.120	142°	H9
20.30	.799		870-2030-20-PM	★	☆	☆	☆	☆	9.4	.371	3.1	.121	142°	H9
20.40	.803		870-2040-20-PM	★	☆	☆	☆	☆	9.4	.370	3.1	.122	142°	H9

102 150

CoroDrill® 870 drill tip

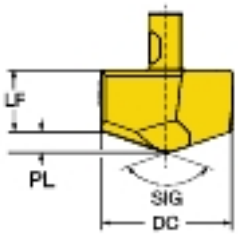


DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	LF	LF"	PL	PL"	SIG	TCHA
				Dimensions, mm, inch										
20.50	.807	20	870-2050-20-PM	★	☆	☆	☆	☆	9.4	.370	3.1	.122	142°	H9
20.60	.811		870-2060-20-PM	★	☆	☆	☆	☆	9.4	.369	3.1	.123	142°	H9
20.64	.812		870-2064-20-PM	★	☆	☆	☆	☆	9.4	.369	3.1	.123	142°	H9
20.70	.815		870-2070-20-PM	★	☆	☆	☆	☆	9.4	.369	3.1	.124	142°	H9
20.80	.818		870-2080-20-PM	★	☆	☆	☆	☆	9.3	.368	3.2	.124	142°	H9
20.90	.822		870-2090-20-PM	★	☆	☆	☆	☆	9.3	.367	3.2	.125	142°	H9
21.00	.826	21	870-2100-21-PM	★	☆	☆	☆	☆	10.0	.395	3.2	.124	142°	H9
21.10	.830		870-2110-21-PM	★	☆	☆	☆	☆	10.0	.394	3.2	.125	142°	H9
21.20	.834		870-2120-21-PM	★	☆	☆	☆	☆	10.0	.394	3.2	.126	142°	H9
21.30	.838		870-2130-21-PM	★	☆	☆	☆	☆	10.0	.393	3.2	.126	142°	H9
21.40	.842		870-2140-21-PM	★	☆	☆	☆	☆	10.0	.393	3.2	.127	142°	H9
21.50	.846		870-2150-21-PM	★	☆	☆	☆	☆	10.0	.392	3.3	.128	142°	H9
21.60	.850		870-2160-21-PM	★	☆	☆	☆	☆	9.9	.391	3.3	.129	142°	H9
21.70	.854		870-2170-21-PM	★	☆	☆	☆	☆	9.9	.391	3.3	.129	142°	H9
21.80	.858		870-2180-21-PM	★	☆	☆	☆	☆	9.9	.390	3.3	.130	142°	H9
21.90	.862		870-2190-21-PM	★	☆	☆	☆	☆	9.9	.389	3.3	.131	142°	H9
22.00	.866	22	870-2200-22-PM	★	☆	☆	☆	☆	10.5	.413	3.3	.131	142°	H9
22.10	.870		870-2210-22-PM	★	☆	☆	☆	☆	10.5	.412	3.3	.131	142°	H9
22.20	.874		870-2220-22-PM	★	☆	☆	☆	☆	10.5	.411	3.4	.132	142°	H9
22.23	.875		870-2223-22-PM	★	☆	☆	☆	☆	10.5	.411	3.4	.132	142°	H9
22.30	.878		870-2230-22-PM	★	☆	☆	☆	☆	10.4	.411	3.4	.133	142°	H9
22.40	.881		870-2240-22-PM	★	☆	☆	☆	☆	10.4	.410	3.4	.133	142°	H9
22.50	.885		870-2250-22-PM	★	☆	☆	☆	☆	10.4	.409	3.4	.134	142°	H9
22.60	.889		870-2260-22-PM	★	☆	☆	☆	☆	10.4	.409	3.4	.135	142°	H9
22.70	.893		870-2270-22-PM	★	☆	☆	☆	☆	10.4	.408	3.4	.135	142°	H9
22.80	.897		870-2280-22-PM	★	☆	☆	☆	☆	10.4	.407	3.5	.136	142°	H9
22.90	.901		870-2290-22-PM	★	☆	☆	☆	☆	10.3	.407	3.5	.137	142°	H9
23.00	.905	23	870-2300-23-PM	★	☆	☆	☆	☆	11.0	.435	3.5	.136	142°	H9
23.10	.909		870-2310-23-PM	★	☆	☆	☆	☆	11.0	.434	3.5	.137	142°	H9
23.20	.913		870-2320-23-PM	★	☆	☆	☆	☆	11.0	.433	3.5	.137	142°	H9
23.30	.917		870-2330-23-PM	★	☆	☆	☆	☆	11.0	.433	3.5	.138	142°	H9
23.40	.921		870-2340-23-PM	★	☆	☆	☆	☆	11.0	.432	3.5	.139	142°	H9
23.50	.925		870-2350-23-PM	★	☆	☆	☆	☆	11.0	.431	3.5	.139	142°	H9
23.60	.929		870-2360-23-PM	★	☆	☆	☆	☆	10.9	.431	3.6	.140	142°	H9
23.70	.933		870-2370-23-PM	★	☆	☆	☆	☆	10.9	.430	3.6	.141	142°	H9
23.80	.937		870-2380-23-PM	★	☆	☆	☆	☆	10.9	.430	3.6	.141	142°	H9
23.81	.937		870-2381-23-PM	★	☆	☆	☆	☆	10.9	.430	3.6	.141	142°	H9
23.90	.940		870-2390-23-PM	★	☆	☆	☆	☆	10.9	.429	3.6	.142	142°	H9
24.00	.944	24	870-2400-24-PM	★	☆	☆	☆	☆	11.4	.448	3.6	.143	142°	H9
24.10	.948		870-2410-24-PM	★	☆	☆	☆	☆	11.4	.447	3.6	.143	142°	H9
24.20	.952		870-2420-24-PM	★	☆	☆	☆	☆	11.4	.447	3.7	.144	142°	H9
24.30	.956		870-2430-24-PM	★	☆	☆	☆	☆	11.3	.446	3.7	.144	142°	H9
24.40	.960		870-2440-24-PM	★	☆	☆	☆	☆	11.3	.445	3.7	.145	142°	H9
24.50	.964		870-2450-24-PM	★	☆	☆	☆	☆	11.3	.445	3.7	.146	142°	H9
24.60	.968		870-2460-24-PM	★	☆	☆	☆	☆	11.3	.444	3.7	.146	142°	H9
24.70	.972		870-2470-24-PM	★	☆	☆	☆	☆	11.3	.443	3.7	.147	142°	H9
24.80	.976		870-2480-24-PM	★	☆	☆	☆	☆	11.3	.443	3.8	.148	142°	H9
24.90	.980		870-2490-24-PM	★	☆	☆	☆	☆	11.2	.442	3.8	.148	142°	H9
25.00	.984	25	870-2500-25-PM	★	☆	☆	☆	☆	11.9	.470	3.8	.148	142°	H9
25.10	.988		870-2510-25-PM	★	☆	☆	☆	☆	11.9	.469	3.8	.149	142°	H9
25.20	.992		870-2520-25-PM	★	☆	☆	☆	☆	11.9	.469	3.8	.149	142°	H9
25.30	.996		870-2530-25-PM	★	☆	☆	☆	☆	11.9	.468	3.8	.150	142°	H9
25.40	1.000		870-2540-25-PM	★	☆	☆	☆	☆	11.9	.467	3.8	.151	142°	H9
25.50	1.003		870-2550-25-PM	★	☆	☆	☆	☆	11.9	.467	3.8	.151	142°	H9
25.60	1.007		870-2560-25-PM	★	☆	☆	☆	☆	11.8	.466	3.9	.152	142°	H9
25.70	1.011		870-2570-25-PM	★	☆	☆	☆	☆	11.8	.465	3.9	.153	142°	H9

102 150

ENG

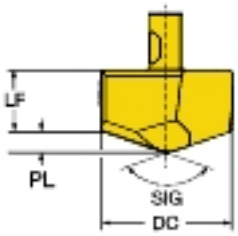
CoroDrill® 870 drill tip



DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
25.80	1.015	25	870-2580-25-PM	★	☆	☆	☆	☆	11.8	.465	3.9	.153	142°	H9
25.90	1.019		870-2590-25-PM	★	☆	☆	☆	☆	11.8	.464	3.9	.154	142°	H9
26.00	1.023	26	870-2600-26-PM	★	☆	☆	☆	☆	12.5	.492	3.9	.154	142°	H9
26.50	1.043		870-2650-26-PM	★	☆	☆	☆	☆	12.4	.489	4.0	.157	142°	H9
26.65	1.049		870-2665-26-PM	★	☆	☆	☆	☆	12.4	.487	4.0	.159	142°	H9
27.00	1.063	27	870-2700-27-PM	★	☆	☆	☆	☆	13.0	.510	4.1	.159	142°	H9
27.50	1.082		870-2750-27-PM	★	☆	☆	☆	☆	12.9	.506	4.1	.163	142°	H9
28.00	1.102	28	870-2800-28-PM	★	☆	☆	☆	☆	13.4	.527	4.2	.166	142°	H9
28.50	1.122		870-2850-28-PM	★	☆	☆	☆	☆	13.3	.524	4.3	.169	142°	H9
28.58	1.125		870-2858-28-PM	★	☆	☆	☆	☆	13.3	.523	4.3	.170	142°	H9
29.00	1.141	29	870-2900-29-PM	★	☆	☆	☆	☆	13.9	.549	4.4	.172	142°	H9
29.50	1.161		870-2950-29-PM	★	☆	☆	☆	☆	13.9	.545	4.5	.175	142°	H9
29.65	1.167		870-2965-29-PM	★	☆	☆	☆	☆	13.8	.544	4.5	.176	142°	H9
30.00	1.181	30	870-3000-30-PM	★	☆	☆	☆	☆	14.4	.566	4.5	.178	142°	H9
30.50	1.200		870-3050-30-PM	★	☆	☆	☆	☆	14.3	.563	4.6	.181	142°	H9
31.00	1.220	31	870-3100-31-PM	★	☆	☆	☆	☆	14.8	.581	4.8	.187	142°	H9
31.50	1.240		870-3150-31-PM	★	☆	☆	☆	☆	14.7	.578	4.8	.190	142°	H9
31.75	1.250		870-3175-31-PM	★	☆	☆	☆	☆	14.6	.576	4.9	.192	142°	H9
32.00	1.259		870-3200-31-PM	★	☆	☆	☆	☆	14.6	.574	4.9	.194	142°	H9
32.15	1.265		870-3215-31-PM	★	☆	☆	☆	☆	14.6	.573	5.0	.195	142°	H9
32.50	1.279		870-3250-31-PM	★	☆	☆	☆	☆	14.5	.571	5.0	.197	142°	H9
33.00	1.299		870-3300-31-PM	★	☆	☆	☆	☆	14.4	.568	5.1	.200	142°	H9

102 150

CoroDrill® 870 drill tip

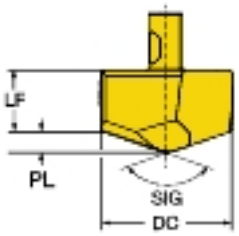


DC	DC"		Ordering code	P 3334	K 3334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
10.00	.393	6	870-1000-6-KM	☆	★	4.4	.172	1.8	.072	142°	H9
10.10	.397		870-1010-6-KM	☆	★	4.4	.172	1.8	.072	142°	H9
10.20	.401		870-1020-6-KM	☆	★	4.3	.171	1.9	.073	142°	H9
10.30	.405		870-1030-6-KM	☆	★	4.3	.170	1.9	.074	142°	H9
10.40	.409		870-1040-6-KM	☆	★	4.3	.170	1.9	.074	142°	H9
10.50	.413	7	870-1050-7-KM	☆	★	4.3	.169	1.9	.075	142°	H9
10.60	.417		870-1060-7-KM	☆	★	4.3	.169	1.9	.076	142°	H9
10.70	.421		870-1070-7-KM	☆	★	4.3	.168	1.9	.076	142°	H9
10.80	.425		870-1080-7-KM	☆	★	4.3	.167	2.0	.077	142°	H9
10.90	.429		870-1090-7-KM	☆	★	4.2	.167	2.0	.078	142°	H9
11.00	.433	8	870-1100-8-KM	☆	★	4.9	.194	2.0	.077	142°	H9
11.10	.437		870-1110-8-KM	☆	★	4.9	.194	2.0	.078	142°	H9
11.11	.437		870-1111-8-KM	☆	★	4.9	.194	2.0	.078	142°	H9
11.20	.440		870-1120-8-KM	☆	★	4.9	.193	2.0	.079	142°	H9
11.30	.444		870-1130-8-KM	☆	★	4.9	.193	2.0	.079	142°	H9
11.40	.448		870-1140-8-KM	☆	★	4.9	.192	2.0	.080	142°	H9
11.50	.452	9	870-1150-9-KM	☆	★	4.8	.188	2.1	.083	142°	H9
11.60	.456		870-1160-9-KM	☆	★	4.8	.188	2.1	.084	142°	H9
11.70	.460		870-1170-9-KM	☆	★	4.8	.187	2.2	.085	142°	H9
11.80	.464		870-1180-9-KM	☆	★	4.7	.186	2.2	.085	142°	H9
11.90	.468		870-1190-9-KM	☆	★	4.7	.186	2.2	.086	142°	H9
12.00	.472	10	870-1200-10-KM	☆	★	5.3	.209	2.2	.086	142°	H9
12.10	.476		870-1210-10-KM	☆	★	5.3	.209	2.2	.087	142°	H9
12.20	.480		870-1220-10-KM	☆	★	5.3	.208	2.2	.087	142°	H9
12.30	.484		870-1230-10-KM	☆	★	5.3	.207	2.2	.088	142°	H9
12.40	.488		870-1240-10-KM	☆	★	5.3	.207	2.3	.089	142°	H9
12.50	.492	11	870-1250-11-KM	☆	★	5.2	.206	2.3	.089	142°	H9
12.60	.496		870-1260-11-KM	☆	★	5.2	.206	2.3	.090	142°	H9
12.70	.500		870-1270-11-KM	☆	★	5.2	.205	2.3	.091	142°	H9
12.80	.503		870-1280-11-KM	☆	★	5.2	.204	2.3	.091	142°	H9
12.90	.507		870-1290-11-KM	☆	★	5.2	.203	2.3	.092	142°	H9
13.00	.511	12	870-1300-12-KM	☆	★	5.6	.220	2.4	.095	142°	H9
13.10	.515		870-1310-12-KM	☆	★	5.6	.219	2.4	.096	142°	H9
13.20	.519		870-1320-12-KM	☆	★	5.6	.219	2.5	.096	142°	H9
13.30	.523		870-1330-12-KM	☆	★	5.5	.218	2.5	.097	142°	H9
13.40	.527		870-1340-12-KM	☆	★	5.5	.217	2.5	.098	142°	H9
13.50	.531	13	870-1350-13-KM	☆	★	5.5	.217	2.5	.098	142°	H9
13.60	.535		870-1360-13-KM	☆	★	5.5	.216	2.5	.099	142°	H9
13.70	.539		870-1370-13-KM	☆	★	5.5	.215	2.5	.100	142°	H9
13.80	.543		870-1380-13-KM	☆	★	5.5	.215	2.6	.100	142°	H9
13.90	.547		870-1390-13-KM	☆	★	5.4	.214	2.6	.101	142°	H9
14.00	.551	14	870-1400-14-KM	☆	★	6.1	.242	2.6	.101	142°	H9
14.10	.555		870-1410-14-KM	☆	★	6.1	.241	2.6	.102	142°	H9
14.20	.559		870-1420-14-KM	☆	★	6.1	.241	2.6	.102	142°	H9
14.29	.562		870-1429-14-KM	☆	★	6.1	.240	2.6	.102	142°	H9
14.30	.563		870-1430-14-KM	☆	★	6.1	.240	2.6	.103	142°	H9
14.40	.566		870-1440-14-KM	☆	★	6.1	.239	2.6	.104	142°	H9
14.50	.570		870-1450-14-KM	☆	★	6.1	.239	2.6	.104	142°	H9
14.60	.574		870-1460-14-KM	☆	★	6.0	.238	2.7	.105	142°	H9
14.70	.578		870-1470-14-KM	☆	★	6.0	.237	2.7	.105	142°	H9
14.80	.582		870-1480-14-KM	☆	★	6.0	.237	2.7	.106	142°	H9
14.90	.586		870-1490-14-KM	☆	★	6.0	.236	2.7	.107	142°	H9
15.00	.590	15	870-1500-15-KM	☆	★	6.5	.257	2.8	.109	142°	H9
15.10	.594		870-1510-15-KM	☆	★	6.5	.256	2.8	.110	142°	H9
15.20	.598		870-1520-15-KM	☆	★	6.5	.255	2.8	.111	142°	H9
15.30	.602		870-1530-15-KM	☆	★	6.5	.255	2.8	.111	142°	H9

102 150

ENG

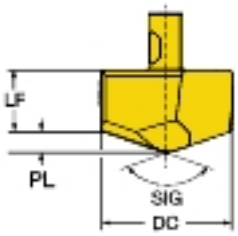
CoroDrill® 870 drill tip



DC	DC"		Ordering code	P 3334	K 3334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
15.40	.606	15	870-1540-15-KM	☆	★	6.5	.254	2.9	.112	142°	H9
15.50	.610		870-1550-15-KM	☆	★	6.4	.253	2.9	.113	142°	H9
15.60	.614		870-1560-15-KM	☆	★	6.4	.252	2.9	.114	142°	H9
15.70	.618		870-1570-15-KM	☆	★	6.4	.252	2.9	.114	142°	H9
15.80	.622		870-1580-15-KM	☆	★	6.4	.251	2.9	.115	142°	H9
15.88	.625		870-1588-15-KM	☆	★	6.4	.251	2.9	.115	142°	H9
15.90	.626		870-1590-15-KM	☆	★	6.4	.250	2.9	.116	142°	H9
16.00	.629	16	870-1600-16-KM	☆	★	7.0	.276	3.0	.118	142°	H9
16.10	.633		870-1610-16-KM	☆	★	7.0	.275	3.0	.119	142°	H9
16.13	.635		870-1613-16-KM	☆	★	7.0	.275	3.0	.119	142°	H9
16.20	.637		870-1620-16-KM	☆	★	7.0	.274	3.0	.119	142°	H9
16.30	.641		870-1630-16-KM	☆	★	7.0	.274	3.1	.120	142°	H9
16.40	.645		870-1640-16-KM	☆	★	6.9	.273	3.1	.121	142°	H9
16.50	.649		870-1650-16-KM	☆	★	6.9	.272	3.1	.121	142°	H9
16.60	.653		870-1660-16-KM	☆	★	6.9	.272	3.1	.122	142°	H9
16.70	.657		870-1670-16-KM	☆	★	6.9	.271	3.1	.123	142°	H9
16.80	.661		870-1680-16-KM	☆	★	6.9	.270	3.1	.123	142°	H9
16.90	.665		870-1690-16-KM	☆	★	6.9	.270	3.2	.124	142°	H9
17.00	.669	17	870-1700-17-KM	☆	★	7.4	.291	3.2	.127	142°	H9
17.10	.673		870-1710-17-KM	☆	★	7.4	.290	3.2	.128	142°	H9
17.20	.677		870-1720-17-KM	☆	★	7.3	.289	3.3	.128	142°	H9
17.30	.681		870-1730-17-KM	☆	★	7.3	.289	3.3	.129	142°	H9
17.40	.685		870-1740-17-KM	☆	★	7.3	.288	3.3	.130	142°	H9
17.46	.687		870-1746-17-KM	☆	★	7.3	.288	3.3	.130	142°	H9
17.50	.689		870-1750-17-KM	☆	★	7.3	.287	3.3	.130	142°	H9
17.60	.692		870-1760-17-KM	☆	★	7.3	.287	3.3	.131	142°	H9
17.70	.696		870-1770-17-KM	☆	★	7.3	.286	3.3	.131	142°	H9
17.80	.700		870-1780-17-KM	☆	★	7.2	.285	3.4	.132	142°	H9
17.90	.704		870-1790-17-KM	☆	★	7.2	.285	3.4	.133	142°	H9
18.00	.708	18	870-1800-18-KM	☆	★	7.9	.313	3.4	.132	142°	H9
18.10	.712		870-1810-18-KM	☆	★	7.9	.312	3.4	.133	142°	H9
18.20	.716		870-1820-18-KM	☆	★	7.9	.311	3.4	.134	142°	H9
18.30	.720		870-1830-18-KM	☆	★	7.9	.310	3.4	.135	142°	H9
18.40	.724		870-1840-18-KM	☆	★	7.9	.310	3.4	.135	142°	H9
18.50	.728		870-1850-18-KM	☆	★	7.9	.309	3.5	.136	142°	H9
18.60	.732		870-1860-18-KM	☆	★	7.8	.308	3.5	.137	142°	H9
18.70	.736		870-1870-18-KM	☆	★	7.8	.308	3.5	.137	142°	H9
18.80	.740		870-1880-18-KM	☆	★	7.8	.307	3.5	.138	142°	H9
18.90	.744		870-1890-18-KM	☆	★	7.8	.306	3.5	.139	142°	H9
19.00	.748	19	870-1900-19-KM	☆	★	8.3	.327	3.6	.141	142°	H9
19.05	.750		870-1905-19-KM	☆	★	8.3	.327	3.6	.142	142°	H9
19.10	.752		870-1910-19-KM	☆	★	8.3	.327	3.6	.142	142°	H9
19.20	.755		870-1920-19-KM	☆	★	8.3	.326	3.6	.143	142°	H9
19.25	.757		870-1925-19-KM	☆	★	8.3	.326	3.6	.143	142°	H9
19.30	.759		870-1930-19-KM	☆	★	8.3	.325	3.6	.143	142°	H9
19.40	.763		870-1940-19-KM	☆	★	8.2	.324	3.7	.144	142°	H9
19.50	.767		870-1950-19-KM	☆	★	8.2	.324	3.7	.144	142°	H9
19.60	.771		870-1960-19-KM	☆	★	8.2	.323	3.7	.145	142°	H9
19.70	.775		870-1970-19-KM	☆	★	8.2	.322	3.7	.146	142°	H9
19.80	.779		870-1980-19-KM	☆	★	8.2	.322	3.7	.146	142°	H9
19.90	.783		870-1990-19-KM	☆	★	8.2	.321	3.7	.147	142°	H9
20.00	.787	20	870-2000-20-KM	☆	★	8.7	.342	3.8	.150	142°	H9
20.10	.791		870-2010-20-KM	☆	★	8.7	.341	3.8	.151	142°	H9
20.20	.795		870-2020-20-KM	☆	★	8.7	.341	3.9	.152	142°	H9
20.30	.799		870-2030-20-KM	☆	★	8.6	.340	3.9	.152	142°	H9
20.40	.803		870-2040-20-KM	☆	★	8.6	.339	3.9	.153	142°	H9

102 150

CoroDrill® 870 drill tip



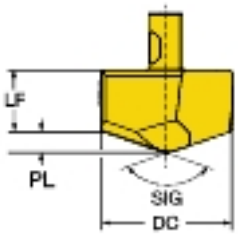
Dimensions, mm, inch

DC	DC"		Ordering code	P 3334	K 3334	LF	LF"	PL	PL"	SIG	TCHA
20.50	.807	20	870-2050-20-KM	☆	★	8.6	.339	3.9	.154	142°	H9
20.60	.811		870-2060-20-KM	☆	★	8.6	.338	3.9	.154	142°	H9
20.64	.812		870-2064-20-KM	☆	★	8.6	.337	3.9	.155	142°	H9
20.70	.815		870-2070-20-KM	☆	★	8.6	.337	3.9	.155	142°	H9
20.80	.818		870-2080-20-KM	☆	★	8.6	.337	4.0	.156	142°	H9
20.90	.822		870-2090-20-KM	☆	★	8.5	.336	4.0	.156	142°	H9
21.00	.826	21	870-2100-21-KM	☆	★	9.2	.364	4.0	.156	142°	H9
21.10	.830		870-2110-21-KM	☆	★	9.2	.363	4.0	.157	142°	H9
21.20	.834		870-2120-21-KM	☆	★	9.2	.362	4.0	.157	142°	H9
21.30	.838		870-2130-21-KM	☆	★	9.2	.362	4.0	.158	142°	H9
21.40	.842		870-2140-21-KM	☆	★	9.2	.361	4.0	.159	142°	H9
21.50	.846		870-2150-21-KM	☆	★	9.2	.361	4.0	.159	142°	H9
21.60	.850		870-2160-21-KM	☆	★	9.1	.360	4.1	.160	142°	H9
21.70	.854		870-2170-21-KM	☆	★	9.1	.359	4.1	.161	142°	H9
21.80	.858		870-2180-21-KM	☆	★	9.1	.358	4.1	.161	142°	H9
21.90	.862		870-2190-21-KM	☆	★	9.1	.358	4.1	.162	142°	H9
22.00	.866	22	870-2200-22-KM	☆	★	9.6	.379	4.2	.165	142°	H9
22.10	.870		870-2210-22-KM	☆	★	9.6	.378	4.2	.165	142°	H9
22.20	.874		870-2220-22-KM	☆	★	9.6	.378	4.2	.166	142°	H9
22.23	.875		870-2223-22-KM	☆	★	9.6	.378	4.2	.166	142°	H9
22.30	.878		870-2230-22-KM	☆	★	9.6	.377	4.2	.167	142°	H9
22.40	.881		870-2240-22-KM	☆	★	9.6	.376	4.2	.167	142°	H9
22.50	.885		870-2250-22-KM	☆	★	9.5	.375	4.3	.168	142°	H9
22.60	.889		870-2260-22-KM	☆	★	9.5	.375	4.3	.169	142°	H9
22.70	.893		870-2270-22-KM	☆	★	9.5	.374	4.3	.169	142°	H9
22.80	.897		870-2280-22-KM	☆	★	9.5	.374	4.3	.170	142°	H9
22.90	.901		870-2290-22-KM	☆	★	9.5	.373	4.3	.170	142°	H9
23.00	.905	23	870-2300-23-KM	☆	★	10.1	.398	4.4	.173	142°	H9
23.10	.909		870-2310-23-KM	☆	★	10.1	.397	4.4	.174	142°	H9
23.20	.913		870-2320-23-KM	☆	★	10.1	.396	4.4	.174	142°	H9
23.30	.917		870-2330-23-KM	☆	★	10.1	.396	4.5	.175	142°	H9
23.40	.921		870-2340-23-KM	☆	★	10.0	.395	4.5	.176	142°	H9
23.50	.925		870-2350-23-KM	☆	★	10.0	.394	4.5	.176	142°	H9
23.60	.929		870-2360-23-KM	☆	★	10.0	.394	4.5	.177	142°	H9
23.70	.933		870-2370-23-KM	☆	★	10.0	.393	4.5	.178	142°	H9
23.80	.937		870-2380-23-KM	☆	★	10.0	.393	4.5	.178	142°	H9
23.81	.937		870-2381-23-KM	☆	★	10.0	.393	4.5	.178	142°	H9
23.90	.940		870-2390-23-KM	☆	★	10.0	.392	4.6	.179	142°	H9
24.00	.944	24	870-2400-24-KM	☆	★	10.4	.408	4.6	.182	142°	H9
24.10	.948		870-2410-24-KM	☆	★	10.4	.407	4.7	.183	142°	H9
24.20	.952		870-2420-24-KM	☆	★	10.3	.407	4.7	.183	142°	H9
24.30	.956		870-2430-24-KM	☆	★	10.3	.406	4.7	.184	142°	H9
24.40	.960		870-2440-24-KM	☆	★	10.3	.406	4.7	.185	142°	H9
24.50	.964		870-2450-24-KM	☆	★	10.3	.405	4.7	.185	142°	H9
24.60	.968		870-2460-24-KM	☆	★	10.3	.404	4.7	.186	142°	H9
24.70	.972		870-2470-24-KM	☆	★	10.3	.404	4.8	.187	142°	H9
24.80	.976		870-2480-24-KM	☆	★	10.2	.403	4.8	.188	142°	H9
24.90	.980		870-2490-24-KM	☆	★	10.2	.402	4.8	.188	142°	H9
25.00	.984	25	870-2500-25-KM	☆	★	10.9	.430	4.8	.188	142°	H9
25.10	.988		870-2510-25-KM	☆	★	10.9	.430	4.8	.189	142°	H9
25.20	.992		870-2520-25-KM	☆	★	10.9	.429	4.8	.189	142°	H9
25.30	.996		870-2530-25-KM	☆	★	10.9	.428	4.8	.190	142°	H9
25.40	1.000		870-2540-25-KM	☆	★	10.9	.428	4.8	.191	142°	H9
25.50	1.003		870-2550-25-KM	☆	★	10.9	.427	4.9	.191	142°	H9
25.60	1.007		870-2560-25-KM	☆	★	10.8	.426	4.9	.192	142°	H9
25.70	1.011		870-2570-25-KM	☆	★	10.8	.426	4.9	.193	142°	H9

102 150

ENG

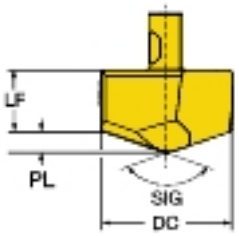
CoroDrill® 870 drill tip



DC	DC"		Ordering code	P 3334	K 3334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
25.80	1.015	25	870-2580-25-KM	☆	★	10.8	.425	4.9	.193	142°	H9
25.90	1.019		870-2590-25-KM	☆	★	10.8	.424	4.9	.194	142°	H9
26.00	1.023	26	870-2600-26-KM	☆	★	11.4	.449	5.0	.196	142°	H9
26.50	1.043		870-2650-26-KM	☆	★	11.3	.446	5.1	.200	142°	H9
26.65	1.049		870-2665-26-KM	☆	★	11.3	.444	5.1	.201	142°	H9
27.00	1.063	27	870-2700-27-KM	☆	★	11.8	.464	5.2	.205	142°	H9
27.50	1.082		870-2750-27-KM	☆	★	11.7	.461	5.3	.208	142°	H9
28.00	1.102	28	870-2800-28-KM	☆	★	12.2	.481	5.4	.211	142°	H9
28.50	1.122		870-2850-28-KM	☆	★	12.1	.478	5.5	.215	142°	H9
28.58	1.125		870-2858-28-KM	☆	★	12.1	.478	5.5	.215	142°	H9
29.00	1.141	29	870-2900-29-KM	☆	★	12.7	.500	5.6	.220	142°	H9
29.50	1.161		870-2950-29-KM	☆	★	12.6	.497	5.7	.223	142°	H9
29.65	1.167		870-2965-29-KM	☆	★	12.6	.496	5.7	.224	142°	H9
30.00	1.181	30	870-3000-30-KM	☆	★	13.1	.515	5.8	.229	142°	H9
30.50	1.200		870-3050-30-KM	☆	★	13.0	.512	5.9	.232	142°	H9
31.00	1.220	31	870-3100-31-KM	☆	★	13.4	.527	6.1	.241	142°	H9
31.50	1.240		870-3150-31-KM	☆	★	13.3	.524	6.2	.244	142°	H9
31.75	1.250		870-3175-31-KM	☆	★	13.3	.522	6.2	.245	142°	H9
32.00	1.259		870-3200-31-KM	☆	★	13.2	.521	6.3	.247	142°	H9
32.15	1.265		870-3215-31-KM	☆	★	13.2	.519	6.3	.249	142°	H9
32.50	1.279		870-3250-31-KM	☆	★	13.1	.516	6.4	.252	142°	H9
33.00	1.299		870-3300-31-KM	☆	★	13.0	.511	6.5	.256	142°	H9

102 150

CoroDrill® 870 drill tip

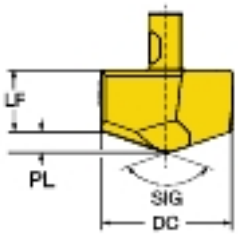


DC	DC"		Ordering code	M 2334	S 2334	LF	LF"	PL	PL"	SIG	TCHA
				Dimensions, mm, inch							
10.00	.393	6	870-1000-6-MM	★	☆	4.7	.183	1.5	.061	142°	H9
10.10	.397		870-1010-6-MM	★	☆	4.7	.183	1.6	.061	142°	H9
10.20	.401		870-1020-6-MM	★	☆	4.6	.182	1.6	.062	142°	H9
10.30	.405		870-1030-6-MM	★	☆	4.6	.181	1.6	.063	142°	H9
10.40	.409		870-1040-6-MM	★	☆	4.6	.181	1.6	.063	142°	H9
10.50	.413	7	870-1050-7-MM	★	☆	4.6	.180	1.6	.064	142°	H9
10.60	.417		870-1060-7-MM	★	☆	4.6	.180	1.6	.065	142°	H9
10.70	.421		870-1070-7-MM	★	☆	4.6	.179	1.7	.065	142°	H9
10.80	.425		870-1080-7-MM	★	☆	4.5	.178	1.7	.066	142°	H9
10.90	.429		870-1090-7-MM	★	☆	4.5	.178	1.7	.067	142°	H9
11.00	.433	8	870-1100-8-MM	★	☆	5.2	.206	1.7	.066	142°	H9
11.10	.437		870-1110-8-MM	★	☆	5.2	.205	1.7	.067	142°	H9
11.11	.437		870-1111-8-MM	★	☆	5.2	.205	1.7	.067	142°	H9
11.20	.440		870-1120-8-MM	★	☆	5.2	.204	1.7	.067	142°	H9
11.30	.444		870-1130-8-MM	★	☆	5.2	.204	1.7	.068	142°	H9
11.40	.448		870-1140-8-MM	★	☆	5.2	.203	1.8	.069	142°	H9
11.50	.452	9	870-1150-9-MM	★	☆	5.1	.202	1.8	.069	142°	H9
11.60	.456		870-1160-9-MM	★	☆	5.1	.202	1.8	.070	142°	H9
11.70	.460		870-1170-9-MM	★	☆	5.1	.201	1.8	.071	142°	H9
11.80	.464		870-1180-9-MM	★	☆	5.1	.200	1.8	.071	142°	H9
11.90	.468		870-1190-9-MM	★	☆	5.1	.200	1.8	.072	142°	H9
12.00	.472	10	870-1200-10-MM	★	☆	5.7	.223	1.8	.072	142°	H9
12.10	.476		870-1210-10-MM	★	☆	5.7	.222	1.9	.073	142°	H9
12.20	.480		870-1220-10-MM	★	☆	5.6	.222	1.9	.073	142°	H9
12.30	.484		870-1230-10-MM	★	☆	5.6	.221	1.9	.074	142°	H9
12.40	.488		870-1240-10-MM	★	☆	5.6	.220	1.9	.075	142°	H9
12.50	.492	11	870-1250-11-MM	★	☆	5.6	.220	1.9	.075	142°	H9
12.60	.496		870-1260-11-MM	★	☆	5.6	.219	1.9	.076	142°	H9
12.70	.500		870-1270-11-MM	★	☆	5.6	.219	2.0	.077	142°	H9
12.80	.503		870-1280-11-MM	★	☆	5.5	.218	2.0	.078	142°	H9
12.90	.507		870-1290-11-MM	★	☆	5.5	.217	2.0	.078	142°	H9
13.00	.511	12	870-1300-12-MM	★	☆	6.0	.237	2.0	.078	142°	H9
13.10	.515		870-1310-12-MM	★	☆	6.0	.236	2.0	.079	142°	H9
13.20	.519		870-1320-12-MM	★	☆	6.0	.235	2.0	.080	142°	H9
13.30	.523		870-1330-12-MM	★	☆	6.0	.235	2.0	.080	142°	H9
13.40	.527		870-1340-12-MM	★	☆	5.9	.234	2.1	.081	142°	H9
13.50	.531	13	870-1350-13-MM	★	☆	5.9	.233	2.1	.082	142°	H9
13.60	.535		870-1360-13-MM	★	☆	5.9	.233	2.1	.082	142°	H9
13.70	.539		870-1370-13-MM	★	☆	5.9	.232	2.1	.083	142°	H9
13.80	.543		870-1380-13-MM	★	☆	5.9	.231	2.1	.084	142°	H9
13.90	.547		870-1390-13-MM	★	☆	5.9	.231	2.1	.084	142°	H9
14.00	.551	14	870-1400-14-MM	★	☆	6.6	.259	2.1	.084	142°	H9
14.10	.555		870-1410-14-MM	★	☆	6.6	.258	2.2	.085	142°	H9
14.20	.559		870-1420-14-MM	★	☆	6.5	.257	2.2	.085	142°	H9
14.29	.562		870-1429-14-MM	★	☆	6.5	.257	2.2	.086	142°	H9
14.30	.563		870-1430-14-MM	★	☆	6.5	.257	2.2	.086	142°	H9
14.40	.566		870-1440-14-MM	★	☆	6.5	.256	2.2	.087	142°	H9
14.50	.570		870-1450-14-MM	★	☆	6.5	.255	2.2	.087	142°	H9
14.60	.574		870-1460-14-MM	★	☆	6.5	.255	2.2	.088	142°	H9
14.70	.578		870-1470-14-MM	★	☆	6.5	.254	2.3	.089	142°	H9
14.80	.582		870-1480-14-MM	★	☆	6.4	.253	2.3	.089	142°	H9
14.90	.586		870-1490-14-MM	★	☆	6.4	.253	2.3	.090	142°	H9
15.00	.590	15	870-1500-15-MM	★	☆	7.0	.276	2.3	.090	142°	H9
15.10	.594		870-1510-15-MM	★	☆	7.0	.276	2.3	.091	142°	H9
15.20	.598		870-1520-15-MM	★	☆	7.0	.275	2.3	.091	142°	H9
15.30	.602		870-1530-15-MM	★	☆	7.0	.274	2.3	.092	142°	H9

102 150

ENG

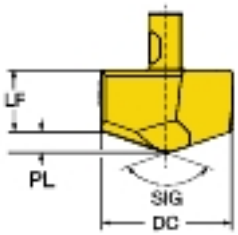
CoroDrill® 870 drill tip



DC	DC"		Ordering code	M 2334	S 2334	LF	LF"	PL	PL"	SIG	TCHA
				Dimensions, mm, inch							
15.40	.606	15	870-1540-15-MM	★	☆	7.0	.274	2.4	.093	142°	H9
15.50	.610		870-1550-15-MM	★	☆	6.9	.273	2.4	.093	142°	H9
15.60	.614		870-1560-15-MM	★	☆	6.9	.272	2.4	.094	142°	H9
15.70	.618		870-1570-15-MM	★	☆	6.9	.272	2.4	.094	142°	H9
15.80	.622		870-1580-15-MM	★	☆	6.9	.271	2.4	.095	142°	H9
15.88	.625		870-1588-15-MM	★	☆	6.9	.270	2.4	.096	142°	H9
15.90	.626		870-1590-15-MM	★	☆	6.9	.270	2.4	.096	142°	H9
16.00	.629	16	870-1600-16-MM	★	☆	7.6	.298	2.4	.096	142°	H9
16.10	.633		870-1610-16-MM	★	☆	7.6	.298	2.4	.096	142°	H9
16.13	.635		870-1613-16-MM	★	☆	7.6	.297	2.5	.096	142°	H9
16.20	.637		870-1620-16-MM	★	☆	7.5	.297	2.5	.097	142°	H9
16.30	.641		870-1630-16-MM	★	☆	7.5	.296	2.5	.098	142°	H9
16.40	.645		870-1640-16-MM	★	☆	7.5	.296	2.5	.098	142°	H9
16.50	.649		870-1650-16-MM	★	☆	7.5	.295	2.5	.099	142°	H9
16.60	.653		870-1660-16-MM	★	☆	7.5	.294	2.5	.100	142°	H9
16.70	.657		870-1670-16-MM	★	☆	7.5	.294	2.5	.100	142°	H9
16.80	.661		870-1680-16-MM	★	☆	7.4	.293	2.6	.101	142°	H9
16.90	.665		870-1690-16-MM	★	☆	7.4	.292	2.6	.102	142°	H9
17.00	.669	17	870-1700-17-MM	★	☆	8.0	.316	2.6	.102	142°	H9
17.10	.673		870-1710-17-MM	★	☆	8.0	.315	2.6	.102	142°	H9
17.20	.677		870-1720-17-MM	★	☆	8.0	.315	2.6	.103	142°	H9
17.30	.681		870-1730-17-MM	★	☆	8.0	.314	2.6	.104	142°	H9
17.40	.685		870-1740-17-MM	★	☆	8.0	.313	2.7	.104	142°	H9
17.46	.687		870-1746-17-MM	★	☆	7.9	.313	2.7	.105	142°	H9
17.50	.689		870-1750-17-MM	★	☆	7.9	.313	2.7	.105	142°	H9
17.60	.692		870-1760-17-MM	★	☆	7.9	.312	2.7	.106	142°	H9
17.70	.696		870-1770-17-MM	★	☆	7.9	.311	2.7	.106	142°	H9
17.80	.700		870-1780-17-MM	★	☆	7.9	.311	2.7	.107	142°	H9
17.90	.704		870-1790-17-MM	★	☆	7.9	.310	2.7	.107	142°	H9
18.00	.708	18	870-1800-18-MM	★	☆	8.6	.338	2.7	.107	142°	H9
18.10	.712		870-1810-18-MM	★	☆	8.6	.337	2.7	.108	142°	H9
18.20	.716		870-1820-18-MM	★	☆	8.6	.337	2.8	.108	142°	H9
18.30	.720		870-1830-18-MM	★	☆	8.5	.336	2.8	.109	142°	H9
18.40	.724		870-1840-18-MM	★	☆	8.5	.335	2.8	.110	142°	H9
18.50	.728		870-1850-18-MM	★	☆	8.5	.335	2.8	.110	142°	H9
18.60	.732		870-1860-18-MM	★	☆	8.5	.334	2.8	.111	142°	H9
18.70	.736		870-1870-18-MM	★	☆	8.5	.333	2.8	.112	142°	H9
18.80	.740		870-1880-18-MM	★	☆	8.5	.333	2.9	.112	142°	H9
18.90	.744		870-1890-18-MM	★	☆	8.4	.332	2.9	.113	142°	H9
19.00	.748	19	870-1900-19-MM	★	☆	9.0	.356	2.9	.113	142°	H9
19.05	.750		870-1905-19-MM	★	☆	9.0	.355	2.9	.113	142°	H9
19.10	.752		870-1910-19-MM	★	☆	9.0	.355	2.9	.114	142°	H9
19.20	.755		870-1920-19-MM	★	☆	9.0	.354	2.9	.115	142°	H9
19.25	.757		870-1925-19-MM	★	☆	9.0	.354	2.9	.115	142°	H9
19.30	.759		870-1930-19-MM	★	☆	9.0	.354	2.9	.115	142°	H9
19.40	.763		870-1940-19-MM	★	☆	9.0	.353	2.9	.116	142°	H9
19.50	.767		870-1950-19-MM	★	☆	8.9	.352	3.0	.117	142°	H9
19.60	.771		870-1960-19-MM	★	☆	8.9	.352	3.0	.117	142°	H9
19.70	.775		870-1970-19-MM	★	☆	8.9	.351	3.0	.118	142°	H9
19.80	.779		870-1980-19-MM	★	☆	8.9	.350	3.0	.119	142°	H9
19.90	.783		870-1990-19-MM	★	☆	8.9	.350	3.0	.119	142°	H9
20.00	.787	20	870-2000-20-MM	★	☆	9.5	.373	3.0	.119	142°	H9
20.10	.791		870-2010-20-MM	★	☆	9.5	.372	3.0	.120	142°	H9
20.20	.795		870-2020-20-MM	★	☆	9.4	.372	3.1	.120	142°	H9
20.30	.799		870-2030-20-MM	★	☆	9.4	.371	3.1	.121	142°	H9
20.40	.803		870-2040-20-MM	★	☆	9.4	.370	3.1	.122	142°	H9

102 150

CoroDrill® 870 drill tip

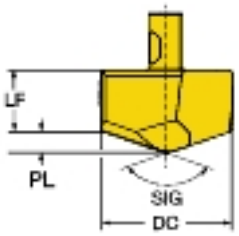


DC	DC"		Ordering code	M 2334	S 2334	LF	LF"	PL	PL"	SIG	TCHA
				Dimensions, mm, inch							
20.50	.807	20	870-2050-20-MM	★	☆	9.4	.370	3.1	.122	142°	H9
20.60	.811		870-2060-20-MM	★	☆	9.4	.369	3.1	.123	142°	H9
20.64	.812		870-2064-20-MM	★	☆	9.4	.369	3.1	.123	142°	H9
20.70	.815		870-2070-20-MM	★	☆	9.4	.369	3.1	.124	142°	H9
20.80	.818		870-2080-20-MM	★	☆	9.3	.368	3.2	.124	142°	H9
20.90	.822		870-2090-20-MM	★	☆	9.3	.367	3.2	.125	142°	H9
21.00	.826	21	870-2100-21-MM	★	☆	10.0	.395	3.2	.124	142°	H9
21.10	.830		870-2110-21-MM	★	☆	10.0	.394	3.2	.125	142°	H9
21.20	.834		870-2120-21-MM	★	☆	10.0	.394	3.2	.126	142°	H9
21.30	.838		870-2130-21-MM	★	☆	10.0	.393	3.2	.126	142°	H9
21.40	.842		870-2140-21-MM	★	☆	10.0	.393	3.2	.127	142°	H9
21.50	.846		870-2150-21-MM	★	☆	10.0	.392	3.3	.128	142°	H9
21.60	.850		870-2160-21-MM	★	☆	9.9	.391	3.3	.129	142°	H9
21.70	.854		870-2170-21-MM	★	☆	9.9	.391	3.3	.129	142°	H9
21.80	.858		870-2180-21-MM	★	☆	9.9	.390	3.3	.130	142°	H9
21.90	.862		870-2190-21-MM	★	☆	9.9	.389	3.3	.131	142°	H9
22.00	.866	22	870-2200-22-MM	★	☆	10.5	.413	3.3	.131	142°	H9
22.10	.870		870-2210-22-MM	★	☆	10.5	.412	3.3	.131	142°	H9
22.20	.874		870-2220-22-MM	★	☆	10.5	.411	3.4	.132	142°	H9
22.23	.875		870-2223-22-MM	★	☆	10.5	.411	3.4	.132	142°	H9
22.30	.878		870-2230-22-MM	★	☆	10.4	.411	3.4	.133	142°	H9
22.40	.881		870-2240-22-MM	★	☆	10.4	.410	3.4	.133	142°	H9
22.50	.885		870-2250-22-MM	★	☆	10.4	.409	3.4	.134	142°	H9
22.60	.889		870-2260-22-MM	★	☆	10.4	.409	3.4	.135	142°	H9
22.70	.893		870-2270-22-MM	★	☆	10.4	.408	3.4	.135	142°	H9
22.80	.897		870-2280-22-MM	★	☆	10.4	.407	3.5	.136	142°	H9
22.90	.901		870-2290-22-MM	★	☆	10.3	.407	3.5	.137	142°	H9
23.00	.905	23	870-2300-23-MM	★	☆	11.0	.435	3.5	.136	142°	H9
23.10	.909		870-2310-23-MM	★	☆	11.0	.434	3.5	.137	142°	H9
23.20	.913		870-2320-23-MM	★	☆	11.0	.433	3.5	.137	142°	H9
23.30	.917		870-2330-23-MM	★	☆	11.0	.433	3.5	.138	142°	H9
23.40	.921		870-2340-23-MM	★	☆	11.0	.432	3.5	.139	142°	H9
23.50	.925		870-2350-23-MM	★	☆	11.0	.431	3.5	.139	142°	H9
23.60	.929		870-2360-23-MM	★	☆	10.9	.431	3.6	.140	142°	H9
23.70	.933		870-2370-23-MM	★	☆	10.9	.430	3.6	.141	142°	H9
23.80	.937		870-2380-23-MM	★	☆	10.9	.430	3.6	.141	142°	H9
23.81	.937		870-2381-23-MM	★	☆	10.9	.430	3.6	.141	142°	H9
23.90	.940		870-2390-23-MM	★	☆	10.9	.429	3.6	.142	142°	H9
24.00	.944	24	870-2400-24-MM	★	☆	11.4	.448	3.6	.143	142°	H9
24.10	.948		870-2410-24-MM	★	☆	11.4	.447	3.6	.143	142°	H9
24.20	.952		870-2420-24-MM	★	☆	11.4	.447	3.7	.144	142°	H9
24.30	.956		870-2430-24-MM	★	☆	11.3	.446	3.7	.144	142°	H9
24.40	.960		870-2440-24-MM	★	☆	11.3	.445	3.7	.145	142°	H9
24.50	.964		870-2450-24-MM	★	☆	11.3	.445	3.7	.146	142°	H9
24.60	.968		870-2460-24-MM	★	☆	11.3	.444	3.7	.146	142°	H9
24.70	.972		870-2470-24-MM	★	☆	11.3	.443	3.7	.147	142°	H9
24.80	.976		870-2480-24-MM	★	☆	11.3	.443	3.8	.148	142°	H9
24.90	.980		870-2490-24-MM	★	☆	11.2	.442	3.8	.148	142°	H9
25.00	.984	25	870-2500-25-MM	★	☆	11.9	.470	3.8	.148	142°	H9
25.10	.988		870-2510-25-MM	★	☆	11.9	.469	3.8	.149	142°	H9
25.20	.992		870-2520-25-MM	★	☆	11.9	.469	3.8	.149	142°	H9
25.30	.996		870-2530-25-MM	★	☆	11.9	.468	3.8	.150	142°	H9
25.40	1.000		870-2540-25-MM	★	☆	11.9	.467	3.8	.151	142°	H9
25.50	1.003		870-2550-25-MM	★	☆	11.9	.467	3.8	.151	142°	H9
25.60	1.007		870-2560-25-MM	★	☆	11.8	.466	3.9	.152	142°	H9
25.70	1.011		870-2570-25-MM	★	☆	11.8	.465	3.9	.153	142°	H9

102 150

ENG

CoroDrill® 870 drill tip

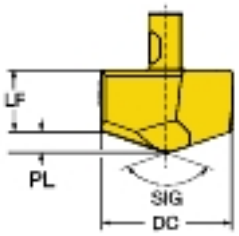


DC	DC"		Ordering code	M 2334	S 2334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
25.80	1.015	25	870-2580-25-MM	★	☆	11.8	.465	3.9	.153	142°	H9
25.90	1.019		870-2590-25-MM	★	☆	11.8	.464	3.9	.154	142°	H9
26.00	1.023	26	870-2600-26-MM	★	☆	12.5	.492	3.9	.154	142°	H9
26.50	1.043		870-2650-26-MM	★	☆	12.4	.489	4.0	.157	142°	H9
26.65	1.049		870-2665-26-MM	★	☆	12.4	.487	4.0	.159	142°	H9
27.00	1.063	27	870-2700-27-MM	★	☆	13.0	.510	4.1	.159	142°	H9
27.50	1.082		870-2750-27-MM	★	☆	12.9	.506	4.1	.163	142°	H9
28.00	1.102	28	870-2800-28-MM	★	☆	13.4	.527	4.2	.166	142°	H9
28.50	1.122		870-2850-28-MM	★	☆	13.3	.524	4.3	.169	142°	H9
28.58	1.125		870-2858-28-MM	★	☆	13.3	.523	4.3	.170	142°	H9
29.00	1.141	29	870-2900-29-MM	★	☆	13.9	.549	4.4	.172	142°	H9
29.50	1.161		870-2950-29-MM	★	☆	13.9	.545	4.5	.175	142°	H9
29.65	1.167		870-2965-29-MM	★	☆	13.8	.544	4.5	.176	142°	H9
30.00	1.181	30	870-3000-30-MM	★	☆	14.4	.566	4.5	.178	142°	H9
30.50	1.200		870-3050-30-MM	★	☆	14.3	.563	4.6	.181	142°	H9
31.00	1.220	31	870-3100-31-MM	★	☆	14.8	.581	4.8	.187	142°	H9
31.50	1.240		870-3150-31-MM	★	☆	14.7	.578	4.8	.190	142°	H9
31.75	1.250		870-3175-31-MM	★	☆	14.6	.576	4.9	.192	142°	H9
32.00	1.259		870-3200-31-MM	★	☆	14.6	.574	4.9	.194	142°	H9
32.15	1.265		870-3215-31-MM	★	☆	14.6	.573	5.0	.195	142°	H9
32.50	1.279		870-3250-31-MM	★	☆	14.5	.571	5.0	.197	142°	H9
33.00	1.299		870-3300-31-MM	★	☆	14.4	.568	5.1	.200	142°	H9

102 150

CoroDrill® 870 drill tip

For pilot holes



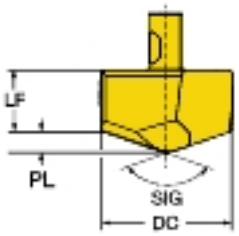
DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
10.00	.393	6	870-1000-6-GP	★	★	★	☆	☆	4.6	.181	1.1	.043	152°	F9
10.10	.397		870-1010-6-GP	★	★	★	☆	☆	4.6	.181	1.1	.043	152°	F9
10.20	.401		870-1020-6-GP	★	★	★	☆	☆	4.6	.180	1.1	.044	152°	F9
10.30	.405		870-1030-6-GP	★	★	★	☆	☆	4.6	.180	1.1	.044	152°	F9
10.40	.409		870-1040-6-GP	★	★	★	☆	☆	4.6	.180	1.1	.045	152°	F9
10.50	.413	7	870-1050-7-GP	★	★	★	☆	☆	4.6	.179	1.2	.045	152°	F9
10.60	.417		870-1060-7-GP	★	★	★	☆	☆	4.6	.179	1.2	.045	152°	F9
10.70	.421		870-1070-7-GP	★	★	★	☆	☆	4.5	.179	1.2	.046	152°	F9
10.80	.425		870-1080-7-GP	★	★	★	☆	☆	4.5	.178	1.2	.046	152°	F9
10.90	.429		870-1090-7-GP	★	★	★	☆	☆	4.5	.178	1.2	.046	152°	F9
11.00	.433	8	870-1100-8-GP	★	★	★	☆	☆	5.2	.206	1.2	.046	152°	F9
11.10	.437		870-1110-8-GP	★	★	★	☆	☆	5.2	.205	1.2	.047	152°	F9
11.11	.437		870-1111-8-GP	★	★	★	☆	☆	5.2	.205	1.2	.047	152°	F9
11.20	.440		870-1120-8-GP	★	★	★	☆	☆	5.2	.204	1.2	.048	152°	F9
11.30	.444		870-1130-8-GP	★	★	★	☆	☆	5.2	.204	1.2	.048	152°	F9
11.40	.448		870-1140-8-GP	★	★	★	☆	☆	5.2	.204	1.2	.048	152°	F9
11.50	.452	9	870-1150-9-GP	★	★	★	☆	☆	5.2	.203	1.2	.049	152°	F9
11.60	.456		870-1160-9-GP	★	★	★	☆	☆	5.2	.203	1.3	.049	152°	F9
11.70	.460		870-1170-9-GP	★	★	★	☆	☆	5.1	.202	1.3	.050	152°	F9
11.80	.464		870-1180-9-GP	★	★	★	☆	☆	5.1	.202	1.3	.050	152°	F9
11.90	.468		870-1190-9-GP	★	★	★	☆	☆	5.1	.202	1.3	.050	152°	F9
12.00	.472	10	870-1200-10-GP	★	★	★	☆	☆	5.7	.225	1.3	.051	152°	F9
12.10	.476		870-1210-10-GP	★	★	★	☆	☆	5.7	.224	1.3	.051	152°	F9
12.20	.480		870-1220-10-GP	★	★	★	☆	☆	5.7	.224	1.3	.052	152°	F9
12.30	.484		870-1230-10-GP	★	★	★	☆	☆	5.7	.224	1.3	.052	152°	F9
12.40	.488		870-1240-10-GP	★	★	★	☆	☆	5.7	.223	1.3	.052	152°	F9
12.50	.492	11	870-1250-11-GP	★	★	★	☆	☆	5.7	.223	1.3	.053	152°	F9
12.60	.496		870-1260-11-GP	★	★	★	☆	☆	5.6	.222	1.4	.054	152°	F9
12.70	.500		870-1270-11-GP	★	★	★	☆	☆	5.6	.222	1.4	.054	152°	F9
12.80	.503		870-1280-11-GP	★	★	★	☆	☆	5.6	.221	1.4	.054	152°	F9
12.90	.507		870-1290-11-GP	★	★	★	☆	☆	5.6	.221	1.4	.055	152°	F9
13.00	.511	12	870-1300-12-GP	★	★	★	☆	☆	6.1	.240	1.4	.055	152°	F9
13.10	.515		870-1310-12-GP	★	★	★	☆	☆	6.1	.240	1.4	.056	152°	F9
13.20	.519		870-1320-12-GP	★	★	★	☆	☆	6.1	.239	1.4	.056	152°	F9
13.30	.523		870-1330-12-GP	★	★	★	☆	☆	6.1	.239	1.4	.056	152°	F9
13.40	.527		870-1340-12-GP	★	★	★	☆	☆	6.1	.239	1.4	.057	152°	F9
13.50	.531	13	870-1350-13-GP	★	★	★	☆	☆	6.1	.238	1.5	.057	152°	F9
13.60	.535		870-1360-13-GP	★	★	★	☆	☆	6.0	.238	1.5	.057	152°	F9
13.70	.539		870-1370-13-GP	★	★	★	☆	☆	6.0	.237	1.5	.058	152°	F9
13.80	.543		870-1380-13-GP	★	★	★	☆	☆	6.0	.237	1.5	.058	152°	F9
13.90	.547		870-1390-13-GP	★	★	★	☆	☆	6.0	.237	1.5	.058	152°	F9
14.00	.551	14	870-1400-14-GP	★	★	★	☆	☆	6.7	.264	1.5	.059	152°	F9
14.10	.555		870-1410-14-GP	★	★	★	☆	☆	6.7	.264	1.5	.059	152°	F9
14.20	.559		870-1420-14-GP	★	★	★	☆	☆	6.7	.263	1.5	.059	152°	F9
14.29	.562		870-1429-14-GP	★	★	★	☆	☆	6.7	.263	1.5	.060	152°	F9
14.30	.563		870-1430-14-GP	★	★	★	☆	☆	6.7	.263	1.5	.060	152°	F9
14.40	.566		870-1440-14-GP	★	★	★	☆	☆	6.7	.262	1.5	.061	152°	F9
14.50	.570		870-1450-14-GP	★	★	★	☆	☆	6.7	.262	1.6	.061	152°	F9
14.60	.574		870-1460-14-GP	★	★	★	☆	☆	6.6	.261	1.6	.061	152°	F9
14.70	.578		870-1470-14-GP	★	★	★	☆	☆	6.6	.261	1.6	.062	152°	F9
14.80	.582		870-1480-14-GP	★	★	★	☆	☆	6.6	.261	1.6	.062	152°	F9
14.90	.586		870-1490-14-GP	★	★	★	☆	☆	6.6	.260	1.6	.063	152°	F9
15.00	.590	15	870-1500-15-GP	★	★	★	☆	☆	7.2	.284	1.6	.063	152°	F9
15.10	.594		870-1510-15-GP	★	★	★	☆	☆	7.2	.283	1.6	.063	152°	F9
15.20	.598		870-1520-15-GP	★	★	★	☆	☆	7.2	.283	1.6	.063	152°	F9
15.30	.602		870-1530-15-GP	★	★	★	☆	☆	7.2	.282	1.6	.064	152°	F9

102 150

ENG

CoroDrill® 870 drill tip

For pilot holes

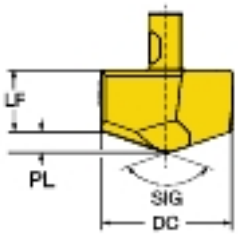


DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
15.40	.606	15	870-1540-15-GP	★	★	★	☆	☆	7.2	.282	1.6	.065	152°	F9
15.50	.610		870-1550-15-GP	★	★	★	☆	☆	7.2	.281	1.7	.065	152°	F9
15.60	.614		870-1560-15-GP	★	★	★	☆	☆	7.1	.281	1.7	.065	152°	F9
15.70	.618		870-1570-15-GP	★	★	★	☆	☆	7.1	.281	1.7	.065	152°	F9
15.80	.622		870-1580-15-GP	★	★	★	☆	☆	7.1	.281	1.7	.066	152°	F9
15.88	.625		870-1588-15-GP	★	★	★	☆	☆	7.1	.280	1.7	.066	152°	F9
15.90	.626		870-1590-15-GP	★	★	★	☆	☆	7.1	.280	1.7	.067	152°	F9
16.00	.629	16	870-1600-16-GP	★	★	★	☆	☆	7.8	.307	1.7	.067	152°	F9
16.10	.633		870-1610-16-GP	★	★	★	☆	☆	7.8	.307	1.7	.067	152°	F9
16.13	.635		870-1613-16-GP	★	★	★	☆	☆	7.8	.307	1.7	.067	152°	F9
16.20	.637		870-1620-16-GP	★	★	★	☆	☆	7.8	.306	1.7	.068	152°	F9
16.30	.641		870-1630-16-GP	★	★	★	☆	☆	7.8	.306	1.7	.068	152°	F9
16.40	.645		870-1640-16-GP	★	★	★	☆	☆	7.8	.306	1.7	.069	152°	F9
16.50	.649		870-1650-16-GP	★	★	★	☆	☆	7.8	.305	1.8	.069	152°	F9
16.60	.653		870-1660-16-GP	★	★	★	☆	☆	7.7	.305	1.8	.069	152°	F9
16.70	.657		870-1670-16-GP	★	★	★	☆	☆	7.7	.304	1.8	.070	152°	F9
16.80	.661		870-1680-16-GP	★	★	★	☆	☆	7.7	.304	1.8	.070	152°	F9
16.90	.665		870-1690-16-GP	★	★	★	☆	☆	7.7	.304	1.8	.070	152°	F9
17.00	.669	17	870-1700-17-GP	★	★	★	☆	☆	8.2	.323	1.8	.070	152°	F9
17.10	.673		870-1710-17-GP	★	★	★	☆	☆	8.2	.323	1.8	.071	152°	F9
17.20	.677		870-1720-17-GP	★	★	★	☆	☆	8.2	.322	1.8	.071	152°	F9
17.30	.681		870-1730-17-GP	★	★	★	☆	☆	8.2	.322	1.8	.072	152°	F9
17.40	.685		870-1740-17-GP	★	★	★	☆	☆	8.2	.322	1.8	.072	152°	F9
17.46	.687		870-1746-17-GP	★	★	★	☆	☆	8.2	.321	1.8	.072	152°	F9
17.50	.689		870-1750-17-GP	★	★	★	☆	☆	8.2	.321	1.9	.073	152°	F9
17.60	.692		870-1760-17-GP	★	★	★	☆	☆	8.1	.320	1.9	.073	152°	F9
17.70	.696		870-1770-17-GP	★	★	★	☆	☆	8.1	.320	1.9	.074	152°	F9
17.80	.700		870-1780-17-GP	★	★	★	☆	☆	8.1	.320	1.9	.074	152°	F9
17.90	.704		870-1790-17-GP	★	★	★	☆	☆	8.1	.320	1.9	.074	152°	F9
18.00	.708	18	870-1800-18-GP	★	★	★	☆	☆	8.8	.347	1.9	.074	152°	F9
18.10	.712		870-1810-18-GP	★	★	★	☆	☆	8.8	.346	1.9	.075	152°	F9
18.20	.716		870-1820-18-GP	★	★	★	☆	☆	8.8	.346	1.9	.075	152°	F9
18.30	.720		870-1830-18-GP	★	★	★	☆	☆	8.8	.346	1.9	.076	152°	F9
18.40	.724		870-1840-18-GP	★	★	★	☆	☆	8.8	.345	1.9	.076	152°	F9
18.50	.728		870-1850-18-GP	★	★	★	☆	☆	8.8	.345	1.9	.076	152°	F9
18.60	.732		870-1860-18-GP	★	★	★	☆	☆	8.8	.344	2.0	.077	152°	F9
18.70	.736		870-1870-18-GP	★	★	★	☆	☆	8.7	.344	2.0	.077	152°	F9
18.80	.740		870-1880-18-GP	★	★	★	☆	☆	8.7	.344	2.0	.078	152°	F9
18.90	.744		870-1890-18-GP	★	★	★	☆	☆	8.7	.343	2.0	.078	152°	F9
19.00	.748	19	870-1900-19-GP	★	★	★	☆	☆	9.2	.363	2.0	.078	152°	F9
19.05	.750		870-1905-19-GP	★	★	★	☆	☆	9.2	.363	2.0	.078	152°	F9
19.10	.752		870-1910-19-GP	★	★	★	☆	☆	9.2	.362	2.0	.079	152°	F9
19.20	.755		870-1920-19-GP	★	★	★	☆	☆	9.2	.362	2.0	.079	152°	F9
19.25	.757		870-1925-19-GP	★	★	★	☆	☆	9.2	.361	2.0	.080	152°	F9
19.30	.759		870-1930-19-GP	★	★	★	☆	☆	9.2	.361	2.0	.080	152°	F9
19.40	.763		870-1940-19-GP	★	★	★	☆	☆	9.2	.361	2.0	.080	152°	F9
19.50	.767		870-1950-19-GP	★	★	★	☆	☆	9.2	.360	2.1	.081	152°	F9
19.60	.771		870-1960-19-GP	★	★	★	☆	☆	9.1	.360	2.1	.081	152°	F9
19.70	.775		870-1970-19-GP	★	★	★	☆	☆	9.1	.360	2.1	.081	152°	F9
19.80	.779		870-1980-19-GP	★	★	★	☆	☆	9.1	.359	2.1	.081	152°	F9
19.90	.783		870-1990-19-GP	★	★	★	☆	☆	9.1	.359	2.1	.082	152°	F9
20.00	.787	20	870-2000-20-GP	★	★	★	☆	☆	9.7	.382	2.1	.082	152°	F9
20.10	.791		870-2010-20-GP	★	★	★	☆	☆	9.7	.382	2.1	.083	152°	F9
20.20	.795		870-2020-20-GP	★	★	★	☆	☆	9.7	.381	2.1	.083	152°	F9
20.30	.799		870-2030-20-GP	★	★	★	☆	☆	9.7	.381	2.1	.084	152°	F9
20.40	.803		870-2040-20-GP	★	★	★	☆	☆	9.7	.380	2.1	.084	152°	F9

102 150

CoroDrill® 870 drill tip

For pilot holes



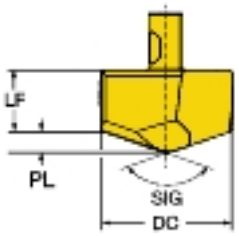
DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
20.50	.807	20	870-2050-20-GP	★	★	★	☆	☆	9.7	.380	2.2	.085	152°	F9
20.60	.811		870-2060-20-GP	★	★	★	☆	☆	9.7	.380	2.2	.085	152°	F9
20.64	.812		870-2064-20-GP	★	★	★	☆	☆	9.6	.380	2.2	.085	152°	F9
20.70	.815		870-2070-20-GP	★	★	★	☆	☆	9.6	.379	2.2	.085	152°	F9
20.80	.818		870-2080-20-GP	★	★	★	☆	☆	9.6	.379	2.2	.086	152°	F9
20.90	.822		870-2090-20-GP	★	★	★	☆	☆	9.6	.378	2.2	.086	152°	F9
21.00	.826	21	870-2100-21-GP	★	★	★	☆	☆	10.3	.406	2.2	.086	152°	F9
21.10	.830		870-2110-21-GP	★	★	★	☆	☆	10.3	.406	2.2	.087	152°	F9
21.20	.834		870-2120-21-GP	★	★	★	☆	☆	10.3	.405	2.2	.087	152°	F9
21.30	.838		870-2130-21-GP	★	★	★	☆	☆	10.3	.405	2.2	.087	152°	F9
21.40	.842		870-2140-21-GP	★	★	★	☆	☆	10.3	.404	2.2	.088	152°	F9
21.50	.846		870-2150-21-GP	★	★	★	☆	☆	10.3	.404	2.2	.088	152°	F9
21.60	.850		870-2160-21-GP	★	★	★	☆	☆	10.3	.404	2.3	.089	152°	F9
21.70	.854		870-2170-21-GP	★	★	★	☆	☆	10.2	.403	2.3	.089	152°	F9
21.80	.858		870-2180-21-GP	★	★	★	☆	☆	10.2	.403	2.3	.089	152°	F9
21.90	.862		870-2190-21-GP	★	★	★	☆	☆	10.2	.402	2.3	.090	152°	F9
22.00	.866	22	870-2200-22-GP	★	★	★	☆	☆	10.8	.426	2.3	.090	152°	F9
22.10	.870		870-2210-22-GP	★	★	★	☆	☆	10.8	.425	2.3	.091	152°	F9
22.20	.874		870-2220-22-GP	★	★	★	☆	☆	10.8	.425	2.3	.091	152°	F9
22.23	.875		870-2223-22-GP	★	★	★	☆	☆	10.8	.424	2.3	.091	152°	F9
22.30	.878		870-2230-22-GP	★	★	★	☆	☆	10.8	.424	2.3	.092	152°	F9
22.40	.881		870-2240-22-GP	★	★	★	☆	☆	10.8	.424	2.3	.092	152°	F9
22.50	.885		870-2250-22-GP	★	★	★	☆	☆	10.8	.423	2.4	.093	152°	F9
22.60	.889		870-2260-22-GP	★	★	★	☆	☆	10.7	.423	2.4	.093	152°	F9
22.70	.893		870-2270-22-GP	★	★	★	☆	☆	10.7	.423	2.4	.093	152°	F9
22.80	.897		870-2280-22-GP	★	★	★	☆	☆	10.7	.422	2.4	.093	152°	F9
22.90	.901		870-2290-22-GP	★	★	★	☆	☆	10.7	.422	2.4	.094	152°	F9
23.00	.905	23	870-2300-23-GP	★	★	★	☆	☆	11.4	.450	2.4	.094	152°	F9
23.10	.909		870-2310-23-GP	★	★	★	☆	☆	11.4	.449	2.4	.094	152°	F9
23.20	.913		870-2320-23-GP	★	★	★	☆	☆	11.4	.448	2.4	.095	152°	F9
23.30	.917		870-2330-23-GP	★	★	★	☆	☆	11.4	.448	2.4	.095	152°	F9
23.40	.921		870-2340-23-GP	★	★	★	☆	☆	11.4	.448	2.4	.096	152°	F9
23.50	.925		870-2350-23-GP	★	★	★	☆	☆	11.4	.447	2.4	.096	152°	F9
23.60	.929		870-2360-23-GP	★	★	★	☆	☆	11.4	.447	2.4	.096	152°	F9
23.70	.933		870-2370-23-GP	★	★	★	☆	☆	11.4	.447	2.5	.096	152°	F9
23.80	.937		870-2380-23-GP	★	★	★	☆	☆	11.3	.446	2.5	.097	152°	F9
23.81	.937		870-2381-23-GP	★	★	★	☆	☆	11.3	.446	2.5	.097	152°	F9
23.90	.940		870-2390-23-GP	★	★	★	☆	☆	11.3	.446	2.5	.098	152°	F9
24.00	.944	24	870-2400-24-GP	★	★	★	☆	☆	11.8	.465	2.5	.098	152°	F9
24.10	.948		870-2410-24-GP	★	★	★	☆	☆	11.8	.464	2.5	.099	152°	F9
24.20	.952		870-2420-24-GP	★	★	★	☆	☆	11.8	.464	2.5	.099	152°	F9
24.30	.956		870-2430-24-GP	★	★	★	☆	☆	11.8	.463	2.5	.100	152°	F9
24.40	.960		870-2440-24-GP	★	★	★	☆	☆	11.8	.463	2.6	.100	152°	F9
24.50	.964		870-2450-24-GP	★	★	★	☆	☆	11.7	.462	2.6	.101	152°	F9
24.60	.968		870-2460-24-GP	★	★	★	☆	☆	11.7	.461	2.6	.102	152°	F9
24.70	.972		870-2470-24-GP	★	★	★	☆	☆	11.7	.461	2.6	.102	152°	F9
24.80	.976		870-2480-24-GP	★	★	★	☆	☆	11.7	.460	2.6	.103	152°	F9
24.90	.980		870-2490-24-GP	★	★	★	☆	☆	11.7	.460	2.6	.103	152°	F9
25.00	.984	25	870-2500-25-GP	★	★	★	☆	☆	12.3	.483	2.6	.104	152°	F9
25.10	.988		870-2510-25-GP	★	★	★	☆	☆	12.3	.482	2.7	.104	152°	F9
25.20	.992		870-2520-25-GP	★	★	★	☆	☆	12.2	.481	2.7	.105	152°	F9
25.30	.996		870-2530-25-GP	★	★	★	☆	☆	12.2	.481	2.7	.106	152°	F9
25.40	1.000		870-2540-25-GP	★	★	★	☆	☆	12.2	.480	2.7	.106	152°	F9
25.50	1.003		870-2550-25-GP	★	★	★	☆	☆	12.2	.480	2.7	.107	152°	F9
25.60	1.007		870-2560-25-GP	★	★	★	☆	☆	12.2	.480	2.7	.107	152°	F9
25.70	1.011		870-2570-25-GP	★	★	★	☆	☆	12.2	.479	2.7	.108	152°	F9

102 150

ENG

CoroDrill® 870 drill tip

For pilot holes



DC	DC"		Ordering code	P 4334	M 4334	K 4334	N 4334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
25.80	1.015	25	870-2580-25-GP	★	★	★	☆	☆	12.1	.478	2.8	.109	152°	F9
25.90	1.019		870-2590-25-GP	★	★	★	☆	☆	12.1	.478	2.8	.109	152°	F9
26.00	1.023	26	870-2600-26-GP	★	★	★	☆	☆	12.9	.507	2.7	.107	152°	F9
26.50	1.043		870-2650-26-GP	★	★	★	☆	☆	12.8	.505	2.8	.109	152°	F9
26.65	1.049		870-2665-26-GP	★	★	★	☆	☆	12.8	.504	2.8	.110	152°	F9
27.00	1.063	27	870-2700-27-GP	★	★	★	☆	☆	13.3	.522	2.8	.111	152°	F9
27.50	1.082		870-2750-27-GP	★	★	★	☆	☆	13.2	.520	2.9	.114	152°	F9
28.00	1.102	28	870-2800-28-GP	★	★	★	☆	☆	13.8	.542	2.9	.116	152°	F9
28.50	1.122		870-2850-28-GP	★	★	★	☆	☆	13.7	.540	3.0	.118	152°	F9
28.58	1.125		870-2858-28-GP	★	★	★	☆	☆	13.7	.539	3.0	.118	152°	F9
29.00	1.141	29	870-2900-29-GP	★	★	★	☆	☆	14.3	.561	3.0	.120	152°	F9
29.50	1.161		870-2950-29-GP	★	★	★	☆	☆	14.2	.559	3.1	.122	152°	F9
29.65	1.167		870-2965-29-GP	★	★	★	☆	☆	14.2	.559	3.1	.122	152°	F9
30.00	1.181	30	870-3000-30-GP	★	★	★	☆	☆	14.7	.577	3.2	.124	152°	F9
30.50	1.200		870-3050-30-GP	★	★	★	☆	☆	14.6	.574	3.2	.126	152°	F9
31.00	1.220	31	870-3100-31-GP	★	★	★	☆	☆	15.1	.593	3.3	.131	152°	F9
31.50	1.240		870-3150-31-GP	★	★	★	☆	☆	15.0	.591	3.4	.133	152°	F9
31.75	1.250		870-3175-31-GP	★	★	★	☆	☆	15.0	.590	3.4	.134	152°	F9
32.00	1.259		870-3200-31-GP	★	★	★	☆	☆	15.0	.589	3.4	.135	152°	F9
32.15	1.265		870-3215-31-GP	★	★	★	☆	☆	14.9	.588	3.5	.136	152°	F9
32.50	1.279		870-3250-31-GP	★	★	★	☆	☆	14.9	.587	3.5	.138	152°	F9
33.00	1.299		870-3300-31-GP	★	★	★	☆	☆	14.8	.584	3.6	.140	152°	F9

102 150

ENG

CoroDrill® 400

Metric values

ISO	MC No.	Material	Cutting speed (V_c) m/min	Drill diameter, mm 1.50 - 3.00	3.01 - 6.00	6.01 - 10.00	10.01 - 14.00	14.01 - 20.00	20.01 - 32.00
				Feed f_n mm/r (min - max)					
N	N1.1	Commercially pure	300 - 600	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.40 - 0.55	0.45 - 0.60
	N1.2	Al Si ≤1% Si	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.3	Al Si cast alloys, Si ≥1% and <13%	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.4	Al Si cast alloys, Si ≥13%	200 - 400	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60

Inch values

ISO	MC No.	Material	Cutting speed (v_c), ft/min	Drill diameter, inch .059 - .118	.118 - .236	.236 - .394	.394 - .551	.552 - .787	.787 - 1.260
				Feed f_n inch/r (min - max)					
N	N1.1	Commercially pure	984 - 1968	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.2	Al Si ≤1% Si	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.3	Al Si cast alloys, Si ≥1% and <13%	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.4	Al Si cast alloys, Si ≥13%	656 - 1312	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024

Drill Type 4 to use DC2 RPM, and DC1 Feed rate.

CoroDrill® 430

Metric values

ISO	MC No.	Material	Cutting speed (V_c) m/min	Drill diameter, mm 1.50 - 3.00	3.01 - 6.00	6.01 - 10.00	10.01 - 14.00	14.01 - 20.00	20.01 - 32.00
				Feed f_n mm/r (min - max)					
N	N1.1	Commercially pure	300 - 600	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.40 - 0.55	0.45 - 0.60
	N1.2	Al Si ≤1% Si	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.3	Al Si cast alloys, Si ≥1% and <13%	250 - 500	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60
	N1.4	Al Si cast alloys, Si ≥13%	200 - 400	0.06 - 0.15	0.15 - 0.25	0.25 - 0.40	0.30 - 0.45	0.30 - 0.45	0.45 - 0.60

Inch values

ISO	MC No.	Material	Cutting speed (v_c), ft/min	Drill diameter, inch .059 - .118	.118 - .236	.236 - .394	.394 - .551	.552 - .787	.787 - 1.260
				Feed f_n inch/r (min - max)					
N	N1.1	Commercially pure	984 - 1968	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.2	Al Si ≤1% Si	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.3	Al Si cast alloys, Si ≥1% and <13%	820 - 1640	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024
	N1.4	Al Si cast alloys, Si ≥13%	656 - 1312	.002 - .006	.006 - .010	.010 - .016	.012 - .018	.016 - .022	.018 - .024

GENERAL NOTE FOR ALL will be programmed in design program

Note: N1DU is veined PCD and can utilize higher feeds and speeds than solid carbide.
Note: For step drills calculate the RPM on the largest diameter & the feed on the smallest diameter
Note: For drill types 2,4,5 & 6 where the step ratio is above 1.5 i.e. 5.00mm pilot with a 8.00mm largest diameter start at min recommended feed rate.
Note: Solid drill Vc is reduced by 20% on coolant drill value
Note: Speed and feed can be within 20% of starting value

CoroDrill® 452

Cutting speed recommendations

	v_c m/min	v_c ft/min	f_n mm/rev	f_n inch/rev
CFRP	60	197	0.08	.00315
Aluminium	60	197	0.08	.00315
Titanium	15	49	0.05	.00197
Stainless steel	15	49	0.05	.00197

CoroDrill® 870

< 6 x DC

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V_c) m/min correlating with drill diameter					
					10.00-20.99mm			21.00-33.00mm		
					Min.	Rec.	Max.	Min.	Rec.	Max.
P			**Unalloyed steel**				Grade 4334			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	80	120	160	80	120	160
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	80	120	160	80	120	160
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	70	100	130	70	100	130
	P1.5.C.UT	06.1	Cast - untreated	150	80	110	140	80	110	140
			Low alloy steel				Grade 4334 and 3334			
	P2.1.Z.AN	02.1	Annealed	175	80	110	140	80	110	140
	P2.2.Z.AN	02.1	Annealed	240	80	110	140	80	110	140
	P2.4.Z.AN	02.1	Annealed	225	80	110	140	80	110	140
	P2.5.Z.HT	02.2	Hardened and tempered	330	70	100	130	50	75	100
	P2.6.C.UT	06.2	Cast - untreated	200	70	100	130	70	100	130
			High alloy steel							
	P3.0.Z.AN	03.11	Annealed	200	60	80	100	60	80	100
	P3.0.Z.HT	03.21	Hardened and tempered	380	40	60	80	40	60	80
M			**Ferritic/martensitic stainless steel**				Grade 4334 and 2334			
	P5.0.Z.AN	05.11	Annealed	200	30	40	50	30	40	50
	P5.0.Z.HT	05.13	Hardened and tempered	330	70	90	110	60	75	90
			Austenitic stainless steel				Grade 2334 and 4334			
	M1.0.Z.AQ	05.21	Annealed/quenched	200	40	50	60	40	50	60
	M1.0.C.UT	15.21	Cast+untreated	200	50	60	70	50	60	70
	M1.1.Z.AQ	05.21	Machinability improved	200	60	75	90	60	75	90
			Super-austenitic (Ni≥20%) stainless steel							
	M2.0.Z.AQ	05.23	Annealed/quenched	200	20	40	60	20	40	60
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	20	40	60	20	40	60
			Duplex (austenitic/ferritic) stainless steel				Grade 2334 and 4334			
	M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	40	55	70	40	55	70
	M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	20	40	60	20	40	60
K			**Malleable cast iron**				Grade 3334 and 4334			
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	100	145	190	100	145	190
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	90	125	160	90	125	160
			Grey cast iron							
	K2.1.C.UT	08.1	Low tensile strength	180	100	150	200	100	150	200
	K2.2.C.UT	08.2	High tensile strength	245	90	130	170	90	130	170
			Nodular cast iron							
	K3.1.C.UT	09.1	Ferritic	155	100	145	190	100	145	190
	K3.3.C.UT	09.2	Pearlitic	265	90	125	160	90	125	160
N			**Aluminium based alloys**				Grade 4334			
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	150	200	250	150	200	250
	N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	150	200	250	150	200	250
S			**Heat resistant super alloys**				Grade 4334 and 2334			
	S2.0.Z.AG	20.22	Ni based	350	18	20	30	18	20	30
	S4.3.Z.AN	23.21	Titanium based	330	25	40	60	25	40	60

CoroDrill® 870

< 6 x DC

Feed (f_n) mm/r correlating with drill diameter																	
10.00-11.99 mm			12.00-13.99 mm			14.00-15.99 mm			16.00-20.99 mm			21.00-25.99 mm			26.00-33.00 mm		
Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.
Geometry -PM and -GP																	
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
Geometry -PM. -KM and -GP																	
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.10	0.16	0.24	0.12	0.19	0.33	0.14	0.22	0.38	0.18	0.25	0.40	0.18	0.30	0.45	0.18	0.30	0.45
0.10	0.16	0.24	0.12	0.19	0.33	0.14	0.22	0.38	0.18	0.25	0.40	0.18	0.30	0.45	0.18	0.30	0.45
Geometry -PM, -MM and -GP																	
0.12	0.14	0.19	0.14	0.16	0.22	0.14	0.18	0.24	0.18	0.24	0.30	0.22	0.28	0.34	0.22	0.28	0.34
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.18	0.22	0.16	0.22	0.26	0.16	0.22	0.26
Geometry -MM, PM and -GP																	
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.16	0.22	0.14	0.18	0.24	0.14	0.18	0.24
0.10	0.12	0.14	0.10	0.12	0.16	0.10	0.12	0.16	0.10	0.14	0.16	0.12	0.14	0.18	0.12	0.14	0.18
0.10	0.12	0.14	0.10	0.12	0.16	0.10	0.12	0.16	0.10	0.14	0.16	0.12	0.14	0.18	0.12	0.14	0.18
Geometry -MM and -GP																	
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.16	0.22	0.14	0.16	0.22	0.14	0.16	0.22
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2
Geometry -KM, PM and -GP																	
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
Geometry -PM and -GP																	
0.20	0.25	0.30	0.22	0.32	0.40	0.26	0.34	0.42	0.30	0.36	0.44	0.32	0.38	0.50	0.32	0.38	0.50
0.20	0.25	0.30	0.22	0.32	0.40	0.26	0.34	0.42	0.30	0.36	0.44	0.32	0.38	0.50	0.32	0.38	0.50
Geometry -MM, -PM and -GP																	
0.08	0.10	0.14	0.08	0.11	0.14	0.10	0.12	0.14	0.11	0.13	0.16	0.12	0.15	0.20	0.12	0.15	0.20
0.09	0.12	0.15	0.10	0.14	0.16	0.12	0.16	0.20	0.14	0.18	0.22	0.16	0.20	0.25	0.18	0.22	0.27

CoroDrill® 870

≥ 6 x DC

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V_c) m/min correlating with drill diameter					
					10.00-20.99mm			21.00-33.00mm		
					Min.	Rec.	Max.	Min.	Rec.	Max.
P			**Unalloyed steel**				Grade 4334			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	80	120	160	80	120	160
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	80	120	160	80	120	160
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	70	100	130	70	100	130
	P1.5.C.UT	06.1	Cast - untreated	150	80	110	140	80	110	140
			Low alloy steel				Grade 4334 and 3334			
	P2.1.Z.AN	02.1	Annealed	175	80	110	140	80	110	140
	P2.2.Z.AN	02.1	Annealed	240	80	110	140	80	110	140
	P2.4.Z.AN	02.1	Annealed	225	80	110	140	80	110	140
	P2.5.Z.HT	02.2	Hardened and tempered	330	70	100	130	50	75	100
	P2.6.C.UT	06.2	Cast - untreated	200	70	100	130	70	100	130
			High alloy steel							
	P3.0.Z.AN	03.11	Annealed	200	60	80	100	60	80	100
	P3.0.Z.HT	03.21	Hardened and tempered	380	40	60	80	40	60	80
M			**Ferritic/martensitic stainless steel**				Grade 4334 and 2334			
	P5.0.Z.AN	05.11	Annealed	200	30	40	50	30	40	50
	P5.0.Z.HT	05.13	Hardened and tempered	330	70	90	110	60	75	90
			Austenitic stainless steel				Grade 2334 and 4334			
	M1.0.Z.AQ	05.21	Annealed/quenched	200	40	50	60	40	50	60
	M1.0.C.UT	15.21	Cast+untreated	200	50	60	70	50	60	70
	M1.1.Z.AQ	05.21	Machinability improved	200	60	75	90	60	75	90
			Super-austenitic (Ni≥20%) stainless steel							
	M2.0.Z.AQ	05.23	Annealed/quenched	200	20	40	60	20	40	60
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	20	40	60	20	40	60
			Duplex (austenitic/ferritic) stainless steel				Grade 2334 and 4334			
	M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	40	55	70	40	55	70
	M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	20	40	60	20	40	60
K			**Malleable cast iron**				Grade 3334 and 4334			
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	100	130	170	100	130	170
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	90	115	145	90	115	145
			Grey cast iron							
	K2.1.C.UT	08.1	Low tensile strength	180	100	135	180	100	135	180
	K2.2.C.UT	08.2	High tensile strength	245	90	120	155	90	120	155
			Nodular cast iron							
	K3.1.C.UT	09.1	Ferritic	155	100	130	170	100	130	170
	K3.3.C.UT	09.2	Pearlitic	265	90	115	145	90	115	145
N			**Aluminium based alloys**				Grade 4334			
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	150	200	250	150	200	250
	N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	150	200	250	150	200	250
S			**Heat resistant super alloys**				Grade 4334 and 2334			
	S2.0.Z.AG	20.22	Ni based	350	18	20	30	18	20	30
	S4.3.Z.AN	23.21	Titanium based	330	25	40	60	25	40	60

ENG

CoroDrill® 870

≥ 6 x DC

Feed (f_n) mm/r correlating with drill diameter

10.00-11.99 mm			12.00-13.99 mm			14.00-15.99 mm			16.00-20.99 mm			21.00-25.99 mm			26.00-33.00 mm		
Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.
Geometry -PM																	
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
Geometry -PM and -KM																	
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.12	0.13	0.21	0.14	0.15	0.26	0.16	0.18	0.32	0.20	0.22	0.34	0.20	0.25	0.35	0.20	0.28	0.36
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.10	0.13	0.19	0.12	0.15	0.26	0.14	0.18	0.30	0.18	0.20	0.32	0.18	0.24	0.36	0.18	0.24	0.36
0.10	0.11	0.17	0.12	0.13	0.23	0.14	0.15	0.27	0.18	0.19	0.28	0.18	0.21	0.32	0.18	0.21	0.32
Geometry -PM and -MM																	
0.12	0.13	0.15	0.14	0.15	0.18	0.14	0.15	0.19	0.18	0.19	0.24	0.22	0.23	0.27	0.22	0.23	0.27
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.14	0.15	0.16	0.16	0.17	0.18	0.16	0.17	0.18
Geometry -MM and -PM																	
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.12	0.13	0.16	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.12	0.13	0.16	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.14	0.15	0.18	0.14	0.15	0.19	0.14	0.15	0.19
0.10	0.11	0.12	0.10	0.11	0.13	0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.14
0.10	0.11	0.12	0.10	0.11	0.13	0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.14
Geometry -MM																	
0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.14	0.15	0.18	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.12	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.16	0.12	0.13	0.16	0.12	0.13	0.16
Geometry -KM and -PM																	
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
Geometry -PM																	
0.20	0.22	0.28	0.22	0.24	0.35	0.26	0.28	0.38	0.30	0.32	0.40	0.32	0.34	0.45	0.32	0.34	0.45
0.20	0.22	0.28	0.22	0.24	0.35	0.26	0.28	0.38	0.30	0.32	0.40	0.32	0.34	0.45	0.32	0.34	0.45
Geometry -MM and -PM																	
0.08	0.10	0.14	0.08	0.11	0.14	0.10	0.12	0.14	0.11	0.13	0.16	0.12	0.15	0.20	0.12	0.15	0.20
0.09	0.11	0.14	0.10	0.12	0.15	0.12	0.14	0.18	0.14	0.16	0.20	0.16	0.18	0.22	0.18	0.20	0.25

CoroDrill® 870

< 6 x DC

Inch values

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V_c) ft/min correlating with drill diameter .3937-.8264" Min.	Rec.	Max.	.8268-1.2992" Min.	Rec.	Max.
P			**Unalloyed steel**		**Grade 4234**					
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	260	395	525	260	395	525
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	260	395	525	260	395	525
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	230	330	425	230	330	425
	P1.5.C.UT	06.1	Cast - untreated	150	260	360	460	260	360	460
			Low alloy steel		**Grade 4234 and 3234**					
	P2.1.Z.AN	02.1	Annealed	175	260	360	460	260	360	460
	P2.2.Z.AN	02.1	Annealed	240	260	360	460	260	360	460
	P2.4.Z.AN	02.1	Annealed	225	260	360	460	260	360	460
	P2.5.Z.HT	02.2	Hardened and tempered	330	230	330	425	165	245	330
	P2.6.C.UT	06.2	Cast - untreated	200	230	330	425	230	330	425
			High alloy steel							
	P3.0.Z.AN	03.11	Annealed	200	195	260	330	195	260	330
	P3.0.Z.HT	03.21	Hardened and tempered	380	130	195	260	130	195	260
M			**Ferritic/martensitic stainless steel**		**Grade 4234 and 2234**					
	P5.0.Z.AN	05.11	Annealed	200	100	130	165	100	130	165
	P5.0.Z.HT	05.13	Hardened and tempered	330	230	295	360	195	245	295
			Austenitic stainless steel		**Grade 2234 and 4234**					
	M1.0.Z.AQ	05.21	Annealed/quenched	200	130	165	195	130	165	195
	M1.0.C.UT	15.21	Cast+untreated	200	165	195	230	165	195	230
	M1.1.Z.AQ	05.21	Machinability improved	200	195	245	295	195	245	295
			Super-austenitic (Ni≥20%) stainless steel							
	M2.0.Z.AQ	05.23	Annealed/quenched	200	65	130	195	65	130	195
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	65	130	195	65	130	195
			Duplex (austenitic/ferritic) stainless steel							
	M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	130	180	230	130	180	230
	M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	65	130	195	65	130	195
K			**Malleable cast iron**		**Grade 3234 and 4234**					
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	330	475	620	330	475	620
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	295	410	525	295	410	525
			Grey cast iron							
	K2.1.C.UT	08.1	Low tensile strength	180	330	490	655	330	490	655
	K2.2.C.UT	08.2	High tensile strength	245	295	425	560	295	425	560
			Nodular cast iron							
	K3.1.C.UT	09.1	Ferritic	155	330	475	620	330	475	620
	K3.3.C.UT	09.2	Pearlitic	265	295	410	525	295	410	525
N			**Aluminium based alloys**		**Grade 4234**					
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	490	650	820	490	650	820
	N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	490	650	820	490	650	820
S			**Heat resistant super alloys**		**Grade 2234 and 4234**					
	S2.0.Z.AG	20.22	Ni based	350	60	65	100	60	65	100
	S4.3.Z.AN	23.21	Titanium based	330	80	130	195	80	130	195

CoroDrill® 870

< 6 x DC

Inch values

Feed (f_n) inch/rev. correlating with drill diameter

.3937-.4720"			.4724-.5508"			.5512-.6295"			.6299-.8264"			.8268-1.0232"			1.0237-1.2992"		
Min.	**Rec.**	**Max.**	**Min.**	**Rec.**	**Max.**	**Min.**	**Rec.**	**Max.**	**Min.**	**Rec.**	**Max.**	**Min.**	**Rec.**	**Max.**	**Min.**	**Rec.**	**Max.**
Geometry -PM and -GP																	
.0047	.0071	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
.0047	.0071	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
.0047	.0071	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
.0047	.0074	.0110	.0055	.0079	.0138	.0063	.0098	.0161	.0079	.0126	.0177	.0079	.0134	.0177	.0079	.0134	.0177
Geometry -PM. -KM and -GP																	
.0047	.0071	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0157	.0205
.0047	.0071	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0157	.0205
.0047	.0071	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0157	.0205
.0047	.0071	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0157	.0205
.0047	.0074	.0118	.0055	.0079	.0146	.0063	.0098	.0177	.0079	.0126	.0189	.0079	.0142	.0197	.0079	.0142	.0197
.0039	.0063	.0094	.0047	.0075	.0130	.0055	.0087	.0150	.0071	.0098	.0157	.0071	.0118	.0177	.0071	.0118	.0177
.0039	.0063	.0094	.0047	.0075	.0130	.0055	.0087	.0150	.0071	.0098	.0157	.0071	.0118	.0177	.0071	.0118	.0177
Geometry -PM, -MM and -GP																	
.0047	.0055	.0075	.0055	.0063	.0087	.0055	.0071	.0094	.0071	.0094	.0118	.0087	.0110	.0134	.0087	.0110	.0134
.0039	.0047	.0063	.0039	.0047	.0063	.0047	.0055	.0071	.0055	.0071	.0087	.0063	.0087	.0102	.0063	.0087	.0102
Geometry -MM, PM and -GP																	
.0039	.0047	.0055	.0039	.0047	.0055	.0047	.0055	.0063	.0047	.0063	.0079	.0055	.0071	.0087	.0055	.0071	.0087
.0039	.0047	.0055	.0039	.0047	.0055	.0047	.0055	.0063	.0047	.0063	.0079	.0055	.0071	.0087	.0055	.0071	.0087
.0039	.0047	.0063	.0039	.0047	.0063	.0047	.0055	.0071	.0055	.0063	.0087	.0055	.0071	.0094	.0055	.0071	.0094
.0039	.0047	.0055	.0039	.0047	.0063	.0039	.0047	.0063	.0039	.0055	.0063	.0047	.0055	.0071	.0047	.0055	.0071
.0039	.0047	.0055	.0039	.0047	.0063	.0039	.0047	.0063	.0039	.0055	.0063	.0047	.0055	.0071	.0047	.0055	.0071
Geometry -MM and -GP																	
.0039	.0047	.0063	.0039	.0047	.0063	.0039	.0055	.0071	.0055	.0063	.0087	.0055	.0063	.0087	.0055	.0063	.0087
.0039	.0047	.0055	.0039	.0047	.0055	.0047	.0055	.0063	.0047	.0063	.0079	.0047	.0063	.0079	.0047	.0063	.0079
Geometry -KM, PM and -GP																	
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
.0063	.0098	.0142	.0071	.0118	.0165	.0083	.0146	.0189	.0098	.0173	.0217	.0118	.0189	.0236	.0118	.0197	.0236
Geometry -PM and -GP																	
.0079	.0098	.0118	.0087	.0126	.0157	.0102	.0134	.0165	.0118	.0142	.0173	.0126	.0150	.0197	.0126	.0150	.0197
.0079	.0098	.0118	.0087	.0126	.0157	.0102	.0134	.0165	.0118	.0142	.0173	.0126	.0150	.0197	.0126	.0150	.0197
Geometry -MM, -PM and -GP																	
.0031	.0039	.0055	.0031	.0043	.0055	.0039	.0047	.0055	.0043	.0051	.0063	.0047	.0059	.0079	.0047	.0059	.0079
.0035	.0047	.0059	.0039	.0055	.0063	.0047	.0063	.0079	.0055	.0071	.0087	.0063	.0079	.0098	.0071	.0087	.0106

CoroDrill® 870

≥ 6 x DC

Inch values

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V_c) ft/min correlating with drill diameter .3937-.8264" Min.	Rec.	Max.	.8268-1.2992" Min.	Rec.	Max.
P			**Unalloyed steel**				**Grade 4234**			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	260	395	525	260	395	525
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	260	395	525	260	395	525
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	230	330	425	230	330	425
	P1.5.C.UT	06.1	Cast - untreated	150	260	360	460	260	360	460
			Low alloy steel				**Grade 4234 and 3234**			
	P2.1.Z.AN	02.1	Annealed	175	260	360	460	260	360	460
	P2.2.Z.AN	02.1	Annealed	240	260	360	460	260	360	460
	P2.4.Z.AN	02.1	Annealed	225	260	360	460	260	360	460
	P2.5.Z.HT	02.2	Hardened and tempered	330	230	330	425	165	245	330
	P2.6.C.UT	06.2	Cast - untreated	200	230	330	425	230	330	425
			High alloy steel							
	P3.0.Z.AN	03.11	Annealed	200	195	260	330	195	260	330
	P3.0.Z.HT	03.21	Hardened and tempered	380	130	195	260	130	195	260
M			**Ferritic/martensitic stainless steel**				**Grade 4234 and 2234**			
	P5.0.Z.AN	05.11	Annealed	200	100	130	165	100	130	165
	P5.0.Z.HT	05.13	Hardened and tempered	330	230	295	360	195	245	295
			Austenitic stainless steel				**Grade 2234 and 4234**			
	M1.0.Z.AQ	05.21	Annealed/quenched	200	130	165	195	130	165	195
	M1.0.C.UT	15.21	Cast+untreated	200	165	195	230	165	195	230
	M1.1.Z.AQ	05.21	Machinability improved	200	195	245	295	195	245	295
			Super-austenitic (Ni≥20%) stainless steel							
	M2.0.Z.AQ	05.23	Annealed/quenched	200	65	130	195	65	130	195
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	65	130	195	65	130	195
			Duplex (austenitic/ferritic) stainless steel				**Grade 2234**			
	M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	130	180	230	130	180	230
	M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	65	130	195	65	130	195
K			**Malleable cast iron**				**Grade 3234 and 4234**			
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	330	425	560	330	425	560
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	295	380	475	295	380	475
			Grey cast iron							
	K2.1.C.UT	08.1	Low tensile strength	180	330	440	590	330	440	590
	K2.2.C.UT	08.2	High tensile strength	245	295	395	510	295	395	510
			Nodular cast iron							
	K3.1.C.UT	09.1	Ferritic	155	330	425	560	330	425	560
	K3.3.C.UT	09.2	Pearlitic	265	295	380	475	295	380	475
N			**Aluminium based alloys**				**Grade 4234**			
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	490	650	820	490	650	820
	N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	490	650	820	490	650	820
S			**Heat resistant super alloys**				**Grade 2234 and 4234**			
	S2.0.Z.AG	20.22	Ni based	350	60	65	100	60	65	100
	S4.3.Z.AN	23.21	Titanium based	330	80	130	195	80	130	195

CoroDrill® 870

≥ 6 x DC

Inch values

Feed (f_n) inch/rev. correlating with drill diameter																	
.3937-.4720"			.4724-.5508"			.5512-.6295"			.6299-.8264"			.8268-1.0232"			1.0237-1.2992"		
Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.
Geometry -PM																	
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
.0047	.0057	.0088	.0055	.0063	.0110	.0063	.0079	.0129	.0079	.0101	.0142	.0079	.0107	.0142	.0079	.0107	.0142
Geometry -PM and -KM																	
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0047	.0050	.0083	.0055	.0059	.0102	.0063	.0069	.0124	.0079	.0088	.0132	.0079	.0099	.0138	.0079	.0110	.0143
.0047	.0057	.0094	.0055	.0063	.0117	.0063	.0079	.0142	.0079	.0101	.0151	.0079	.0113	.0157	.0079	.0126	.0164
.0039	.0050	.0076	.0047	.0060	.0104	.0055	.0069	.0120	.0071	.0079	.0126	.0071	.0094	.0142	.0071	.0094	.0142
.0039	.0044	.0066	.0047	.0052	.0091	.0055	.0061	.0105	.0071	.0075	.0110	.0071	.0083	.0124	.0071	.0083	.0124
Geometry -PM and -MM																	
.0047	.0051	.0060	.0055	.0059	.0069	.0055	.0059	.0076	.0071	.0076	.0094	.0087	.0091	.0107	.0087	.0091	.0107
.0039	.0043	.0047	.0039	.0043	.0047	.0047	.0051	.0055	.0055	.0059	.0063	.0063	.0067	.0072	.0063	.0067	.0072
Geometry -MM and -PM																	
.0039	.0043	.0047	.0039	.0043	.0047	.0047	.0051	.0055	.0047	.0050	.0063	.0055	.0059	.0069	.0055	.0059	.0069
.0039	.0043	.0047	.0039	.0043	.0047	.0047	.0051	.0055	.0047	.0050	.0063	.0055	.0059	.0069	.0055	.0059	.0069
.0039	.0043	.0050	.0039	.0043	.0050	.0047	.0051	.0057	.0055	.0059	.0069	.0055	.0059	.0076	.0055	.0059	.0076
.0039	.0043	.0047	.0039	.0043	.0050	.0039	.0043	.0050	.0039	.0044	.0050	.0047	.0051	.0057	.0047	.0051	.0057
.0039	.0043	.0047	.0039	.0043	.0050	.0039	.0043	.0050	.0039	.0044	.0050	.0047	.0051	.0057	.0047	.0051	.0057
Geometry -MM																	
.0039	.0043	.0050	.0039	.0043	.0050	.0047	.0051	.0057	.0055	.0059	.0069	.0055	.0059	.0069	.0055	.0059	.0069
.0039	.0043	.0047	.0039	.0043	.0050	.0047	.0051	.0055	.0047	.0050	.0063	.0047	.0050	.0063	.0047	.0050	.0063
Geometry -KM and -PM																	
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
.0063	.0079	.0113	.0071	.0094	.0132	.0083	.0117	.0151	.0098	.0139	.0173	.0118	.0151	.0189	.0118	.0157	.0189
Geometry -PM																	
.0079	.0087	.0110	.0087	.0094	.0138	.0102	.0110	.0150	.0118	.0126	.0157	.0126	.0134	.0177	.0126	.0134	.0177
.0079	.0087	.0110	.0087	.0094	.0138	.0102	.0110	.0150	.0118	.0126	.0157	.0126	.0134	.0177	.0126	.0134	.0177
Geometry -MM and -PM																	
.0031	.0039	.0055	.0031	.0043	.0055	.0039	.0047	.0055	.0043	.0051	.0063	.0047	.0059	.0079	.0047	.0059	.0079
.0035	.0043	.0055	.0039	.0047	.0059	.0047	.0055	.0071	.0055	.0063	.0079	.0063	.0071	.0087	.0071	.0079	.0098

ENG

Tapping

Cutting taps

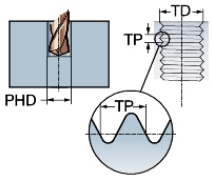
Forming taps

Cutting data

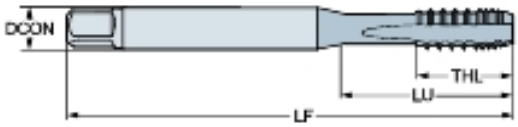
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

DIN 371



ULDR 2.0
SUBSTRATE HSS-E-PM
COATING UNCOAT

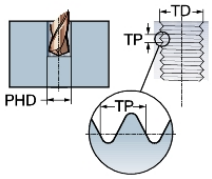


N

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N / D150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6H	T100-NM100DA-M3	★	3.5	3.00	56.0	9.0	3	2.5	DIN 371
		.709						*.138*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	21.00	4.50 x 3.40	C	6H	T100-NM100DA-M4	★	4.5	4.00	63.0	12.0	3	3.3	DIN 371
		.827						*.177*	*.157*	*2.480*	*.472*		*.130*	
M 5	0.80	25.00	6.00 x 4.90	C	6H	T100-NM100DA-M5	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.984						*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	30.00	6.00 x 4.90	C	6H	T100-NM100DA-M6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		1.181						*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	C	6H	T100-NM100DA-M8	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.378						*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	C	6H	T100-NM100DA-M10	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.535						*.394*	*.394*	*3.937*	*.787*		*.335*	

DIN 376

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING UNCOAT



N

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N / D150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
M 12	1.75	83.00	9.00 x 7.00	C	6H	T100-NM101DA-M12	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376
		3.268						*.354*	*.472*	*4.331*	*.906*		*.402*	
M 14	2.00	81.00	11.00 x 9.00	C	6H	T100-NM101DA-M14	★	11.0	14.00	110.0	25.0	4	12.0	DIN 376
		3.189						*.433*	*.551*	*4.331*	*.984*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	C	6H	T100-NM101DA-M16	★	12.0	16.00	110.0	25.0	4	14.0	DIN 376
		2.677						*.472*	*.630*	*4.331*	*.984*		*.551*	

123 150

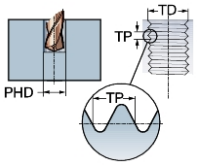
ENG

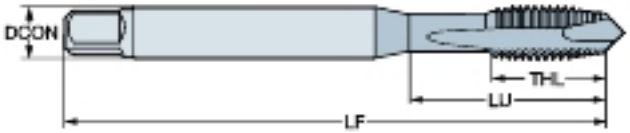
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD ZrN - B125
UNCOAT - B150



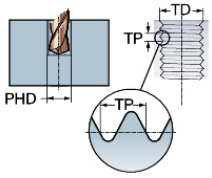


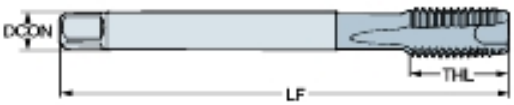
N

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N B125	N B150	DCON	TD	LF	THL	NOF	PHD	BSG
									Dimensions, mm, inch						
M 3	0.50	16.00	3.50 x 2.70	B	6H	T200-NM100DA-M3	★	★	3.5	3.00	56.0	9.0	2	2.5	DIN 371
		.630							*.138*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	19.00	4.50 x 3.40	B	6H	T200-NM100DA-M4	★	★	4.5	4.00	63.0	12.0	2	3.3	DIN 371
		.748							*.177*	*.157*	*2.480*	*.472*		*.130*	
M 5	0.80	23.00	6.00 x 4.90	B	6H	T200-NM100DA-M5	★	★	6.0	5.00	70.0	13.0	2	4.2	DIN 371
		.906							*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	27.00	6.00 x 4.90	B	6H	T200-NM100DA-M6	★	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		1.063							*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	28.00	8.00 x 6.20	B	6H	T200-NM100DA-M8	★	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.102							*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	30.00	10.00 x 8.00	B	6H	T200-NM100DA-M10	★	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.181							*.394*	*.394*	*3.937*	*.787*		*.335*	

DIN 376

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD ZrN - B125
UNCOAT - B150





N

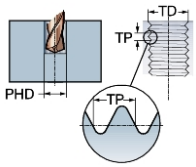
TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N B125	N B150	DCON	TD	LF	THL	NOF	PHD	BSG
									Dimensions, mm, inch						
M 12	1.75	83.00	9.00 x 7.00	B	6H	T200-NM101DA-M12	★	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		*.402*	
M 14	2.00	81.00	11.00 x 9.00	B	6H	T200-NM101DA-M14	★	★	11.0	14.00	110.0	25.0	4	12.0	DIN 376
		3.189							*.433*	*.551*	*4.331*	*.984*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	B	6H	T200-NM101DA-M16	★	★	12.0	16.00	110.0	25.0	4	14.0	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.984*		*.551*	

123 150

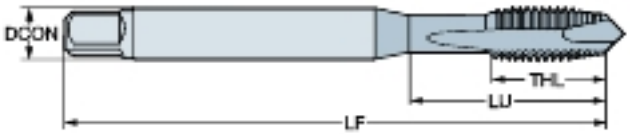
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN/ANSI



ULDR 3.0
SUBSTRATE HSS-E-PM
COATING UNCOAT



N

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N / D150	DCON	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	15.88	.141 x .110	B	6H	T200-NM100AA-M3	★	3.6	3.00	56.0	9.0	2	2.5	DIN/ANSI
		.625						*.141*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	16.58	.168 x .131	B	6H	T200-NM100AA-M4	★	4.3	4.00	63.0	13.0	2	3.3	DIN/ANSI
		.653						*.168*	*.157*	*2.480*	*.512*		*.130*	
M 5	0.80	21.42	.194 x .152	B	6H	T200-NM100AA-M5	★	4.9	5.00	70.0	14.0	2	4.2	DIN/ANSI
		.843						*.194*	*.197*	*2.756*	*.551*		*.165*	
M 6	1.00	25.59	.255 x .191	B	6H	T200-NM100AA-M6	★	6.5	6.00	80.0	15.0	3	5.0	DIN/ANSI
		1.007						*.255*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	30.20	.318 x .238	B	6H	T200-NM100AA-M8	★	8.1	8.00	90.0	18.0	3	6.8	DIN/ANSI
		1.189						*.318*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	32.80	.381 x .286	B	6H	T200-NM100AA-M10	★	9.7	10.00	100.0	20.0	3	8.5	DIN/ANSI
		1.292						*.381*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	86.02	.367 x .275	B	6H	T200-NM101AA-M12	★	9.3	12.00	110.0	23.0	4	10.2	DIN/ANSI
		3.386						*.367*	*.472*	*4.331*	*.906*		*.402*	

123 150

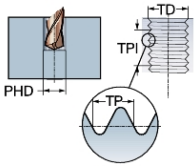
ENG

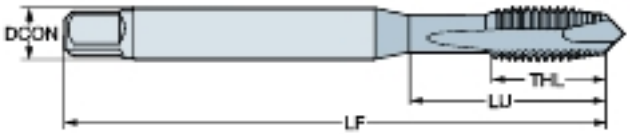
CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING UNCOAT





N

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N	D150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	15.47	.141 x .110	B	2B	T200-NM100AE-4-40	★		3.6	2.84	56.0	9.0	2	2.4	DIN/ANSI
		.609							*.141*	*.112*	*2.205*	*.354*		*.093*	
UNC #6-32	32.00	15.08	.141 x .110	B	2B	T200-NM100AE-6-32	★		3.6	3.51	56.0	11.0	2	2.9	DIN/ANSI
		.594							*.141*	*.138*	*2.205*	*.433*		*.112*	
UNC #8-32	32.00	16.58	.168 x .131	B	2B	T200-NM100AE-8-32	★		4.3	4.17	63.0	13.0	2	3.5	DIN/ANSI
		.653							*.168*	*.164*	*2.480*	*.512*		*.138*	
UNC #10-24	24.00	21.42	.194 x .152	B	2B	T200-NM100AE-10-24	★		4.9	4.83	70.0	14.0	2	3.9	DIN/ANSI
		.843							*.194*	*.190*	*2.756*	*.551*		*.154*	
UNC 1/4-20	20.00	25.59	.255 x .191	B	2B	T200-NM100AE-1/4	★		6.5	6.35	80.0	15.0	3	5.1	DIN/ANSI
		1.007							*.255*	*.250*	*3.150*	*.591*		*.201*	
UNC 5/16-18	18.00	30.20	.318 x .238	B	2B	T200-NM100AE-5/16	★		8.1	7.94	90.0	18.0	3	6.6	DIN/ANSI
		1.189							*.318*	*.313*	*3.543*	*.709*		*.260*	
UNC 3/8-16	16.00	32.80	.381 x .286	B	2B	T200-NM100AE-3/8	★		9.7	9.53	100.0	20.0	3	8.0	DIN/ANSI
		1.292							*.381*	*.375*	*3.937*	*.787*		*.315*	
UNC 7/16-14	14.00	72.60	.323 x .242	B	2B	T200-NM100AE-7/16	★		8.2	11.11	100.0	20.0	3	9.4	DIN/ANSI
		2.858							*.323*	*.438*	*3.937*	*.787*		*.370*	
UNC 1/2-13	13.00	81.80	.367 x .275	B	2B	T200-NM100AE-1/2	★		9.3	12.70	110.0	23.0	3	10.8	DIN/ANSI
		3.220							*.367*	*.500*	*4.331*	*.906*		*.425*	

Thread form: UNF

DIN/ANSI

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N	D150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
UNF #10-32	32.00	21.42	.194 x .152	B	2B	T200-NM100AF-10-32	★		4.9	4.83	70.0	14.0	2	4.1	DIN/ANSI
		.843							*.194*	*.190*	*2.756*	*.551*		*.161*	
UNF 1/4-28	28.00	25.59	.255 x .191	B	2B	T200-NM100AF-1/4	★		6.5	6.35	80.0	15.0	3	5.5	DIN/ANSI
		1.007							*.255*	*.250*	*3.150*	*.591*		*.217*	
UNF 3/8-24	24.00	32.80	.381 x .286	B	2B	T200-NM100AF-3/8	★		9.7	9.53	100.0	20.0	3	8.5	DIN/ANSI
		1.292							*.381*	*.375*	*3.937*	*.787*		*.335*	

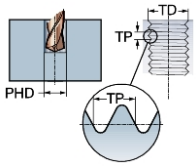
123 150

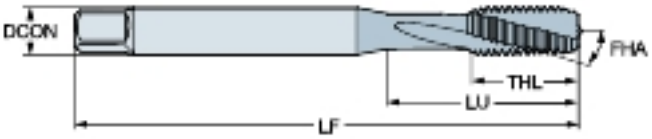
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371

ULDR	1.5
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD ZrN - D125
	UNCOAT - D150





N

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N D125	N D150	DCON	TD	LF	THL	NOF	PHD	BSG
									Dimensions, mm, inch						
M 3	0.50	18.00	3.50 x 2.70	C	6H	T300-NM100DA-M3	★	★	3.5	3.00	56.0	9.0	3	2.5	DIN 371
		.709							*.138*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	21.00	4.50 x 3.40	C	6H	T300-NM100DA-M4	★	★	4.5	4.00	63.0	12.0	3	3.3	DIN 371
		.827							*.177*	*.157*	*2.480*	*.472*		*.130*	
M 5	0.80	25.00	6.00 x 4.90	C	6H	T300-NM100DA-M5	★	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.984							*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	30.00	6.00 x 4.90	C	6H	T300-NM100DA-M6	★	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		1.181							*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	C	6H	T300-NM100DA-M8	★	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.378							*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	C	6H	T300-NM100DA-M10	★	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.535							*.394*	*.394*	*3.937*	*.787*		*.335*	

124 150

SANDVIK Coromant

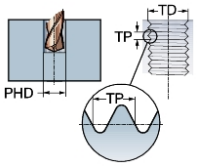
ENG

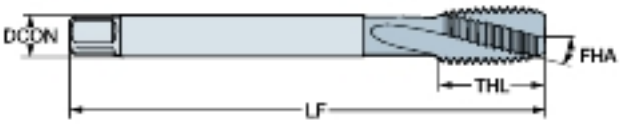
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 376

ULDR	1.5
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD ZrN - D125
	UNCOAT - D150





N

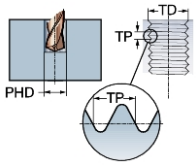
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N D125	N D150	DCON	TD	LF	THL	NOF	PHD	BSG
									Dimensions, mm, inch						
M 12	1.75	83.00	9.00 x 7.00	C	6H	T300-NM101DA-M12	★	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		*.402*	
M 14	2.00	81.00	11.00 x 9.00	C	6H	T300-NM101DA-M14	★	★	11.0	14.00	110.0	25.0	3	12.0	DIN 376
		3.189							*.433*	*.551*	*4.331*	*.984*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	C	6H	T300-NM101DA-M16	★	★	12.0	16.00	110.0	25.0	3	14.0	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.984*		*.551*	

124 150

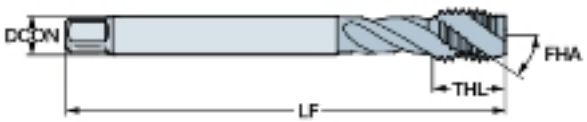
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376



ULDR	2.5
FHA	35°
SUBSTRATE	HSS-E
COATING	UNCOAT



N

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N	B150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6H	T300-NM100DA-M3	★		3.5	3.00	56.0	9.0	3	2.5	DIN 371
		.709							*.138*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	21.00	4.50 x 3.40	C	6H	T300-NM100DA-M4	★		4.5	4.00	63.0	12.0	3	3.3	DIN 371
		.827							*.177*	*.157*	*2.480*	*.472*		*.130*	
M 5	0.80	25.00	6.00 x 4.90	C	6H	T300-NM100DA-M5	★		6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.984							*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	30.00	6.00 x 4.90	C	6H	T300-NM100DA-M6	★		6.0	6.00	80.0	15.0	3	5.0	DIN 371
		1.181							*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	C	6H	T300-NM100DA-M8	★		8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.378							*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	C	6H	T300-NM100DA-M10	★		10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.535							*.394*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	83.00	9.00 x 7.00	C	6H	T300-NM101DA-M12	★		9.0	12.00	110.0	23.0	3	10.2	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		*.402*	
M 14	2.00	81.00	11.00 x 9.00	C	6H	T300-NM101DA-M14	★		11.0	14.00	110.0	25.0	3	12.0	DIN 376
		3.189							*.433*	*.551*	*4.331*	*.984*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	C	6H	T300-NM101DA-M16	★		12.0	16.00	110.0	25.0	3	14.0	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.984*		*.551*	
M 20	2.50	95.00	16.00 x 12.00	C	6H	T300-NM101DA-M20	★		16.0	20.00	140.0	30.0	3	17.5	DIN 376
		3.740							*.630*	*.787*	*5.512*	*1.181*		*.689*	

124 150

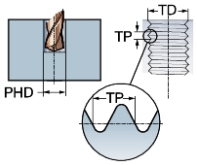
ENG

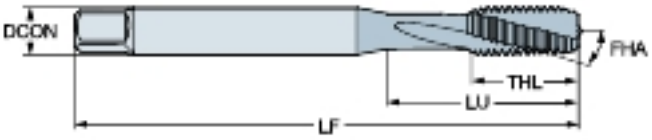
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN/ANSI

ULDR	1.5
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	UNCOAT





N

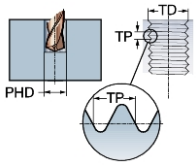
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N / D150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	15.88	.141 x .110	C	6H	T300-NM100AA-M3	★	3.6	3.00	56.0	9.0	3	2.5	DIN/ANSI
		.625						*.141*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	16.58	.168 x .131	C	6H	T300-NM100AA-M4	★	4.3	4.00	63.0	13.0	3	3.3	DIN/ANSI
		.653						*.168*	*.157*	*2.480*	*.512*		*.130*	
M 5	0.80	21.42	.194 x .152	C	6H	T300-NM100AA-M5	★	4.9	5.00	70.0	14.0	3	4.2	DIN/ANSI
		.843						*.194*	*.197*	*2.756*	*.551*		*.165*	
M 6	1.00	25.59	.255 x .191	C	6H	T300-NM100AA-M6	★	6.5	6.00	80.0	15.0	3	5.0	DIN/ANSI
		1.007						*.255*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	30.20	.318 x .238	C	6H	T300-NM100AA-M8	★	8.1	8.00	90.0	18.0	3	6.8	DIN/ANSI
		1.189						*.318*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	32.80	.381 x .286	C	6H	T300-NM100AA-M10	★	9.7	10.00	100.0	20.0	3	8.5	DIN/ANSI
		1.292						*.381*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	86.02	.367 x .275	C	6H	T300-NM101AA-M12	★	9.3	12.00	110.0	23.0	3	10.2	DIN/ANSI
		3.386						*.367*	*.472*	*4.331*	*.906*		*.402*	

124 150

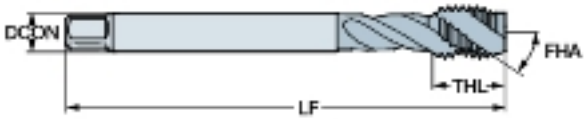
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374



ULDR	2.5
FHA	35°
SUBSTRATE	HSS-E
COATING	UNCOAT



N

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N R150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
MF 4x0.5	0.50	43.00	2.80 x 2.10	C	6H	T300-NM100DB-M4X050	★	2.8	4.00	63.0	12.0	2	3.5	DIN 374
		1.693						*.110*	*.157*	*2.480*	*.472*		*.138*	
MF 5x0.5	0.50	49.00	3.50 x 2.70	C	6H	T300-NM100DB-M5X050	★	3.5	5.00	70.0	13.0	2	4.5	DIN 374
		1.929						*.138*	*.197*	*2.756*	*.512*		*.177*	
MF 6x0.75	0.75	59.00	4.50 x 3.40	C	6H	T300-NM100DB-M6X075	★	4.5	6.00	80.0	15.0	2	5.3	DIN 374
		2.323						*.177*	*.236*	*3.150*	*.591*		*.209*	
MF 8x1	1.00	67.00	6.00 x 4.90	C	6H	T300-NM100DB-M8X100	★	6.0	8.00	90.0	18.0	2	7.0	DIN 374
		2.638						*.236*	*.315*	*3.543*	*.709*		*.276*	
MF 10x1	1.00	67.00	7.00 x 5.50	C	6H	T300-NM100DB-M10X100	★	7.0	10.00	90.0	20.0	3	9.0	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.787*		*.354*	
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6H	T300-NM100DB-M10X125	★	7.0	10.00	100.0	20.0	3	8.8	DIN 374
		3.032						*.276*	*.394*	*3.937*	*.787*		*.346*	
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6H	T300-NM100DB-M12X125	★	9.0	12.00	100.0	21.0	3	10.8	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.425*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6H	T300-NM100DB-M12X150	★	9.0	12.00	100.0	21.0	3	10.5	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.413*	
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6H	T300-NM100DB-M14X125	★	11.0	14.00	100.0	21.0	3	12.8	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.504*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6H	T300-NM100DB-M14X150	★	11.0	14.00	100.0	21.0	3	12.5	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.492*	
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6H	T300-NM100DB-M16X150	★	12.0	16.00	100.0	21.0	3	14.5	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.827*		*.571*	
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6H	T300-NM100DB-M18X150	★	14.0	18.00	110.0	24.0	3	16.5	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.945*		*.650*	
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6H	T300-NM100DB-M20X150	★	16.0	20.00	125.0	24.0	3	18.5	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.945*		*.728*	

124 150

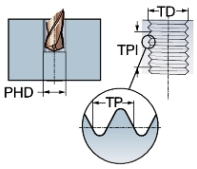
ENG

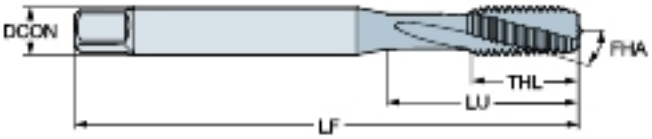
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN/ANSI

ULDR	1.5
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	UNCOAT





N

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N	D150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	15.47	.141 x .110	C	2B	T300-NM100AE-4-40	★		3.6	2.84	56.0	9.0	3	2.4	DIN/ANSI
		.609							*.141*	*.112*	*2.205*	*.354*		*.093*	
UNC #6-32	32.00	15.08	.141 x .110	C	2B	T300-NM100AE-6-32	★		3.6	3.51	56.0	11.0	3	2.9	DIN/ANSI
		.594							*.141*	*.138*	*2.205*	*.433*		*.112*	
UNC #8-32	32.00	16.58	.168 x .131	C	2B	T300-NM100AE-8-32	★		4.3	4.17	63.0	13.0	3	3.5	DIN/ANSI
		.653							*.168*	*.164*	*2.480*	*.512*		*.138*	
UNC #10-24	24.00	21.42	.194 x .152	C	2B	T300-NM100AE-10-24	★		4.9	4.83	70.0	14.0	3	3.9	DIN/ANSI
		.843							*.194*	*.190*	*2.756*	*.551*		*.154*	
UNC 1/4-20	20.00	25.59	.255 x .191	C	2B	T300-NM100AE-1/4	★		6.5	6.35	80.0	15.0	3	5.1	DIN/ANSI
		1.007							*.255*	*.250*	*3.150*	*.591*		*.201*	
UNC 5/16-18	18.00	30.20	.318 x .238	C	2B	T300-NM100AE-5/16	★		8.1	7.94	90.0	18.0	3	6.6	DIN/ANSI
		1.189							*.318*	*.313*	*3.543*	*.709*		*.260*	
UNC 3/8-16	16.00	32.80	.381 x .286	C	2B	T300-NM100AE-3/8	★		9.7	9.53	100.0	20.0	3	8.0	DIN/ANSI
		1.292							*.381*	*.375*	*3.937*	*.787*		*.315*	
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	T300-NM100AE-1/2	★		9.3	12.70	110.0	23.0	3	10.8	DIN/ANSI
		3.220							*.367*	*.500*	*4.331*	*.906*		*.425*	
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	T300-NM100AE-5/8	★		12.2	15.88	110.0	23.0	3	13.5	DIN/ANSI
		2.591							*.480*	*.625*	*4.331*	*.906*		*.531*	
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	T300-NM100AE-3/4	★		15.0	19.05	125.0	30.0	4	16.5	DIN/ANSI
		3.051							*.590*	*.750*	*4.921*	*1.181*		*.650*	

Thread form: UNF

DIN/ANSI

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N	D150	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
UNF #10-32	32.00	21.42	.194 x .152	C	2B	T300-NM100AF-10-32	★		4.9	4.83	70.0	14.0	3	4.1	DIN/ANSI
		.843							*.194*	*.190*	*2.756*	*.551*		*.161*	
UNF 1/4-28	28.00	25.59	.255 x .191	C	2B	T300-NM100AF-1/4	★		6.5	6.35	80.0	15.0	3	5.5	DIN/ANSI
		1.007							*.255*	*.250*	*3.150*	*.591*		*.217*	
UNF 5/16-24	24.00	30.20	.318 x .238	C	2B	T300-NM100AF-5/16	★		8.1	7.94	90.0	18.0	3	6.9	DIN/ANSI
		1.189							*.318*	*.313*	*3.543*	*.709*		*.272*	
UNF 3/8-24	24.00	32.80	.381 x .286	C	2B	T300-NM100AF-3/8	★		9.7	9.53	100.0	20.0	3	8.5	DIN/ANSI
		1.292							*.381*	*.375*	*3.937*	*.787*		*.335*	
UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	T300-NM100AF-1/2	★		9.3	12.70	110.0	23.0	3	11.5	DIN/ANSI
		3.220							*.367*	*.500*	*4.331*	*.906*		*.453*	

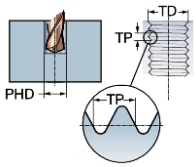
124 150

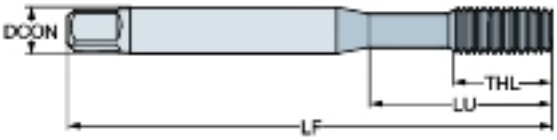
CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E
COATING DLC a-C:N





N

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N / B105	Dimensions, mm, inch DCON	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6HX	T400-NM100DA-M3	★	3.5	3.00	56.0	9.0	4	2.8	DIN 2174
		.709						*.138*	*.118*	*2.205*	*.354*		*.110*	
M 4	0.70	21.00	4.50 x 3.40	C	6HX	T400-NM100DA-M4	★	4.5	4.00	63.0	12.0	5	3.7	DIN 2174
		.827						*.177*	*.157*	*2.480*	*.472*		*.146*	
M 5	0.80	25.00	6.00 x 4.90	C	6HX	T400-NM100DA-M5	★	6.0	5.00	70.0	13.0	5	4.6	DIN 2174
		.984						*.236*	*.197*	*2.756*	*.512*		*.181*	
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T400-NM100DA-M6	★	6.0	6.00	80.0	15.0	5	5.5	DIN 2174
		1.181						*.236*	*.236*	*3.150*	*.591*		*.217*	
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T400-NM100DA-M8	★	8.0	8.00	90.0	18.0	5	7.4	DIN 2174
		1.378						*.315*	*.315*	*3.543*	*.709*		*.291*	

124 150

ENG

CoroTap™ 100

Metric values

				Grade D150		
			ULDR(xTD)	1.5	2	3
ISO	MC No.	Material	HB	v_c m/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	43	35	30
	N1.2.Z.AG		100	43	35	30
	N1.2.C.UT		75	43	35	30
	N1.3.C.AG		90	24	20	17
	N1.4.C.NS		130	18	15	13

Inch values

				Grade D150		
			ULDR(xTD)	1.5	2	3
ISO	MC No.	Material	HB	v_c ft/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	140	115	98
	N1.2.Z.AG		100	140	115	98
	N1.2.C.UT		75	140	115	98
	N1.3.C.AG		90	80	66	56
	N1.4.C.NS		130	60	49	42

CoroTap™ 200

Metric values

				Grade B150 / D150			Grade B125		
			ULDR(xTD)	1.5	2	3	1.5	2	3
ISO	MC No.	Material	HB	v_c m/min			v_c m/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	43	35	30	55	45	38
	N1.2.Z.AG		100	43	35	30	55	45	38
	N1.3.C.UT		75	43	35	30	55	45	38
	N1.3.C.AG		90	24	20	17	37	30	26
	N1.4.C.NS		130	18	15	13	24	20	17
	N3.1.U.UT	**Copper based alloys**	110	37	30	26	55	45	38
	N3.3.U.UT		100	15	12	10	22	18	15

Inch values

				Grade B150 / D150			Grade B125		
			ULDR(xTD)	1.5	2	3	1.5	2	3
ISO	MC No.	Material	HB	v_c ft/min			v_c ft/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	140	115	98	181	148	126
	N1.2.Z.AG		100	140	115	98	181	148	126
	N1.3.C.UT		75	140	115	98	181	148	126
	N1.3.C.AG		90	80	66	56	120	98	84
	N1.4.C.NS		130	60	49	42	80	66	56
	N3.1.U.UT	**Copper based alloys**	110	120	98	84	181	148	126
	N3.3.U.UT		100	48	39	34	72	59	51

CoroTap™ 300

Metric values

				Grade D150			Grade D125			Grade B150		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	**MC No.**	**Material**	**HB**	v_c m/min			v_c m/min			v_c m/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	43	35	30	55	45	38	43	35	30
	N1.2.Z.AG		100	43	35	30	55	45	38	43	35	30
	N1.3.C.UT		75	43	35	30	55	45	38	43	35	30
	N1.3.C.AG		90	24	20	17	37	30	26	24	20	17
	N1.4.C.NS		130	18	15	13	24	20	17			
	N3.1.U.UT	**Copper based alloys**	110	15	12	10	22	18	15	15	12	10
	N3.3.U.UT		100	37	30	26	55	45	38			

Inch version

				Grade D150			Grade D125			Grade B150		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	**MC No.**	**Material**	**HB**	v_c ft/min			v_c ft/min			v_c ft/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	140	115	98	181	148	126	140	115	98
	N1.2.Z.AG		100	140	115	98	181	148	126	140	115	98
	N1.3.C.UT		75	140	115	98	181	148	126	140	115	98
	N1.3.C.AG		90	80	66	56	120	98	84	80	66	56
	N1.4.C.NS		130	60	49	42	80	66	56			
	N3.1.U.UT	**Copper based alloys**	110	48	39	34	72	59	51	48	39	34
	N3.3.U.UT		100	120	98	84	181	148	126			

CoroTap™ 400

Metric values

				Grade B105		
			ULDR(xTD)	1.5	2	3
ISO	**MC No.**	**Material**	**HB**	v_c m/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	67	55	47
	N1.2.Z.AG		100	67	55	47
	N1.3.C.UT		75	67	55	47
	N1.3.C.AG		90	49	40	34
	N3.1.U.UT	**Copper based alloys**	100	31	25	21

Inch values

				Grade B105		
			ULDR(xTD)	1.5	2	3
ISO	**MC No.**	**Material**	**HB**	v_c ft/min		
N	N1.2.Z.UT	**Aluminium based alloys**	60	221	180	154
	N1.2.Z.AG		100	221	180	154
	N1.3.C.UT		75	221	180	154
	N1.3.C.AG		90	161	131	112
	N3.1.U.UT	**Copper based alloys**	100	100	82	70

ENG

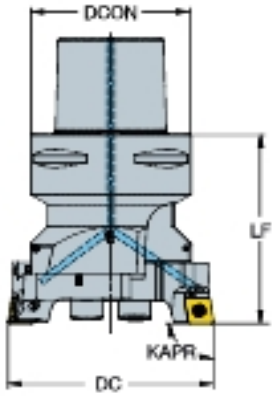
Boring

Rough boring

CoroBore® BR20 twin-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR 90°



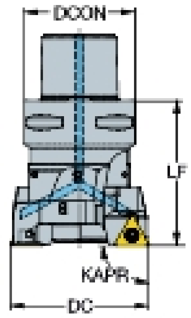
DCN	DCX			CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch DCON	$ADJLX_{RDL}$	LF	BAR PSI	NM	KG	CICT	MIID
70.00	90.00	12	1/2	C6	3	BR20-90CN12F-C6	63.00	10.00	78.00	70	3.0	1.620	2	CNMU 12 04 08
2.756	*3.543*						*2.480*	*.394*	*3.071*	*1015*				
89.00	116.00	12	1/2	C8	3	BR20-116CN12F-C8	80.00	13.50	94.00	70	3.0	3.050	2	CNMU 12 04 08
3.504	*4.567*						*3.150*	*.531*	*3.701*	*1015*				
115.00	150.00	12	1/2	C8	3	BR20-150CN12F-C8	80.00	17.50	100.00	70	3.0	3.690	2	CNMU 12 04 08
4.528	*5.906*						*3.150*	*.689*	*3.937*	*1015*				

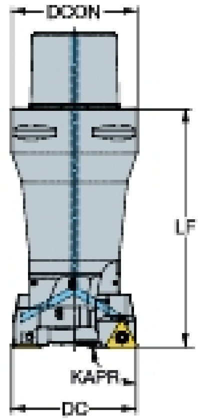
150 155

CoroBore® BR20 twin-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR	90°	90°
DSGN	1	2





Dimensions, mm, inch

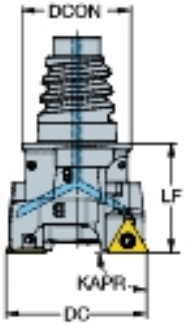
DCN	DCX	(insert size)	(IC)	CZC_{MS}	CNSC	DSGN	Ordering code	DCON	$ADJLX_{RDL}$	ULDR	LF	BD_1	BAR PSI	NM	KG	CICT	MIID
28.00	36.00	09	7/32	C3	3	2	BR20-36TC09F-C3	32.00	4.00	2.00	83.00	24.00	70	0.8	0.380	2	TCMT 09 02 04
1.102	*1.417*							*1.260*	*.157*		*3.268*	*.945*	*1015*				
35.00	45.00	11	1/4	C3	3	1	BR20-45TC11F-C3	32.00	5.00		48.00		70	0.9	0.270	2	TCMT 11 03 04
1.378	*1.772*							*1.260*	*.197*		*1.890*		*1015*				
44.00	56.00	11	1/4	C4	3	1	BR20-56TC11F-C4	40.00	6.00		56.00		70	0.9	0.500	2	TCMT 11 03 04
1.732	*2.205*							*1.575*	*.236*		*2.205*		*1015*				
55.00	71.00	16	3/8	C5	3	1	BR20-71TC16F-C5	50.00	8.00		66.00		70	3.0	0.860	2	TCMT 16 T3 08
2.165	*2.795*							*1.969*	*.315*		*2.598*		*1015*				
70.00	90.00	16	3/8	C5	3	1	BR20-90TC16F-C5	50.00	10.00		70.00		70	3.0	1.250	2	TCMT 16 T3 08
2.756	*3.543*							*1.969*	*.394*		*2.756*		*1015*				
70.00	90.00	16	3/8	C6	3	1	BR20-90TC16F-C6	63.00	10.00		78.00		70	3.0	1.600	2	TCMT 16 T3 08
2.756	*3.543*							*2.480*	*.394*		*3.071*		*1015*				
89.00	116.00	16	3/8	C6	3	1	BR20-116TC16F-C6	63.00	13.50		90.00		70	3.0	2.100	2	TCMT 16 T3 08
3.504	*4.567*							*2.480*	*.531*		*3.543*		*1015*				
115.00	150.00	16	3/8	C8	3	1	BR20-150TC16F-C8	80.00	17.50		100.00		70	3.0	3.650	2	TCMT 16 T3 08
4.528	*5.906*							*3.150*	*.689*		*3.937*		*1015*				

ISO 13399 150 CNSC CXSC 155

CoroBore® BR20 twin-edge rough boring tool

Coromant EH - Internal coolant supply

KAPR 90°



DCN	DCX			CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm, inch DCON	ADJLX$_{RDL}$	LF	BAR PSI	NM	KG	CICT	MIID
28.00	36.00	09	7/32	E25	1	BR20-36TC09F-EH25	24.20	4.00	25.00	70	0.8	0.130	2	TCMT 09 02 04
1.102	*1.417*						*.953*	*.157*	*.984*	*1015*				

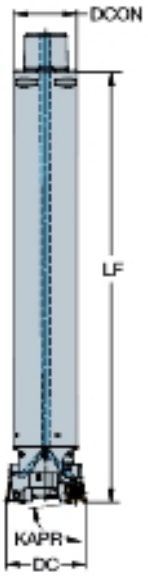
150 155

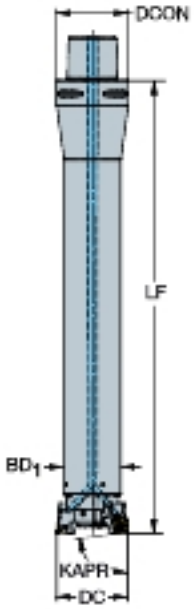
ENG

CoroBore® BR20 twin-edge damped rough boring tool

Coromant Capto® - Internal coolant supply

KAPR	84°	84°
DSGN	1	2





							Ordering code	Dimensions, mm, inch									
DCN	DCX		IC	CZC_{MS}	CNSC	DSGN		DCON	$ADJLX_{RDL}$	ULDR	LF	BD_1	BAR PSI	NM	KG	CICT	MIID
23.00	29.00	06	06	C4	3	2	BR20D-29SP06Y-C4L	40.00	3.00	6.00	199.00	20.00	70	0.8	0.740	2	SPMT 0606-BM
.906	*1.142*							*1.575*	*.118*		*7.835*	*.787*	*1015*				
28.00	36.00	06	06	C3	3	2	BR20D-36SP06Y-C3L	32.00	4.00	6.00	216.00	25.00	70	0.8	1.030	2	SPMT 0606-BM
1.102	*1.417*							*1.260*	*.157*		*8.504*	*.984*	*1015*				
35.00	45.00	08	08	C3	3	1	BR20D-45SP08Y-C3L	32.00	5.00		221.00		70	1.7	1.540	2	SPMT 0808-BM
1.378	*1.772*							*1.260*	*.197*		*8.701*		*1015*				
35.00	45.00	08	08	C4	3	2	BR20D-45SP08Y-C4L	40.00	5.00	6.00	270.00	32.00	70	1.7	1.980	2	SPMT 0808-BM
1.378	*1.772*							*1.575*	*.197*		*10.630*	*1.260*	*1015*				
35.00	45.00	08	08	C6	3	2	BR20D-45SP08Y-C6L	63.00	5.00	6.00	297.00	32.00	70	1.7	2.630	2	SPMT 0808-BM
1.378	*1.772*							*2.480*	*.197*		*11.693*	*1.260*	*1015*				
44.00	56.00	08	08	C4	3	1	BR20D-56SP08Y-C4L	40.00	6.00		220.00		70	1.7	2.380	2	SPMT 0808-BM
1.732	*2.205*							*1.575*	*.236*		*8.661*		*1015*				
44.00	56.00	08	08	C5	3	2	BR20D-56SP08Y-C5L	50.00	6.00	6.00	336.00	40.00	70	1.7	3.720	2	SPMT 0808-BM
1.732	*2.205*							*1.969*	*.236*		*13.228*	*1.575*	*1015*				
44.00	56.00	08	08	C6	3	1	BR20D-56SP08Y-C6L	63.00	6.00	6.00	363.00	40.00	70	1.7	4.350	2	SPMT 0808-BM
1.732	*2.205*							*2.480*	*.236*		*14.291*	*1.575*	*1015*				
55.00	71.00	12	12	C5	3	1	BR20D-71SP12Y-C5M	50.00	8.00		300.00		70	2.0	5.080	2	SPMT 1210-BM
2.165	*2.795*							*1.969*	*.315*		*11.811*		*1015*				
55.00	71.00	12	12	C6	3	2	BR20D-71SP12Y-C6M	63.00	8.00	5.60	400.00	50.00	70	2.0	6.940	2	SPMT 1210-BM
2.165	*2.795*							*2.480*	*.315*		*15.748*	*1.969*	*1015*				
70.00	90.00	12	12	C6	3	1	BR20D-90SP12Y-C6M	63.00	10.00		400.00		70	2.0	9.910	2	SPMT 1210-BM
2.756	*3.543*							*2.480*	*.394*		*15.748*		*1015*				
70.00	90.00	12	12	C8	3	2	BR20D-90SP12Y-C8M	80.00	10.00	5.60	500.00	63.00	70	3.0	12.660	2	SPMT 1210-BM
2.756	*3.543*							*3.150*	*.394*		*19.685*	*2.480*	*1015*				
89.00	116.00	12	12	C8	3	1	BR20D-116SP12Y-C8M	80.00	13.50		500.00		70	2.0	18.490	2	SPMT 1210-BM
3.504	*4.567*							*3.150*	*.531*		*19.685*		*1015*				
89.00	116.00	12	12	C8	3	1	BR20D-116SP12Y-C8S	80.00	13.50		410.00		70	2.0	16.140	2	SPMT 1210-BM
3.504	*4.567*							*3.150*	*.531*		*16.142*		*1015*				
115.00	150.00	12	12	C8	3	1	BR20D-150SP12Y-C8M	80.00	17.50		500.00		70	2.0	18.620	2	SPMT 1210-BM
4.528	*5.906*							*3.150*	*.689*		*19.685*		*1015*				

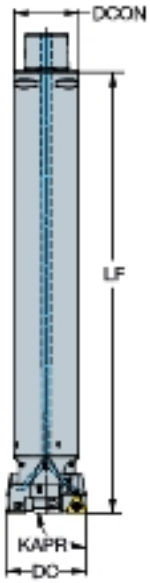
For spare parts, visit www.sandvik.coromant.com

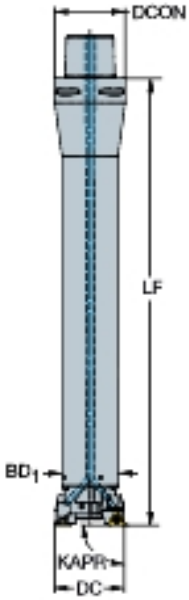
150 155

CoroBore® BR20 twin-edge damped rough boring tool

Coromant Capto® - Internal coolant supply

KAPR	90°	90°
DSGN	1	2





								Dimensions, mm, inch											
DCN	DCX			CZC_{MS}	CNSC	DSGN	Ordering code	DCON	$ADJLX_{RDL}$	ULDR	LF	BD_1	BAR PSI	NM	KG	CICT	MIID
28.00	36.00	09	7/32	C3	3	2	BR20D-36TC09F-C3L	32.00	4.00	6.00	216.00	25.00	70	0.8	1.050	2	TCMT 09 02 04
1.102	*1.417*							*1.260*	*.157*		*8.504*	*.984*	*1015*				
35.00	45.00	11	1/4	C3	3	1	BR20D-45TC11F-C3L	32.00	5.00		221.00		70	0.9	1.540	2	TCMT 11 03 04
1.378	*1.772*							*1.260*	*.197*		*8.701*		*1015*				
35.00	45.00	11	1/4	C4	3	2	BR20D-45TC11F-C4L	40.00	5.00	6.00	270.00	32.00	70	0.9	1.980	2	TCMT 11 03 04
1.378	*1.772*							*1.575*	*.197*		*10.630*	*1.260*	*1015*				
44.00	56.00	11	1/4	C4	3	1	BR20D-56TC11F-C4L	40.00	6.00		220.00		70	0.9	2.400	2	TCMT 11 03 04
1.732	*2.205*							*1.575*	*.236*		*8.661*		*1015*				
44.00	56.00	11	1/4	C5	3	2	BR20D-56TC11F-C5L	50.00	6.00	6.00	336.00	40.00	70	0.9	3.740	2	TCMT 11 03 04
1.732	*2.205*							*1.969*	*.236*		*13.228*	*1.575*	*1015*				
55.00	71.00	16	3/8	C5	3	1	BR20D-71TC16F-C5M	50.00	8.00		300.00		70	3.0	5.080	2	TCMT 16 T3 08
2.165	*2.795*							*1.969*	*.315*		*11.811*		*1015*				
70.00	90.00	16	3/8	C6	3	1	BR20D-90TC16F-C6M	63.00	10.00		400.00		70	3.0	9.930	2	TCMT 16 T3 08
2.756	*3.543*							*2.480*	*.394*		*15.748*		*1015*				
89.00	116.00	16	3/8	C8	3	1	BR20D-116TC16F-C8M	80.00	13.50		500.00		70	3.0	18.510	2	TCMT 16 T3 08
3.504	*4.567*							*3.150*	*.531*		*19.685*		*1015*				
89.00	116.00	16	3/8	C8	3	1	BR20D-116TC16F-C8S	80.00	13.50		410.00		70	3.0	16.160	2	TCMT 16 T3 08
3.504	*4.567*							*3.150*	*.531*		*16.142*		*1015*				
115.00	150.00	16	3/8	C8	3	1	BR20D-150TC16F-C8M	80.00	17.50		500.00		70	3.0	18.640	2	TCMT 16 T3 08
4.528	*5.906*							*3.150*	*.689*		*19.685*		*1015*				

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

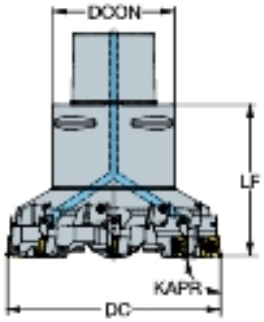
150 155

ENG

CoroBore® BR30 multi-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR 84°



							Dimensions, mm, inch							
DCN	DCX			CZC_{MS}	CNSC	Ordering code	DCON	$ADJLX_{RDL}$	LF	BAR PSI	NM	KG	CICT	MIID
85.00	94.50	12	12	C6	3	BR30-095-4-SP12Y-C6	63.00	4.75	80.00	20	2.0	2.050	4	SPMT 1210-BM
3.346	*3.720*						*2.480*	*.187*	*3.150*	*290*				
93.50	103.00	12	12	C6	3	BR30-103-4-SP12Y-C6	63.00	4.75	80.00	20	2.0	2.130	4	SPMT 1210-BM
3.681	*4.055*						*2.480*	*.187*	*3.150*	*290*				
102.00	111.50	12	12	C8	3	BR30-112-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	4.110	6	SPMT 1210-BM
4.016	*4.390*						*3.150*	*.187*	*3.937*	*290*				
110.50	120.00	12	12	C8	3	BR30-120-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	4.230	6	SPMT 1210-BM
4.350	*4.724*						*3.150*	*.187*	*3.937*	*290*				
119.00	128.50	12	12	C8	3	BR30-129-8-SP12Y-C8	80.00	4.75	100.00	20	2.0	4.510	8	SPMT 1210-BM
4.685	*5.059*						*3.150*	*.187*	*3.937*	*290*				
127.50	137.00	12	12	C8	3	BR30-137-8-SP12Y-C8	80.00	4.75	100.00	20	2.0	4.670	8	SPMT 1210-BM
5.020	*5.394*						*3.150*	*.187*	*3.937*	*290*				
136.00	145.50	12	12	C8	3	BR30-146-8-SP12Y-C8	80.00	4.75	100.00	20	2.0	4.900	8	SPMT 1210-BM
5.354	*5.728*						*3.150*	*.187*	*3.937*	*290*				
144.50	154.00	12	12	C8	3	BR30-154-8-SP12Y-C8	80.00	4.75	100.00	20	2.0	5.060	8	SPMT 1210-BM
5.689	*6.063*						*3.150*	*.187*	*3.937*	*290*				
153.00	162.50	12	12	C8	3	BR30-163-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	5.150	6	SPMT 1210-BM
6.024	*6.398*						*3.150*	*.187*	*3.937*	*290*				
161.50	171.00	12	12	C8	3	BR30-171-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	5.270	6	SPMT 1210-BM
6.358	*6.732*						*3.150*	*.187*	*3.937*	*290*				
170.00	179.50	12	12	C8	3	BR30-180-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	5.730	6	SPMT 1210-BM
6.693	*7.067*						*3.150*	*.187*	*3.937*	*290*				
178.50	188.00	12	12	C8	3	BR30-188-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	5.850	6	SPMT 1210-BM
7.028	*7.402*						*3.150*	*.187*	*3.937*	*290*				
187.00	196.50	12	12	C8	3	BR30-197-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	6.470	6	SPMT 1210-BM
7.362	*7.736*						*3.150*	*.187*	*3.937*	*290*				
195.50	205.00	12	12	C8	3	BR30-205-6-SP12Y-C8	80.00	4.75	100.00	20	2.0	6.590	6	SPMT 1210-BM
7.697	*8.071*						*3.150*	*.187*	*3.937*	*290*				

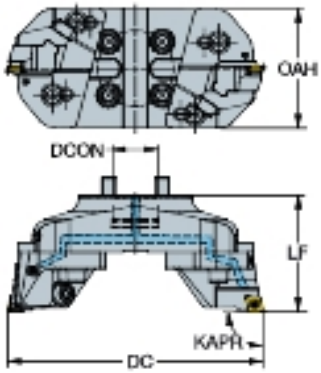
For spare parts, visit www.sandvik.coromant.com

150 155

CoroBore® 820 XL lightweight rough boring tool

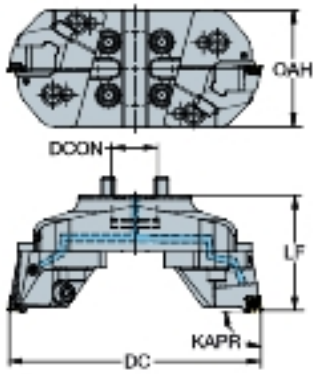
Arbor - Internal coolant supply

KAPR 90°



DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch DCON	$ADJLX_{AXL}$	$ADJLX_{RDL}$	HSUP	LF	OAH	BAR PSI	NM	KG	CICT	MIID
148.00	200.00	12	1/2	40S	1	**820L-200CC12F**	40.00	1.50	26.00	51.0	102.00	104.00	70	3.0	3.860	2	CCMT 12 04 08
5.827	*7.874*						*1.575*	*.059*	*1.024*	*2.008*	*4.016*	*4.094*	*1015*				
198.00	250.00	12	1/2	40S	1	**820L-250CC12F**	40.00	1.50	26.00	51.0	102.00	104.00	70	3.0	4.390	2	CCMT 12 04 08
7.795	*9.843*						*1.575*	*.059*	*1.024*	*2.008*	*4.016*	*4.094*	*1015*				
248.00	300.00	12	1/2	40S	1	**820L-300CC12F**	40.00	1.50	26.00	51.0	102.00	104.00	70	3.0	4.870	2	CCMT 12 04 08
9.764	*11.811*						*1.575*	*.059*	*1.024*	*2.008*	*4.016*	*4.094*	*1015*				

KAPR 84°



DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch DCON	$ADJLX_{AXL}$	$ADJLX_{RDL}$	HSUP	LF	OAH	BAR PSI	NM	KG	CICT	MIID
148.00	200.00	12	12	40S	1	**820L-200SP12Y**	40.00	1.50	26.00	51.0	102.00	104.00	70	3.0	3.860	2	SPMT 1210-BM
5.827	*7.874*						*1.575*	*.059*	*1.024*	*2.008*	*4.016*	*4.094*	*1015*				
198.00	250.00	12	12	40S	1	**820L-250SP12Y**	40.00	1.50	26.00	51.0	102.00	104.00	70	3.0	4.390	2	SPMT 1210-BM
7.795	*9.843*						*1.575*	*.059*	*1.024*	*2.008*	*4.016*	*4.094*	*1015*				
248.00	300.00	12	12	40S	1	**820L-300SP12Y**	40.00	1.50	26.00	51.0	102.00	104.00	70	3.0	4.870	2	SPMT 1210-BM
9.764	*11.811*						*1.575*	*.059*	*1.024*	*2.008*	*4.016*	*4.094*	*1015*				

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

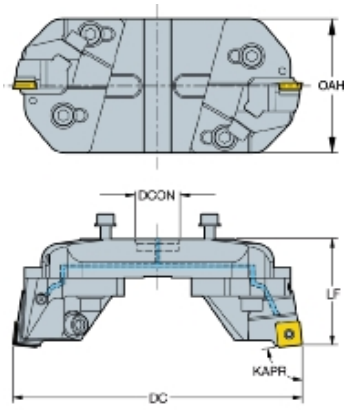
ISO 13399 150 155

ENG

CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

KAPR 84°



DCN	DCX			CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm, inch DCON	ADJLX$_{AXL}$	ADJLX$_{RDL}$	HSUP	LF	OAH	BAR PSI	NM	KG	CICT	MIID
148.00	200.00	12	12	33	1	**820D-200SP12Y**	33.00	1.50	26.00	51.0	82.00	104.00	70	3.0	3.350	2	SPMT 1210-BM
5.827	*7.874*						*1.299*	*.059*	*1.024*	*2.008*	*3.228*	*4.094*	*1015*				
198.00	250.00	12	12	33	1	**820D-250SP12Y**	33.00	1.50	26.00	51.0	82.00	104.00	70	3.0	3.670	2	SPMT 1210-BM
7.795	*9.843*						*1.299*	*.059*	*1.024*	*2.008*	*3.228*	*4.094*	*1015*				
248.00	300.00	12	12	33	1	**820D-300SP12Y**	33.00	1.50	26.00	52.0	82.00	104.00	70	3.0	4.030	2	SPMT 1210-BM
9.764	*11.811*						*1.299*	*.059*	*1.024*	*2.047*	*3.228*	*4.094*	*1015*				

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

150 155

CoroBore® 826 HP

Cartridge set

	Ordering code	Cartridges included	F-dimension (mm)
Size B	R826B-6-TC09U	R826B-AF17STUC09HP (1 pcs)	0.0
		R826B-BF17STUC09HP (1 pcs)	0.5
		R826B-CF17STUC09HP (1 pcs)	1.0
		R826B-DF17STUC09HP (1 pcs)	1.5

	Ordering code	Cartridges included	F-dimension (mm)
Size C	R826C-6-TC11U	R826C-AF23STUC11HP (1 pcs)	0.0
		R826C-BF23STUC11HP (1 pcs)	0.5
		R826C-CF23STUC11HP (1 pcs)	1.0
		R826C-DF23STUC11HP (1 pcs)	1.5
		R826C-EF23STUC11HP (1 pcs)	2.0
		R826C-FF23STUC11HP (1 pcs)	2.5

ENG

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

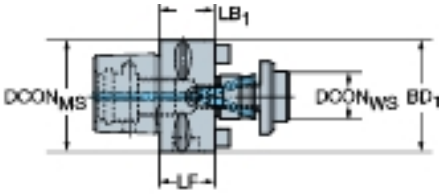
Machine side interface DIN 2080

Machine side interface Coromant EH

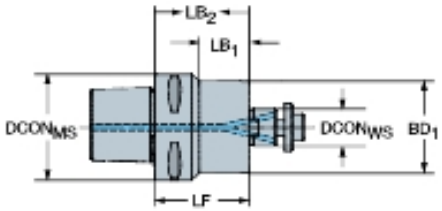
Coromant Capto® to arbor adaptor

Coolant through arbor

DSGN 1



2



Metric pilot

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR PSI	KG
C4	16	3	4	2	C4-391.05C-16 055	40.0	16.0	55.0	33.0	55.0	32.0	40.0	80	0.40
						1.575	*.630*	*2.165*	*1.299*	*2.165*	*1.260*	*1.575*	*1160*	
	22	3	4	1	C4-391.05C-22 055	40.0	22.0	55.0	55.0		40.0		80	0.60
						1.575	*.866*	*2.165*	*2.165*		*1.575*		*1160*	
C5	16	3	4	2	C5-391.05C-16 070	50.0	16.0	70.0	44.8	70.0	32.0	50.0	80	0.70
						1.969	*.630*	*2.756*	*1.764*	*2.756*	*1.260*	*1.969*	*1160*	
	22	3	4	2	C5-391.05C-22 070	50.0	22.0	70.0	47.0	70.0	40.0	50.0	80	0.90
						1.969	*.866*	*2.756*	*1.850*	*2.756*	*1.575*	*1.969*	*1160*	
C6	22	3	4	2	C6-391.05C-22 080	63.0	22.0	80.0	40.0	80.0	40.0	63.0	80	1.40
						2.480	*.866*	*3.150*	*1.575*	*3.150*	*1.575*	*2.480*	*1160*	
	27	3	4	2	C6-391.05C-27 080	63.0	27.0	80.0	55.0	80.0	50.0	63.0	80	1.60
						2.480	*1.063*	*3.150*	*2.165*	*3.150*	*1.969*	*2.480*	*1160*	
C8	22	3	4	2	C8-391.05C-22 090	80.0	22.0	90.0	45.0	90.0	40.0	80.0	80	2.40
						3.150	*.866*	*3.543*	*1.772*	*3.543*	*1.575*	*3.150*	*1160*	
	27	3	4	2	C8-391.05C-27 090	80.0	27.0	90.0	50.0	90.0	50.0	80.0	80	2.70
						3.150	*1.063*	*3.543*	*1.969*	*3.543*	*1.969*	*3.150*	*1160*	

Inch pilot

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR PSI	KG
C4	3/4	3	4	1	C4-A391.05C-19 055	40.0	19.1	55.0	55.0		40.0		80	0.60
						1.575	*.750*	*2.165*	*2.165*		*1.575*		*1160*	
C5	3/4	3	4	1	C5-A391.05C-19 070	50.0	19.1	70.0	48.0	70.0	43.0	50.0	80	0.90
						1.969	*.750*	*2.756*	*1.890*	*2.756*	*1.693*	*1.969*	*1160*	
	1	3	4	1	C5-A391.05C-25 070	50.0	25.4	70.0	70.0		50.0		80	1.10
						1.969	*1.000*	*2.756*	*2.756*		*1.969*		*1160*	
C6	3/4	3	4	2	C6-A391.05C-19 080	63.0	19.1	80.0	40.0	80.0	43.0	63.0	80	1.50
						2.480	*.750*	*3.150*	*1.575*	*3.150*	*1.693*	*2.480*	*1160*	
	1	3	4	2	C6-A391.05C-25 080	63.0	25.4	80.0	55.0	80.0	50.0	63.0	80	1.60
						2.480	*1.000*	*3.150*	*2.165*	*3.150*	*1.969*	*2.480*	*1160*	
C8	3/4	3	4	2	C8-A391.05C-19 090	80.0	19.1	90.0	45.0	90.0	43.0	80.0	80	2.50
						3.150	*.750*	*3.543*	*1.772*	*3.543*	*1.693*	*3.150*	*1160*	
	1	3	4	2	C8-A391.05C-25 090	80.0	25.4	90.0	50.0	90.0	50.0	80.0	80	2.60
						3.150	*1.000*	*3.543*	*1.969*	*3.543*	*1.969*	*3.150*	*1160*	

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

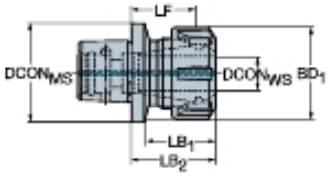
150 155

ENG

Coromant Capto® to ER collet chuck

Short design, for segment clamping only

Workpiece side interface DIN 6499-B

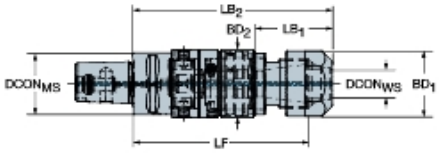


					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BAR PSI	KG
C3	ER16	3	1	**C3-391.14-16 035**	32.0	16.0	24.0	26.6	34.6	28.0	80	0.10
					1.260	*.630*	*.945*	*1.047*	*1.362*	*1.102*	*1160*	
C4	ER16	3	1	**C4-391.14-16 035**	40.0	16.0	24.0	26.6	34.6	28.0	80	0.20
					1.575	*.630*	*.945*	*1.047*	*1.362*	*1.102*	*1160*	
C5	ER20	3	1	**C5-391.14-20 036**	50.0	20.0	24.0	27.5	35.5	35.0	80	0.30
					1.969	*.787*	*.945*	*1.083*	*1.398*	*1.378*	*1160*	
	ER25	3	1	**C5-391.14-25 037**	50.0	25.0	25.0	29.0	37.0	42.0	80	0.30
					1.969	*.984*	*.984*	*1.142*	*1.457*	*1.654*	*1160*	

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

Coromant Capto® to CoroChuck™ 970

Workpiece side interface DIN 6499-B



						Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BAR PSI	KG
C6	ER32	M27	3	1	**970-C6-32-128**	63.0	32.0	118.3	105.8	127.8	50.0	80	1.53
						2.480	*1.260*	*4.657*	*4.165*	*5.032*	*1.969*	*1160*	
C8	ER32	M27	3	1	**970-C8-32-135**	80.0	32.0	125.3	104.8	134.8	50.0	80	2.50
						3.150	*1.260*	*4.933*	*4.126*	*5.307*	*1.969*	*1160*	

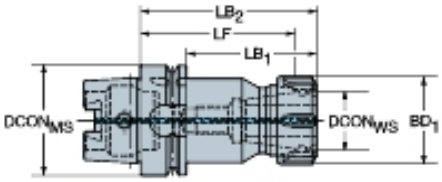
For spare parts, visit www.sandvik.coromant.com

150 155

HSK to ER collet chuck

Machine side interface HSK A/C

Workpiece side interface DIN 6499-B



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BAR PSI	KG
63.0	ER20	1	1	**392.41014-63 20 100**	63.0	20.0	88.5	71.0	100.0	34.0	80	1.02
					2.480	*.787*	*3.484*	*2.797*	*3.937*	*1.339*	*1160*	

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

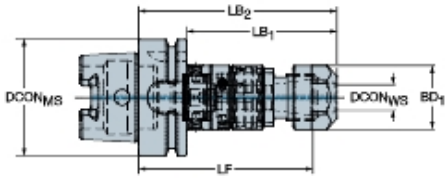
150 155

ENG

HSK to CoroChuck™ 970

Machine side interface HSK A/C

Workpiece side interface DIN 6499-B



CZC$_{MS}$	CZC$_{WS}$	TRMAX	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BAR PSI	KG
63.0	ER32	M27	1	1	**970-HA06-32-131**	63.0	32.0	121.7	105.2	131.2	50.0	80	1.41
						2.480	*1.260*	*4.791*	*4.142*	*5.165*	*1.969*	*1160*	
100.0	ER32	M27	1	1	**970-HA10-32-138**	100.0	32.0	128.2	108.7	137.7	50.0	80	2.80
						3.937	*1.260*	*5.047*	*4.280*	*5.421*	*1.969*	*1160*	

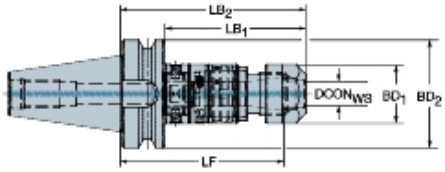
For spare parts, visit www.sandvik.coromant.com

150 155

ISO 7388-1 to CoroChuck™ 970

Machine side interface compatible with DIN 69871-AD

Workpiece side interface DIN 6499-B



CZC$_{MS}$	CZC$_{WS}$	TRMAX	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON	CRKS	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR PSI	KG
40.0	ER32	M27	1	1	**970-I40-32-125**	32	M16	115.8	106.2	125.3	50.0	63.5	80	1.58
						1.260		*4.559*	*4.181*	*4.933*	*1.969*	*2.500*	*1160*	
50.0	ER32	M27	1	1	**970-I50-32-129**	32	M24	119.8	110.2	129.3	50.0	97.5	80	3.36
						1.260		*4.717*	*4.339*	*5.091*	*1.969*	*3.837*	*1160*	

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

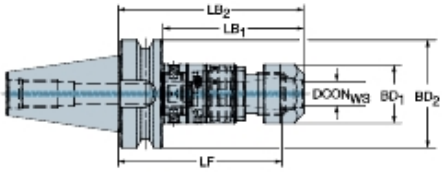
150 155

ENG

MAS-BT 403 to CoroChuck™ 970

Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6499-B



						Dimensions, mm, inch							BAR PSI	KG
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	**Ordering code**	DCON	CRKS	LF	LB_1	LB_2	BD_1	BD_2		
40.0	ER32	M27	1	1	**970-B40-32-133**	32	M16	123.8	106.3	133.3	50.0	63.0	80	1.74
						1.260		*4.874*	*4.185*	*5.248*	*1.969*	*2.480*	*1160*	
50.0	ER32	M27	1	1	**970-B50-32-148**	32	M24	138.8	110.3	148.3	50.0	100.0	80	4.33
						1.260		*5.465*	*4.343*	*5.839*	*1.969*	*3.937*	*1160*	

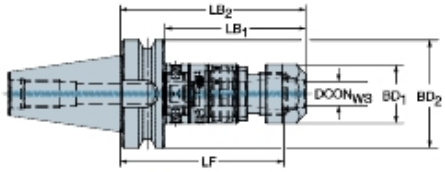
For spare parts, visit www.sandvik.coromant.com

150 155

CAT-V to CoroChuck™ 970

Machine side interface ASME B5.50-2009

Workpiece side interface DIN 6499-B



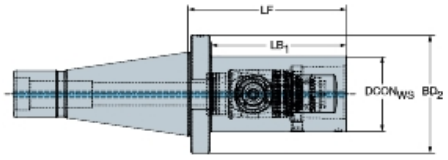
						Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	**Ordering code**	DCON	CRKS	LF	LB_1	LB_2	BD_1	BD_2	BAR PSI	KG
40.0	ER32	M27	1	1	**970-V40-32-125**	32	5/8"-11	115.8	106.2	125.3	50.0	63.5	80	1.59
						1.260		*4.559*	*4.181*	*4.933*	*1.969*	*2.500*	*1160*	
50.0	ER32	M27	1	1	**970-V50-32-129**	32	1"-8	119.8	110.2	129.3	50.0	98.4	80	3.36
						1.260		*4.717*	*4.339*	*5.091*	*1.969*	*3.874*	*1160*	

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

150 155

ENG

DIN 2080 to Coromant Capto® adaptor with Quick change

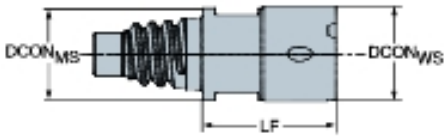


					Dimensions, mm, inch						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	BAR PSI	KG
40.0	C5	1	1	**DN40-QC-C5-095**	M16	50.0	95.0	83.4	62.8	80	1.70
						1.969	*3.740*	*3.283*	*2.472*	*1160*	
50.0	C8	1	1	**DN50-QC-C8-140**	M24	80.0	140.0	124.8	97.3	80	6.30
						3.150	*5.512*	*4.913*	*3.831*	*1160*	

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

150 155

Coromant EH to CoroMill® 327 adaptor



					Dimensions, mm, inch					
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	BD_1	BAR PSI	KG
E10	09	1	3	**327-EH10-09-015**	9.7	9.0	15.0	10.0	20	0.02
					.382	*.354*	*.591*	*.394*	*290*	
E12	12	1	3	**327-EH12-12-017**	11.7	12.0	17.0	12.0	20	0.02
					.461	*.472*	*.669*	*.472*	*290*	
	14	1	3	**327-EH12-14-017**	11.7	14.3	17.0	14.3	20	0.01
					.461	*.563*	*.669*	*.563*	*290*	

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

150 155

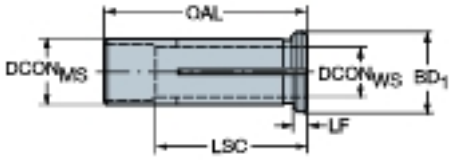
ENG

Accessories

Sleeves and collets

Cylindrical sleeves

Precision coolant supply



Metric version

					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	OAL	LF	LB_1	BD_1	BAR	KG
12	3.00	1	4	**393.CF-12 03 40**	12.00	3.00	40.00	44.00	4	4.00	16.00	80	0.03
	4.00	1	4	**393.CF-12 04 40**	12.00	4.00	36.00	44.00	4	4.00	16.00	80	0.03
	5.00	1	4	**393.CF-12 05 40**	12.00	5.00	36.00	44.00	4	4.00	16.00	80	0.03

Inch version

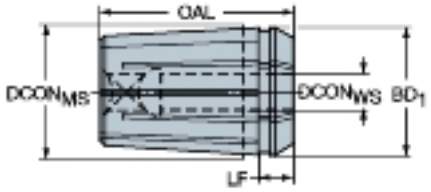
					Dimensions, inch								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	OAL	LF	LB_1	BD_1	PSI	LBS
12	1/4	1	4	**A393.CF-12 04 40**	.472	.250	1.417	1.732	0	.157	.630	1160	.070
20	1/2	1	4	**A393.CF-20 08 52**	.787	.500	1.968	2.125	0	.157	.984	1160	.193
	3/8	1	4	**A393.CF-20 06 52**	.787	.375	1.496	2.125	0	.157	.984	1160	.215
	5/8	1	4	**A393.CF-20 10 52**	.787	.625	1.968	2.125	0	.157	.984	1160	.134

150 155

ENG

ER Collet for tap shank

Compatible with DIN 6499-B

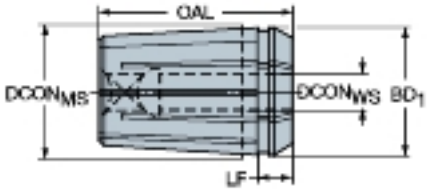


CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$DCON_{WS}$	OAL	LF	BAR PSI	KG
ER32	10.00 x 8.00	1	1	393.14-32 D100X080	32	10	40	9	80	0.148
					1.260	.394	1.575	.358	1160	
	11.00 x 9.00	1	1	393.14-32 D110X090	32	11	40	9	80	0.150
					1.260	.433	1.575	.358	1160	
	12.00 x 9.00	1	1	393.14-32 D120X090	32	12	40	9	80	0.140
					1.260	.472	1.575	.358	1160	
	14.00 x 11.00	1	1	393.14-32 D140X110	32	14	40	9	80	0.135
					1.260	.551	1.575	.358	1160	
	16.00 x 12.00	1	1	393.14-32 D160X120	32	16	40	9	80	0.125
					1.260	.630	1.575	.358	1160	
	18.00 x 14.50	1	1	393.14-32 D180X145	32	18	40	9	80	0.110
					1.260	.709	1.575	.358	1160	
	20.00 x 16.00	1	1	393.14-32 D200X160	32	20	40	9	80	0.093
					1.260	.787	1.575	.358	1160	

150 155

ER Collet for tap shank

Compatible with DIN 6499-B



For inch standard taps

CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$DCON_{WS}$	OAL	LF	BAR PSI	KG
ER32	.318 x .238	1	1	A393.14-32-5/16	32	8	40	9	80	0.200
					1.260	.318	1.575	.358	1160	
	.323 x .242	1	1	A393.14-32-1/2	32	8	40	9	80	0.144
					1.260	.323	1.575	.358	1160	
	.367 x .275	1	1	A393.14-32-3/8	32	9	40	9	80	0.200
					1.260	.367	1.575	.358	1160	
	.381 x .286	1	1	A393.14-32-7/16	32	9	40	9	80	0.200
					1.260	.381	1.575	.358	1160	
	.480 x .360	1	1	A393.14-32-5/8	32	12	40	9	80	0.200
					1.260	.480	1.575	.358	1160	
	.590 x .442	1	1	A393.14-32-3/4	32	14	40	9	80	0.200
					1.260	.590	1.575	.358	1160	
	.697 x .523	1	1	A393.14-32-7/8	32	17	40	9	80	0.112
					1.260	.697	1.575	.358	1160	

150 155

ENG

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.

C

What does this mean to you?

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

D

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

E

F

G

H

I

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

ENG

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

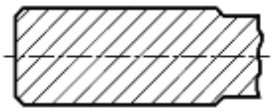
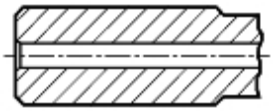
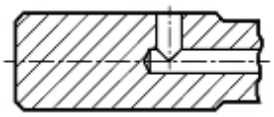
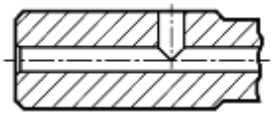
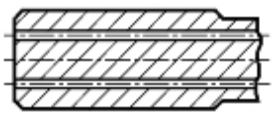
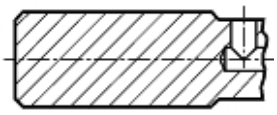
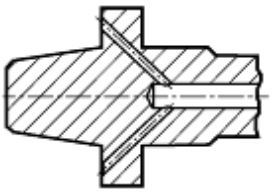
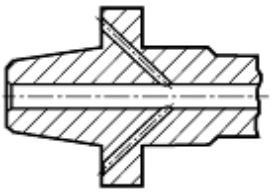
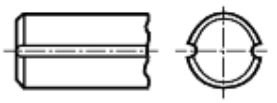
- A worldwide ISO and OHAS certified recycling system.
- Open to all Sandvik Coromant customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.

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

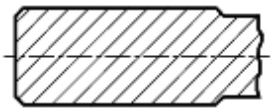
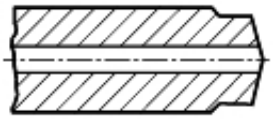
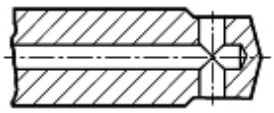
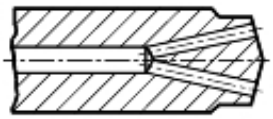
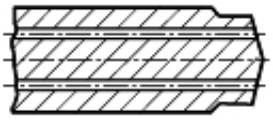
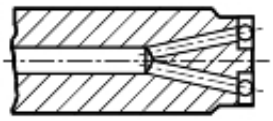
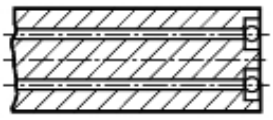
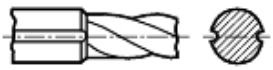
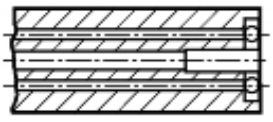
CNSC

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

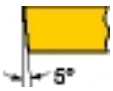
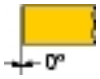
Inserts, advanced cutting materials, inch

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

4 Insert type

A		Q	
G		R	
M		T	
N		W	
P		X	 Special design

5 Insert size

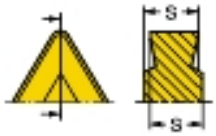
Inscribed circle is indicated in 1/8".

*) For insert shape K (KNMX, KNUX) only the theoretical cutting edge length is indicated.

1) Metric base design
2) Inch base design

Cutting edge length, metric									
IC mm	IC inch	C	D	R	S	T	V	W	K
3.18	1/8"					05			
3.97	5/32"					06		02	
5.0				05					
5.56	7/32"			09					
6.0			06						
6.35	1/4"	06	07			11	11	04	
8.0				08					
9.525	3/8"	09	11	09	09	16	16	06	16*)
10.0	10.0			10					
12.0				12					
12.7	1/2"	12	15	12	12	22	22	08	
13			13				13		
15.875	5/8"	16		15	15	27			
16.0				16					
19.0	3/4"	19		19	19	33			
20.0				20					
25.0				25 1)					
25.4	1"	25		25 2)	25				
31.75	1/4"			31					
32				32					

6 Insert thickness, S mm, inch



Metric			Inch		
01	S =	1.59	1	S	.0625
T1	S =	1.98	(1.2)	S	.075
02	S =	2.38	(1.5)	S	3/32
03	S=	3.18	2	S	1/8
T3	S =	3.97	(2.5)	S	5/32
04	S =	4.76	3	S	3/16
05	S =	5.56	4	S	1/4
06	S =	6.35	5	S	5/16
07	S =	7.94	6	S	3/8
09	S =	9.52	6.3	S	.394
10	S =	10.00	7.6	S	.475
12	S =	12.00			

7 Nose radius, RE mm, inch

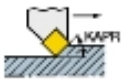
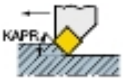
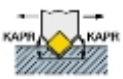
Metric: Code	Value	Inch: Code		Value
00	0	00		0
01	0.1	.30		.004
		03	(older)	.004
02	0.2	.50		.008
		0	(older)	.008
04	0.4	1		0.16
05	0.5			
08	0.8	2		.031
10	1.0			
12	1.2	3		.047
15	1.5			
16	1.6	4		.063
24	2.4	6		.094
32	3.2	8		.125

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.

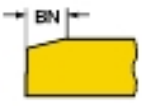
8 Cutting edge condition

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

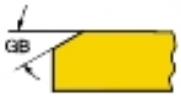
R		Feed	
L	Feed		
N	Feed		Feed

10 Chamfer width metric, inch



Metric:
010 BN = 0.10
025 BN = 0.25
070 BN = 0.70
150 BN = 1.50
200 BN = 2.00
Inch:
03 BN = .003
08 BN = .008
30 BN = .030
60 BN = .060
80 BN = .080

11 Chamfer angle



15 GB = 15°
20 GB = 20°

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