
New cutting tools





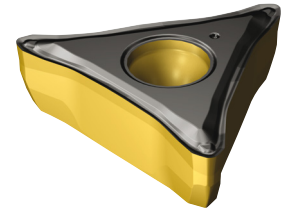
General turning	A
Milling	B
Drilling	C
Boring	D
Rotating tool adaptors	E
Accessories	F
General information	G

General turning

CoroTurn® Prime

L3WX wiper geometry for A-type inserts

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



See page A2

CoroTurn® TR and CoroTurn® 107

With over and under coolant capabilities

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



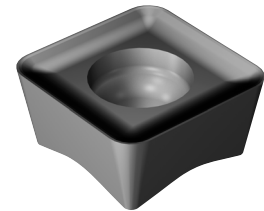
See chapter A

Milling

CoroMill® 415 insert for milling

New insert geometry

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



See page B2

CoroMill® 390 square shoulder milling cutter

Lightweight shoulder milling cutter

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



See page B3

CoroMill® Plura

Heavy duty milling

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



See page B4

CoroMill® 316

Grade GC1730

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



See chapter B

Drilling

CoroDrill® DS20

Indexable insert drill

Extended assortment with new drill diameters and insert size

See page C2



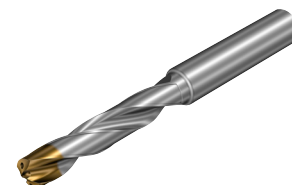
B

CoroDrill® 860-GM

Solid carbide drill

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

See page C5



C

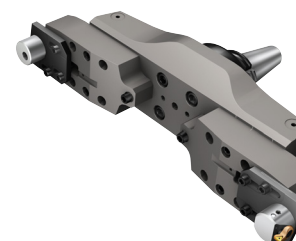
Boring

CoroBore 826

CoroBore® XL

New CoroBore® 826 fine boring heads with high precision nozzles

See page D3



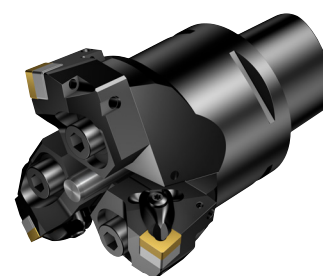
D

CoroBore® BR30

Extended assortment

Larger diameters now available.

See page D2



E

Tooling systems

CoroChuck™ 930

Extended assortment with new slender and pencil dimensions

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

See chapter E



F

G



SAND
CORPORATION

General turning

CoroTurn® Prime

Inserts A2

CoroTurn® TR

External tools A4-A6

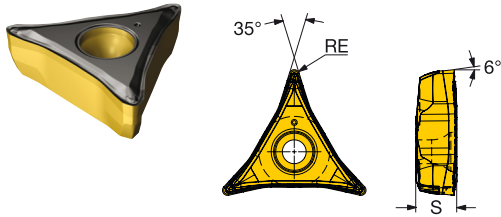
CoroTurn® 107

External tools A7-A10

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

CoroTurn® Prime insert for turning

A-type insert



B

C

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

D

E

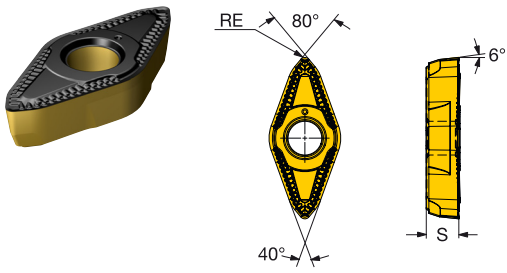
F

G



CoroTurn® Prime insert for turning

B-type insert



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

SSC = To correspond with SSC on holder.



G2

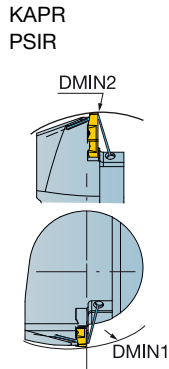
A

CoroTurn® TR cutting unit for turning

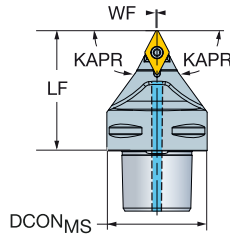
Screw clamp design

Coromant Capto® - Internal coolant supply

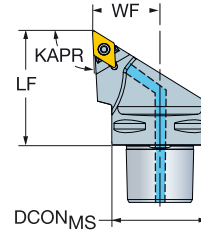
B



Cx-TR-D13NCN..C
62.5°
27.5°



Cx-TR-D13JCR/L..C
93.0°
-3.0°



C

TR-DC

D

	CZC _{MS}	DMIN ₁	DMIN ₂	RMPX	CNCS	Ordering code	Dimensions, mm, inch						MIID	
							DCON _{MS}	LF	WF	BAR PSI	NM	KG		
	13	C4	251.0	150.0	27°	3	C4-TR-D13JCR/L-27050C	40	50.0	27.0	150	3.0	0.37	TR-DC1308
			9.882	5.906				1.575	1.969	1.063	2175			
		C5	249.0	175.0	27°	3	C5-TR-D13JCR/L-35060C	50	60.0	35.0	150	3.0	0.69	TR-DC1308
			9.803	6.890				1.969	2.362	1.378	2175			
		C6	253.0	240.0	27°	3	C6-TR-D13JCR/L-45065C	63	65.0	45.0	150	3.0	1.39	TR-DC1308
		9.961	9.449				2.480	2.559	1.772	2175				
	C8	253.0	250.0	27°	3	C8-TR-D13JCR/L-55080C	80	80.0	55.0	150	3.0	2.54	TR-DC1308	
		9.961	9.843				3.150	3.150	2.165	2175				
	13	C4		140.0	57°	3	C4-TR-D13NCN-00050C	40	50.0	0.5	150	3.0	0.32	TR-DC1308
			5.512					1.575	1.969	.020	2175			
		C5		165.0	57°	3	C5-TR-D13NCN-00060C	50	60.0	0.5	150	3.0	0.62	TR-DC1308
			6.496					1.969	2.362	.020	2175			
	C6		190.0	57°	3	C6-TR-D13NCN-00065C	63	65.0	0.5	150	3.0	1.06	TR-DC1308	
		7.480					2.480	2.559	.020	2175				

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

E

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

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

F

G



G2



G5

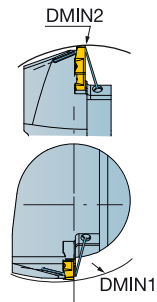
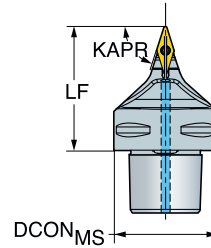
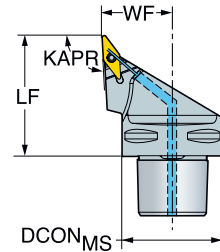
ENG

CoroTurn® TR cutting unit for turning

Screw clamp design

Coromant Capto® - Internal coolant supply



KAPR
PSIRCx-TR-V13VBN..C
72.5°
17.5°Cx-TR-V13JBR/L..C
93.0°
-3.0°

B

C

		CZC _{MS}	DMIN ₁	DMIN ₂	RMPX	CNCS	Ordering code	Dimensions, mm, inch						MIID	
								DCON _{MS}	LF	WF	BAR PSI	NM	KG		
	13	C4	253.0	140.0	50°	3	C4-TR-V13JBR/L-27050C	40	50.0	27.0	150	2.0	0.34	TR-VB1308	
			9.961	5.512					1.575	1.969	1.063	2175			
			228.0	165.0	50°	3	C5-TR-V13JBR/L-35060C	50	60.0	35.0	150	2.0	0.68	TR-VB1308	
			8.976	6.496					1.969	2.362	1.378	2175			
	13	C4	232.0	190.0	50°	3	C6-TR-V13JBR/L-45065C	63	65.0	45.0	150	2.0	1.13	TR-VB1308	
			9.134	7.480					2.480	2.559	1.772	2175			
			233.0	250.0	50°	3	C8-TR-V13JBR/L-55080C	80	80.0	55.0	150	2.0	2.44	TR-VB1308	
			9.173	9.843					3.150	3.150	2.165	2175			
	13	C4	140.0	70°	3	C4-TR-V13VBN-00050C	40	50.0	0.5	150	2.0	0.29	TR-VB1308		
			5.512						1.575	1.969	.020	2175			
			165.0	70°	3	C5-TR-V13VBN-00060C	50	60.0	0.5	150	2.0	0.58	TR-VB1308		
			6.496						1.969	2.362	.020	2175			
	13	C6	190.0	70°	3	C6-TR-V13VBN-00065C	63	65.0	0.5	150	2.0	1.00	TR-VB1308		
			7.480						2.480	2.559	.020	2175			

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

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

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

D

E

F

G



G2



G5

A

CoroTurn® TR cutting unit for turning

Screw clamp design

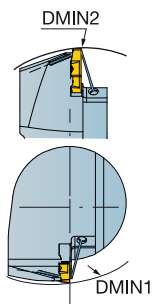
Coromant Capto® - Internal coolant supply

ENG

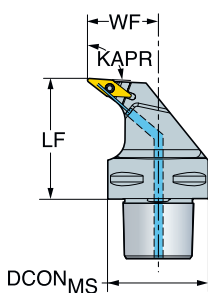
B



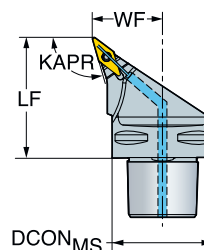
KAPR



Cx-TR-V13UBR/L..C
93.0°



Cx-TR-V13HBR/L..C
107.5°



C

TR-VB

D

	CZC _{MS}	DMIN ₁	DMIN ₂	RMPX	CNCS	Ordering code	Dimensions, mm, inch						MID	
							DCON _{MS}	LF	WF	BAR PSI	NM	KG		
	13	C5	99.0	165.0	35°	3	C5-TR-V13HBR/L-35060C	50	60.0	35.0	150	2.0	0.64	TR-VB1308
			3.898	6.496				1.969	2.362	1.378	2175			
		C6	150.0	190.0	35°	3	C6-TR-V13HBR/L-45065C	63	65.0	45.0	150	2.0	1.15	TR-VB1308
			5.906	7.480				2.480	2.559	1.772	2175			
		C8	133.0	250.0	35°	3	C8-TR-V13HBR/L-55080C	80	80.0	55.0	150	2.0	2.46	TR-VB1308
		5.236	9.843				3.150	3.150	2.165	2175				
	C4	95.0	140.0	35°	3	C4-TR-V13HBR/L-27050C	40	50.0	27.0	150	2.0	0.35	TR-VB1308	
		3.740	5.512				1.575	1.969	1.063	2175				
	13	C5	67.0	165.0	50°	3	C5-TR-V13UBR/L-35060C	50	60.0	35.0	150	2.0	0.71	TR-VB1308
			2.638	6.496				1.969	2.362	1.378	2175			
		C6	118.0	190.0	50°	3	C6-TR-V13UBR/L-45065C	63	65.0	45.0	150	2.0	1.24	TR-VB1308
			4.646	7.480				2.480	2.559	1.772	2175			
		C8	100.0	250.0	50°	3	C8-TR-V13UBR/L-55080C	80	80.0	55.0	150	2.0	2.61	TR-VB1308
		3.937	9.843				3.150	3.150	2.165	2175				
	C4	54.0	140.0	50°	3	C4-TR-V13UBR/L-27050C	40	50.0	27.0	150	2.0	0.38	TR-VB1308	
		2.126	5.512				1.575	1.969	1.063	2175				

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

E

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

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

F

G



G2

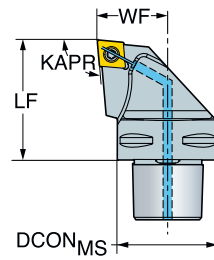
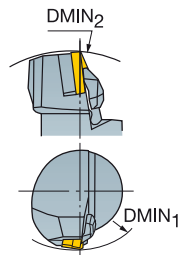


G5

CoroTurn® 107 cutting unit for turning

Screw clamp design

Coromant Capto® - Precision coolant supply

KAPR
PSIR95.0°
-5.0°

CCMT, CCGT

CCGX, CCET

CCMW

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

R = Right hand, L = Left hand

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

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

G2



G5

A

CoroTurn® 107 cutting unit for turning

Screw clamp design

Coromant Capto® - Precision coolant supply

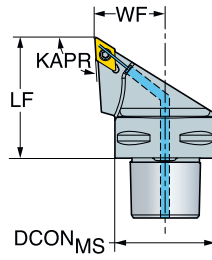
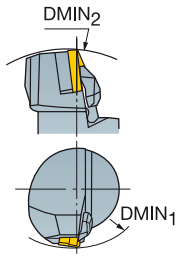
ENG

B



KAPR
PSIR

93.0°
-3.0°



C

- DCMT, DCMX
DCGT, DCGX, DCET
- DCMW

D

								Dimensions, mm, inch							
		CZC _{MS}	DMIN ₁	DMIN ₂	RMPX	CNSC	Ordering code	DCON _{MS}	LF	WF				MID	
															11
			9.606	5.315				1.260	1.575	.866	2175				
		C4	246.0	140.0	27°	3	C4-SDJCR/L-27050-11C	40	50.0	27.0	150	3.0	0.38	DCMT 11 T3 08	
			9.685	5.512				1.575	1.969	1.063	2175				
		C5	250.0	165.0	27°	3	C5-SDJCR/L-35060-11C	50	60.0	35.0	150	3.0	0.70	DCMT 11 T3 08	
			9.843	6.496				1.969	2.362	1.378	2175				
		C6	250.0	190.0	27°	3	C6-SDJCR/L-45065-11C	63	65.0	45.0	150	3.0	1.19	DCMT 11 T3 08	
			9.843	7.480				2.480	2.559	1.772	2175				

R = Right hand, L = Left hand

Spare parts

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

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

E

F

G



G2

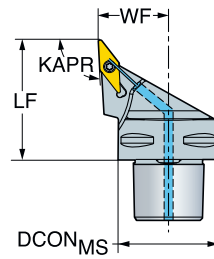
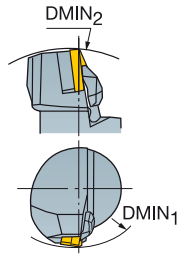


G5






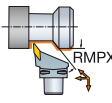
CoroTurn® 107 cutting unit for turning

Screw clamp design

Coromant Capto® - Precision coolant supply

KAPR
PSIRCx-SVJBR/L..C
93.0°
-3.0°

 VBMT, VBGT
VCGX,
VCGT, VCET
 VBW, VCMW

								Dimensions, mm, inch							
		CZC _{MS}	DMIN ₁	DMIN ₂	RMPX	CNSC	Ordering code	DCON _{MS}	LF	WF				MIID	
	11	1/4	C3	368.0	116.0	50°	3	C3-SVJBR/L-2204011B1C	32	40.0	22.0	150	0.9	0.18	VBMT 11 03 04
				14.488	4.567			1.260	1.575	.866	2175				
		C4	434.0	140.0	50°	3	C4-SVJBL-2705011B1C	40	50.0	27.0	150	0.9	0.36	VBMT 11 03 04	
			17.087	5.512			1.575	1.969	1.063	2175					
	16	3/8	C4	270.0	140.0	50°	3	C4-SVJBR/L-27050-16C	40	50.0	27.0	150	3.0	0.33	VBMT 11 03 04
				17.087	5.512			1.575	1.969	1.063	2175				
		C5	270.0	165.0	50°	3	C5-SVJBR/L-35060-16C	50	60.0	35.0	150	3.0	0.63	VBMT 11 03 04	
			10.630	6.496			1.969	2.362	1.378	2175					
C6	270.0	190.0	50°	3	C6-SVJBR/L-45065-16C	63	65.0	45.0	150	3.0	1.14	VBMT 11 03 04			
	10.630	7.480			2.480	2.559	1.772	2175							
C8	272.0	248.0	50°	3	C8-SVJBR/L-55080-16C	80	80.0	55.0	150	3.0	2.40	VBMT 11 03 04			
	10.709	9.764			3.150	3.150	2.165	2175							

R = Right hand, L = Left hand

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

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

G2



G5

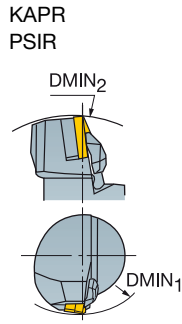
A

CoroTurn® 107 cutting unit for turning

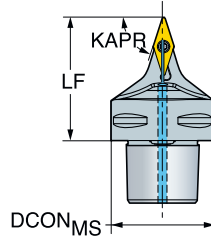
Screw clamp design

Coromant Capto® - Internal coolant supply

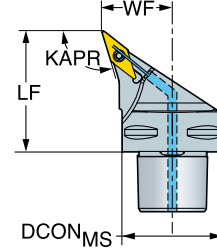
B



Cx-SVBN..C
72.5°
17.5°



Cx-SVHBR/L..C
107.5°
-17.5°



C

- VBMT, VBGT
- VCGX, VCGT, VCET
- VBMW, VCMW

D

									Dimensions, mm, inch							
				CZC _{MS}	DMIN ₁	DMIN ₂	RMPX	CNSC	Ordering code	DCON _{MS}	LF	WF				MIID
	16	3/8	C4	124.0	140.0	35°	3	C4-SVHBR/L-27050-16C	40	50.0	27.0	150	3.0	0.35	VBMT 16 04 08	
				4.882	5.512				1.575	1.969	1.063	2175				
			C5	124.0	165.0	35°	3	C5-SVHBR/L-35060-16C	50	60.0	35.0	150	3.0	0.63	VBMT 16 04 08	
				4.882	6.496				1.969	2.362	1.378	2175				
			C6	134.0	190.0	35°	3	C6-SVHBR/L-45065-16C	63	65.0	45.0	150	3.0	1.14	VBMT 16 04 08	
				5.276	7.480				2.480	2.559	1.772	2175				
	16	3/8	C5	165.0	70°	3	C4-SVBN-00055-16C	50	60.0	0.6	150	3.0	0.31	VBMT 16 04 08		
				6.496					1.969	2.362	.024	2175				
			C5	165.0	70°	3	C5-SVBN-00060-16C	50	60.0	0.6	150	3.0	0.55	VBMT 16 04 08		
				6.496					1.969	2.362	.024	2175				
			C6	190.0	70°	3	C6-SVBN-00065-16C	63	65.0	0.6	150	3.0	0.97	VBMT 16 04 08		
				7.480					2.480	2.559	.024	2175				

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

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

E

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

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

F

G



G2



G5

ENG

Milling

High-feed milling tools

CoroMill® 415 B2

Shoulder milling tools

CoroMill® 390 B3

Optimized solid milling tools

CoroMill® Plura solid carbide end mill for heavy duty milling	B4-B9
CoroMill® 316 solid carbide head for high chip load milling	B11
CoroMill® 316 solid carbide head for roughing with chip breaker	B12
CoroMill® 316 solid carbide head for profiling	B13-B14
CoroMill® 316 solid carbide head for finishing	B15-B16
CoroMill® 316 solid carbide head for chamfer milling	B17-B19

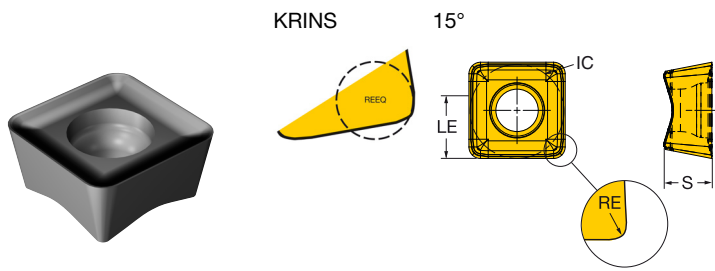
Cutting data B20-B25

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

CoroMill® 415 insert for milling

ENG

B



C

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

D

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

E

F

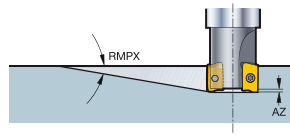
G



CoroMill® 390 square shoulder milling cutter

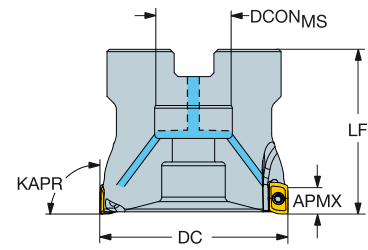
Arbor - Internal coolant supply

Lightweight shoulder milling cutter



KAPR

90°



Inch version

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

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

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



G2

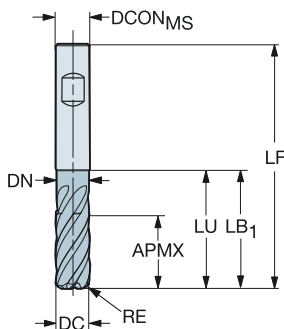


G5

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA 38°
 BSG COROMANT
 TCDC h10
 TCDCON h6



Metric version

						P		K		Dimensions, mm			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	1730	1730	DCON _{MS}	LF	DN	LB ₁	
10.0	10	22.0	0.50	30.0	5	2F342-1000-050-PD	★	☆	10.0	72.0	9.5	30.0	
	10	22.0	1.00	30.0	5	2F342-1000-100-PD	★	☆	10.0	72.0	9.5	30.0	
	10	22.0	2.00	30.0	5	2F342-1000-200-PD	★	☆	10.0	72.0	9.5	30.0	
12.0	12	26.0	0.50	36.0	5	2F342-1200-050-PD	★	☆	12.0	83.0	11.4	36.0	
	12	26.0	1.00	36.0	5	2F342-1200-100-PD	★	☆	12.0	83.0	11.4	36.0	
	12	26.0	2.00	36.0	5	2F342-1200-200-PD	★	☆	12.0	83.0	11.4	36.0	
16.0	16	34.0	0.50	42.0	5	2F342-1600-050-PD	★	☆	16.0	92.0	15.2	42.0	
	16	34.0	1.00	42.0	5	2F342-1600-100-PD	★	☆	16.0	92.0	15.2	42.0	
	16	34.0	2.00	42.0	5	2F342-1600-200-PD	★	☆	16.0	92.0	15.2	42.0	
20.0	20	42.0	1.00	52.0	5	2F342-2000-100-PD	★	☆	20.0	104.0	19.0	52.0	
	20	42.0	2.00	52.0	5	2F342-2000-200-PD	★	☆	20.0	104.0	19.0	52.0	

Inch version

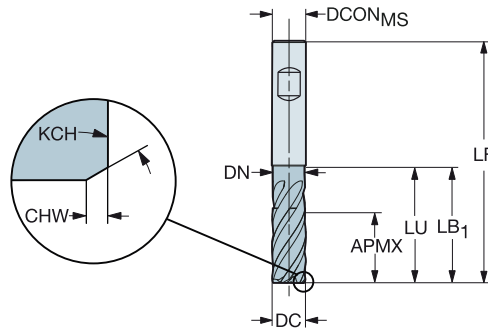
						P		K		Dimensions, inch			
DC	CZC _{MS}	APMX	RE	LU	ZEFP	Ordering code	1730	1730	DCON _{MS}	LF	DN	LB ₁	
.625	5/8	1.315	.030	1.625	5	2F342-1588-076-PD	★	☆	.625	3.500	.594	1.626	
	5/8	1.315	.060	1.625	5	2F342-1588-152-PD	★	☆	.625	3.500	.594	1.626	
.750	3/4	1.626	.030	1.937	5	2F342-1905-076-PD	★	☆	.750	4.000	.713	1.937	
	3/4	1.626	.060	1.937	5	2F342-1905-152-PD	★	☆	.750	4.000	.713	1.937	



CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA 38°
 BSG COROMANT
 TCDC h10
 TCDCON h6

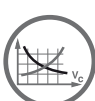


Metric version

							P	K	Dimensions, mm				
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	1730	1730	DCON _{MS}	LF	DN	LB ₁
10.0	10	22.0	0.15	45°	30.0	5	2N342-1000-PD	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.15	45°	36.0	5	2N342-1200-PD	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.25	45°	42.0	5	2N342-1600-PD	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	0.25	45°	52.0	5	2N342-2000-PD	★	☆	20.0	104.0	19.0	52.0
25.0	25	52.0	0.25	45°	63.0	5	2N342-2500-PD	★	☆	25.0	121.0	24.0	63.0

Inch version

							P	K	Dimensions, inch				
DC	CZC _{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	1730	1730	DCON _{MS}	LF	DN	LB ₁
.625	5/8	1.315	.010	45°	1.625	5	2N342-1588-PD	★	☆	.625	3.500	.594	1.625
.750	3/4	1.626	.010	45°	1.937	5	2N342-1905-PD	★	☆	.750	4.000	.713	1.937



B20



B26



G2



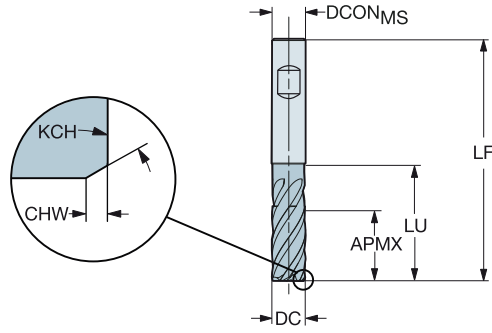
G6



CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA 42°
 BSG COROMANT
 TCDC h10
 TCDCON h6



C **Metric version**

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

D **Inch version**

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

E

F

G



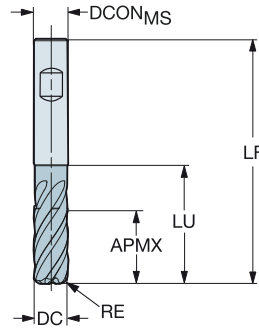
B 6



CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA 42°
 BSG COROMANT
 TCDC h10
 TCDCON h6



Metric version

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

Inch version

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



B20



B26



G2



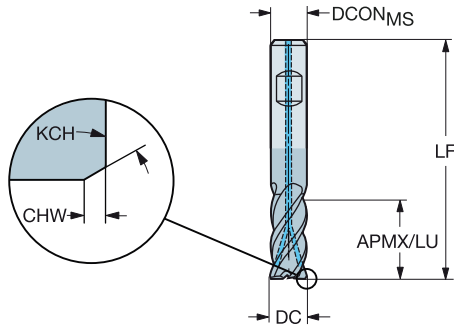
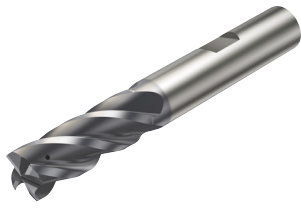
G6



CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

FHA 38°
 BSG COROMANT
 TCDC h10
 TCDCON h6



C **Metric version**

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

E

F

G

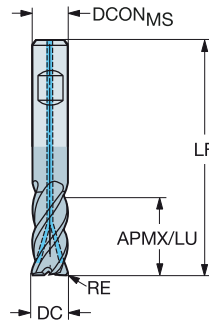


CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

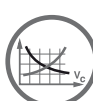
BSG
TCDC
TCDCON

COROMANT
h10
h6



Metric version

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



B20



B26



G2



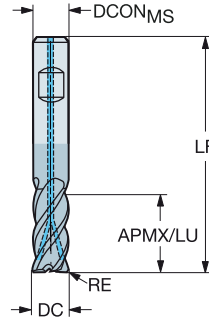
G6

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

BSG
TCDC
TCDCON

COROMANT
h10
h6



C Inch version

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

E

F

G

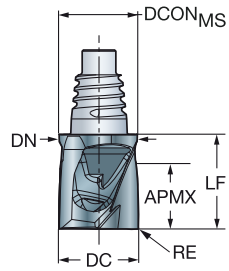


CoroMill® 316 solid carbide head for high chip load milling

For multi-material with hardness ≤ 48 HRc

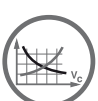
FHA
BSG
TCDC

10°
COROMANT
h10



Metric version

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



B21



B26



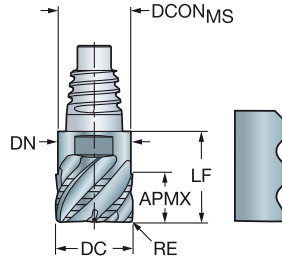
G2

CoroMill® 316 solid carbide head for roughing with chip breaker

For multi-material with hardness ≤ 48 HRc

FHA
BSG
TCDC

45°
COROMANT
h12



Metric version

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

Inch version

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

F

G

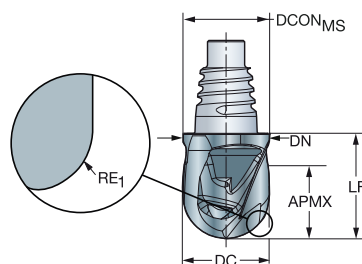
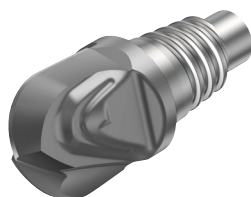


CoroMill® 316 solid carbide head for profiling

For multi-material with hardness ≤ 48 HRc

BSG
TCDC
PSIR

COROMANT
h9
0°



Metric version

DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Ordering code	P	M	K	S	Dimensions, mm		
							1730	1730	1730	1730	DCON _{MS}	LF	DN
10.0	E10	8.0	5.00	2	10°	316-10BM210-10050G	★	★	☆	☆	9.7	11.8	9.7
12.0	E12	10.0	6.00	2	10°	316-12BM210-12060G	★	★	☆	☆	11.7	14.0	11.7
16.0	E16	13.0	8.00	2	10°	316-16BM210-16080G	★	★	☆	☆	15.5	18.1	15.5

Inch version

DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Ordering code	P	M	K	S	Dimensions, inch		
							1730	1730	1730	1730	DCON _{MS}	LF	DN
.375	E10	.315	.188	2	10°	A316-10BM210-03750G	★	★	☆	☆	.364	.465	.382
.500	E12	.413	.250	2	10°	A316-12BM210-05060G	★	★	☆	☆	.484	.551	.461
.625	E16	.512	.313	2	10°	A316-16BM210-06280G	★	★	☆	☆	.610	.713	.610



B25



B26



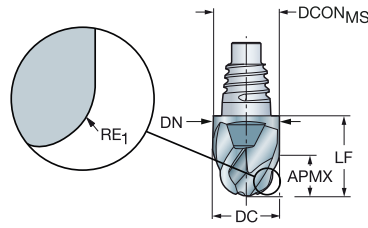
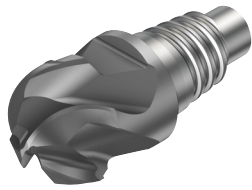
G2

CoroMill® 316 solid carbide head for profiling

For multi-material with hardness ≤ 48 HRC

BSG
TCDC
PSIR

COROMANT
h9
0°



C Metric version

DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Ordering code	P M K S				Dimensions, mm		
							1730	1730	1730	1730	DCON _{MS}	LF	DN
10.0	E10	5.5	5.00	4	40°	316-10BM440-10050G	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	6.00	4	40°	316-12BM440-12060G	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	8.00	4	40°	316-16BM440-16080G	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	10.00	2	40°	316-20BM240-200AG	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	10.00	4	40°	316-20BM440-200AG	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	12.50	4	40°	316-25BM440-250DG	★	★	☆	☆	24.2	25.6	24.2

D Inch version

DC	CZC _{MS}	APMX	RE ₁	ZEFP	FHA	Ordering code	P M K S				Dimensions, inch		
							1730	1730	1730	1730	DCON _{MS}	LF	DN
.375	E10	.209	.188	4	40°	A316-10BM440-03750G	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.250	4	40°	A316-12BM440-05060G	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.313	4	40°	A316-16BM440-06280G	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.375	4	40°	A316-20BM440-075AG	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.500	4	40°	A316-25BM440-100CG	★	★	☆	☆	.965	1.008	.965

F

G

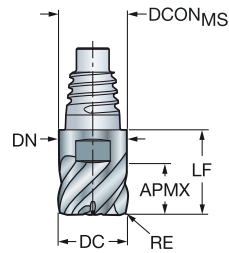
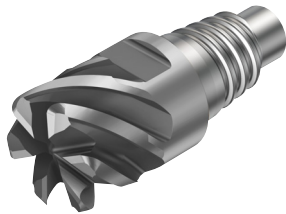


CoroMill® 316 solid carbide head for finishing

For multi-material with hardness ≤ 48 HRC

FHA
BSG
TCDC

50°
COROMANT
h9



Metric version

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

Inch version

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



B23



B26



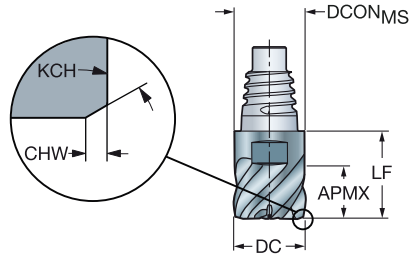
G2

CoroMill® 316 solid carbide head for finishing

For multi-material with hardness ≤ 48 HRc

FHA
BSG
TCDC

50°
COROMANT
h10



C **Metric version**

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

D

E

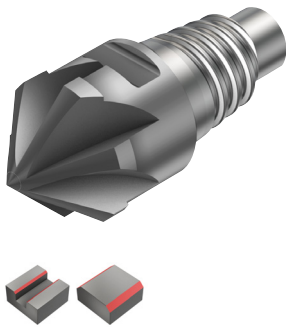
F

G



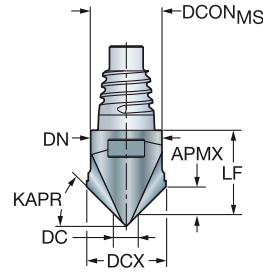
CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc



BSG

COROMANT



Metric version

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

Inch version

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



B24



B26



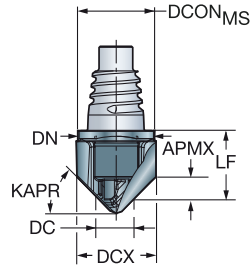
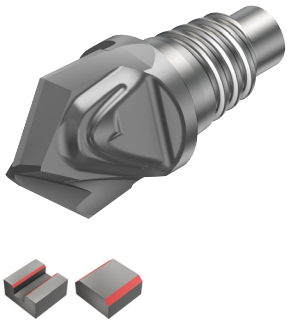
G2

CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc

BSG

COROMANT



B

Metric version

C

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

D

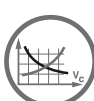
Inch version

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

E

F

G



B24



B26



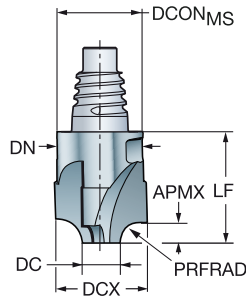
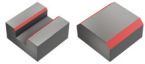
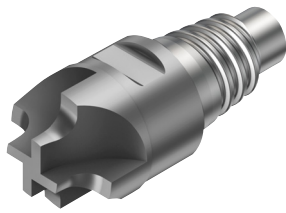
G2

CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRC

BSG

COROMANT

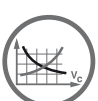


Metric version

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

Inch version

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



B24



B26



G2

Cutting speed recommendations

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

ENG



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

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

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

Cutting speed recommendations

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



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

For optimized cutting data see CoroPlus® ToolGuide.

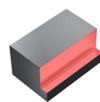
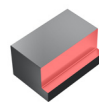
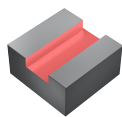
Feed recommendations

mm/tooth
inch/tooth

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

Cutting speed recommendations

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



$a_e = 1.0 \times DC$

$a_e = 0.5 \times DC$

$a_e = 0.1 \times DC$

$a_p = 0.5 \times DC$

$a_p = 1.0 \times DC$

$a_p = 1.5 \times DC$

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

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations



mm/tooth
inch/tooth

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

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for finishing



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

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth

inch/tooth

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

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for chamfer milling



$$a_e = 0.1 \times DC$$

$$a_p = 0.1 \times DC$$

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

For optimized cutting data see CoroPlus® ToolGuide.

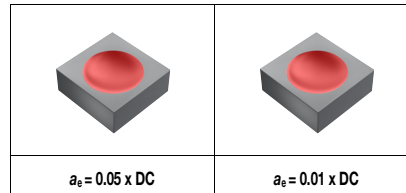
Feed recommendations

mm/tooth
inch/tooth

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

Cutting speed recommendations

Optimized - CoroMill® 316 solid carbide head for profiling



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

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth

inch/tooth

DC	1.000	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	16.000	20.000	25.000	25.400
f_z	0.039	0.079	0.118	0.157	0.236	0.250	0.313	0.315	0.375	0.394	0.472	0.500	0.630	0.787	0.984	1.000
N01	0.020	0.030	0.050	0.060	0.080	0.080	0.120	0.120	0.150	0.150	0.150	0.150	0.160	0.020	0.025	0.025
N02	0.020	0.030	0.040	0.050	0.060	0.060	0.100	0.100	0.120	0.120	0.120	0.120	0.140	0.016	0.020	0.020
N03	0.060	0.080	0.100	0.130	0.180	0.180	0.260	0.260	0.330	0.330	0.330	0.330	0.380	0.440	0.500	0.500
N04	0.030	0.050	0.080	0.100	0.120	0.120	0.150	0.150	0.200	0.200	0.200	0.200	0.200	0.250	0.250	0.250
N05	0.020	0.040	0.065	0.080	0.100	0.100	0.120	0.120	0.160	0.160	0.160	0.160	0.160	0.200	0.200	0.200
N06	0.070	0.110	0.175	0.220	0.260	0.260	0.330	0.330	0.440	0.440	0.440	0.440	0.440	0.500	0.500	0.500

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

For composite materials

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

Feed is same for all diameters.

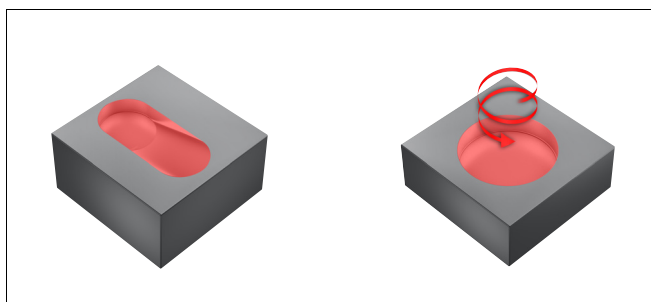
Maximum ramping angle

CoroMill® Plura - Optimized

CoroMill® Plura - Versatile

CoroMill® 316

B



Number of teeth (ZFP)

C

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

D

Grades for milling

E

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

G

Drilling

Indexable drills

CoroDrill® DS20 C2-C4

Optimized solid drilling tools

CoroDrill® 860 solid carbide drill C5-C13

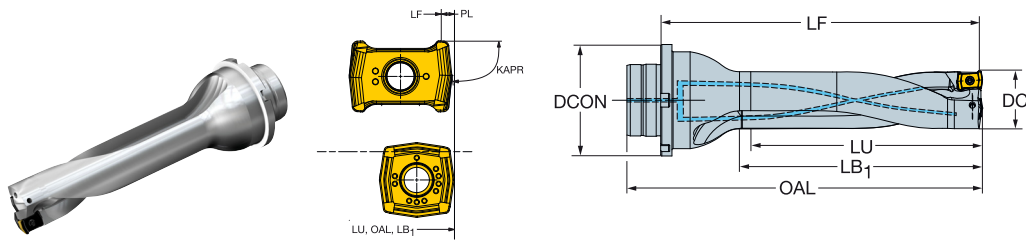
Cutting data C36-C35

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

CoroDrill® DS20 indexable insert drill

Modular drill interface

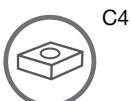
Internal coolant supply



										Dimensions, mm									
DC			LU	CZC _{MS}	ADJLX	TCHAL	TCHAU	Ordering code		DCON _{MS}	LF	OAL	LB ₁	PL	KAPR	BAR	KG	RPMX	
28.00	04C	04P	112.00	MDI-32	2.12	0.00	0.33	DS20-D2800DM32-04	32.00	150.16	166.00	116.00	0.83	81°	10	0.705	13000		
			196.00	MDI-32	2.12	-0.10	0.40	DS20-D2800DM32-07	32.00	234.16	250.00	200.00	0.83	81°	10	0.901	4000		
28.57	04C	04P	114.30	MDI-32	1.95	0.00	0.33	DS20-D2858DM32-04	32.00	151.82	167.65	117.90	0.83	81°	10	0.718	13000		
			200.02	MDI-32	1.95	-0.10	0.40	DS20-D2858DM32-07	32.00	237.54	253.37	203.63	0.83	81°	10	0.927	4000		
29.00	04C	04P	116.00	MDI-32	1.84	0.00	0.33	DS20-D2900DM32-04	32.00	154.16	170.00	120.00	0.83	81°	10	0.734	12000		
			203.00	MDI-32	1.84	-0.10	0.40	DS20-D2900DM32-07	32.00	241.16	257.00	207.00	0.83	81°	10	0.952	4000		
30.00	04C	04P	120.00	MDI-32	1.56	0.00	0.33	DS20-D3000DM32-04	32.00	158.16	174.00	124.00	0.83	81°	10	0.766	12000		
			210.00	MDI-32	1.56	-0.10	0.40	DS20-D3000DM32-07	32.00	248.16	264.00	214.00	0.83	81°	10	1.008	4000		
30.14	04C	04P	120.59	MDI-32	1.51	0.00	0.33	DS20-D3015DM32-04	32.00	157.99	173.82	124.20	0.83	81°	10	0.767	12000		
			211.04	MDI-32	1.51	-0.10	0.40	DS20-D3015DM32-07	32.00	248.44	264.27	214.65	0.83	81°	10	1.012	4000		
31.00	04C	04P	124.00	MDI-32	1.28	0.00	0.35	DS20-D3100DM32-04	32.00	164.16	180.00	128.00	0.83	81°	10	0.818	12000		
			217.00	MDI-32	1.28	-0.10	0.40	DS20-D3100DM32-07	32.00	256.16	272.00	221.00	0.83	81°	10	1.075	4000		
31.75	04C	04P	127.00	MDI-32	1.07	0.00	0.35	DS20-D3175DM32-04	32.00	166.27	182.10	130.60	0.83	81°	10	0.839	11000		
			222.25	MDI-32	1.07	-0.10	0.40	DS20-D3175DM32-07	32.00	261.49	277.33	225.85	0.83	81°	10	1.125	3000		
32.00	04C	04P	128.00	MDI-40	1.00	0.00	0.35	DS20-D3200DM40-04	40.00	175.16	191.00	132.00	0.83	81°	10	1.260	11000		
			224.00	MDI-40	1.00	-0.10	0.40	DS20-D3200DM40-07	40.00	271.16	287.00	228.00	0.83	81°	10	1.553	3000		
33.00	04C	04P	132.00	MDI-40	0.72	0.00	0.35	DS20-D3300DM40-04	40.00	179.16	195.00	136.00	0.83	81°	10	1.299	11000		
			231.00	MDI-40	0.72	-0.10	0.40	DS20-D3300DM40-07	40.00	278.16	294.00	235.00	0.83	81°	10	1.620	3000		

Spare parts
Insert screw
5513 020-57

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



C4



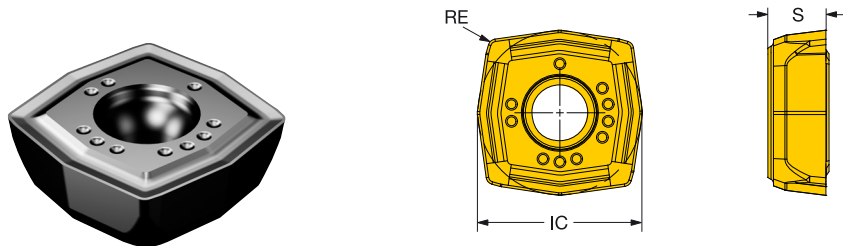
G2



G5

CoroDrill® DS20 insert for drilling

Central insert

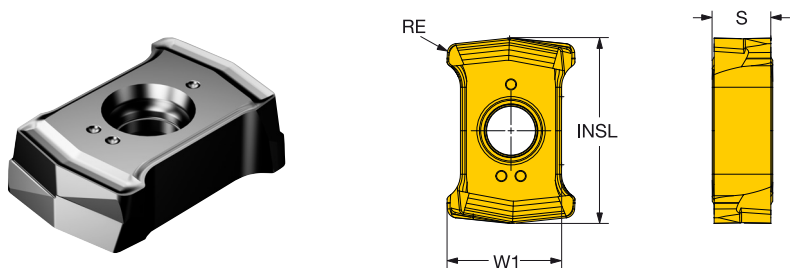


B

C

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

Peripheral insert



D

E

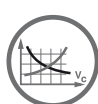
INSUC	Ordering code	Material						Dimensions, mm		
		P	M	K	N	S	H	S	RE	W1
P	DS20-0407-P-H5W	☆	☆	☆	☆	☆		4.25	0.70	9.2
	DS20-0407-P-L5W	★	★	★	☆	☆		.167	.028	.366
04P	DS20-0407-P-L6W		☆		☆		★	4.25	0.70	9.2
	DS20-0407-P-M7W	☆	★	☆		☆	★	.167	.028	.366
P	DS20-0407-P-S5W				☆	★	★	4.25	0.70	9.2
								.167	.028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

F

G



C2



C14

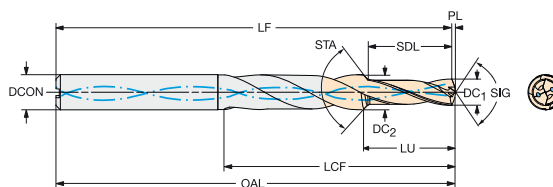
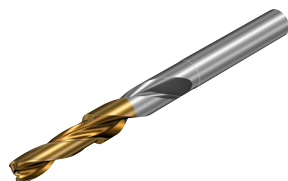


G2

CoroDrill® 860 solid carbide drill

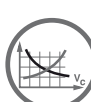
For multi-materials
Internal coolant supply

TCHA H9
SIG 140°



Step and chamfer drill

											P	M	K	N	S	H	Dimensions, mm, inch										
											XI BM	XI BM	XI BM	XI BM	XI BM	XI BM	D CON _{MS}	D CON _{MS} *	OAL	OAL*	LF	LF*	LCF	LCF*	PL	PL*	
DC ₁	DC ₁ *	DC ₂	DC ₂ *	SDL	SDL*	STA	LU	LU*	CZC _{MS}	Ordering code																	
3.35	.132	4.50	.177	10.10	.398	90°	11.3	.445	6	860.2-0335-011A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	61.4	2.417	19	.748	0.6	.024	
3.40	.134	4.60	.181	10.20	.402	90°	11.4	.449	6	860.2-0340-011A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	19	.748	0.6	.024	
4.25	.167	5.70	.224	12.80	.504	90°	14.3	.563	6	860.2-0425-014A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028	
4.30	.169	5.80	.228	13.00	.512	90°	14.5	.571	6	860.2-0430-014A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028	
4.65	.183	5.90	.232	14.00	.551	90°	15.5	.610	6	860.2-0465-015A1-GM	★	★	★	★	★	★	6.0	.236	66	2.598	65.2	2.567	23	.906	0.8	.031	
5.00	.197	6.80	.268	15.00	.591	90°	16.8	.661	8	860.2-0500-016A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	28	1.102	0.8	.031	
5.10	.201	6.90	.272	15.30	.602	90°	17.1	.673	8	860.2-0510-017A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035	
5.50	.217	7.40	.291	16.60	.654	90°	18.6	.732	8	860.2-0550-018A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035	
5.55	.219	7.50	.295	16.70	.657	90°	18.7	.736	8	860.2-0555-018A1-GM	★	★	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035	
6.60	.260	8.90	.350	19.90	.783	90°	22.3	.878	10	860.2-0660-022A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	37	1.457	1.1	.043	
6.75	.266	9.10	.358	20.30	.799	90°	22.7	.894	10	860.2-0675-022A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047	
6.85	.270	9.20	.362	20.60	.811	90°	23.0	.906	10	860.2-0685-023A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047	
6.90	.272	9.30	.366	20.70	.815	90°	23.2	.913	10	860.2-0690-023A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047	
7.00	.276	9.50	.374	21.10	.831	90°	23.6	.929	10	860.2-0700-023A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047	
7.40	.291	9.80	.386	22.20	.874	90°	24.7	.972	10	860.2-0740-024A1-GM	★	★	★	★	★	★	10.0	.394	89	3.504	87.7	3.453	37	1.457	1.3	.051	
8.00	.315	10.80	.425	24.00	.945	90°	26.9	1.059	12	860.2-0800-026A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.6	3.961	42	1.654	1.4	.055	
8.50	.335	11.50	.453	25.50	1.004	90°	28.5	1.122	12	860.2-0850-028A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059	
8.60	.339	11.60	.457	25.80	1.016	90°	28.9	1.138	12	860.2-0860-028A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059	
8.70	.343	11.70	.461	26.10	1.028	90°	29.2	1.150	12	860.2-0870-029A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059	
9.00	.354	11.80	.465	27.00	1.063	90°	30.0	1.181	12	860.2-0900-030A1-GM	★	★	★	★	★	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059	
10.25	.404	13.80	.543	30.80	1.213	90°	34.4	1.354	14	860.2-1025-034A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071	
10.30	.406	13.80	.543	31.00	1.220	90°	34.6	1.362	14	860.2-1030-034A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071	
10.40	.409	13.80	.543	31.20	1.228	90°	34.8	1.370	14	860.2-1040-034A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071	
10.50	.413	13.80	.543	31.60	1.244	90°	35.2	1.386	14	860.2-1050-035A1-GM	★	★	★	★	★	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071	
12.00	.472	15.80	.622	36.00	1.417	90°	40.1	1.579	16	860.2-1200-040A1-GM	★	★	★	★	★	★	16.0	.630	115	4.528	112.9	4.445	59	2.323	2.1	.083	
14.00	.551	18.90	.744	42.10	1.657	90°	47.1	1.854	20	860.2-1400-047A1-GM	★	★	★	★	★	★	20.0	.787	131	5.157	128.6	5.063	78	3.071	2.4	.094	



C30



G2



G5



G6



CoroDrill® DS20

4-5xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 4xD					Drill length 5xD				
					-SSW	-L5W	-L6W		-M7W	-H5W	-SSW	-L5W	-L6W	-M7W	-H5W			
N	N1.2.ZAG	Aluminium based alloys AlSi alloys, Si ≤ 1%	100	H13A 4344	4-5xD			15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00	0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
					0.06-0.18	0.06-0.18	0.06-0.18		-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-			
					0.06-0.2	0.06-0.2	0.06-0.2		-	-	0.06-0.17	0.06-0.17	0.06-0.17	-	-			
					0.08-0.22	0.08-0.22	0.08-0.22		-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-			
					0.08-0.25	0.08-0.25	0.08-0.25		-	-	0.08-0.21	0.08-0.21	0.08-0.21	-	-			
					0.1-0.25	0.1-0.25	0.1-0.25		-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-			
					0.1-0.25	0.1-0.25	0.1-0.25		-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-			
	N1.3.C.UT	Aluminium based alloys AlSi cast alloys (1% < Si < 13%)	75	H13A 4344	250	350	400	15.00-18.00	0.06-0.14	0.06-0.14	0.06-0.14	-	-	0.06-0.12	0.06-0.12	0.06-0.12	-	-
					250	350	400	18.01-22.00	0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
								22.01-27.00	0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-
								27.01-33.00	0.08-0.2	0.08-0.2	0.08-0.2	-	-	0.08-0.17	0.08-0.17	0.08-0.17	-	-
								33.01-40.00	0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-
								40.01-52.00	0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-
								52.01-65.00	0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-
	N1.3.C.AG	Aluminium based alloys AlSi cast and aged alloys (1% < Si < 13%)	90	H13A 4344	250	315	350	15.00-18.00	0.06-0.14	0.06-0.14	0.06-0.14	-	-	0.06-0.12	0.06-0.12	0.06-0.12	-	-
					250	315	350	18.01-22.00	0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-
								22.01-27.00	0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-
								27.01-33.00	0.08-0.2	0.08-0.2	0.08-0.2	-	-	0.08-0.17	0.08-0.17	0.08-0.17	-	-
								33.01-40.00	0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-
								40.01-52.00	0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-
							52.01-65.00	0.1-0.22	0.1-0.22	0.1-0.22	-	-	0.1-0.19	0.1-0.19	0.1-0.19	-	-	
N3.3.U.UT	Copper based alloys Free cutting copper based alloys	110	H13A 4344	250	350	400	15.00-18.00	0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-	
				250	350	400	18.01-22.00	0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-	
							22.01-27.00	0.06-0.2	0.06-0.2	0.06-0.2	-	-	0.06-0.17	0.06-0.17	0.06-0.17	-	-	
							27.01-33.00	0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-	
							33.01-40.00	0.08-0.25	0.08-0.25	0.08-0.25	-	-	0.08-0.21	0.08-0.21	0.08-0.21	-	-	
							40.01-52.00	0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-	
							52.01-65.00	0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-	
N3.2.C.UT	Copper based alloys Leaded brass and bronzes (Pb<1%)	90	H13A 4344	180	220	240	15.00-18.00	0.06-0.16	0.06-0.16	0.06-0.16	-	-	0.06-0.14	0.06-0.14	0.06-0.14	-	-	
				180	220	240	18.01-22.00	0.06-0.18	0.06-0.18	0.06-0.18	-	-	0.06-0.15	0.06-0.15	0.06-0.15	-	-	
							22.01-27.00	0.06-0.2	0.06-0.2	0.06-0.2	-	-	0.06-0.17	0.06-0.17	0.06-0.17	-	-	
							27.01-33.00	0.08-0.22	0.08-0.22	0.08-0.22	-	-	0.08-0.19	0.08-0.19	0.08-0.19	-	-	
							33.01-40.00	0.08-0.25	0.08-0.25	0.08-0.25	-	-	0.08-0.21	0.08-0.21	0.08-0.21	-	-	
							40.01-52.00	0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-	
							52.01-65.00	0.1-0.25	0.1-0.25	0.1-0.25	-	-	0.1-0.21	0.1-0.21	0.1-0.21	-	-	

CoroDrill® DS20

6-7xD

Metric values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 6xD					Drill length 7xD				
									-SSW	-L5W	-L6W	-M7W	-H5W	-SSW	-L5W	-L6W	-M7W	-H5W
N	N1.2.ZAG	Aluminium based alloys AlSi alloys, Si ≤ 1%	100	H13A 4344	6-7xD			15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00	0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
					0.06-0.12	0.06-0.12	0.06-0.12		-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-			
					0.06-0.13	0.06-0.13	0.06-0.13		-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-			
					0.08-0.14	0.08-0.14	0.08-0.14		-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-			
					0.08-0.16	0.08-0.16	0.08-0.16		-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-			
					0.1-0.16	0.1-0.16	0.1-0.16		-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-			
	N1.3.C.UT	Aluminium based alloys AlSi cast alloys (1% < Si < 13%)	75	H13A 4344	250	315	360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00	0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-
					250	315	360		0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
									0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
									0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-
									0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
									0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-
	N1.3.C.AG	Aluminium based alloys AlSi cast and aged alloys (1% < Si < 13%)	90	H13A 4344	250	285	315	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00	0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-
					250	285	315		0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
									0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
									0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-
									0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
									0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-
	N3.3.U.UT	Copper based alloys Free cutting copper based alloys	110	H13A 4344	250	315	360	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00	0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
					250	315	360		0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
									0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-
									0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
									0.08-0.16	0.08-0.16	0.08-0.16	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-
									0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-
N3.2.C.UT	Copper based alloys Leaded brass and bronzes (Pb<1%)	90	H13A 4344	180	200	215	15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00	0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-	
				180	200	215		0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-	
								0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-	
								0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-	
								0.08-0.16	0.08-0.16	0.08-0.16	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-	
								0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-	

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

CoroDrill® DS20

4-5xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 4xD					Drill length 5xD				
					Min.	Rec.	Max.		Recommended start value at middle of feed range					Recommended start value at middle of feed range				
									-SSW	-LSW	-L6W	-M7W	-H5W	-SSW	-LSW	-L6W	-M7W	-H5W
P	P1.0.ZAN	Unalloyed steel C=0.05-0.10%	110	4324	755	1115	1310	0.591-0.709	0.002-0.003	0.002-0.003	0.002-0.003	-	0.002-0.004	0.002-0.003	0.002-0.003	0.002-0.003	-	0.002-0.004
					4334	690	935	1065	0.709-0.866	0.002-0.004	0.002-0.004	0.002-0.004	-	0.002-0.004	0.002-0.003	0.002-0.003	0.002-0.003	-
P1.1.ZAN	Unalloyed steel C=0.05-0.25%	125	4324	755	1055	1215	0.591-0.709	0.002-0.004	0.002-0.004	0.002-0.004	-	0.002-0.004	0.002-0.004	0.002-0.004	0.002-0.004	-	0.002-0.004	
				4334	655	880	1000	0.709-0.866	0.002-0.004	0.002-0.004	0.002-0.004	-	0.002-0.004	0.002-0.004	0.002-0.004	0.002-0.004	-	0.002-0.004
P1.2.ZAN	Unalloyed steel C=0.25-0.55%	190	4324	625	870	1000	0.591-0.709	-	0.002-0.005	0.002-0.006	0.002-0.006	-	-	0.002-0.004	0.002-0.005	0.002-0.005	-	
				4334	510	710	820	0.709-0.866	-	0.002-0.006	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-
P1.3.ZAN	Unalloyed steel C=0.55-0.80%	190	4324	560	815	950	0.591-0.709	-	0.002-0.005	0.002-0.006	0.002-0.006	-	-	0.002-0.004	0.002-0.005	0.002-0.005	-	
				4334	460	670	785	0.709-0.866	-	0.002-0.006	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-
P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324	460	855	1065	0.591-0.709	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	
				4334	445	720	870	0.709-0.866	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-
P2.1.ZAN	Low alloy steel Annealed	175	4324	590	855	1000	0.591-0.709	-	-	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	
				4334	490	705	820	0.709-0.866	-	-	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-
P2.2.ZAN	Low alloy steel Annealed	240	4324	590	825	950	0.591-0.709	-	-	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	
				4334	490	655	740	0.709-0.866	-	-	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-
P2.5.ZHT	Low alloy steel Hardened and tempered	330	4324	295	625	805	0.591-0.709	-	-	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	
				4334	280	515	640	0.709-0.866	-	-	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-
P2.6.C.UT	Low alloy steel Cast - untreated	200	4324	360	690	870	0.591-0.709	-	-	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.006	0.002-0.006	-	
				4334	345	570	690	0.709-0.866	-	-	0.002-0.007	0.002-0.008	-	-	0.002-0.006	0.002-0.007	0.002-0.007	-
P3.0.ZAN	High alloy steel Annealed	200	4324	525	800	950	0.591-0.709	-	-	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	
				4334	425	660	785	0.709-0.866	-	-	0.002-0.006	0.002-0.007	-	-	0.002-0.005	0.002-0.005	0.002-0.006	-

CoroDrill® DS20

4-5xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 4xD					Drill length 5xD					
					985	1195	1310		-SSW	-LSW	-L6W	-M7W	-H5W	-SSW	-LSW	-L6W	-M7W	-H5W	
					4344	985	1195		Recommended start value at middle of feed range					Recommended start value at middle of feed range					
N	N1.2.ZAG	Aluminium based alloys AISI alloys, Si ≤ 1%	100	H13A	985	1195	1310	0.591-0.709	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	
					4344	985	1195	1310	0.709-0.866	0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-
						0.866-1.063	0.002-0.008	0.002-0.008	0.002-0.008	-	-	0.002-0.007	0.002-0.007	0.002-0.007	-	-			
						1.063-1.299	0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-			
						1.299-1.575	0.003-0.01	0.003-0.01	0.003-0.01	-	-	0.003-0.008	0.003-0.008	0.003-0.008	-	-			
						1.575-2.047	0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-			
						2.047-2.559	0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-			
	N1.3.C.UT	Aluminium based alloys AISI alloys, Si ≤ 1%	75	H13A	820	1140	1310	0.591-0.709	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	
					4344	820	1140	1310	0.709-0.866	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
						0.866-1.063	0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-			
						1.063-1.299	0.003-0.008	0.003-0.008	0.003-0.008	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-			
						1.299-1.575	0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-			
						1.575-2.047	0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-			
						2.047-2.559	0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-			
	N1.3.C.AG	Aluminium based alloys AISI cast and aged alloys (1% < Si < 13%)	90	H13A	820	1035	1150	0.591-0.709	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-	
					4344	820	1035	1150	0.709-0.866	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-
						0.866-1.063	0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-			
						1.063-1.299	0.003-0.008	0.003-0.008	0.003-0.008	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-			
						1.299-1.575	0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-			
						1.575-2.047	0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-			
					2.047-2.559	0.004-0.009	0.004-0.009	0.004-0.009	-	-	0.004-0.007	0.004-0.007	0.004-0.007	-	-				
N3.3.U.UT	Copper based alloys Free cutting copper based alloys	110	H13A	820	1140	1310	0.591-0.709	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-		
				4344	820	1140	1310	0.709-0.866	0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-	
					0.866-1.063	0.002-0.008	0.002-0.008	0.002-0.008	-	-	0.002-0.007	0.002-0.007	0.002-0.007	-	-				
					1.063-1.299	0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-				
					1.299-1.575	0.003-0.01	0.003-0.01	0.003-0.01	-	-	0.003-0.008	0.003-0.008	0.003-0.008	-	-				
					1.575-2.047	0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-				
					2.047-2.559	0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-				
N3.2.C.UT	Copper based alloys Leaded brass & bronzes (Pb ≤ 1%)	90	H13A	590	715	785	0.591-0.709	0.002-0.006	0.002-0.006	0.002-0.006	-	-	0.002-0.005	0.002-0.005	0.002-0.005	-	-		
				4344	590	715	785	0.709-0.866	0.002-0.007	0.002-0.007	0.002-0.007	-	-	0.002-0.006	0.002-0.006	0.002-0.006	-	-	
					0.866-1.063	0.002-0.008	0.002-0.008	0.002-0.008	-	-	0.002-0.007	0.002-0.007	0.002-0.007	-	-				
					1.063-1.299	0.003-0.009	0.003-0.009	0.003-0.009	-	-	0.003-0.007	0.003-0.007	0.003-0.007	-	-				
					1.299-1.575	0.003-0.01	0.003-0.01	0.003-0.01	-	-	0.003-0.008	0.003-0.008	0.003-0.008	-	-				
					1.575-2.047	0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-				
					2.047-2.559	0.004-0.01	0.004-0.01	0.004-0.01	-	-	0.004-0.008	0.004-0.008	0.004-0.008	-	-				

CoroDrill® DS20

6-7xD

Inch values

ISO	MC No.	Material	HB	Grade	Cutting data recommendations			Drill diameter	Drill length 6xD					Drill length 7xD				
									-SSW	-LSW	-L6W	-M7W	-H5W	-SSW	-LSW	-L6W	-M7W	-H5W
					6-7xD			Recommended start value at middle of feed range					Recommended start value at middle of feed range					
N	N1.2.Z.AG	Aluminium based alloys	100	H13A	985	1075	1180	0.591-0.709	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
				4344	985	1075	1180	0.709-0.866	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
		AlSi alloys, Si ≤ 1%	0.866-1.063	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-					
			1.063-1.299	0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-					
			1.299-1.575	0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-					
			1.575-2.047	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-					
	2.047-2.559	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-							
	N1.3.C.UT	Aluminium based alloys	75	H13A	820	1025	1180	0.591-0.709	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
				4344	820	1025	1180	0.709-0.866	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
		AlSi alloys, Si ≤ 1%	0.866-1.063	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-					
			1.063-1.299	0.003-0.005	0.003-0.005	0.003-0.005	-	-	0.003-0.004	0.003-0.004	0.003-0.004	-	-					
			1.299-1.575	0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-					
			1.575-2.047	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-					
	2.047-2.559	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-							
	N1.3.C.AG	Aluminium based alloys	90	H13A	820	930	1035	0.591-0.709	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
				4344	820	930	1035	0.709-0.866	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
		AlSi cast and aged alloys (1% < Si < 13%)	0.866-1.063	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-					
			1.063-1.299	0.003-0.005	0.003-0.005	0.003-0.005	-	-	0.003-0.004	0.003-0.004	0.003-0.004	-	-					
			1.299-1.575	0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-					
			1.575-2.047	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-					
	2.047-2.559	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-							
	N3.3.U.UT	Copper based alloys	110	H13A	820	1025	1180	0.591-0.709	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-
				4344	820	1025	1180	0.709-0.866	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-
		Free cutting copper based alloys	0.866-1.063	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-					
1.063-1.299			0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-						
1.299-1.575			0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-						
1.575-2.047			0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-						
2.047-2.559	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-								
N3.2.C.UT	Copper based alloys	90	H13A	590	645	705	0.591-0.709	0.002-0.004	0.002-0.004	0.002-0.004	-	-	0.002-0.003	0.002-0.003	0.002-0.003	-	-	
			4344	590	645	705	0.709-0.866	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-	
	Leaded brass & bronzes (Pb ≤ 1%)	0.866-1.063	0.002-0.005	0.002-0.005	0.002-0.005	-	-	0.002-0.004	0.002-0.004	0.002-0.004	-	-						
		1.063-1.299	0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-						
		1.299-1.575	0.003-0.006	0.003-0.006	0.003-0.006	-	-	0.003-0.005	0.003-0.005	0.003-0.005	-	-						
		1.575-2.047	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-						
2.047-2.559	0.004-0.006	0.004-0.006	0.004-0.006	-	-	0.004-0.005	0.004-0.005	0.004-0.005	-	-								

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

Selecting your cutting data

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

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

Effects of cutting speed – v_c

Cutting speed that is too high:

Rapid flank wear
Plastic deformation
Poor hole quality and bad hole tolerance

Cutting speed that is too low:

Built-up edge
Bad chip evacuation
Longer time in cut

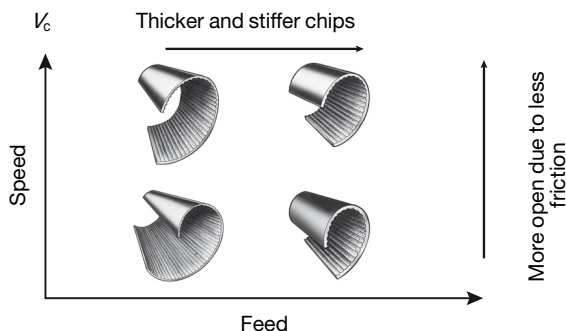
Effects of feed – f_n

High feed rate:

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

Low feed rate:

Preferable for long-chipping materials
Quality improvement
Accelerated tool wear
Longer time in cut



Achieving good hole quality

Chip evacuation

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

Stability, tool set-up

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

Tool life

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

Maintenance

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

Drilling deep holes with CoroDrill® DS20

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

Boring

Rough boring

CoroBore® BR30

D2

Fine boring

CoroBore® 826 XL

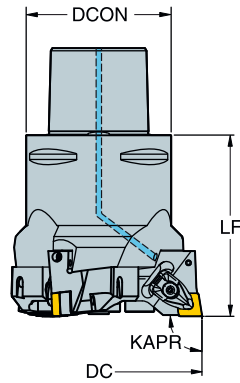
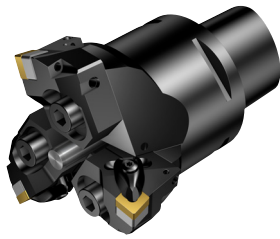
D3-D8

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

CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR 90°



- CNMM
- CNMG
- CNMA, CNGA

C

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

D

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

E

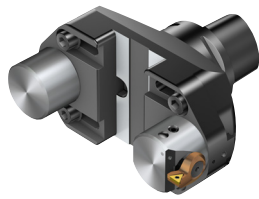
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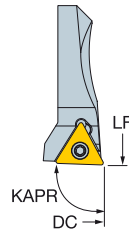


CoroBore® 826 XL fine boring tool

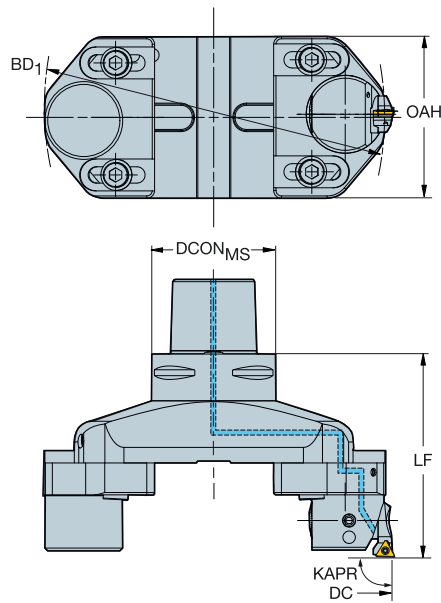
Coromant Capto® - High precision coolant supply



KAPR
STDNO



92°
ISO26623-1



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

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

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

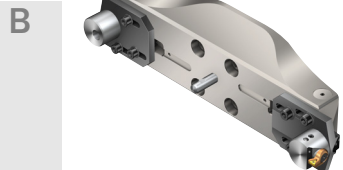
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

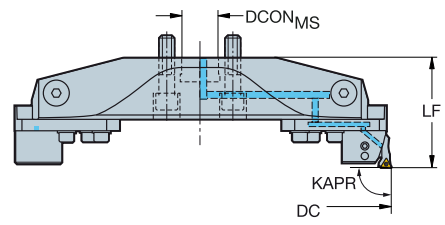
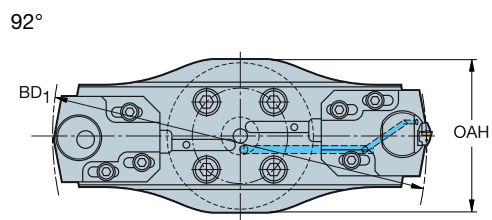
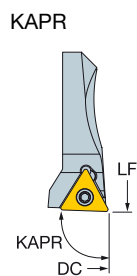


CoroBore® 826 XL fine boring tool

Arbor - High precision coolant supply



- C
- TCMT, TCMX, TCGT, TCGX, TCEX
 - TCMW



		Dimensions, mm, inch													
DCN	DCX			CZC _{MS}	CNSC	Ordering code	DCON _{MS}	ADJL _{XFDL}	LF	OAH	BD ₁			CICT	MIID
304.35	387.65	11	1/4	40X	1	826-387TC11HP	40.00	41.65	121.00	164.00	295.00	70	8.870	1	TCMT 11 03 04
11.982	15.262						1.575	1.640	4.764	6.457	11.614	1015			
384.35	467.65	11	1/4	40X	1	826-467TC11HP	40.00	41.65	126.00	164.00	375.00	70	10.400	1	TCMT 11 03 04
15.132	18.411						1.575	1.640	4.961	6.457	14.764	1015			
464.35	547.65	11	1/4	40X	1	826-547TC11HP	40.00	41.65	131.00	164.00	455.00	70	12.340	1	TCMT 11 03 04
18.282	21.561						1.575	1.640	5.157	6.457	17.913	1015			

Diameters are valid when frontboring.
 Backboring is not recommended with CoroBore® 826
 Use with 40X CoroBore XL holders only. To be ordered separately. See Rotating tools catalogue
 In case of direct flange to the machine spindle, use centering plug, see Rotating tools catalogue
 For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue

E

F

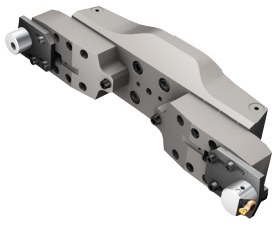
G



CoroBore® 826 XL fine boring tool

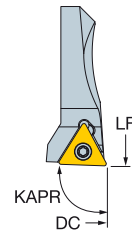
Arbor - High precision coolant supply

With bridge extension

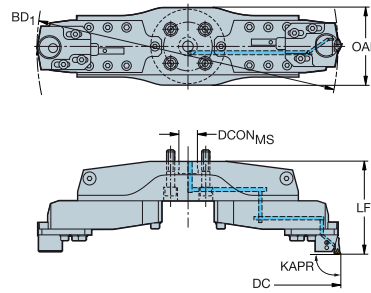


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR



92°



						Dimensions, mm, inch										
DCN	DCX			CZC _{MS}	CNSC	Ordering code	DCON _{MS}	ADJLX _{FDL}	LF	OAH	BD ₁			CICT	MIID	
544.35	787.65	11	1/4	40X	1	826-787TC11HP	40.00	121.65	205.00	164.00	535.00	70	24.430	1	TCMT 11 03 04	
21.431	31.010						1.575	4.789	8.071	6.457	21.063	1015				
784.35	1027.65	11	1/4	40X	1	826-1027TC11HP	40.00	121.65	225.00	164.00	775.00	70	35.060	1	TCMT 11 03 04	
30.880	40.459						1.575	4.789	8.858	6.457	30.512	1015				
1024.35	1267.65	11	1/4	40X	1	826-1267TC11HP	40.00	121.65	225.00	164.00	1015.00	70	44.110	1	TCMT 11 03 04	
40.329	49.908						1.575	4.789	8.858	6.457	39.961	1015				

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

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

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

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

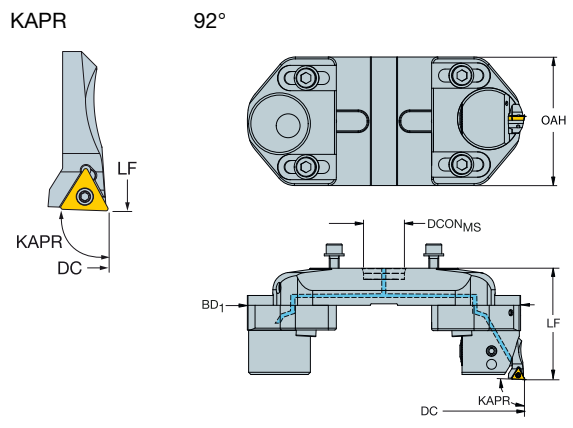
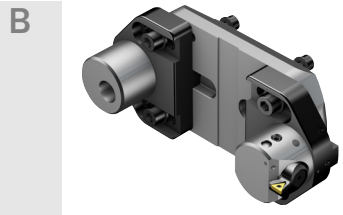
For inserts, see Turning tools catalogue



CoroBore® 826 XL fine boring tool

Arbor - High precision coolant supply

Dedicated for Silent Tools boring



- C
- TCMT, TCMX, TCGT, TCGX, TCEX
 - TCMW

D

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

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

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

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

For inserts, see Turning tools catalogue

E

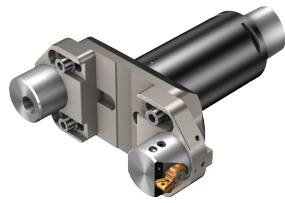
F



G



CoroBore® 826 XL lightweight fine boring tool

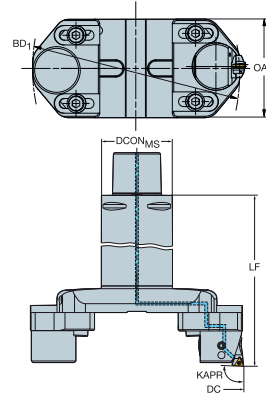
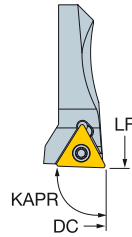
Coromant Capto® - High precision coolant supply







-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW

KAPR

92°



						Dimensions, mm, inch										
DCN	DCX			CZC _{MS}	CNSC	Ordering code	DCON _{MS}	ADJLX _{FDL}	LF	OAH	BD ₁			CICT	MIID	
154.35	207.65	11	1/4	C8	3	826L-207TC11-C8HP	80.00	26.65	237.00	104.00	145.00	70	6.300	1	TCMT 11 03 04	
<i>6.077</i>	<i>8.175</i>						<i>3.150</i>	<i>1.049</i>	<i>9.331</i>	<i>4.094</i>	<i>5.709</i>	<i>1015</i>				
204.35	257.65	11	1/4	C8	3	826L-257TC11-C8HP	80.00	26.65	237.00	104.00	195.00	70	6.660	1	TCMT 11 03 04	
<i>8.045</i>	<i>10.144</i>						<i>3.150</i>	<i>1.049</i>	<i>9.331</i>	<i>4.094</i>	<i>7.677</i>	<i>1015</i>				
254.35	307.65	11	1/4	C8	3	826L-307TC11-C8HP	80.00	26.65	237.00	104.00	245.00	70	7.030	1	TCMT 11 03 04	
<i>10.014</i>	<i>12.112</i>						<i>3.150</i>	<i>1.049</i>	<i>9.331</i>	<i>4.094</i>	<i>9.646</i>	<i>1015</i>				

Backboring is not recommended with CoroBore® 826

Diameters are valid when frontboring.

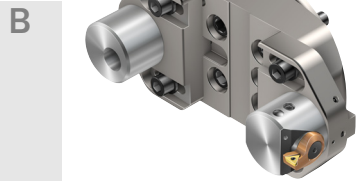
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

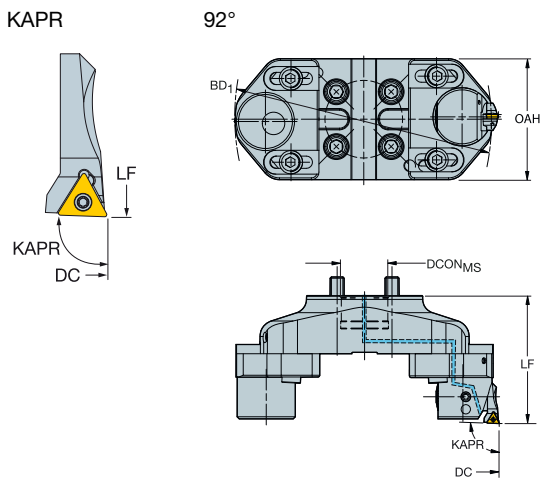


CoroBore® 826 XL lightweight fine boring tool

Arbor - High precision coolant supply



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



C

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

D

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.

Backboring is not recommended with CoroBore® 826

Diameters are valid when frontboring.

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

For inserts, see Turning tools catalogue

E

F

G



G2



G5



Rotating tool adaptors

Adaptors	
Coromant Capto®	E2-E3
HSK	E4-E5
BIG-PLUS ISO	E6
BIG-PLUS MAS-BT	E7-E8
BIG-PLUS CAT V	E9
ISO 7388-1	E10
MAS-BT	E11-E12
CAT-V	E13

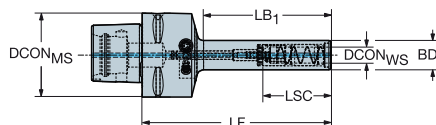
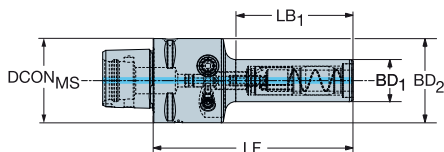
Coromant Capto® to CoroChuck™ 930

Pencil design

DSGN

2

5



Dimensions, mm, inch

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

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

E

F

G



G2

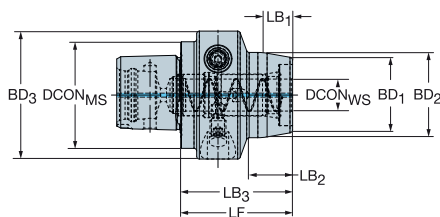


G5

Coromant Capto® to CoroChuck™ 930

For driven tool holders

Segment clamping and manual tool change only



		Dimensions, mm, inch																	
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BD ₃	BHTA ₁	BAR PSI	NM	KG	RPMX	
C3	6	3	1	930-C3-T-06-036	32.0	6.0	37	36.0	9.3	12.8	22.0	26.0	42.0	12°	80	8.0	0.26	10000	
					1.260	.236	1.457	1.417	.366	.504	.866	1.024	1.654	1160					
				8	3	1	930-C3-T-08-036	32.0	8.0	37	36.0	9.3	12.8	24.0	28.0	44.0	12°	80	8.0
10	3	1	930-C3-T-10-038	32.0	10.0	41	38.0	11.3	14.8	26.0	30.0	46.0	10°	80	8.0	0.31	10000		
				1.260	.394	1.614	1.496	.445	.583	1.024	1.181	1.811	1160						
C4	6	3	1	930-C4-T-06-036	40.0	6.0	37	36.0	9.3	12.8	22.0	26.0	42.0	12°	80	8.0	0.33	10000	
					1.575	.236	1.457	1.417	.366	.504	.866	1.024	1.654	1160					
				8	3	1	930-C4-T-08-036	40.0	8.0	37	36.0	9.3	12.8	24.0	28.0	44.0	12°	80	8.0
10	3	1	930-C4-T-10-038	40.0	10.0	41	38.0	11.3	14.8	26.0	30.0	46.0	10°	80	8.0	0.37	10000		
				1.575	.394	1.614	1.496	.445	.583	1.024	1.181	1.811	1160						
C5	6	3	1	930-C5-T-06-036	50.0	6.0	37	36.0	9.3	12.8	22.0	26.0	50.0	12°	80	8.0	0.49	10000	
					1.969	.236	1.457	1.417	.366	.504	.866	1.024	1.969	1160					
				8	3	1	930-C5-T-08-036	50.0	8.0	37	36.0	9.3	12.8	24.0	28.0	50.0	12°	80	8.0
10	3	1	930-C5-T-10-038	50.0	10.0	41	38.0	11.3	14.8	26.0	30.0	50.0	10°	80	8.0	0.51	10000		
				1.969	.315	1.457	1.417	.366	.504	.945	1.102	1.969	1160						
				1.969	.394	1.614	1.496	.445	.583	1.024	1.181	1.969	1160						

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

G2



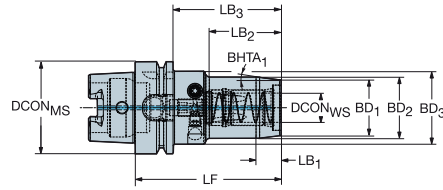
G5

HSK to CoroChuck™ 930

Slender design

Machine side interface HSK A/C

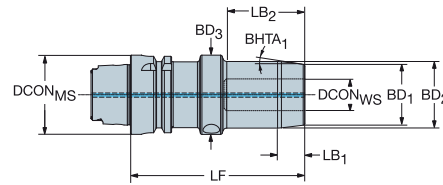
B



C

				Dimensions, mm, inch																		RPMX
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	LB ₂	LB ₃	BD ₁	BD ₂	BD ₃	BD ₄	BHTA ₁	BAR PSI	NM	KG	RPMX		
40.0	6	1	1	930-HA04-S-06-070	40.0	6.0	37	70.0	11.3	33.2	50.0	22.0	26.0	32.0	40.0	10°	80	8.0	0.40	30000		
					1.575	.236	1.457	2.756	.445	1.307	1.969	.866	1.024	1.260	1.575		1160					
8	1	1	1	930-HA04-S-08-070	40.0	8.0	37	70.0	11.3	35.3	50.0	24.0	28.0	32.0	40.0	10°	80	8.0	0.42	30000		
					1.575	.315	1.457	2.756	.445	1.390	1.969	.945	1.102	1.260	1.575		1160					
10	1	1	1	930-HA04-S-10-075	40.0	10.0	41	75.0	11.3	39.6	55.0	26.0	30.0	32.0	40.0	10°	80	8.0	0.46	30000		
					1.575	.394	1.614	2.953	.445	1.559	2.165	1.024	1.181	1.260	1.575		1160					
12	1	1	1	930-HA04-S-12-080	40.0	12.0	46	80.0	11.3	41.0	60.0	28.0	32.0	33.5	40.0	10°	80	8.0	0.51	30000		
					1.575	.472	1.811	3.150	.445	1.614	2.362	1.102	1.260	1.319	1.575		1160					
50.0	6	1	1	930-HA05-S-06-074	50.0	6.0	37	74.0	11.3	30.2	48.0	22.0	26.0	40.0	50.0	10°	80	8.0	0.64	25000		
					1.969	.236	1.457	2.913	.445	1.189	1.890	.866	1.024	1.575	1.969		1160					
8	1	1	1	930-HA05-S-08-074	50.0	8.0	37	74.0	11.3	30.2	48.0	24.0	28.0	40.0	50.0	10°	80	8.0	0.65	25000		
					1.969	.315	1.457	2.913	.445	1.189	1.890	.945	1.102	1.575	1.969		1160					
10	1	1	1	930-HA05-S-10-080	50.0	10.0	41	80.0	11.3	34.2	54.0	26.0	30.0	40.0	50.0	10°	80	8.0	0.71	25000		
					1.969	.394	1.614	3.150	.445	1.346	2.126	1.024	1.181	1.575	1.969		1160					
12	1	1	1	930-HA05-S-12-085	50.0	12.0	46	85.0	11.3	38.2	59.0	28.0	32.0	40.0	50.0	10°	80	8.0	0.75	25000		
					1.969	.472	1.811	3.346	.445	1.504	2.323	1.102	1.260	1.575	1.969		1160					

D



E

				Dimensions, mm, inch																		RPMX
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BHTA ₁	BAR PSI	NM	KG	RPMX					
50.0	20	1	1	930-HA05-S-20-090	50.0	20.0	51	90.0	16.0	64.0	37.6	41.5	7°	80	8.0	0.89	25000					
					1.969	.787	2.008	3.543	.630	2.520	1.480	1.634		1160								

F

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G



G2

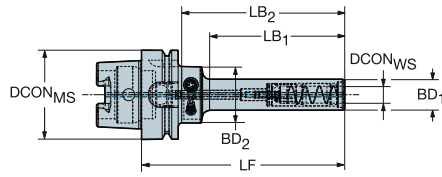


G5

HSK to CoroChuck™ 930

Pencil design

Machine side interface HSK A/C



		Dimensions, mm, inch														
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BAR PSI	NM	KG	RPMX
63.0	8	1	1	930-HA06-P-08-094	63.0	8.0	37	94.0	45.8	65.5	17.5	40.0	80	8.0	0.87	20000
					2.480	.315	1.457	3.701	1.803	2.579	.689	1.575	1160			
	10	1	1	930-HA06-P-10-104	63.0	10.0	41	104.0	55.8	75.5	20.0	40.0	80	8.0	0.91	20000
					2.480	.394	1.614	4.094	2.197	2.972	.787	1.575	1160			
	10	1	1	930-HA06-P-10-144	63.0	10.0	41	144.0	95.8	115.5	20.0	40.0	80	8.0	1.01	20000
					2.480	.394	1.614	5.669	3.772	4.547	.787	1.575	1160			

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

G2



G5

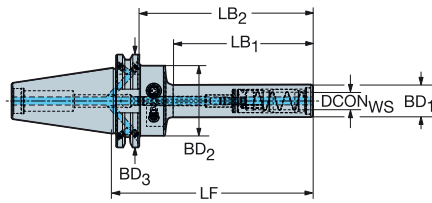
A

BIG-PLUS ISO to CoroChuck™ 930

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

ENG

B



Pencil design

C

				Dimensions, mm, inch													
CZC _{MS}	CZC _{VS}	CNSC	CXSC	Ordering code	DCON _{WS}	CRKS	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BD ₃	BAR PSI	NM	KG	RPMX
40.0	8	7	1	930-IB40-P-08-088	8.0	M16	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.06	18000
					.315		1.457	3.465	1.803	2.618	.689	1.575	2.500	1160			
	10	7	1	930-IB40-P-10-098	10.0	M16	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.10	18000
					.394		1.614	3.858	2.197	3.012	.787	1.575	2.500	1160			
	10	7	1	930-IB40-P-10-138	10.0	M16	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.20	18000
					.394		1.614	5.433	3.772	4.587	.787	1.575	2.500	1160			

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G2



G5

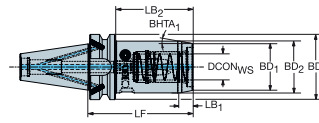
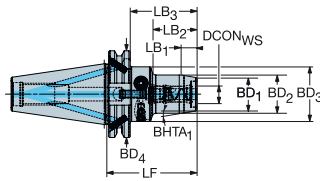
BIG-PLUS MAS-BT to CoroChuck™ 930

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

DSGN

10

6



Slender design

		Dimensions, mm, inch																					
CZC _{MS}	CZC _{WS}	CNSC	CXSC	DSGN	Ordering code	DCON _{WS}	CRKS	LSC	LF	LB ₁	LB ₂	LB ₃	LB ₄	BD ₁	BD ₂	BD ₃	BD ₄	BHTA ₁	BAR PSI	NM	KG	RPMX	
30.0	6	1	1	6	930-BB30-S-06-048	6.0	M12	37	48.0	9.3	12.8	48.0		22.0	26.0	46.0		12°	80	8.0	0.56	25000	
						.236		1.457	1.890	.366	.504	1.890		.866	1.024	1.811			1160				
	8	1	1	6	930-BB30-S-08-048	8.0	M12	37	48.0	9.3	12.8	48.0		24.0	28.0	46.0		12°	80	8.0	0.57	25000	
						.315		1.457	1.890	.366	.504	1.890		.945	1.102	1.811			1160				
	10	1	1	6	930-BB30-S-10-048	10.0	M12	41	48.0	9.3	13.8	48.0		26.0	30.0	46.0		12°	80	8.0	0.56	25000	
						.394		1.614	1.890	.366	.543	1.890		1.024	1.181	1.811			1160				
	12	1	1	10	930-BB30-S-12-082	12.0	M12	46	82.0	11.3	38.2	60.0	82.0	28.0	32.0	40.0	46	10°	80	8.0	0.76	25000	
						.472		1.811	3.228	.445	1.504	2.362	3.228	1.102	1.260	1.575	1.811		1160				
	20	1	1	6	930-BB30-S-20-088	20.0	M12	51	88.0	16.0	66.0	88.0		38.0	42.0	46.0		7°	80	8.0	0.94	25000	
						.787		2.008	3.465	.630	2.598	3.465		1.496	1.654	1.811			1160				

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G2



G5

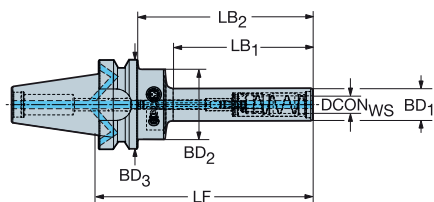
A

BIG-PLUS MAS-BT to CoroChuck™ 930

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

ENG

B



Pencil design

				Dimensions, mm, inch													
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{WS}	CRKS	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BD ₃	BAR PSI	NM	KG	RPMX
30.0	8	1	1	930-BB30-P-08-088	8.0	M12	37	88.0	45.8	66.0	17.5	40.0	46.0	80	8.0	0.60	25000
					.315		1.457	3.465	1.803	2.598	.689	1.575	1.811	1160			
					10.0	M12	41	98.0	55.8	76.0	20.0	40.0	46.0	80	8.0	0.64	25000
10	1	1	930-BB30-P-10-098	10.0	M12	41	98.0	55.8	76.0	20.0	40.0	46.0	80	8.0	0.64	25000	
				.394		1.614	3.858	2.197	2.992	.787	1.575	1.811	1160				
				10.0	M12	41	138.0	95.8	116.0	20.0	40.0	46.0	80	8.0	0.74	25000	
10	1	1	930-BB30-P-10-138	10.0	M12	41	138.0	95.8	116.0	20.0	40.0	46.0	80	8.0	0.74	25000	
				.394		1.614	5.433	3.772	4.567	.787	1.575	1.811	1160				
				40.0	M16	37	95.0	45.8	65.5	17.5	40.0	63.0	80	8.0	1.21	18000	
10	7	1	930-BB40-P-10-105	10.0	M16	41	105.0	55.8	75.5	20.0	40.0	63.0	80	8.0	1.25	18000	
				.394		1.614	4.134	2.197	2.972	.787	1.575	2.480	1160				
				10.0	M16	41	145.0	95.8	115.5	20.0	40.0	63.0	80	8.0	1.35	18000	
10	7	1	930-BB40-P-10-145	10.0	M16	41	145.0	95.8	115.5	20.0	40.0	63.0	80	8.0	1.35	18000	
				.394		1.614	5.709	3.772	4.547	.787	1.575	2.480	1160				

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G2

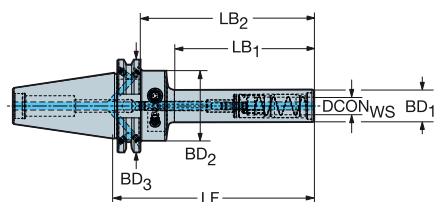


G5

BIG-PLUS CAT-V to CoroChuck™ 930

Machine side interface compatible with ASME B5.50-2009

Pencil design

**Metric bore**

				Dimensions, mm, inch													
CZC _{MS}	CZC _{HS}	CNSC	CXSC	Ordering code	DCON _{WS}	CRKS	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BD ₃	BAR PSI	NM	KG	RPMX
40.0	8	7	1	930-VB40-P-08-088	8.0	5/8"-11	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.07	18000
					.315	1.457	3.465	1.803	2.618	.689	1.575	2.500	1160				
	10	7	1	930-VB40-P-10-098	10.0	5/8"-11	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.11	18000
					.394	1.614	3.858	2.197	3.012	.787	1.575	2.500	1160				
	10	7	1	930-VB40-P-10-138	10.0	5/8"-11	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.21	18000
					.394	1.614	5.433	3.772	4.587	.787	1.575	2.500	1160				

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

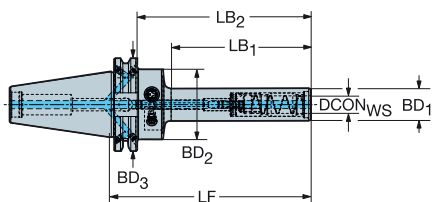
G2



G5

ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB



Pencil design

				Dimensions, mm, inch													
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{WS}	CRKS	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BD ₃	BAR PSI	NM	KG	RPMX
40.0	8	7	1	930-I40-P-08-088	8.0	M16	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.04	18000
					.315		1.457	3.465	1.803	2.618	.689	1.575	2.500	1160			
	10	7	1	930-I40-P-10-098	10.0	M16	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.09	18000
					.394		1.614	3.858	2.197	3.012	.787	1.575	2.500	1160			
	10	7	1	930-I40-P-10-138	10.0	M16	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.18	18000
					.394		1.614	5.433	3.772	4.587	.787	1.575	2.500	1160			

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

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G2



G5

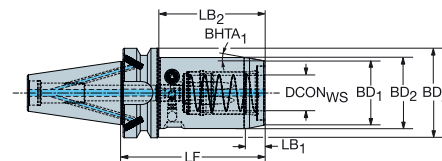
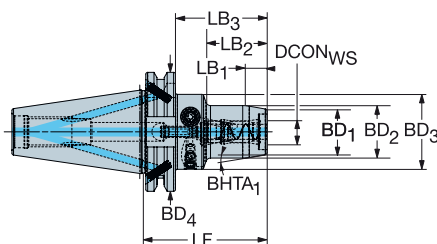
MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

DSGN

10

6



Slender design

					Dimensions, mm, inch																		
CZC _{MS}	CZC _{WS}	CNSC	CXSC	DSGN	Ordering code	DCON _{WS}	CRKS	LSC	LF	LB ₁	LB ₂	LB ₃	LB ₄	BD ₁	BD ₂	BD ₃	BD ₄	BHTA ₁	BAR PSI	NM	KG	RPMX	
30.0	6	1	1	6	930-B30-S-06-048	6.0	M12	37	48.0	9.3	12.8	48.0		22.0	26.0	46.0		12°	80	8.0	0.55	25000	
						.236		1.457	1.890	.366	.504	1.890		.866	1.024	1.811			1160				
	8	1	1	6	930-B30-S-08-048	8.0	M12	37	48.0	9.3	12.8	48.0		24.0	28.0	46.0		12°	80	8.0	0.56	25000	
						.315		1.457	1.890	.366	.504	1.890		.945	1.102	1.811			1160				
	10	1	1	6	930-B30-S-10-048	10.0	M12	41	48.0	9.3	13.8	48.0		26.0	30.0	46.0		12°	80	8.0	0.55	25000	
						.394		1.614	1.890	.366	.543	1.890		1.024	1.181	1.811			1160				
	12	1	1	10	930-B30-S-12-082	12.0	M12	46	82.0	11.3	38.2	60.0	82.0	28.0	32.0	40.0	46	10°	80	8.0	0.75	25000	
						.472		1.811	3.228	.445	1.504	2.362	3.228	1.102	1.260	1.575	1.811			1160			
	20	1	1	6	930-B30-S-20-088	20.0	M12	51	88.0	16.0	66.0	88.0		38.0	42.0	46.0		7°	80	8.0	0.93	25000	
						.787		2.008	3.465	.630	2.598	3.465		1.496	1.654	1.811			1160				

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G2

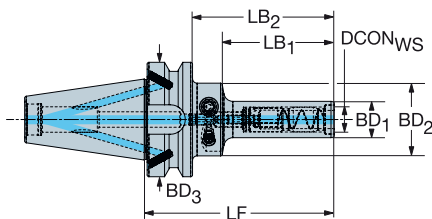


G5

MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

Pencil design



Dimensions, mm, inch

CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{WS}	CRKS	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BD ₃	BAR PSI	NM	KG	RPMX
30.0	8	1	1	930-B30-P-08-088	8.0	M12	37	88.0	45.8	66.0	17.5	40.0	46.0	80	8.0	0.59	25000
					.315		1.457	3.465	1.803	2.598	.689	1.575	1.811	1160			
	10	1	1	930-B30-P-10-098	10.0	M12	41	98.0	55.8	76.0	20.0	40.0	46.0	80	8.0	0.63	25000
					.394		1.614	3.858	2.197	2.992	.787	1.575	1.811	1160			
	10	1	1	930-B30-P-10-138	10.0	M12	41	138.0	95.8	116.0	20.0	40.0	46.0	80	8.0	0.73	25000
					.394		1.614	5.433	3.772	4.567	.787	1.575	1.811	1160			
40.0	8	7	1	930-B40-P-08-095	8.0	M16	37	95.0	45.8	65.5	17.5	40.0	63.0	80	8.0	1.20	18000
					.315		1.457	3.740	1.803	2.579	.689	1.575	2.480	1160			
	10	7	1	930-B40-P-10-105	10.0	M16	41	105.0	55.8	75.5	20.0	40.0	63.0	80	8.0	1.24	18000
					.394		1.614	4.134	2.197	2.972	.787	1.575	2.480	1160			
	10	7	1	930-B40-P-10-145	10.0	M16	41	145.0	95.8	115.5	20.0	40.0	63.0	80	8.0	1.34	18000
					.394		1.614	5.709	3.772	4.547	.787	1.575	2.480	1160			

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



G2

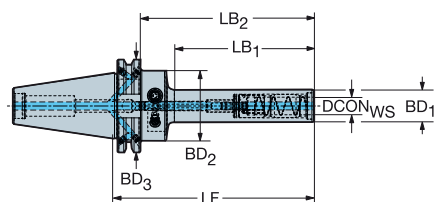


G5

CAT-V to CoroChuck™ 930

Pencil design

Machine side interface ASME B5.50-2009



				Dimensions, mm, inch													
CZC _{MS}	CZC _{HS}	CNSC	CXSC	Ordering code	DCON _{HS}	CRKS	LSC	LF	LB ₁	LB ₂	BD ₁	BD ₂	BD ₃	BAR PSI	NM	KG	RPMX
40.0	8	7	1	930-V40-P-08-088	8.0	5/8"-11	37	88.0	45.8	66.5	17.5	40.0	63.5	80	8.0	1.05	18000
					.315		1.457	3.465	1.803	2.618	.689	1.575	2.500	1160			
	10	7	1	930-V40-P-10-098	10.0	5/8"-11	41	98.0	55.8	76.5	20.0	40.0	63.5	80	8.0	1.09	18000
					.394		1.614	3.858	2.197	3.012	.787	1.575	2.500	1160			
	10	7	1	930-V40-P-10-138	10.0	5/8"-11	41	138.0	95.8	116.5	20.0	40.0	63.5	80	8.0	1.19	18000
					.394		1.614	5.433	3.772	4.587	.787	1.575	2.500	1160			

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

G2

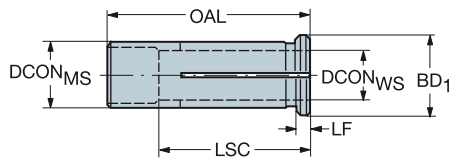


G5

A

Cylindrical sleeves

Precision coolant supply



B

Inch version

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

For extractors for cylindrical collets, see Rotating tools catalogue

D

E

F

G



G2



G5

General information

ISO 13399	G2
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Coromant Recycling Concept (CRC)	G8

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.

B

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!

C

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

F

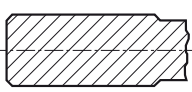
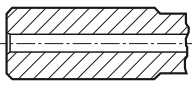
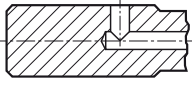
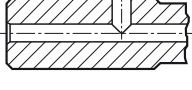
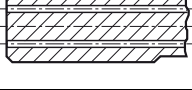
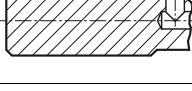
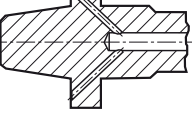
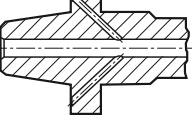
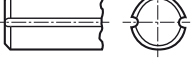
G

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

A	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	
	B	PNA	Profile included angle
		PRFRAD	Profile radius
PRSPC		Profile specification	
PSIR		Tool lead angle	
PSIRL		Cutting edge angle major left hand	
PSIRR		Cutting edge angle major right hand	
PSW		Premachined slot width	
RADH		Radial body height	
RADW		Radial body width	
RAR		Right hand relief angle	
RE		Corner radius	
REEQ		Corner radius equivalent	
REL		Corner radius left	
RER		Corner radius right	
C		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	
	D	STDNO	Standard number
		SUBSTRATE	Substrate
		TCDC	Tolerance class cutting diameter
		TCDCON	Connection diameter tolerance
		TCDMM	Shank diameter tolerance
TCHA		Achievable hole tolerance	
TCHAL		Achievable hole tolerance lower	
TCHAU		Achievable hole tolerance upper	
TCT		Tolerance class tool	
TCTR		Thread tolerance class	
TD		Thread diameter	
TDZ		Thread diameter size	
TFLA		Tap floating length ahead	
TFLB		Tap floating length behind	
E		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	
	F	TPX	Maximum thread pitch
		TRMAX	Tap range max
		TQ	Torque
		TSYC	Tool style code
		TTP	Thread type
ULDR		Usable length diameter ratio	
VCX		Maximum cutting speed	
W1		Insert width	
WB		Body width	
WF		Functional width	
WFCIRP		Width to cutting item reference point	
WSC		Clamping width	
WT		Weight of item	
ZADJ		Insert adjustable count	
G		ZEFF	Face effective cutting edge count
		ZEFP	Peripheral effective cutting edge count (ZEFP)
		ZWX	Maximum number of Wiper inserts

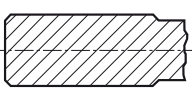
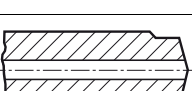
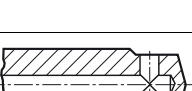

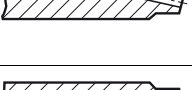

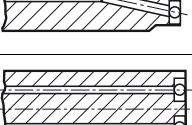
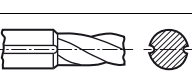
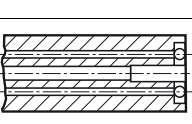
CNSC

Coolant entry style code

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

CXSC

Coolant exit style code

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

Reconditioning

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

B

Our offer



100%



x3



50%

C

Reliability

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

Original performance

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

Savings

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

Products in service

D



Drilling



Milling



Reaming



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

Additional information

E



Reconditioning box

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

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

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



Reconditioning service

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

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

- The tools are delivered back in original packaging



What happens with your tools?

- Complete geometry restoration

- Drill length is reduced

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

- Reamer diameter tolerance is maintained

F

G

For prices contact your local Sandvik Coromant representative.

Safety information in connection with grinding of cemented carbide

Material composition

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

Routes of exposure

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

Acute toxicity

Intake of the aforementioned substances is toxic. Inhalation may cause irritation and inflammation of the airways. Significantly higher acute inhalation toxicity has been reported during simultaneous inhalation of cobalt and tungsten carbide compared to inhalation of cobalt alone.

Skin contact can cause irritation and rash. Sensitive individuals may even experience an allergic reaction.

Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction of the airways. Prolonged exposure to increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers previously exposed to high concentrations of tungsten carbide/cobalt carried an increased risk of developing lung cancer.

Cobalt and nickel are potent skin sensitizers. Repeated or prolonged contact can cause irritation and sensitization.

Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation

Toxic when inhaled

Limited evidence of a carcinogenic effect.

May cause sensitization by inhalation and skin contact

Preventive measures

Avoid formation and inhalation of dust. Use adequate local exhaust ventilation to keep personal exposure well below nationally authorised limits.

If ventilation is not available or adequate, use respirators appropriately approved for the purpose.

Use safety goggles or glasses with side shields when necessary.

Avoid repeated skin contact. Wear suitable gloves. Wash skin thoroughly after handling.

Use suitable protective clothing. Launder clothing if needed.

Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.



For the sake of the environment

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

The Sandvik Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts and solid carbide tools offered by Sandvik Coromant to all its customers.

In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers.

Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way.

All used carbide inserts are collected in the collection box at the workplace.

When the collection box is sufficiently full, its contents are transferred to the transport box.

The full transport box is then sent to the nearest Sandvik Coromant office or to your Sandvik Coromant dealer who can also give you more information.

The benefits of the CRC speak for themselves

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



Order collection boxes for each lathe, milling machine, drill or for your machining centre. We recommend one collection box for inserts and one separate box for solid carbide tools for each cutting workplace.

For detailed instructions on how to sell your used cemented carbide, please visit www.sandvik.coromant.com and select your market.

Collection box:

Transport box for solid carbide tools (plywood):

Transport box inserts (plywood):

Order numbers

91617

92994

92995