SANDVIK coromant

THOMAS SKINNER

CoroDrill® DS20

What innovation looks like

CLICK TO SUBMIT INQUIRY

CONTACT THOMAS SKINNER TO LEARN MORE ABOUT THIS PRODUCT, WE'LL CONNECT YOU TO ONE OF OUR EXPERTS IN YOUR AREA!

Contents

What innovation looks like 3

Drill design 4

Next generation step technology 4

Application area 5

Coolant 6

Optimized chip flutes 6

Drilling strategy for 6–7×DC 7

Advanced operations 7

Drill assortment, cylindrical shank 8

Drill assortment, MDI 15

An insert for every application 18

Peripheral insert: Geometries 19

Peripheral insert: Grades 19

Central insert: Geometries and grades 20

First choice 20

Insert assortment 21

MDI (Modular Drilling Interface) 24

Accessories 26

Cutting data recommendations, metric 27

Cutting data recommendations, inch 33

What innovation looks like

After years of R&D and customer testing, the first indexable drill that can reach up to 7xDC - with no need for pilot drilling - is here, reducing your cycle time and cost per hole.

Innovative drill body and insert designs have resulted in a drilling concept with never-before-seen stiffness, evacuation performance and light cutting action. CoroDrill® DS20 offers superior reliability and predictability with outstanding penetration rates for your 4–7 × DC drilling operations.

Improve your drilling operations even more and reduce your tool inventory by using the stable and high precision Modular Drilling Interface, MDI.

Customer benefits

- A secure and reliable cutting process with high productivity ensuring low cost per hole
- Versatile drill with good chip formation in a broad cutting data range
- Large selection of geometries, from versatile to optimized offer
- Optimized chip control and chip evacuation
- Consistent and predictable hole diameter
- Light cutting with low cutting forces
- Reduced sound level

Standard assortment

Diameter, mm (inch)	Shank type	Drill depth (×DC)
15–45 (0.625–1.75)	Cylindrical with flat according to ISO 9766 (mm and inch)	4, 5, 6, 7
46–65 (1.875–2.50)	Cylindrical with flat according to ISO 9766 (mm and inch)	4, 5
15–45 (0.625–1.75)	MDI (mm and inch)	4, 7
46–59 (1.875–2.25)	MDI (mm and inch)	4

Tailor Made

Can not find the specific tool that you are looking for? Then a customized tool might be the solution.

CoroDrill® DS20 customized solutions are available with Tailor Made® and special tools. Create your Tailor Made® solution in the online configurator or reach out to your local Sandvik Coromant representative.

Drill design

The design of the CoroDrill® DS20 has resulted in a strong and fatigue-resistant drill body where each drill body size is individually optimized to ensure a secure and consistent performance over the entire assortment.

The drill body stiffness, in combination with light-cutting geometries, generates less vibration and significantly increased tool life.

With high process security and good run-out accuracy, CoroDrill® DS20 will reduce your costs and increase your component quality.

4–5×DC

- Predictable and consistent chip control
- Versatile and cost-efficient
- Increased productivity in all materials
- Large functionality over a broad cutting data range
- H12–H13 hole tolerances

6–7×DC

- First to market with a 7 × DC indexable insert drill
- Opens up for new machining processes with increased productivity
- No pilot drilling needed
- Cost-efficient drilling for deeper holes with less demanding hole tolerances (-0.1/+0.5 mm (-0.004/+0.020 inch))

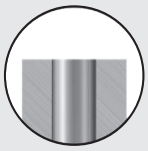
Next generation step technology

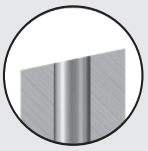
Entering the workpiece with an asymmetrical drill by default generates an unbalance. The new generation of inserts with double steps allows for softer entries and cutting forces are considerably reduced at entry.

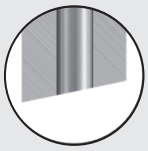
In combination with the stiff drill body, the centring capabilities are dramatically improved enabling deeper holes to be drilled, higher productivity as well as closer hole tolerances.

Application area

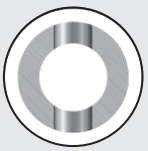
- For hole depths 4–7×DC
- Geometries designed for versatility or optimized applications
- Capable of both non-rotating and rotating set-ups
- Can be used for drilling with radial offset, deburring and back boring


Conventional drilling


Inclined surfaces


Inclined exits


Cross holes


Convex/concave surfaces


Step and chamfer

Use CoroPlus® Tool Guide for cutting data recommendations and details specific to your application.

www.coroguide.com

ISO application areas

Hole tolerance

Drill diameter, mm (inch)	CoroDrill® DS20 hole tolerance, mm (inch)	
	4–5×DC	6–7×DC
15.0–18.0 (0.591–0.709)	0/+0.27 (0/+0.011)	-0.1/+0.5 (-0.004/+0.020)
18.01–30.0 (0.709–1.18)	0/+0.33 (0/+0.013)	
30.01–65.0 (1.18–2.56)	0/+0.35 (0/+0.014)	

Surface finish

Feed	R_a, µm (µin)	R_z (ISO), µm (µin)
Low	Down to 0.5 (20)	3.8 (152)
Medium	0.8–2 (32–78)	6.1–15.2 (243–593)
High	2–4 (78–157)	15.2–30.4 (593–1193)

Achievable hole tolerances

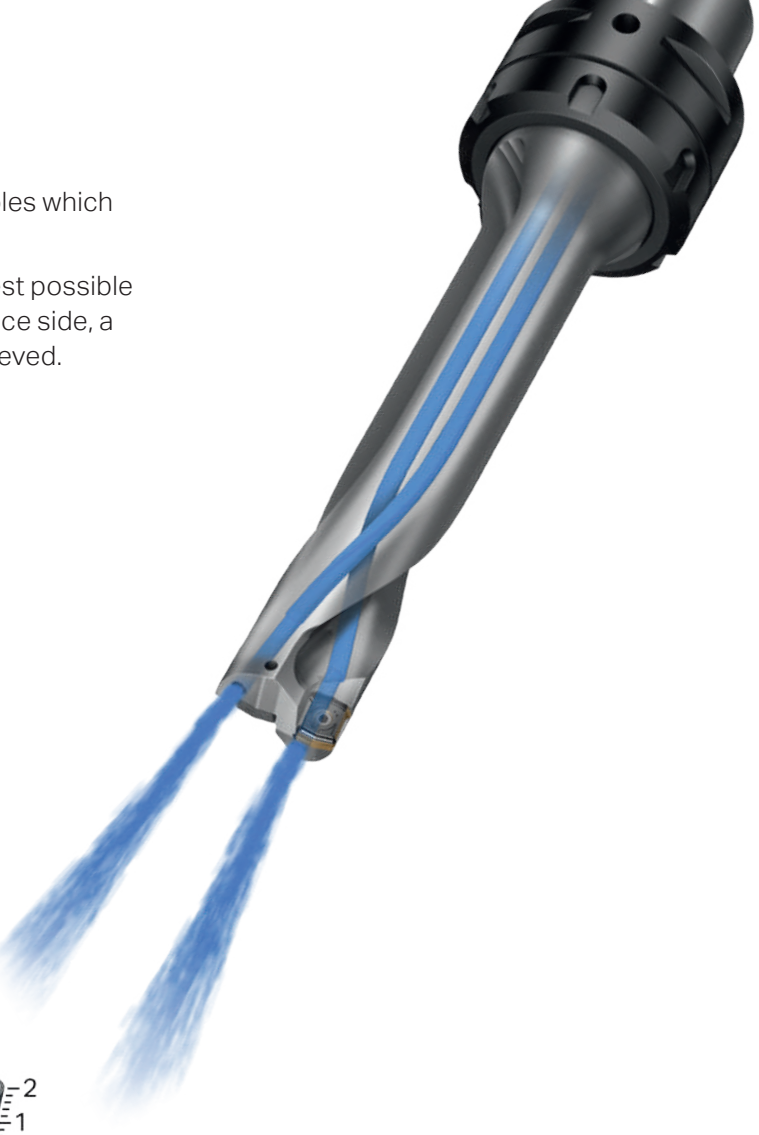
By using an adjustable drill holder or an eccentric sleeve, the tolerance can be kept within ± 0.05 mm (±0.002 inch) (IT 10–11) under stable conditions.

Use the appropriate eccentric sleeve (see Accessories) and drills with metric ISO 9766 shanks when machining with rotating tools. The diameter setting range is ±0.3 mm (± 0.012 inch). Suitable for drilling depths up to 4–5 × DC.

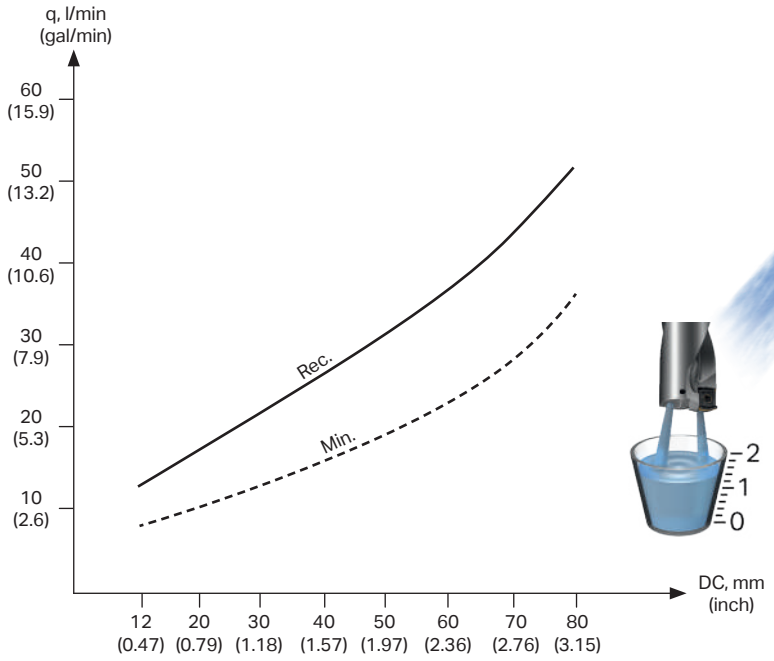
Coolant

CoroDrill® DS20 is designed with variable twisted coolant holes which allow for maintained drill body rigidity.

The coolant outlets are strategically placed to ensure the best possible coolant flow and direction. With more coolant on the clearance side, a longer insert tool life and better chip evacuation can be achieved.



Coolant flow recommendation



Optimized chip flutes

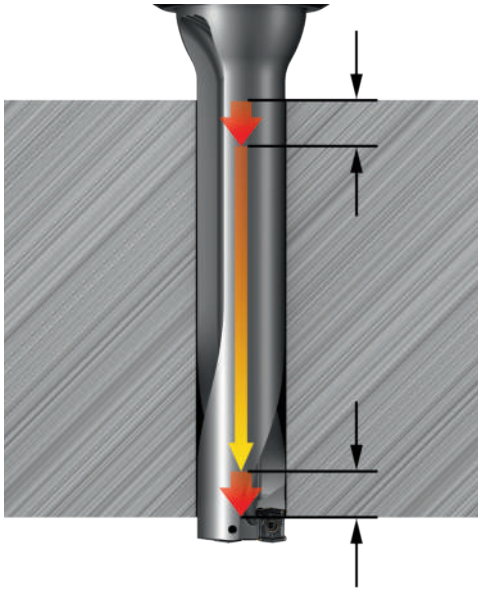
The chip flutes are individually shaped for optimized chip evacuation of the peripheral and central inserts different chip forms. All chips created fits inside the flutes.

The different shaped flutes help to control the rotational centre and the deflection of the drill when axial forces are applied.

To maintain drill body stiffness and for a balanced mass centre, the chip flutes are also individually designed for each drill size.

The square profile adds rigidity while the variable helix secures good chip evacuation, leading to less vibration, predictable wear patterns and increased tool life.

Drilling strategy for 6–7×DC



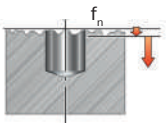
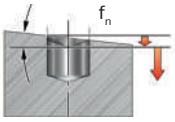
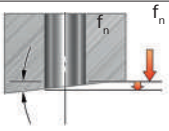
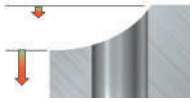
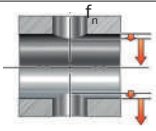
Apply soft entries and exits to maintain the hole tolerance

- f_n at hole entry: f_n × 75%
  Length of entry: 1 mm (0.039 inch)
- f_n at continuous drilling: regular feed recommendations
- f_n at hole exit: 0.05 mm/rev (0.002 in/rev) or even lower if high demands on hole quality
  Length of exit: 3–5 mm (0.118–0.196 inch)

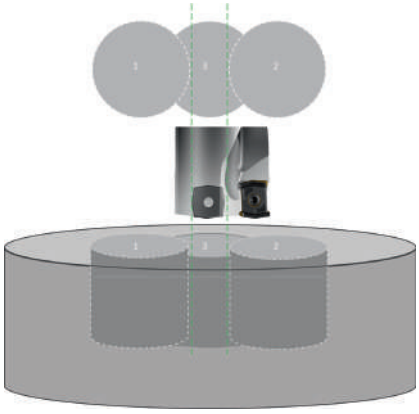
6–7×DC entry, continuous and exit feed recommendations can be found in CoroPlus® Tool Guide.

No v_c change in the different sections of the hole.

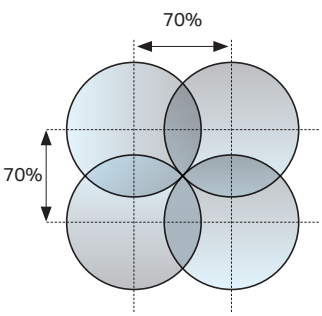
Advanced operations

		Irregular surface	Angled surface entry	Angled surface exit	Asymetricallly curved surface	Pre-drilled holes	Cross holes
Cutting data	L×DC						
v_c	4–5	Start values	Lowest recomendation	Start values	Start values	Start values	Start values
	6–7				Not recommended		
f_n	4–5	Lowest recomendation	1/3 of lowest recomendation	Lowest recomendation	1/3 of lowest recomendation		Lowest recomendation
	6–7				Nicht empfohlen		
Preconditions		Not rec. for 6–7×DC if concave radius ≤ drill radius	4–5×DC: angle ≤ 15° 6–7×DC: angle ≤ 10°	4–5×DC: angle ≤ 15° 6–7×DC: angle≤ 5°	Radius of curved surface > drill radius	Pre-drilled hole ≤ DC/4	Not recommended in long-chipping materials

Plunge drilling up to 5×DC under stable conditions



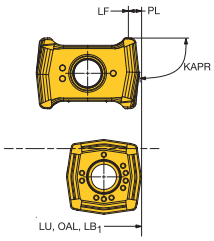
- Drill solid holes first (1 and 3)
- Webbed holes (3): Use very low cutting data with soft entry

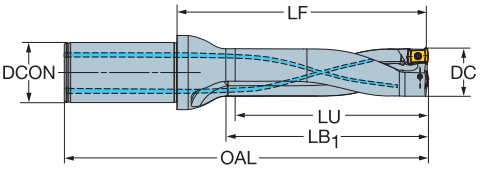


Interrupted cut:
v_c: Start values
f_n: Lowest recommendation

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766
Internal coolant supply

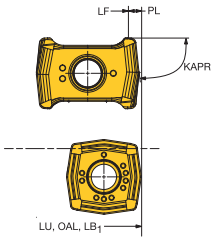


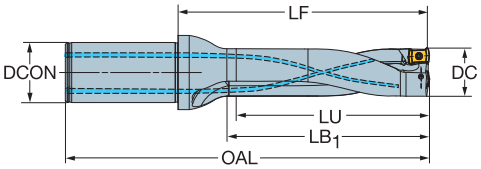


Metric									Dimensions: mm								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
15.00	01C	01P	60.46	20	1.00	0.00	0.27	DS20-D1500L20-04	20.00	80.54	131.00	63.00	0.46	81°	10	0.190	24000
			75.46	20	1.00	0.00	0.27	DS20-D1500L20-05	20.00	95.54	146.00	78.00	0.46	81°	10	0.200	15000
			90.46	20	1.00	-0.10	0.50	DS20-D1500L20-06	20.00	110.54	161.00	93.00	0.46	81°	10	0.210	11000
			105.46	20	1.00	-0.10	0.50	DS20-D1500L20-07	20.00	125.54	176.00	108.00	0.46	81°	10	0.219	8000
15.50	01C	01P	62.46	20	1.00	0.00	0.27	DS20-D1550L20-04	20.00	82.54	131.00	63.00	0.46	81°	10	0.193	24000
			77.96	20	1.00	0.00	0.27	DS20-D1550L20-05	20.00	98.54	146.00	78.00	0.46	81°	10	0.205	15000
16.00	01C	01P	64.46	20	0.75	0.00	0.27	DS20-D1600L20-04	20.00	84.54	135.00	67.00	0.46	81°	10	0.200	22000
			80.46	20	0.75	0.00	0.27	DS20-D1600L20-05	20.00	100.54	151.00	83.00	0.46	81°	10	0.212	14000
			96.46	20	0.75	-0.10	0.40	DS20-D1600L20-06	20.00	116.54	167.00	99.00	0.46	81°	10	0.224	10000
			112.46	20	0.75	-0.10	0.50	DS20-D1600L20-07	20.00	132.54	183.00	115.00	0.46	81°	10	0.236	7000
16.50	01C	01P	66.46	20	0.75	0.00	0.27	DS20-D1650L20-04	20.00	86.54	135.00	67.00	0.46	81°	10	0.203	22000
			82.96	20	0.75	0.00	0.27	DS20-D1650L20-05	20.00	103.54	151.00	83.00	0.46	81°	10	0.217	14000
17.00	01C	01P	68.46	20	0.50	0.00	0.27	DS20-D1700L20-04	20.00	88.54	139.00	71.00	0.46	81°	10	0.211	21000
			85.46	20	0.50	0.00	0.27	DS20-D1700L20-05	20.00	105.54	156.00	88.00	0.46	81°	10	0.226	13000
			102.46	20	0.50	-0.10	0.50	DS20-D1700L20-06	20.00	122.54	173.00	105.00	0.46	81°	10	0.240	9000
			119.46	20	0.50	-0.10	0.50	DS20-D1700L20-07	20.00	139.54	190.00	122.00	0.46	81°	10	0.255	7000
17.50	01C	01P	70.46	25	0.50	0.00	0.27	DS20-D1750L25-04	25.00	94.54	151.00	73.00	0.46	81°	10	0.337	21000
			87.96	25	0.50	0.00	0.27	DS20-D1750L25-05	25.00	112.54	156.00	88.00	0.46	81°	10	0.353	13000
18.00	01C	01P	72.46	25	0.25	0.00	0.27	DS20-D1800L25-04	25.00	96.54	153.00	75.00	0.46	81°	10	0.348	20000
			90.46	25	0.25	0.00	0.27	DS20-D1800L25-05	25.00	114.54	171.00	93.00	0.46	81°	10	0.366	13000
			108.46	25	0.25	-0.10	0.50	DS20-D1800L25-06	25.00	132.54	189.00	111.00	0.46	81°	10	0.383	9000
			126.46	25	0.25	-0.10	0.50	DS20-D1800L25-07	25.00	150.54	207.00	129.00	0.46	81°	10	0.400	6000
18.50	02C	02P	74.56	25	0.25	0.00	0.27	DS20-D1850L25-04	25.00	98.44	153.00	75.00	0.46	81°	10	0.349	20000
			93.06	25	0.25	0.00	0.27	DS20-D1850L25-05	25.00	117.44	171.00	93.00	0.46	81°	10	0.368	13000
19.00	02C	02P	76.56	25	1.06	0.00	0.33	DS20-D1900L25-04	25.00	100.44	157.00	79.00	0.55	81°	10	0.348	19000
			95.56	25	1.06	0.00	0.33	DS20-D1900L25-05	25.00	119.44	176.00	98.00	0.55	81°	10	0.367	12000
			114.56	25	1.06	-0.10	0.50	DS20-D1900L25-06	25.00	138.44	195.00	117.00	0.55	81°	10	0.387	8000
			133.56	25	1.06	-0.10	0.50	DS20-D1900L25-07	25.00	157.44	214.00	136.00	0.55	81°	10	0.405	6000
19.50	02C	02P	78.56	25	1.06	0.00	0.33	DS20-D1950L25-04	25.00	102.44	157.00	79.00	0.55	81°	10	0.362	19000
			98.06	25	1.06	0.00	0.33	DS20-D1950L25-05	25.00	122.44	176.00	98.00	0.55	81°	10	0.385	12000
20.00	02C	02P	80.56	25	0.82	0.00	0.33	DS20-D2000L25-04	25.00	104.44	161.00	83.00	0.55	81°	10	0.364	18000
			100.56	25	0.82	0.00	0.33	DS20-D2000L25-05	25.00	124.44	181.00	103.00	0.55	81°	10	0.386	11000
			120.56	25	0.82	-0.10	0.50	DS20-D2000L25-06	25.00	144.44	201.00	123.00	0.55	81°	10	0.409	8000
			140.56	25	0.82	-0.10	0.50	DS20-D2000L25-07	25.00	164.44	221.00	143.00	0.55	81°	10	0.431	6000
21.00	02C	02P	84.56	25	0.58	0.00	0.33	DS20-D2100L25-04	25.00	108.44	165.00	87.00	0.55	81°	10	0.381	17000
			105.56	25	0.58	0.00	0.33	DS20-D2100L25-05	25.00	129.44	186.00	108.00	0.55	81°	10	0.407	11000
			126.56	25	0.58	-0.10	0.50	DS20-D2100L25-06	25.00	150.44	207.00	129.00	0.55	81°	10	0.434	8000
			147.56	25	0.58	-0.10	0.50	DS20-D2100L25-07	25.00	171.44	228.00	150.00	0.55	81°	10	0.460	5000
22.00	02C	02P	88.56	25	0.34	0.00	0.33	DS20-D2200L25-04	25.00	112.44	169.00	91.00	0.55	81°	10	0.401	16000
			110.56	25	0.34	0.00	0.33	DS20-D2200L25-05	25.00	134.44	191.00	113.00	0.55	81°	10	0.431	10000
			132.56	25	0.34	-0.10	0.50	DS20-D2200L25-06	25.00	156.44	213.00	135.00	0.55	81°	10	0.463	7000
			154.56	25	0.34	-0.10	0.50	DS20-D2200L25-07	25.00	178.44	235.00	157.00	0.55	81°	10	0.494	5000

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766
Internal coolant supply

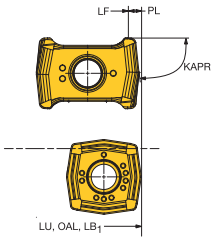


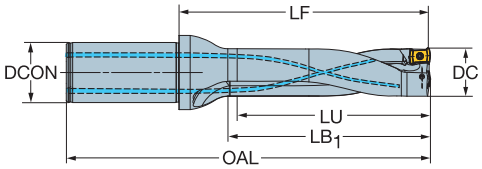


Metric									Dimensions: mm								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
23.00	03C	03P	92.67	25	1.30	0.00	0.33	DS20-D2300L25-04	25.00	117.34	174.00	96.00	0.66	81°	10	0.417	15000
			115.67	25	1.30	0.00	0.33	DS20-D2300L25-05	25.00	140.34	197.00	119.00	0.66	81°	10	0.452	10000
			138.67	25	1.30	-0.10	0.50	DS20-D2300L25-06	25.00	163.34	220.00	142.00	0.66	81°	10	0.488	7000
			161.67	25	1.30	-0.10	0.50	DS20-D2300L25-07	25.00	186.34	243.00	165.00	0.66	81°	10	0.524	5000
24.00	03C	03P	96.67	25	1.10	0.00	0.33	DS20-D2400L25-04	25.00	121.34	178.00	100.00	0.66	81°	10	0.439	15000
			120.67	25	1.10	0.00	0.33	DS20-D2400L25-05	25.00	145.34	202.00	124.00	0.66	81°	10	0.480	9000
			144.67	25	1.10	-0.10	0.50	DS20-D2400L25-06	25.00	169.34	226.00	148.00	0.66	81°	10	0.520	6000
			168.67	25	1.10	-0.10	0.50	DS20-D2400L25-07	25.00	193.34	250.00	172.00	0.66	81°	10	0.561	5000
25.00	03C	03P	100.67	25	0.90	0.00	0.33	DS20-D2500L25-04	25.00	125.34	182.00	104.00	0.66	81°	10	0.463	14000
			125.67	25	0.90	0.00	0.33	DS20-D2500L25-05	25.00	150.34	207.00	129.00	0.66	81°	10	0.510	9000
			150.67	25	0.90	-0.10	0.50	DS20-D2500L25-06	25.00	175.34	232.00	154.00	0.66	81°	10	0.557	6000
			175.67	25	0.90	-0.10	0.50	DS20-D2500L25-07	25.00	200.34	257.00	179.00	0.66	81°	10	0.603	4000
26.00	03C	03P	104.67	32	0.70	0.00	0.33	DS20-D2600L32-04	32.00	133.34	194.00	108.00	0.66	81°	10	0.705	14000
			130.67	32	0.70	0.00	0.33	DS20-D2600L32-05	32.00	159.34	220.00	134.00	0.66	81°	10	0.758	9000
			156.67	32	0.70	-0.10	0.50	DS20-D2600L32-06	32.00	185.34	246.00	160.00	0.66	81°	10	0.812	6000
			182.67	32	0.70	-0.10	0.50	DS20-D2600L32-07	32.00	211.34	272.00	186.00	0.66	81°	10	0.865	4000
27.00	03C	03P	108.67	32	0.50	0.00	0.33	DS20-D2700L32-04	32.00	136.34	197.00	112.00	0.66	81°	10	0.734	13000
			135.67	32	0.50	0.00	0.33	DS20-D2700L32-05	32.00	163.34	224.00	139.00	0.66	81°	10	0.794	8000
			162.67	32	0.50	-0.10	0.50	DS20-D2700L32-06	32.00	190.34	251.00	166.00	0.66	81°	10	0.854	6000
			189.67	32	0.50	-0.10	0.50	DS20-D2700L32-07	32.00	217.34	278.00	193.00	0.66	81°	10	0.912	4000
28.00	04C	04P	112.83	32	2.12	0.00	0.33	DS20-D2800L32-04	32.00	140.17	201.00	116.00	0.83	81°	10	0.743	13000
			140.83	32	2.12	0.00	0.33	DS20-D2800L32-05	32.00	168.17	229.00	144.00	0.83	81°	10	0.809	8000
			168.83	32	2.12	-0.10	0.50	DS20-D2800L32-06	32.00	196.17	257.00	172.00	0.83	81°	10	0.874	6000
			196.83	32	2.12	-0.10	0.50	DS20-D2800L32-07	32.00	224.17	285.00	200.00	0.83	81°	10	0.939	4000
29.00	04C	04P	116.83	32	1.84	0.00	0.33	DS20-D2900L32-04	32.00	144.17	205.00	120.00	0.83	81°	10	0.773	12000
			145.83	32	1.84	0.00	0.33	DS20-D2900L32-05	32.00	173.17	234.00	149.00	0.83	81°	10	0.846	8000
			174.83	32	1.84	-0.10	0.50	DS20-D2900L32-06	32.00	202.17	263.00	178.00	0.83	81°	10	0.918	5000
			203.83	32	1.84	-0.10	0.50	DS20-D2900L32-07	32.00	231.17	292.00	207.00	0.83	81°	10	0.991	4000
30.00	04C	04P	120.83	32	1.56	0.00	0.33	DS20-D3000L32-04	32.00	148.17	209.00	124.00	0.83	81°	10	0.805	12000
			150.83	32	1.56	0.00	0.33	DS20-D3000L32-05	32.00	178.17	239.00	154.00	0.83	81°	10	0.885	8000
			180.83	32	1.56	-0.10	0.50	DS20-D3000L32-06	32.00	208.17	269.00	184.00	0.83	81°	10	0.966	5000
			210.83	32	1.56	-0.10	0.50	DS20-D3000L32-07	32.00	238.17	299.00	214.00	0.83	81°	10	1.046	4000
31.00	04C	04P	124.83	40	1.28	0.00	0.35	DS20-D3100L40-04	40.00	158.17	229.00	128.00	0.83	81°	10	1.250	12000
			155.83	40	1.28	0.00	0.35	DS20-D3100L40-05	40.00	189.17	260.00	159.00	0.83	81°	10	1.339	7000
			186.83	40	1.28	-0.10	0.50	DS20-D3100L40-06	40.00	220.17	291.00	190.00	0.83	81°	10	1.428	5000
			217.83	40	1.28	-0.10	0.50	DS20-D3100L40-07	40.00	251.17	322.00	221.00	0.83	81°	10	1.516	4000
32.00	04C	04P	128.83	40	1.00	0.00	0.35	DS20-D3200L40-04	40.00	162.17	233.00	132.00	0.83	81°	10	1.286	11000
			160.83	40	1.00	0.00	0.35	DS20-D3200L40-05	40.00	194.17	265.00	164.00	0.83	81°	10	1.384	7000
			192.83	40	1.00	-0.10	0.50	DS20-D3200L40-06	40.00	226.17	297.00	196.00	0.83	81°	10	1.481	5000
			224.83	40	1.00	-0.10	0.50	DS20-D3200L40-07	40.00	258.17	329.00	228.00	0.83	81°	10	1.579	3000
33.00	04C	04P	132.83	40	0.72	0.00	0.35	DS20-D3300L40-04	40.00	165.17	236.00	136.00	0.83	81°	10	1.313	11000
			165.83	40	0.72	0.00	0.35	DS20-D3300L40-05	40.00	198.17	269.00	169.00	0.83	81°	10	1.420	7000
			198.83	40	0.72	-0.10	0.50	DS20-D3300L40-06	40.00	231.17	302.00	202.00	0.83	81°	10	1.527	5000
			231.83	40	0.72	-0.10	0.50	DS20-D3300L40-07	40.00	264.17	335.00	235.00	0.83	81°	10	1.634	3000

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766
Internal coolant supply

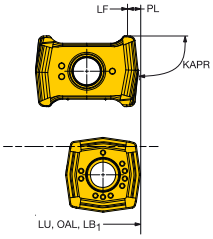


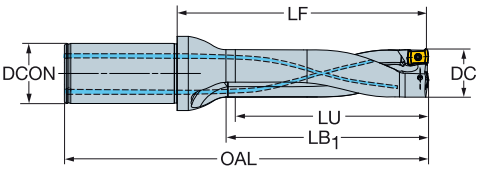


Metric									Dimensions: mm								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
34.00	05C	05P	137.00	40	2.16	0.00	0.35	DS20-D3400L40-04	40.00	169.00	240.00	140.00	1.00	81°	10	1.354	11000
			171.00	40	2.16	0.00	0.35	DS20-D3400L40-05	40.00	203.00	274.00	174.00	1.00	81°	10	1.471	7000
			205.00	40	2.16	-0.10	0.50	DS20-D3400L40-06	40.00	237.00	308.00	208.00	1.00	81°	10	1.588	4000
			239.00	40	2.16	-0.10	0.50	DS20-D3400L40-07	40.00	271.00	342.00	242.00	1.00	81°	10	1.705	3000
35.00	05C	05P	141.00	40	1.92	0.00	0.35	DS20-D3500L40-04	40.00	173.00	244.00	144.00	1.00	81°	10	1.398	10000
			176.00	40	1.92	0.00	0.35	DS20-D3500L40-05	40.00	208.00	279.00	179.00	1.00	81°	10	1.525	6000
			211.00	40	1.92	-0.10	0.50	DS20-D3500L40-06	40.00	243.00	314.00	214.00	1.00	81°	10	1.653	4000
			246.00	40	1.92	-0.10	0.50	DS20-D3500L40-07	40.00	278.00	349.00	249.00	1.00	81°	10	1.781	3000
36.00	05C	05P	145.00	40	1.68	0.00	0.35	DS20-D3600L40-04	40.00	177.00	248.00	148.00	1.00	81°	10	1.443	10000
			181.00	40	1.68	0.00	0.35	DS20-D3600L40-05	40.00	213.00	284.00	184.00	1.00	81°	10	1.582	6000
			217.00	40	1.68	-0.10	0.50	DS20-D3600L40-06	40.00	249.00	320.00	220.00	1.00	81°	10	1.721	4000
			253.00	40	1.68	-0.10	0.50	DS20-D3600L40-07	40.00	285.00	356.00	256.00	1.00	81°	10	1.860	3000
37.00	05C	05P	149.00	40	1.44	0.00	0.35	DS20-D3700L40-04	40.00	181.00	252.00	152.00	1.00	81°	10	1.492	10000
			186.00	40	1.44	0.00	0.35	DS20-D3700L40-05	40.00	218.00	289.00	189.00	1.00	81°	10	1.643	6000
			223.00	40	1.44	-0.10	0.50	DS20-D3700L40-06	40.00	255.00	326.00	226.00	1.00	81°	10	1.794	4000
			260.00	40	1.44	-0.10	0.50	DS20-D3700L40-07	40.00	292.00	363.00	263.00	1.00	81°	10	1.945	3000
38.00	05C	05P	153.00	40	1.20	0.00	0.35	DS20-D3800L40-04	40.00	185.00	256.00	156.00	1.00	81°	10	1.543	9000
			191.00	40	1.20	0.00	0.35	DS20-D3800L40-05	40.00	223.00	294.00	194.00	1.00	81°	10	1.707	6000
			229.00	40	1.20	-0.10	0.50	DS20-D3800L40-06	40.00	261.00	332.00	232.00	1.00	81°	10	1.870	4000
			267.00	40	1.20	-0.10	0.50	DS20-D3800L40-07	40.00	299.00	370.00	270.00	1.00	81°	10	2.034	3000
39.00	05C	05P	157.00	40	0.96	0.00	0.35	DS20-D3900L40-04	40.00	189.00	260.00	160.00	1.00	81°	10	1.597	9000
			196.00	40	0.96	0.00	0.35	DS20-D3900L40-05	40.00	228.00	299.00	199.00	1.00	81°	10	1.774	6000
			235.00	40	0.96	-0.10	0.50	DS20-D3900L40-06	40.00	267.00	338.00	238.00	1.00	81°	10	1.950	4000
			274.00	40	0.96	-0.10	0.50	DS20-D3900L40-07	40.00	306.00	377.00	277.00	1.00	81°	10	2.127	3000
40.00	05C	05P	161.00	40	0.72	0.00	0.35	DS20-D4000L40-04	40.00	193.00	264.00	164.00	1.00	81°	10	1.654	9000
			201.00	40	0.72	0.00	0.35	DS20-D4000L40-05	40.00	233.00	304.00	204.00	1.00	81°	10	1.844	6000
			241.00	40	0.72	-0.10	0.50	DS20-D4000L40-06	40.00	273.00	344.00	244.00	1.00	81°	10	2.035	4000
			281.00	40	0.72	-0.10	0.50	DS20-D4000L40-07	40.00	313.00	384.00	284.00	1.00	81°	10	2.226	3000
41.00	06C	06P	165.28	40	3.73	0.00	0.35	DS20-D4100L40-04	40.00	197.72	269.00	169.00	1.27	81°	10	1.543	9000
			206.28	40	3.73	0.00	0.35	DS20-D4100L40-05	40.00	238.72	310.00	210.00	1.27	81°	10	1.707	6000
			247.28	40	3.73	-0.10	0.50	DS20-D4100L40-06	40.00	279.72	351.00	251.00	1.27	81°	10	1.870	4000
			288.28	40	3.73	-0.10	0.50	DS20-D4100L40-07	40.00	320.72	392.00	292.00	1.27	81°	10	2.034	3000
42.00	06C	06P	169.28	50	3.46	0.00	0.35	DS20-D4200L50-04	50.00	208.72	290.00	173.00	1.27	81°	10	2.578	8000
			211.28	50	3.46	0.00	0.35	DS20-D4200L50-05	50.00	250.72	332.00	215.00	1.27	81°	10	2.805	5000
			253.28	50	3.46	-0.10	0.50	DS20-D4200L50-06	50.00	292.72	374.00	257.00	1.27	81°	10	3.033	4000
			295.28	50	3.46	-0.10	0.50	DS20-D4200L50-07	50.00	334.72	416.00	299.00	1.27	81°	10	3.260	2000
43.00	06C	06P	173.28	50	3.19	0.00	0.35	DS20-D4300L50-04	50.00	212.72	294.00	177.00	1.27	81°	10	2.654	8000
			216.28	50	2.92	0.00	0.35	DS20-D4300L50-05	50.00	255.72	337.00	220.00	1.27	81°	10	2.898	5000
			259.28	50	2.92	-0.10	0.50	DS20-D4300L50-06	50.00	298.72	380.00	263.00	1.27	81°	10	3.143	3000
			302.28	50	2.92	-0.10	0.50	DS20-D4300L50-07	50.00	341.72	423.00	306.00	1.27	81°	10	3.388	2000
44.00	06C	06P	177.28	50	2.92	0.00	0.35	DS20-D4400L50-04	50.00	216.72	298.00	181.00	1.27	81°	10	2.733	8000
			221.28	50	2.92	0.00	0.35	DS20-D4400L50-05	50.00	260.72	342.00	225.00	1.27	81°	10	2.996	5000
			265.28	50	2.92	-0.10	0.50	DS20-D4400L50-06	50.00	304.72	386.00	269.00	1.27	81°	10	3.259	3000
			309.28	50	2.92	-0.10	0.50	DS20-D4400L50-07	50.00	348.72	430.00	313.00	1.27	81°	10	3.521	2000

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766
Internal coolant supply

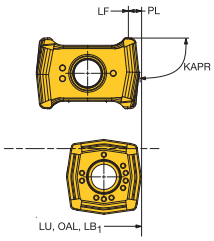


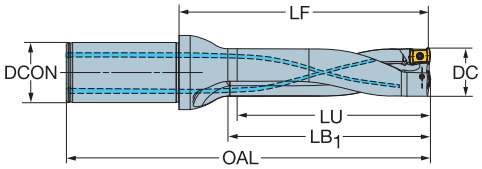


Metric									Dimensions: mm								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
45.00	06C	06P	181.28	50	2.65	0.00	0.35	DS20-D4500L50-04	50.00	220.72	302.00	185.00	1.27	81°	10	2.816	8000
			226.28	50	2.65	0.00	0.35	DS20-D4500L50-05	50.00	265.72	347.00	230.00	1.27	81°	10	3.101	5000
			271.28	50	2.65	-0.10	0.50	DS20-D4500L50-06	50.00	310.72	392.00	275.00	1.27	81°	10	3.385	3000
			316.28	50	2.65	-0.10	0.50	DS20-D4500L50-07	50.00	355.72	437.00	320.00	1.27	81°	10	3.669	2000
46.00	06C	06P	185.28	50	2.38	0.00	0.35	DS20-D4600L50-04	50.00	224.72	306.00	189.00	1.27	81°	10	2.902	8000
			231.28	50	2.38	0.00	0.35	DS20-D4600L50-05	50.00	270.72	352.00	235.00	1.27	81°	10	3.206	5000
47.00	06C	06P	189.28	50	2.11	0.00	0.35	DS20-D4700L50-04	50.00	227.72	309.00	193.00	1.27	81°	10	2.968	8000
			236.28	50	2.11	0.00	0.35	DS20-D4700L50-05	50.00	274.72	356.00	240.00	1.27	81°	10	3.293	5000
48.00	06C	06P	193.28	50	1.84	0.00	0.35	DS20-D4800L50-04	50.00	231.72	313.00	197.00	1.27	81°	10	3.061	7000
			241.28	50	1.84	0.00	0.35	DS20-D4800L50-05	50.00	279.72	361.00	245.00	1.27	81°	10	3.408	5000
49.00	06C	06P	197.28	50	1.57	0.00	0.35	DS20-D4900L50-04	50.00	235.72	317.00	201.00	1.27	81°	10	3.158	7000
			246.28	50	1.57	0.00	0.35	DS20-D4900L50-05	50.00	284.72	366.00	250.00	1.27	81°	10	3.528	4000
50.00	06C	06P	201.28	50	1.30	0.00	0.35	DS20-D5000L50-04	50.00	239.72	321.00	205.00	1.27	81°	10	3.259	7000
			251.28	50	1.30	0.00	0.35	DS20-D5000L50-05	50.00	289.72	371.00	255.00	1.27	81°	10	3.652	4000
51.00	06C	06P	205.28	50	1.03	0.00	0.35	DS20-D5100L50-04	50.00	243.72	325.00	209.00	1.27	81°	10	3.363	7000
			256.28	50	1.03	0.00	0.35	DS20-D5100L50-05	50.00	294.72	376.00	260.00	1.27	81°	10	3.781	4000
52.00	06C	06P	209.28	50	0.76	0.00	0.35	DS20-D5200L50-04	50.00	247.72	329.00	213.00	1.27	81°	10	3.472	7000
			261.28	50	0.76	0.00	0.35	DS20-D5200L50-05	50.00	299.72	381.00	265.00	1.27	81°	10	3.916	4000
53.00	07C	07P	213.59	50	4.21	0.00	0.35	DS20-D5300L50-04	50.00	251.41	333.00	217.00	1.58	81°	10	3.459	7000
			266.59	50	4.21	0.00	0.35	DS20-D5300L50-05	50.00	304.41	386.00	270.00	1.58	81°	10	3.911	4000
54.00	07C	07P	217.59	50	3.92	0.00	0.35	DS20-D5400L50-04	50.00	255.41	337.00	221.00	1.58	81°	10	3.573	7000
			271.59	50	3.92	0.00	0.35	DS20-D5400L50-05	50.00	309.41	391.00	275.00	1.58	81°	10	4.052	4000
55.00	07C	07P	221.59	50	3.63	0.00	0.35	DS20-D5500L50-04	50.00	259.41	341.00	225.00	1.58	81°	10	3.694	6000
			276.59	50	3.63	0.00	0.35	DS20-D5500L50-05	50.00	314.41	396.00	280.00	1.58	81°	10	4.202	4000
56.00	07C	07P	225.59	50	3.34	0.00	0.35	DS20-D5600L50-04	50.00	263.41	345.00	229.00	1.58	81°	10	3.827	6000
			281.59	50	3.34	0.00	0.35	DS20-D5600L50-05	50.00	319.41	401.00	285.00	1.58	81°	10	4.367	4000
57.00	07C	07P	229.59	50	3.05	0.00	0.35	DS20-D5700L50-04	50.00	267.41	349.00	233.00	1.58	81°	10	3.957	6000
			286.59	50	3.05	0.00	0.35	DS20-D5700L50-05	50.00	324.41	406.00	290.00	1.58	81°	10	4.528	4000
58.00	07C	07P	233.59	50	2.76	0.00	0.35	DS20-D5800L50-04	50.00	271.41	353.00	237.00	1.58	81°	10	4.300	6000
			291.59	50	2.76	0.00	0.35	DS20-D5800L50-05	50.00	329.41	411.00	295.00	1.58	81°	10	4.623	4000
59.00	07C	07P	237.59	50	2.47	0.00	0.35	DS20-D5900L50-04	50.00	274.41	356.00	241.00	1.58	81°	10	4.146	6000
			296.59	50	2.47	0.00	0.35	DS20-D5900L50-05	50.00	333.41	415.00	300.00	1.58	81°	10	4.768	4000
60.00	07C	07P	241.59	50	2.18	0.00	0.35	DS20-D6000L50-04	50.00	278.41	360.00	245.00	1.58	81°	10	4.350	6000
			301.59	50	3.63	0.00	0.35	DS20-D6000L50-05	50.00	338.41	420.00	305.00	1.58	81°	10	5.021	4000
61.00	07C	07P	245.59	50	1.89	0.00	0.35	DS20-D6100L50-04	50.00	282.41	364.00	249.00	1.58	81°	10	4.498	6000
			306.59	50	1.89	0.00	0.35	DS20-D6100L50-05	50.00	343.41	425.00	310.00	1.58	81°	10	5.204	4000
62.00	07C	07P	249.59	50	1.60	0.00	0.35	DS20-D6200L50-04	50.00	286.41	368.00	253.00	1.58	81°	10	4.651	6000
			311.59	50	1.60	0.00	0.35	DS20-D6200L50-05	50.00	348.41	430.00	315.00	1.58	81°	10	5.393	3000
63.00	07C	07P	253.59	50	1.31	0.00	0.35	DS20-D6300L50-04	50.00	290.41	372.00	257.00	1.58	81°	10	4.806	6000
			316.59	50	1.31	0.00	0.35	DS20-D6300L50-05	50.00	353.41	435.00	320.00	1.58	81°	10	5.587	3000
64.00	07C	07P	257.59	50	1.02	0.00	0.35	DS20-D6400L50-04	50.00	295.41	377.00	261.00	1.58	81°	10	4.848	5000
			321.59	50	1.02	0.00	0.35	DS20-D6400L50-05	50.00	359.41	441.00	325.00	1.58	81°	10	5.633	3000
65.00	07C	07P	261.59	50	0.73	0.00	0.35	DS20-D6500L50-04	50.00	299.41	381.00	265.00	1.58	81°	10	5.167	5000
			326.59	50	0.73	0.00	0.35	DS20-D6500L50-05	50.00	364.41	446.00	330.00	1.58	81°	10	6.027	3000

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766
Internal coolant supply

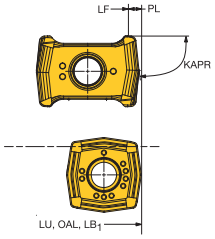


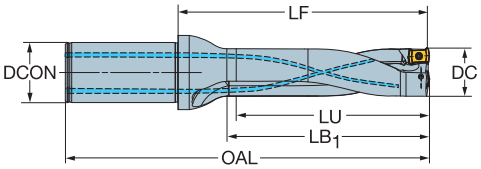


Inch									Dimensions: inch								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	PSI	LBS	RPMX
.625	01C	01P	2.519	3/4	.030	.000	.011	DS20-D1588LX19-04	.750	3.298	5.285	2.611	.018	81°	145	0.480	22000
			3.144	3/4	.030	.000	.011	DS20-D1588LX19-05	.750	3.923	5.910	3.236	.018	81°	145	0.504	14000
			3.769	3/4	.030	-.004	.016	DS20-D1588LX19-06	.750	4.548	6.535	3.861	.018	81°	145	0.540	10000
			4.395	3/4	.030	-.004	.016	DS20-D1588LX19-07	.750	5.173	7.160	4.486	.018	81°	145	0.440	7000
.655	01C	01P	2.642	3/4	.023	.000	.011	DS20-D1666LX19-04	.750	3.420	5.407	2.735	.018	81°	145	0.500	21000
			3.298	3/4	.023	.000	.011	DS20-D1666LX19-05	.750	4.076	6.063	3.391	.018	81°	145	0.529	14000
			3.954	3/4	.023	-.004	.016	DS20-D1666LX19-06	.750	4.732	6.719	4.047	.018	81°	145	0.570	10000
			4.610	3/4	.023	-.004	.016	DS20-D1666LX19-07	.750	5.388	7.375	4.703	.018	81°	145	0.599	7000
.687	01C	01P	2.766	1	.015	.000	.011	DS20-D1745LX25-04	1.000	3.692	5.915	2.859	.018	81°	145	0.661	21000
			3.453	1	.015	.000	.011	DS20-D1745LX25-05	1.000	4.379	6.602	3.546	.018	81°	145	0.800	13000
			4.140	1	.015	-.004	.016	DS20-D1745LX25-06	1.000	5.066	7.289	4.233	.018	81°	145	0.881	9000
			4.827	1	.015	-.004	.016	DS20-D1745LX25-07	1.000	5.753	7.976	4.920	.018	81°	145	1 018	7000
.750	02C	02P	3.022	1	.041	.000	.013	DS20-D1905LX25-04	1.000	3.943	6.170	3.119	.022	81°	145	0.870	19000
			3.772	1	.041	.000	.013	DS20-D1905LX25-05	1.000	4.693	6.920	3.869	.022	81°	145	0.921	12000
			4.522	1	.041	-.004	.016	DS20-D1905LX25-06	1.000	5.443	7.670	4.619	.022	81°	145	0.870	8000
			5.272	1	.041	-.004	.016	DS20-D1905LX25-07	1.000	6.193	8.420	5.369	.022	81°	145	1.051	6000
.812	02C	02P	3.270	1	.026	.000	.013	DS20-D2062LX25-04	1.000	4.186	6.413	3.367	.022	81°	145	0.939	17000
			4.082	1	.026	.000	.013	DS20-D2062LX25-05	1.000	4.998	7.225	4.179	.022	81°	145	0.881	11000
			4.894	1	.026	-.004	.016	DS20-D2062LX25-06	1.000	5.810	8.037	4.991	.022	81°	145	1.102	8000
			5.706	1	.026	-.004	.016	DS20-D2062LX25-07	1.000	6.622	8.849	5.803	.022	81°	145	1.322	6000
.875	03C	03P	3.526	1	.057	.000	.013	DS20-D2223LX25-04	1.000	4.436	6.667	3.626	.026	81°	145	0.899	16000
			4.401	1	.057	.000	.013	DS20-D2223LX25-05	1.000	5.311	7.542	4.501	.026	81°	145	1.075	10000
			5.276	1	.057	-.004	.016	DS20-D2223LX25-06	1.000	6.186	8.417	5.376	.026	81°	145	1.102	7000
			6.151	1	.057	-.004	.016	DS20-D2223LX25-07	1.000	7.061	9.292	6.251	.026	81°	145	1.102	5000
.937	03C	03P	3.774	1	.044	.000	.013	DS20-D2380LX25-04	1.000	4.679	6.910	3.874	.026	81°	145	1.073	15000
			4.711	1	.044	.000	.013	DS20-D2380LX25-05	1.000	5.616	7.847	4.811	.026	81°	145	1.322	10000
			5.648	1	.044	-.004	.016	DS20-D2380LX25-06	1.000	6.553	8.784	5.748	.026	81°	145	1.322	7000
			6.585	1	.044	-.004	.016	DS20-D2380LX25-07	1.000	7.490	9.721	6.685	.026	81°	145	1.234	5000
1.000	03C	03P	4.026	1	.032	.000	.013	DS20-D2540LX25-04	1.000	4.926	7.157	4.126	.026	81°	145	1.155	14000
			5.026	1	.032	.000	.013	DS20-D2540LX25-05	1.000	5.926	8.157	5.126	.026	81°	145	1.309	9000
			6.026	1	.032	-.004	.016	DS20-D2540LX25-06	1.000	6.926	9.157	6.126	.026	81°	145	1.543	6000
			7.026	1	.032	-.004	.016	DS20-D2540LX25-07	1.000	7.926	10.157	7.126	.026	81°	145	1.543	4000
1.062	03C	03P	4.274	1 1/4	.020	.000	.013	DS20-D2697LX31-04	1.250	5.331	7.719	4.374	.026	81°	145	1.984	13000
			5.336	1 1/4	.020	.000	.013	DS20-D2697LX31-05	1.250	6.393	8.781	5.436	.026	81°	145	1.984	8000
			6.398	1 1/4	.020	-.004	.016	DS20-D2697LX31-06	1.250	7.455	9.843	6.498	.026	81°	145	2.425	6000
			7.460	1 1/4	.020	-.004	.016	DS20-D2697LX31-07	1.250	8.517	10.905	7.560	.026	81°	145	2.204	4000
1.125	04C	04P	4.533	1 1/4	.077	.000	.013	DS20-D2858LX31-04	1.250	5.587	7.982	4.642	.033	81°	145	1.660	13000
			5.658	1 1/4	.077	.000	.013	DS20-D2858LX31-05	1.250	6.712	9.107	5.767	.033	81°	145	1.814	8000
			6.783	1 1/4	.077	-.004	.016	DS20-D2858LX31-06	1.250	7.837	10.232	6.892	.033	81°	145	1.966	5000
			7.908	1 1/4	.077	-.004	.016	DS20-D2858LX31-07	1.250	8.962	11.357	8.017	.033	81°	145	2.120	4000

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766
Internal coolant supply

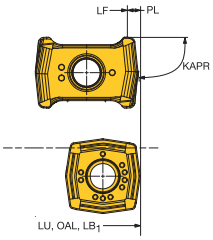


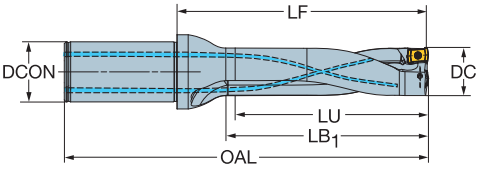


Inch									Dimensions: inch								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	PSI	LBS	RPMX
1.187	04C	04P	4.781	1 1/4	.059	.000	.013	DS20-D3015LX31-04	1.250	5.830	8.225	4.890	.033	81°	145	1.768	12000
			5.968	1 1/4	.059	.000	.013	DS20-D3015LX31-05	1.250	7.017	9.412	6.077	.033	81°	145	1.948	8000
			7.155	1 1/4	.059	-.004	.016	DS20-D3015LX31-06	1.250	8.204	10.599	7.264	.033	81°	145	2.127	5000
			8.342	1 1/4	.059	-.004	.016	DS20-D3015LX31-07	1.250	9.391	11.786	8.451	.033	81°	145	2.308	4000
1.250	04C	04P	5.033	1 1/2	.042	.000	.014	DS20-D3175LX38-04	1.500	6.292	9.081	5.142	.033	81°	145	2.680	11000
			6.283	1 1/2	.042	.000	.014	DS20-D3175LX38-05	1.500	7.542	10.331	6.392	.033	81°	145	2.890	7000
			7.533	1 1/2	.042	-.004	.016	DS20-D3175LX38-06	1.500	8.792	11.581	7.642	.033	81°	145	3.101	5000
			8.783	1 1/2	.042	-.004	.016	DS20-D3175LX38-07	1.500	10.042	12.831	8.892	.033	81°	145	3.311	3000
1.312	05C	05P	5.287	1 1/2	.091	.000	.014	DS20-D3332LX38-04	1.500	6.541	9.336	5.402	.039	81°	145	3.306	11000
			6.599	1 1/2	.091	.000	.014	DS20-D3332LX38-05	1.500	7.853	10.648	6.714	.039	81°	145	3.306	7000
			7.911	1 1/2	.091	-.004	.016	DS20-D3332LX38-06	1.500	9.165	11.960	8.026	.039	81°	145	3.747	5000
			9.223	1 1/2	.091	-.004	.016	DS20-D3332LX38-07	1.500	10.477	13.272	9.338	.039	81°	145	3.747	3000
1.375	05C	05P	5.539	1 1/2	.076	.000	.014	DS20-D3493LX38-04	1.500	6.788	9.583	5.654	.039	81°	145	3.306	10000
			6.914	1 1/2	.076	.000	.014	DS20-D3493LX38-05	1.500	8.163	10.958	7.029	.039	81°	145	3.527	6000
			8.289	1 1/2	.076	-.004	.016	DS20-D3493LX38-06	1.500	9.538	12.333	8.404	.039	81°	145	3.747	4000
			9.664	1 1/2	.076	-.004	.016	DS20-D3493LX38-07	1.500	10.913	13.708	9.779	.039	81°	145	4.409	3000
1.437	05C	05P	5.787	1 1/2	.061	.000	.014	DS20-D3650LX38-04	1.500	7.031	9.826	5.902	.039	81°	145	3.527	10000
			7.224	1 1/2	.061	.000	.014	DS20-D3650LX38-05	1.500	8.468	11.263	7.339	.039	81°	145	3.437	6000
			8.661	1 1/2	.061	-.004	.016	DS20-D3650LX38-06	1.500	9.905	12.700	8.776	.039	81°	145	4.188	4000
			10.098	1 1/2	.061	-.004	.016	DS20-D3650LX38-07	1.500	11.342	14.137	10.213	.039	81°	145	4.629	3000
1.500	05C	05P	6.039	1 1/2	.046	.000	.014	DS20-D3810LX38-04	1.500	7.278	10.073	6.154	.039	81°	145	3.527	9000
			7.539	1 1/2	.046	.000	.014	DS20-D3810LX38-05	1.500	8.778	11.573	7.654	.039	81°	145	3.747	6000
			9.039	1 1/2	.046	-.004	.016	DS20-D3810LX38-06	1.500	10.278	13.073	9.154	.039	81°	145	4.629	4000
			10.539	1 1/2	.046	-.004	.016	DS20-D3810LX38-07	1.500	11.778	14.573	10.654	.039	81°	145	5.291	3000
1.562	05C	05P	6.287	1 1/2	.031	.000	.014	DS20-D3967LX38-04	1.500	7.522	10.317	6.402	.039	81°	145	3.968	9000
			7.849	1 1/2	.031	.000	.014	DS20-D3967LX38-05	1.500	9.084	11.879	7.964	.039	81°	145	4.188	6000
			9.411	1 1/2	.031	-.004	.016	DS20-D3967LX38-06	1.500	10.646	13.441	9.526	.039	81°	145	5.070	4000
			10.973	1 1/2	.031	-.004	.016	DS20-D3967LX38-07	1.500	12.208	15.003	11.088	.039	81°	145	5.732	3000
1.625	06C	06P	6.550	1 1/2	.143	.000	.014	DS20-D4128LX38-04	1.500	7.770	10.576	6.666	.050	81°	145	3.968	9000
			8.175	1 1/2	.143	.000	.014	DS20-D4128LX38-05	1.500	9.395	12.201	8.291	.050	81°	145	4.409	5000
			9.800	1 1/2	.143	-.004	.016	DS20-D4128LX38-06	1.500	11.020	13.826	9.916	.050	81°	145	5.511	4000
			11.425	1 1/2	.143	-.004	.016	DS20-D4128LX38-07	1.500	12.645	15.451	11.541	.050	81°	145	5.952	3000
1.687	06C	06P	6.798	1 1/2	.127	.000	.014	DS20-D4285LX38-04	1.500	8.013	10.819	6.914	.050	81°	145	4.409	8000
			8.485	1 1/2	.127	.000	.014	DS20-D4285LX38-05	1.500	9.700	12.506	8.601	.050	81°	145	4.629	5000
			10.172	1 1/2	.127	-.004	.016	DS20-D4285LX38-06	1.500	11.387	14.193	10.288	.050	81°	145	5.952	3000
			11.859	1 1/2	.127	-.004	.016	DS20-D4285LX38-07	1.500	13.074	15.880	11.975	.050	81°	145	6.393	2000
1.750	06C	06P	7.050	1 1/2	.110	.000	.014	DS20-D4445LX38-04	1.500	8.260	11.066	7.166	.050	81°	145	4.409	8000
			8.800	1 1/2	.110	.000	.014	DS20-D4445LX38-05	1.500	10.010	12.816	8.916	.050	81°	145	4.841	5000
			10.550	1 1/2	.110	-.004	.016	DS20-D4445LX38-06	1.500	11.760	14.566	10.666	.050	81°	145	6.172	3000
			12.300	1 1/2	.110	-.004	.016	DS20-D4445LX38-07	1.500	13.510	16.316	12.416	.050	81°	145	6.038	2000

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766
Internal coolant supply

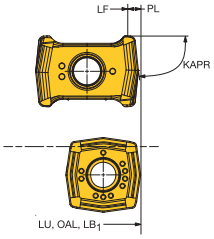


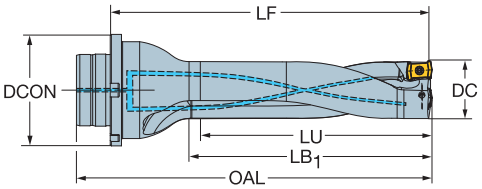


Inch									Dimensions: inch								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	PSI	LBS	RPMX
1.875	06C	06P	7.550	1 1/2	.076	.000	.014	DS20-D4763LX38-04	1.500	8.750	11.556	7.666	.050	81°	145	5.070	7000
			9.425	1 1/2	.076	.000	.014	DS20-D4763LX38-05	1.500	10.625	13.431	9.541	.050	81°	145	6.393	5000
2.000	06C	06P	8.050	1 1/2	.042	.000	.014	DS20-D5080LX38-04	1.500	9.520	12.326	8.166	.050	81°	145	6.172	7000
			10.050	1 1/2	.042	.000	.014	DS20-D5080LX38-05	1.500	11.520	14.326	10.166	.050	81°	145	7.716	4000
2.125	07C	07P	8.563	1 1/2	.154	.000	.014	DS20-D5398LX38-04	1.500	10.009	12.828	8.678	.063	81°	145	6.530	7000
			10.688	1 1/2	.154	.000	.014	DS20-D5398LX38-05	1.500	12.134	14.953	10.803	.063	81°	145	8.377	4000
2.250	07C	07P	9.063	1 1/2	.118	.000	.014	DS20-D5715LX38-04	1.500	10.499	13.318	9.178	.063	81°	145	7.414	6000
			11.313	1 1/2	.118	.000	.014	DS20-D5715LX38-05	1.500	12.749	15.568	11.428	.063	81°	145	9.259	4000
2.375	07C	07P	9.563	1 1/2	.082	.000	.014	DS20-D6033LX38-04	1.500	10.989	13.808	9.678	.063	81°	145	8.377	6000
			11.938	1 1/2	.082	.000	.014	DS20-D6033LX38-05	1.500	13.364	16.183	12.053	.063	81°	145	10.582	4000
2.500	07C	07P	10.063	1 1/2	.045	.000	.014	DS20-D6350LX38-04	1.500	11.480	14.299	10.178	.063	81°	145	9.389	6000
			12.563	1 1/2	.045	.000	.014	DS20-D6350LX38-05	1.500	13.980	16.799	12.678	.063	81°	145	11.905	3000

CoroDrill® DS20 indexable insert drill

Modular drilling interface (MDI)
Internal coolant supply

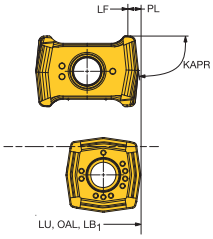


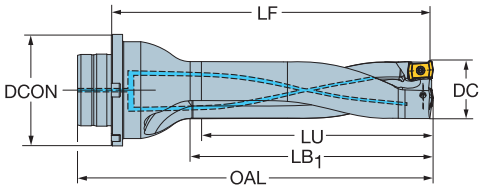


Metric									Dimensions: mm								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
15.00	01C	01P	60.46	MDI-20	1.00	0.00	0.27	DS20-D1500DM20-04	20.00	88.54	104.00	63.00	0.46	81°	10	0.174	24000
			105.46	MDI-20	1.00	-0.10	0.50	DS20-D1500DM20-07	20.00	133.54	149.00	108.00	0.46	81°	10	0.204	8000
16.00	01C	01P	64.46	MDI-20	0.75	0.00	0.27	DS20-D1600DM20-04	20.00	92.54	108.00	67.00	0.46	81°	10	0.183	22000
			112.46	MDI-20	0.75	-0.10	0.50	DS20-D1600DM20-07	20.00	140.54	156.00	115.00	0.46	81°	10	0.219	7000
17.00	01C	01P	68.46	MDI-20	0.50	0.00	0.27	DS20-D1700DM20-04	20.00	96.54	112.00	71.00	0.46	81°	10	0.193	21000
			119.46	MDI-20	0.50	-0.10	0.50	DS20-D1700DM20-07	20.00	147.54	163.00	122.00	0.46	81°	10	0.236	7000
18.00	01C	01P	72.46	MDI-25	0.25	0.00	0.27	DS20-D1800DM25-04	25.00	104.54	120.00	75.00	0.46	81°	10	0.300	20000
			126.46	MDI-25	0.25	-0.10	0.50	DS20-D1800DM25-07	25.00	158.54	174.00	129.00	0.46	81°	10	0.353	6000
19.00	02C	02P	76.56	MDI-25	1.06	0.00	0.33	DS20-D1900DM25-04	25.00	108.44	124.00	79.00	0.55	81°	10	0.313	19000
			133.56	MDI-25	1.06	-0.10	0.50	DS20-D1900DM25-07	25.00	165.44	181.00	136.00	0.55	81°	10	0.374	6000
20.00	02C	02P	80.56	MDI-25	0.82	0.00	0.33	DS20-D2000DM25-04	25.00	112.44	128.00	83.00	0.55	81°	10	0.327	18000
			140.56	MDI-25	0.82	-0.10	0.50	DS20-D2000DM25-07	25.00	172.44	188.00	143.00	0.55	81°	10	0.398	6000
21.00	02C	02P	84.56	MDI-25	0.58	0.00	0.33	DS20-D2100DM25-04	25.00	116.44	132.00	87.00	0.55	81°	10	0.342	17000
			147.56	MDI-25	0.58	-0.10	0.50	DS20-D2100DM25-07	25.00	179.44	195.00	150.00	0.55	81°	10	0.425	5000
22.00	02C	02P	88.56	MDI-25	0.34	0.00	0.33	DS20-D2200DM25-04	25.00	120.44	136.00	91.00	0.55	81°	10	0.359	16000
			154.56	MDI-25	0.34	-0.10	0.50	DS20-D2200DM25-07	25.00	186.44	202.00	157.00	0.55	81°	10	0.454	5000
23.00	03C	03P	92.67	MDI-25	1.30	0.00	0.33	DS20-D2300DM25-04	25.00	125.34	141.00	96.00	0.66	81°	10	0.379	15000
			161.67	MDI-25	1.30	-0.10	0.50	DS20-D2300DM25-07	25.00	194.34	210.00	165.00	0.66	81°	10	0.488	5000
24.00	03C	03P	96.67	MDI-25	1.10	0.00	0.33	DS20-D2400DM25-04	25.00	129.34	145.00	100.00	0.66	81°	10	0.400	15000
			168.67	MDI-25	1.10	-0.10	0.50	DS20-D2400DM25-07	25.00	201.34	217.00	172.00	0.66	81°	10	0.523	5000
25.00	03C	03P	100.67	MDI-25	0.90	0.00	0.33	DS20-D2500DM25-04	25.00	133.34	149.00	104.00	0.66	81°	10	0.422	14000
			175.67	MDI-25	0.90	-0.10	0.50	DS20-D2500DM25-07	25.00	208.34	224.00	179.00	0.66	81°	10	0.561	4000
26.00	03C	03P	104.67	MDI-32	0.70	0.00	0.33	DS20-D2600DM32-04	32.00	142.34	158.00	108.00	0.66	81°	10	0.651	14000
			182.67	MDI-32	0.70	-0.10	0.50	DS20-D2600DM32-07	32.00	220.34	236.00	186.00	0.66	81°	10	0.808	4000
27.00	03C	03P	108.67	MDI-32	0.50	0.00	0.33	DS20-D2700DM32-04	32.00	146.34	162.00	112.00	0.66	81°	10	0.677	13000
			189.67	MDI-32	0.50	-0.10	0.50	DS20-D2700DM32-07	32.00	227.34	243.00	193.00	0.66	81°	10	0.853	4000
28.00	04C	04P	112.83	MDI-32	2.12	0.00	0.33	DS20-D2800DM32-04	32.00	150.17	166.00	116.00	0.83	81°	10	0.705	13000
			196.83	MDI-32	2.12	-0.10	0.50	DS20-D2800DM32-07	32.00	234.17	250.00	200.00	0.83	81°	10	0.901	4000
29.00	04C	04P	116.83	MDI-32	1.84	0.00	0.33	DS20-D2900DM32-04	32.00	154.17	170.00	120.00	0.83	81°	10	0.734	12000
			203.83	MDI-32	1.84	-0.10	0.50	DS20-D2900DM32-07	32.00	241.17	257.00	207.00	0.83	81°	10	0.952	4000
30.00	04C	04P	120.83	MDI-32	1.56	0.00	0.33	DS20-D3000DM32-04	32.00	158.17	174.00	124.00	0.83	81°	10	0.766	12000
			210.83	MDI-32	1.56	-0.10	0.50	DS20-D3000DM32-07	32.00	248.17	264.00	214.00	0.83	81°	10	1.008	400
31.00	04C	04P	124.83	MDI-32	1.28	0.00	0.35	DS20-D3100DM32-04	32.00	164.17	180.00	128.00	0.83	81°	10	0.818	12000
			217.83	MDI-32	1.28	-0.10	0.50	DS20-D3100DM32-07	32.00	256.17	272.00	221.00	0.83	81°	10	1.075	4000
32.00	04C	04P	128.83	MDI-40	1.00	0.00	0.35	DS20-D3200DM40-04	40.00	175.17	191.00	132.00	0.83	81°	10	1.260	11000
			224.83	MDI-40	1.00	-0.10	0.50	DS20-D3200DM40-07	40.00	271.17	287.00	228.00	0.83	81°	10	1.553	3000
33.00	04C	04P	132.83	MDI-40	0.72	0.00	0.35	DS20-D3300DM40-04	40.00	179.17	195.00	136.00	0.83	81°	10	1.299	11000
			231.83	MDI-40	0.72	-0.10	0.50	DS20-D3300DM40-07	40.00	278.17	294.00	235.00	0.83	81°	10	1.620	300
34.00	05C	05P	137.00	MDI-40	2.16	0.00	0.35	DS20-D3400DM40-04	40.00	183.00	199.00	140.00	1.00	81°	10	1.340	11000
			239.00	MDI-40	2.16	-0.10	0.50	DS20-D3400DM40-07	40.00	285.00	301.00	242.00	1.00	81°	10	1.691	3000
35.00	05C	05P	141.00	MDI-40	1.92	0.00	0.35	DS20-D3500DM40-04	40.00	187.00	203.00	144.00	1.00	81°	10	1.383	10000
			246.00	MDI-40	1.92	-0.10	0.50	DS20-D3500DM40-07	40.00	292.00	308.00	249.00	1.00	81°	10	1.766	3000
36.00	05C	05P	145.00	MDI-40	1.68	0.00	0.35	DS20-D3600DM40-04	40.00	191.00	207.00	148.00	1.00	81°	10	1.429	10000
			253.00	MDI-40	1.68	-0.10	0.50	DS20-D3600DM40-07	40.00	299.00	315.00	256.00	1.00	81°	10	1.846	3000

CoroDrill® DS20 indexable insert drill

Modular drilling interface (MDI)
Internal coolant supply

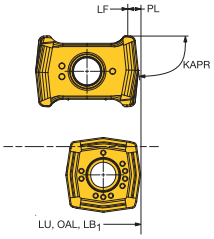


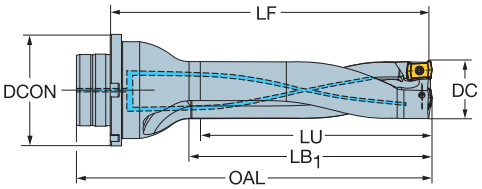


Metric									Dimensions: mm								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
37.00	05C	05P	149.00	MDI-40	1.44	0.00	0.35	DS20-D3700DM40-04	40.00	195.00	211.00	152.00	1.00	81°	10	1.477	10000
			260.00	MDI-40	1.44	-0.10	0.50	DS20-D3700DM40-07	40.00	306.00	322.00	263.00	1.00	81°	10	1.930	3000
38.00	05C	05P	153.00	MDI-40	1.20	0.00	0.35	DS20-D3800DM40-04	40.00	199.00	215.00	156.00	1.00	81°	10	1.529	9000
			267.00	MDI-40	1.20	-0.10	0.50	DS20-D3800DM40-07	40.00	313.00	329.00	270.00	1.00	81°	10	2.019	3000
39.00	05C	05P	157.00	MDI-40	0.96	0.00	0.35	DS20-D3900DM40-04	40.00	203.00	219.00	160.00	1.00	81°	10	1.582	9000
			274.00	MDI-40	0.96	-0.10	0.50	DS20-D3900DM40-07	40.00	320.00	336.00	277.00	1.00	81°	10	2.113	3000
40.00	05C	05P	161.00	MDI-40	0.72	0.00	0.35	DS20-D4000DM40-04	40.00	206.00	222.00	164.00	1.00	81°	10	1.624	9000
			281.00	MDI-40	0.72	-0.10	0.50	DS20-D4000DM40-07	40.00	326.00	342.00	284.00	1.00	81°	10	2.196	3000
41.00	06C	06P	165.28	MDI-40	3.73	0.00	0.35	DS20-D4100DM40-04	40.00	210.72	227.00	169.00	1.28	81	10	1.547	9000
			288.28	MDI-40	3.73	-0.10	0.50	DS20-D4100DM40-07	40.00	333.72	350.00	292.00	1.28	81	10	2.179	3000
42.00	06C	06P	169.28	MDI-40	3.46	0.00	0.35	DS20-D4200DM40-04	40.00	216.72	233.00	173.00	1.28	81	10	1.656	8000
			295.28	MDI-40	3.46	-0.10	0.50	DS20-D4200DM40-07	40.00	340.72	357.00	299.00	1.28	81	10	2.300	2000
43.00	06C	06P	173.28	MDI-40	3.19	0.00	0.35	DS20-D4300DM40-04	40.00	220.72	237.00	177.00	1.28	81	10	1.731	8000
			302.28	MDI-40	3.19	-0.10	0.50	DS20-D4300DM40-07	40.00	347.72	364.00	306.00	1.28	81	10	2.427	2000
44.00	06C	06P	177.28	MDI-50	2.92	0.00	0.35	DS20-D4400DM50-04	50.00	226.72	246.00	181.00	1.28	81	10	2.046	8000
			309.28	MDI-50	2.92	-0.10	0.50	DS20-D4400DM50-07	50.00	358.72	378.00	313.00	1.28	81	10	2.835	2000
45.00	06C	06P	181.28	MDI-50	2.65	0.00	0.35	DS20-D4500DM50-04	50.00	230.72	250.00	185.00	1.28	81	10	2.130	8000
			316.28	MDI-50	2.65	-0.10	0.50	DS20-D4500DM50-07	50.00	365.72	385.00	320.00	1.28	81	10	2.982	2000
46.00	06C	06P	185.28	MDI-50	2.38	0.00	0.35	DS20-D4600DM50-04	50.00	234.72	254.00	189.00	1.28	81	10	2.215	8000
47.00	06C	06P	189.28	MDI-50	2.11	0.00	0.35	DS20-D4700DM50-04	50.00	238.72	258.00	193.00	1.28	81	10	2.304	8000
48.00	06C	06P	193.28	MDI-50	1.84	0.00	0.35	DS20-D4800DM50-04	50.00	241.72	261.00	197.00	1.28	81	10	2.375	7000
49.00	06C	06P	197.28	MDI-50	1.57	0.00	0.35	DS20-D4900DM50-04	50.00	245.72	265.00	201.00	1.28	81	10	2.300	7000
50.00	06C	06P	201.28	MDI-50	1.30	0.00	0.35	DS20-D5000DM50-04	50.00	249.72	269.00	205.00	1.28	81	10	2.571	7000
51.00	06C	06P	205.28	MDI-50	1.03	0.00	0.35	DS20-D5100DM50-04	50.00	253.72	273.00	209.00	1.28	81	10	2.675	7000
52.00	06C	06P	209.28	MDI-50	0.76	0.00	0.35	DS20-D5200DM50-04	50.00	257.72	277.00	213.00	1.28	81	10	2.784	7000
53.00	07C	07P	213.59	MDI-50	4.21	0.00	0.35	DS20-D5300DM50-04	50.00	261.41	281.00	217.00	1.59	81	10	2.790	7000
54.00	07C	07P	217.59	MDI-50	3.92	0.00	0.35	DS20-D5400DM50-04	50.00	265.41	285.00	221.00	1.59	81	10	2.904	7000
55.00	07C	07P	221.59	MDI-50	3.63	0.00	0.35	DS20-D5500DM50-04	50.00	269.41	289.00	225.00	1.59	81	10	3.025	6000
56.00	07C	07P	225.59	MDI-50	3.34	0.00	0.35	DS20-D5600DM50-04	50.00	273.41	293.00	229.00	1.59	81	10	3.157	6000
57.00	07C	07P	229.59	MDI-50	3.05	0.00	0.35	DS20-D5700DM50-04	50.00	277.41	297.00	233.00	1.59	81	10	3.286	6000
58.00	07C	07P	233.59	MDI-50	2.76	0.00	0.35	DS20-D5800DM50-04	50.00	281.41	301.00	237.00	1.59	81	10	3.362	6000
59.00	07C	07P	237.59	MDI-50	2.47	0.00	0.35	DS20-D5900DM50-04	50.00	285.41	305.00	241.00	1.59	81	10	3.497	6000

CoroDrill® DS20 indexable insert drill

Modular drilling interface (MDI)
Internal coolant supply





Inch									Dimensions: inch								
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	PSI	LBS	RPMX
.625	01C	01P	2.518	MDI-20	.030	.000	.011	DS20-D1588DM20-04	.787	3.613	4.222	2.611	.018	81°	145	0.399	22000
			4.393	MDI-20	.030	-.004	.016	DS20-D1588DM20-07	.787	5.488	6.097	4.486	.018	81°	145	0.478	7000
.656	01C	01P	2.642	MDI-20	.023	.000	.011	DS20-D1666DM20-04	.787	3.735	4.344	2.735	.018	81°	145	0.414	21000
			4.610	MDI-20	.023	-.004	.016	DS20-D1666DM20-07	.787	5.703	6.312	4.703	.018	81°	145	0.507	7000
.687	01C	01P	2.766	MDI-25	.015	.000	.011	DS20-D1745DM25-04	.984	4.007	4.616	2.859	.018	81°	145	0.643	21000
			4.827	MDI-25	.015	-.004	.016	DS20-D1745DM25-07	.984	6.068	6.677	4.920	.018	81°	145	0.749	7000
.750	02C	02P	3.022	MDI-25	.041	.000	.013	DS20-D1905DM25-04	.984	4.258	4.871	3.119	.022	81°	145	0.685	19000
			5.272	MDI-25	.041	-.004	.016	DS20-D1905DM25-07	.984	6.508	7.121	5.369	.022	81°	145	0.822	6000
.812	02C	02P	3.270	MDI-25	.026	.000	.013	DS20-D2062DM25-04	.984	4.501	5.114	3.367	.022	81°	145	0.734	17000
			5.706	MDI-25	.026	-.004	.016	DS20-D2062DM25-07	.984	6.937	7.550	5.803	.022	81°	145	0.908	6000
.875	03C	03P	3.526	MDI-25	.057	.000	.013	DS20-D2223DM25-04	.984	4.751	5.368	3.626	.026	81°	145	0.793	16000
			6.151	MDI-25	.057	-.004	.016	DS20-D2223DM25-07	.984	7.376	7.993	6.251	.026	81°	145	1.009	5000
.937	03C	03P	3.774	MDI-25	.044	.000	.013	DS20-D2380DM25-04	.984	4.994	5.611	3.874	.026	81°	145	0.859	15000
			6.585	MDI-25	.044	-.004	.016	DS20-D2380DM25-07	.984	7.805	8.422	6.685	.026	81°	145	1.124	5000
1.000	03C	03P	4.026	MDI-25	.032	.000	.013	DS20-D2540DM25-04	.984	5.241	5.858	4.126	.026	81°	145	0.881	14000
			7.026	MDI-25	.032	-.004	.016	DS20-D2540DM25-07	.984	8.241	8.858	7.126	.026	81°	145	1.258	4000
1.062	03C	03P	4.274	MDI-32	.020	.000	.013	DS20-D2697DM32-04	1.260	5.721	6.338	4.374	.026	81°	145	1.485	13000
			7.460	MDI-32	.020	-.004	.016	DS20-D2697DM32-07	1.260	8.907	9.524	7.560	.026	81°	145	1.871	4000
1.125	04C	04P	4.533	MDI-32	.077	.000	.013	DS20-D2858DM32-04	1.260	5.977	6.601	4.642	.033	81°	145	1.448	13000
			7.908	MDI-32	.077	-.004	.020	DS20-D2858DM32-07	1.260	9.352	9.976	8.017	.033	81°	145	1.925	4000
1.187	04C	04P	4.781	MDI-32	.060	.000	.013	DS20-D3015DM32-04	1.260	6.220	6.844	4.890	.033	81°	145	1.665	12000
			8.342	MDI-32	.060	-.004	.020	DS20-D3015DM32-07	1.260	9.781	10.405	8.451	.033	81°	145	2.002	4000
1.25	04C	04P	5.033	MDI-32	.042	.000	.014	DS20-D3175DM32-04	1.260	6.546	7.170	5.142	.033	81°	145	1.671	11000
			8.783	MDI-32	.042	-.004	.020	DS20-D3175DM32-07	1.260	10.295	10.919	8.892	.033	81°	145	2.280	3000
1.312	05C	05P	5.287	MDI-40	.091	.000	.014	DS20-D3332DM40-04	1.575	7.074	7.704	5.402	.039	81°	145	2.872	11000
			9.223	MDI-40	.091	-.004	.016	DS20-D3332DM40-07	1.575	11.010	11.640	9.338	.039	81°	145	3.602	3000
1.375	05C	05P	5.539	MDI-40	.076	.000	.014	DS20-D3493DM40-04	1.575	7.321	7.951	5.654	.039	81°	145	3.020	10000
			9.664	MDI-40	.076	-.004	.016	DS20-D3493DM40-07	1.575	11.446	12.076	9.779	.039	81°	145	3.858	3000
1.437	05C	05P	5.787	MDI-40	.061	.000	.014	DS20-D3650DM40-04	1.575	7.565	8.195	5.902	.039	81°	145	3.176	10000
			10.098	MDI-40	.061	-.004	.016	DS20-D3650DM40-07	1.575	11.876	12.506	10.213	.039	81°	145	4.135	3000
1.500	05C	05P	6.039	MDI-40	.046	.000	.014	DS20-D3810DM40-04	1.575	7.812	8.442	6.154	.039	81°	145	3.351	9000
			10.539	MDI-40	.046	-.004	.016	DS20-D3810DM40-07	1.575	12.312	12.942	10.654	.039	81°	145	4.442	3000
1. 562	05C	05P	6.287	MDI-40	.031	.000	.014	DS20-D3967DM40-04	1.575	8.055	8.685	6.402	.039	81°	145	3.538	9000
			10.973	MDI-40	.031	-.004	.016	DS20-D3967DM40-07	1.575	12.741	13.371	11.088	.039	81°	145	4.768	3000
1.625	06C	06P	6.550	MDI-40	.144	.000	.014	DS20-D4128DM40-04	1.575	8.303	8.944	6.666	.050	81°	145	3.437	9000
			11.425	MDI-40	.144	-.004	.020	DS20-D4128DM40-07	1.575	13.178	13.819	11.541	.050	81°	145	4.861	3000
1.687	06C	06P	6.798	MDI-40	.127	.000	.014	DS20-D4285DM40-04	1.575	8.625	9.266	6.914	.050	81°	145	3.770	8000
			11.859	MDI-40	.127	-.004	.020	DS20-D4285DM40-07	1.575	13.683	4.324	11.975	.050	81°	145	5.366	2000
1.750	06C	06P	7.050	MDI-50	.110	.000	.014	DS20-D4445DM50-04	1.969	8.936	9.695	7.166	.050	81°	145	4.594	8000
			12.300	MDI-50	.110	-.004	.020	DS20-D4445DM50-07	1.969	14.186	14.945	12.416	.050	81°	145	6.336	2000
1.875	06C	06P	7.550	MDI-50	.076	.000	.014	DS20-D4763DM50-04	1.969	9.427	10.186	7.666	.050	81°	145	5.148	7000
2.000	06C	06P	8.050	MDI-50	.043	.000	.014	DS20-D5080DM50-04	1.969	9.917	10.676	8.166	.050	81°	145	5.728	7000
2.125	07C	07P	8.563	MDI-50	.155	.000	.014	DS20-D5398DM50-04	1.969	10.406	11.178	8.678	.063	81°	145	6.365	7000
2.250	07C	07P	9.063	MDI-50	.118	.000	.014	DS20-D5715DM50-04	1.969	10.896	11.668	9.178	.063	81°	145	7.242	6000

An insert for every application

With three support contact surfaces in each insert seat, there are less insert movements leading to longer tool life and better hole surface.

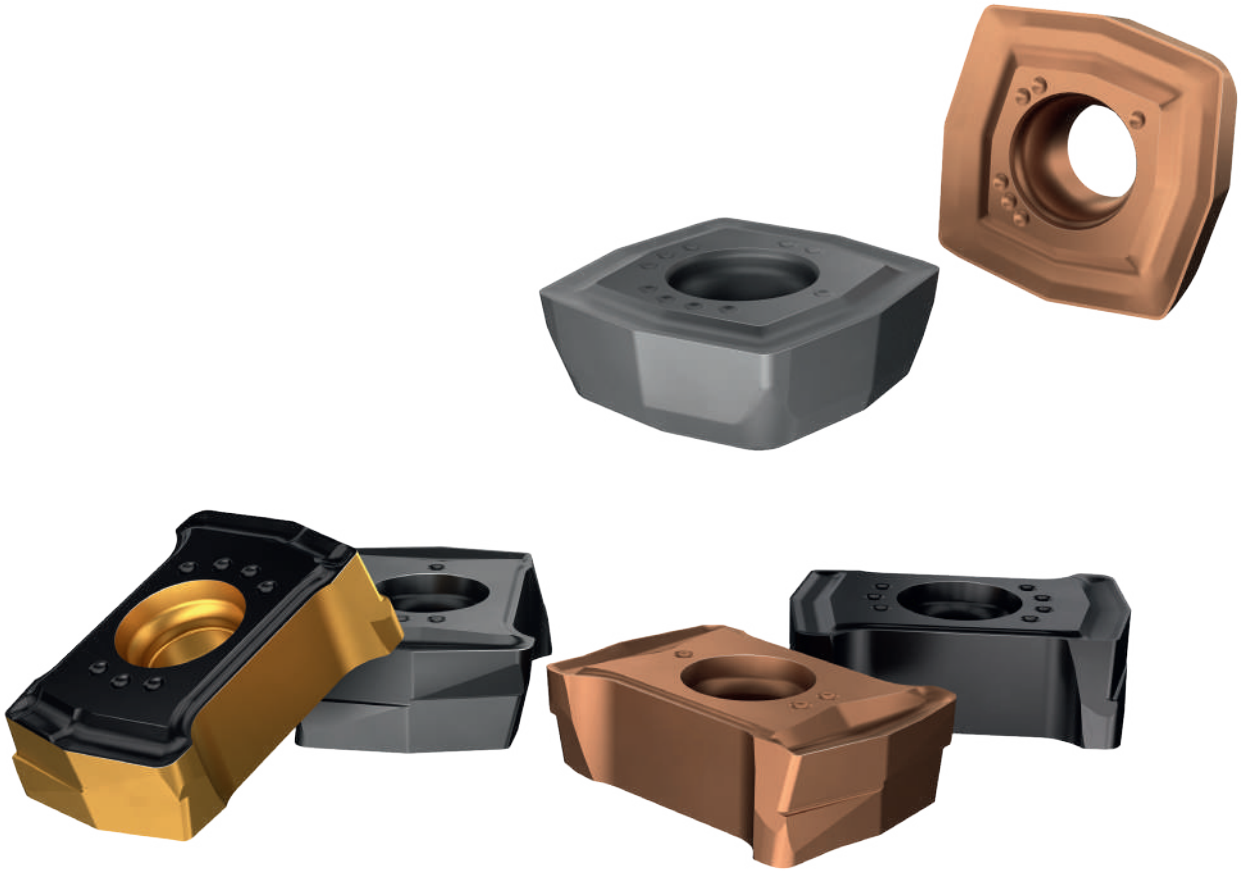
The inserts are strong and have a bulk strength that provides extra toughness resulting in unmatched insert tool life.

Closer hole tolerances can be achieved thanks to the ground dog-bone shaped peripheral insert. This double-sided positive insert, with a negative insert position, directs the cutting forces into the drill body resulting in higher stability and consistent performance.

Grades and geometries

Grades are available for all materials and applications. The PVD-coated grade GC1344, produced with Zertivo® coating process technology, offers excellent wear resistance and toughness for central inserts.

A large selection of geometries is available. With the versatile geometry -L6W it is possible to use the same tool in may operations and materials.



Peripheral insert: Geometries

-M7W
- First choice in short-chipping ISO P and ISO K materials
- Low to high feed
- Strong reinforced edge

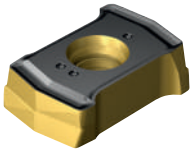
-H5W
- First choice for more challenging long-chipping ISO P and ISO M materials
- Low to medium feed
- Negative T-land
- High cutting forces

-L5W
- First choice in long-chipping ISO P and ISO M materials
- Low to medium feed
- Low cutting forces

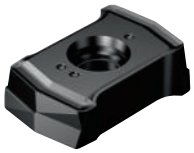
-L6W
- First choice in Inconel and hardened steel
- All-round geometry for mixed production
- Low to medium feed
- Low cutting forces

-S5W
- First choice in titanium and ISO N
- Low feed
- Sharp and extremely low cutting forces

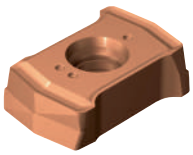
Peripheral insert: Grades



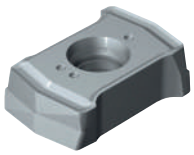
GC4334
- First-choice grade in ISO P and ISO K applications with good to average conditions
- Inveio® insert coating technology provides a high level of wear resistance



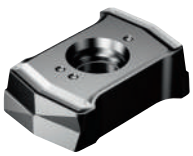
GC4324
- MT-CVD coated grade with Inveio® technology
- Productive choice in stable conditions



GC2044
- PVD-oxide coated grade for excellent wear resistance in all types of ISO M materials and titanium



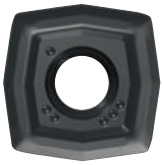
H13A
- Universal, tough and uncoated grade for low to moderate cutting speeds in ISO N materials
- Complementary grade for HRSA and titanium



GC4344
- PVD-coated grade with Zertivo® technology for tough and demanding operations
- Provides good edge-line properties and reliable tool life in average to difficult conditions

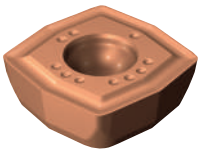
Central insert: Geometries and grades

-M7
- First choice in short-chipping materials such as ISO P and ISO K
- Low to high feed
- Strong reinforced edge



-L5
- First choice in long-chipping materials such as ISO P, M, S, N and H
- Low to medium feed
- Low cutting forces

GC1344
- First choice for ISO P, K, S and H materials
- PVD coated with Zertivo® technology
- Excellent wear resistance and toughness



GC1144
- First-choice PVD-coated grade for all types of ISO M and titanium materials

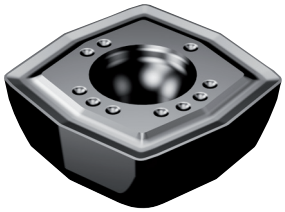
H13A
- Universal, tough and uncoated grade for low to moderate cutting speeds in ISO N materials
- Complementary grade for ISO S

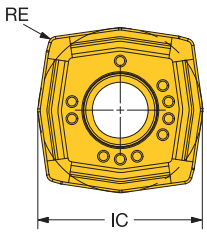
First choice

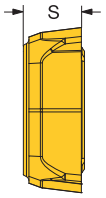
		First choice		Complementary choice	
		Central insert	Peripheral insert	Central insert	Peripheral insert
Low-carbon steel	P	P1.1–1.2: -L5 1344 P1.3–1.5: -M7 1344	P1.1: -H5W 4334 P1.2: -L5W 4334 P1.3–1.5: -M7W 4334	-L5 1344	-L5W 4324 -L5W 4334 -L5W 4344 -H5W 4344 -M7W 4324 -M7W 4344
Low-alloy steel	P	-M7 1344	-M7W 4334	-M7 1344	-M7W 4324 -M7W 4344
Stainless steel	M	-L5 1144	-H5W 2044	-L5 1144	-L5W 2044 -L5W 4344 -H5W 4344
Cast iron	K	-M7 1344	-M7W 4334	-M7 1344	-M7W 4324 -M7W 4344
Non-ferrous material	N	-L5 H13A	-S5W H13A	-L5 1344	-L5W 4344
HRSA	S	-L5 1344	-L6W 4344 (Inconel) -S5W 4344 (Titan)	-L5 H13A	-L5W H13A -S5W H13A
Hardenend steels	H	-L5 1344	-L6W 4344	-M7 1344	-M7W 4344

CoroDrill® DS20 insert for drilling

Central insert



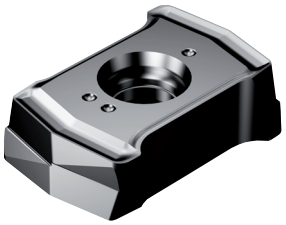




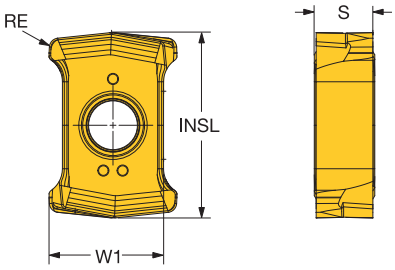
			P	M	K	N		S		H	Dimensions: mm		
	INSUC	Ordering code	1344	1144	1344	H13A	1344	1344	H13A	1344	S	RE	IC
01C	C	DS20-0104-C-L5	★	★		★	☆	★	☆	★	2.30	0.35	6.0
01C	C	DS20-0104-C-M7	★		★					☆	2.30	0.35	6.0
02C	C	DS20-0205-C-L5	★	★		★	☆	★	☆	★	2.60	0.35	7.3
02C	C	DS20-0205-C-M7	★		★					☆	2.60	0.35	7.3
03C	C	DS20-0306-C-L5	★	★		★	☆	★	☆	★	3.00	0.35	8.9
03C	C	DS20-0306-C-M7	★		★					☆	3.00	0.35	8.9
04C	C	DS20-0407-C-L5	★	★		★	☆	★	☆	★	3.20	0.35	11.1
04C	C	DS20-0407-C-M7	★		★					☆	3.20	0.35	11.1
05C	C	DS20-0508-C-L5	★	★		★	☆	★	☆	★	3.50	0.35	13.4
05C	C	DS20-0508-C-M7	★		★					☆	3.50	0.35	13.4
06C	C	DS20-0608-C-L5	★	★		★	☆	★	☆	★	3.90	0.35	17.5
06C	C	DS20-0608-C-M7	★		★					☆	3.90	0.35	17.5
07C	C	DS20-0708-C-L5	★	★		★	☆	★	☆	★	4.50	0.35	21.8
07C	C	DS20-0708-C-M7	★		★					☆	4.50	0.35	21.8

CoroDrill® DS20 insert for drilling

Peripheral insert



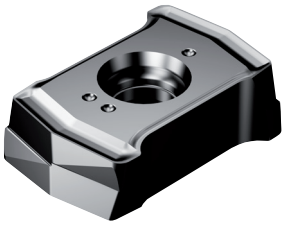
DS20..P-L5W



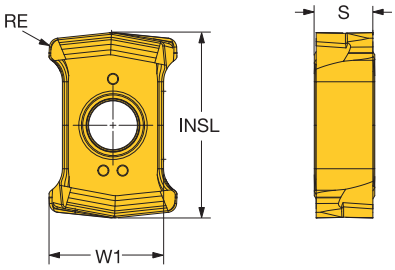
			P			M			K			N		S			H		Dimensions: mm			
	INSUC	Ordering code	4324	4334	4344	2044	4334	4344	4324	4334	4344	4344	H13A	2044	4344	H13A	4334	4344	S	RE	W1	INSL
01P	P	DS20-0104-P-H5W		★	☆	★	☆	☆											2.73	0.40	5.0	8.5
01P	P	DS20-0104-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				2.73	0.40	5.0	8.5
01P	P	DS20-0104-P-L6W			★			★			★	★			★			★	2.73	0.40	5.0	8.5
01P	P	DS20-0104-P-M7W	☆	★	☆				☆	★	☆						☆	★	2.73	0.40	5.0	8.5
01P	P	DS20-0104-P-S5W						★				☆	★		★	☆			2.73	0.40	5.0	8.5
02P	P	DS20-0205-P-H5W		★	☆	★	☆	☆											3.10	0.50	6.1	9.8
02P	P	DS20-0205-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				3.10	0.50	6.1	9.8
02P	P	DS20-0205-P-L6W			★			★			★	★			★			★	3.10	0.50	6.1	9.8
02P	P	DS20-0205-P-M7W	☆	★	☆				☆	★	☆						☆	★	3.10	0.50	6.1	9.8
02P	P	DS20-0205-P-S5W						★				☆	★		★	☆			3.10	0.50	6.1	9.8
03P	P	DS20-0306-P-H5W		★	☆	★	☆	☆											3.53	0.60	7.3	11.3
03P	P	DS20-0306-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				3.53	0.60	7.3	11.3
03P	P	DS20-0306-P-L6W			★			★			★	★			★			★	3.53	0.60	7.3	11.3

CoroDrill® DS20 insert for drilling

Peripheral insert



DS20..P-L5W



			P			M			K			N		S			H		Dimensions: mm			
	INSUC	Ordering code	4324	4334	4344	2044	4334	4344	4324	4334	4344	4344	H13A	2044	4344	H13A	4334	4344	S	RE	W1	INSL
03P	P	DS20-0306-P-M7W	☆	★	☆				☆	★	☆						☆	★	3.53	0.60	7.3	11.3
03P	P	DS20-0306-P-S5W						★				☆	★		★	☆			3.53	0.60	7.3	11.3
04P	P	DS20-0407-P-H5W			☆		☆	☆											4.25	0.70	9.2	12.8
04P	P	DS20-0407-P-L5W	☆	★	☆	★	☆	☆				☆		☆	☆				4.25	0.70	9.2	12.8
04P	P	DS20-0407-P-L6W			☆			☆			☆	☆			★			★	4.25	0.70	9.2	12.8
04P	P	DS20-0407-P-M7W	☆	★	☆				☆	★	☆						☆	☆	4.25	0.70	9.2	12.8
04P	P	DS20-0407-P-S5W						☆				☆	★		★	☆			4.25	0.70	9.2	12.8
05P	P	DS20-0508-P-H5W		★	☆	★	☆	☆											4.75	0.80	11.2	15.2
05P	P	DS20-0508-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				4.75	0.80	11.2	15.2
05P	P	DS20-0508-P-L6W			★			★			★	★			★			★	4.75	0.80	11.2	15.2
05P	P	DS20-0508-P-M7W	☆	★	☆				☆	★	☆						☆	★	4.75	0.80	11.2	15.2
05P	P	DS20-0508-P-S5W						★				☆	★		★	☆			4.75	0.80	11.2	15.2
06P	P	DS20-0608-P-HSW		★	☆	★	☆	☆											6.20	0.80	14.4	19.4
06P	P	DS20-0608-P-L5W	☆	★	☆	★	☆	☆				★			★	☆			6.20	0.80	14.4	19.4
06P	P	DS20-0608-P-L6W			★			★			★	★			★			★	6.20	0.80	14.4	19.4
06P	P	DS20-0608-P-M7W	☆	★	☆				☆	★	☆						☆	★	6.20	0.80	14.4	19.4
06P	P	DS20-0608-P-S5W						★				☆	★		☆	★			6.20	0.80	14.4	19.4
07P	P	DS20-0708-P-HSW		★	☆	★	☆	☆											7.00	0.80	18.0	21.9
07P	P	DS20-0708-P-L5W	☆	★	☆	★	☆	☆				★			★	☆			7.00	0.80	18.0	21.9
07P	P	DS20-0708-P-L6W			★			★			★	★			★			★	7.00	0.80	18.0	21.9
07P	P	DS20-0708-P-M7W	☆	★	☆				☆	★	☆						☆	★	7.00	0.80	18.0	21.9
07P	P	DS20-0708-P-S5W						★				☆	★		★	☆			7.00	0.80	18.0	21.9

MDI (Modular Drilling Interface)

The patented MDI coupling is a stable and high precision modular drilling interface that provides excellent centring capabilities.

One size can be used for several drill diameters leading to less tool inventory and lower costs. In addition, MDI offers quick and easy set-up.

Four locating pins allow for high torque transmission and provide an exact cutting edge position. The position of the locating pins makes it possible to rotate the drill 180° which can be beneficial in poor machine conditions, for example in misaligned or unstable lathes.

With two different diameters on shank and adaptor, double centring with high fitting accuracy is possible. In combination with flange and surface contact between drill body and nut, increased stability, good run-out precision and optimal repeatability can be achieved.

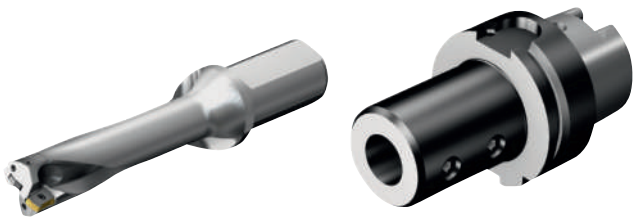
Coromant Capto®

HSK-T

Advantage new MDI interface

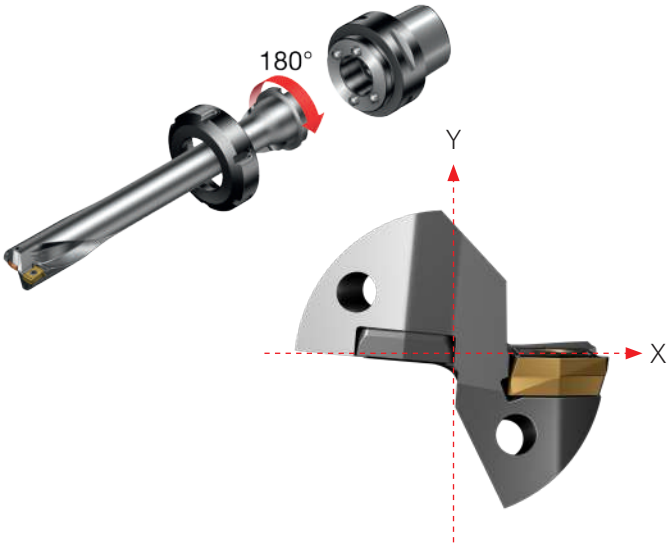
With MDI

Without MDI



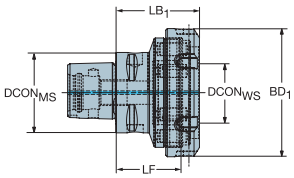
20% shorter modular length when using the MDI interface

Flexible in non-rotating applications

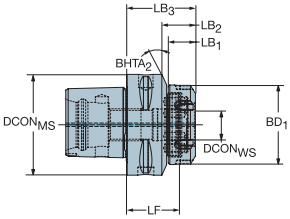


Note: Peripheral insert set parallel to the x-axis of the machine and facing x plus in non-rotating use.

Coromant Capto® with modular drilling interface (MDI)



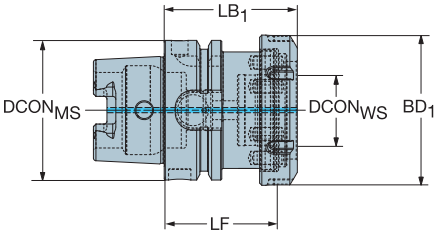
Design 1



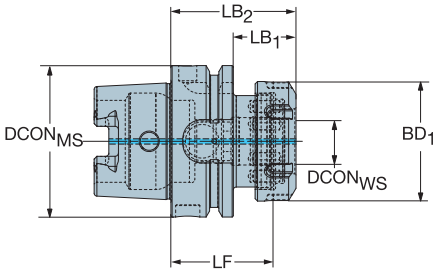
Design 2

	Metric					Dimensions: mm								
Design	CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	BD_1	BAR PSI	NM	KG	RPMX
1	C3	MDI-20	3	1	C3-DM20-N-032	32.0	20.0	32.0	42.0	49.7	80	135.0	0.31	28000
1	C4	MDI-20	3	1	C4-DM20-N-028	40.0	20.0	28.0	38.0	49.7	80	135.0	0.40	39000
1		MDI-25	3	1	C4-DM25-N-035	40.0	25.0	35.0	45.0	62.7	80	170.0	0.58	39000
1		MDI-32	3	1	C4-DM32-N-042	40.0	32.0	42.0	52.0	67.7	80	200.0	0.71	39000
2	C5	MDI-20	3	1	C5-DM20-N-028	50.0	25.0	28.0	17.0	49.7	80	135.0	0.57	28000
1		MDI-25	3	1	C5-DM25-N-030	50.0	25.0	30.0	40.0	62.7	80	170.0	0.67	55000
1		MDI-32	3	1	C5-DM32-N-035	50.0	32.0	35.0	45.0	67.7	80	200.0	0.77	28000
1		MDI-40	3	1	C5-DM40-N-040	50.0	40.0	40.0	52.0	79.7	80	230.0	1.00	55000
2	C6	MDI-20	3	1	C6-DM20-N-033	63.0	20.0	33.0	17.0	49.7	80	135.0	0.96	20000
2		MDI-25	3	1	C6-DM25-N-030	63.0	25.0	30.0	17.0	62.7	80	170.0	1.00	20000
1		MDI-32	3	1	C6-DM32-N-030	63.0	32.0	30.0	40.0	67.7	80	200.0	0.99	20000
1		MDI-40	3	1	C6-DM40-N-040	63.0	40.0	40.0	52.0	79.7	80	230.0	1.34	20000
1		MDI-50	3	1	C6-DM50-N-043	63.0	50.0	43.0	57.0	94.7	80	250.0	1.70	20000
2	C8	MDI-25	3	1	C8-DM25-N-042	80.0	25.0	42.0	17.0	62.7	80	170.0	2.08	14000
2		MDI-32	3	1	C8-DM32-N-040	80.0	32.0	40.0	17.0	67.7	80	200.0	2.01	14000
2		MDI-40	3	1	C8-DM40-N-040	80.0	40.0	40.0	21.0	79.7	80	230.0	2.09	14000
1		MDI-50	3	1	C8-DM50-N-040	80.0	50.0	40.0	54.0	94.7	80	250.0	2.28	14000

HSK-T with modular drilling interface (MDI)



Design 1



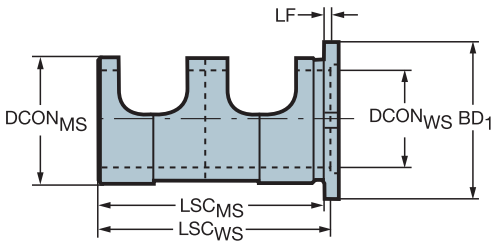
Design 2

	Metric					Dimensions: mm										
Design	CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR PSI	NM	KG	RPMX
2	63.0	MDI-20	1	1	HT06-DM20-N-042	63.0	20.0	42.0	26.0	52.0	49.7	63.0	80	135.0	0.86	20000
2		MDI-25	1	1	HT06-DM25-N-050	63.0	25.0	50.0	34.0	60.0	62.7	63.0	80	170.0	1.10	20000
1		MDI-32	1	1	HT06-DM32-N-050	63.0	32.0	50.0	60.0		67.7		80	200.0	1.18	20000
1		MDI-40	1	1	HT06-DM40-N-061	63.0	40.0	61.0	73.0		79.7		80	230.0	1.51	20500
2	100.0	MDI-25	1	1	HT10-DM25-N-048	100.0	25.0	48.0	29.0	58.0	62.7	100.0	80	170.0	2.37	12500
2		MDI-32	1	1	HT10-DM32-N-048	100.0	32.0	48.0	29.0	58.0	67.7	100.0	80	200.0	2.40	12500
2		MDI-40	1	1	HT10-DM40-N-048	100.0	40.0	48.0	31.0	60.0	79.7	100.0	80	230.0	2.60	12500
2		MDI-50	1	1	HT10-DM50-N-055	99.9	50.0	55.0	40.0	69.0	94.7	100.0	80	250.0	3.15	12500

Complete spare parts list see www.sandvik.coromant.com

Accessories

Eccentric sleeve



Metric					Dimensions: mm				
CZC$_{MS}$	CZC$_{WS}$	ADJLN	ADJLX	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LSC$_{MS}$	LF	BD$_1$
25	20	-0.05	0.15	416.2-L20-25	25.00	20.00	55.00	2.50	33.00
32	25	-0.05	0.15	416.2-L25-32	32.00	25.00	60.00	3.50	40.00
40	32	-0.05	0.15	416.2-L32-40	40.00	32.00	70.00	2.50	50.00
50	40	-0.05	0.15	416.2-L40-50	50.00	40.00	80.00	2.50	60.00

An eccentric sleeve or drilling adaptor can be used to get close hole tolerances (IT10) or to change the tool dimension.
You can find the max. radial adjustment (ADJLX) in the catalog or webshop Note: Not recommended for 6–7 ×DC

Torque wrench

Ordering code	
ER-TK-01M	10–50 Nm (7.38–36.9 lbf-ft)
ER-TK-02M	60–300 Nm (44–221 lbf-ft)

Recommendations		
ER-TK-02M	Torque wrench	60-300, Nm (44–221 lbf-ft)
5680 103-05	MDI 20 (ER 32)	135 (100)
5680 103-06	MDI 25 (ER 40)	170 (125)
5680 103-07	MDI 32	200 (148)
5680 103-08	MDI 40	230 (170)
5680 103-09	MDI 50	250 (184)

Spare parts

Drill dimension, mm (inch)	Insert size	Screw size	Screw	Keygrip TORX PLUS®	Torque, Nm (lbf-ft)	Bits TORX PLUS®	Torque screwdriver for bits (adjustable torque)	Torque screwdriver (preset torque)	Fixed screwdriver
15.00–18.00 (0.591–0.708)	01	M2.0	5513 020-27	6IP	0.6 (0.44)	5680 084-17	5680 105-01	5680 100-01	5680 046-08
18.01–22.00 (0.709–0.866)	02	M2.2	5513 020-88	7IP	0.9 (0.66)	5680 084-18	5680 105-01	5680 100-02	5680 046-03
22.01–27.00 (0.867–1.06)	03	M2.5	5513 020-58	7IP	0.9 (0.66)	5680 084-18	5680 105-01	5680 100-02	5680 046-03
27.01–33.00 (1.06–1.30)	04	M3.0	5513 020-57	9IP	1.4 (1.03)	5680 084-20	5680 105-02	5680 100-04	5680 046-04
33.01–40.00 (1.30–1.57)	05	M3.5	416.1-833	10IP	2.0 (1.48)	5680 084-21	5680 105-02	5680 100-05	5680 046-05
40.01–52.00 (1.58–2.05)	06	M4.0	416.1-834	15IP	3.0 (2.21)	5680 084-15	5680 105-02	5680 100-06	5680 046-02
52.01–65.00 (2.05–2.56)	07								

Note: Bits TORXPLUS® to be used with adjustable torque.

CoroDrill® DS20

Cutting data recommendation, metric
4-5xD

					Cutting speed recommendations				Drill length 4xD					Drill length 5xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (mm)	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev
P	P1.0. Z.AN	Unalloyed steel	110	4324	230	340	400	15.00-18.00	0.04-0.08	0.04-0.08	0.04-0.08	-	**0.04-0.1**	0.04-0.07	0.04-0.07	0.04-0.07	-	**0.04-0.09**
		C=0.05-0.10%		4334	210	285	325	18.01-22.00	0.04-0.09	0.04-0.09	0.04-0.09	-	**0.04-0.11**	0.04-0.08	0.04-0.08	0.04-0.08	-	**0.04-0.1**
				4344	190	225	225	22.01-27.00	0.04-0.1	0.04-0.1	0.04-0.1	-	**0.04-0.12**	0.04-0.09	0.04-0.09	0.04-0.09	-	**0.04-0.11**
								27.01-33.00	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.13**	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.12**
								33.01-40.00	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.16**	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.14**
								40.01-52.00	0.06-0.12	0.06-0.12	0.06-0.12	-	**0.06-0.16**	0.06-0.11	0.06-0.11	0.06-0.11	-	**0.06-0.14**
								52.01-65.00	0.06-0.12	0.06-0.12	0.06-0.12	-	**0.06-0.16**	0.06-0.11	0.06-0.11	0.06-0.11	-	**0.06-0.14**
	P1.1.Z.AN	Unalloyed steel	125	4324	230	320	370	15.00-18.00	0.04-0.1	0.04-0.1	0.04-0.1	-	**0.04-0.1**	0.04-0.09	0.04-0.09	0.04-0.09	-	**0.04-0.09**
		C=0.05-0.25%		4334	200	270	305	18.01-22.00	0.04-0.11	0.04-0.11	0.04-0.11	-	**0.04-0.11**	0.04-0.1	0.04-0.1	0.04-0.1	-	**0.04-0.1**
				4344	170	210	235	22.01-27.00	0.04-0.12	0.04-0.12	0.04-0.12	-	**0.04-0.12**	0.04-0.11	0.04-0.11	0.04-0.11	-	**0.04-0.11**
				-	-	-	-	27.01-33.00	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.13**	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.12**
								33.01-40.00	0.05-0.14	0.05-0.14	0.05-0.14	-	**0.05-0.16**	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.14**
								40.01-52.00	0.06-0.14	0.06-0.14	0.06-0.14	-	**0.06-0.16**	0.06-0.13	0.06-0.13	0.06-0.13	-	**0.06-0.14**
								52.01-65.00	0.06-0.14	0.06-0.14	0.06-0.14	-	**0.06-0.16**	0.06-0.13	0.06-0.13	0.06-0.13	-	**0.06-0.14**
	P1.2.Z.AN	Unalloyed steel	190	4324	190	265	305	15.00-18.00	-	**0.05-0.12**	0.06-0.14	0.06-0.16	-	-	**0.05-0.1**	0.06-0.12	0.06-0.14	-
		C=0.25-0.55%		4334	155	215	250	18.01-22.00	-	**0.05-0.14**	0.06-0.16	0.06-0.18	-	-	**0.05-0.12**	0.06-0.14	0.06-0.15	-
				4344	120	165	190	22.01-27.00	-	**0.05-0.18**	0.06-0.2	0.06-0.22	-	-	**0.05-0.15**	0.06-0.17	0.06-0.19	-
								27.01-33.00	-	**0.07-0.22**	0.08-0.24	0.08-0.26	-	-	**0.07-0.19**	0.08-0.2	0.08-0.22	-
								33.01-40.00	-	**0.07-0.24**	0.08-0.26	0.08-0.28	-	-	**0.07-0.2**	0.08-0.22	0.08-0.24	-
								40.01-52.00	-	**0.09-0.24**	0.1-0.26	0.1-0.28	-	-	**0.09-0.2**	0.1-0.22	0.1-0.24	-
								52.01-65.00	-	**0.09-0.24**	0.1-0.26	0.1-0.28	-	-	**0.09-0.2**	0.1-0.22	0.1-0.24	-
	P1.3.Z.AN	Unalloyed steel	190	4324	170	250	290	15.00-18.00	-	0.05-0.12	0.06-0.14	**0.06-0.16**	-	-	0.05-0.1	0.06-0.12	**0.06-0.14**	-
		C=0.55-0.80%		4334	140	205	240	18.01-22.00	-	0.05-0.14	0.06-0.16	**0.06-0.18**	-	-	0.05-0.12	0.06-0.14	**0.06-0.15**	-
				4344	105	155	185	22.01-27.00	-	0.05-0.18	0.06-0.2	**0.06-0.22**	-	-	0.05-0.15	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	0.07-0.22	0.08-0.24	**0.08-0.26**	-	-	0.07-0.19	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	0.07-0.24	0.08-0.26	**0.08-0.28**	-	-	0.07-0.2	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
	P1.5.C.UT	Unalloyed steel	150	4324	140	260	325	15.00-18.00	-	0.04-0.12	0.04-0.12	**0.04-0.12**	-	-	0.04-0.1	0.04-0.1	**0.04-0.1**	-
		Cast - untreated		4334	135	220	265	18.01-22.00	-	0.04-0.13	0.04-0.13	**0.04-0.13**	-	-	0.04-0.11	0.04-0.11	**0.04-0.11**	-
				4344	125	175	200	22.01-27.00	-	0.04-0.14	0.04-0.14	**0.04-0.14**	-	-	0.04-0.12	0.04-0.12	**0.04-0.12**	-
								27.01-33.00	-	0.05-0.15	0.05-0.15	**0.05-0.15**	-	-	0.05-0.13	0.05-0.13	**0.05-0.13**	-
								33.01-40.00	-	0.05-0.16	0.05-0.16	**0.05-0.16**	-	-	0.05-0.14	0.05-0.14	**0.05-0.14**	-
								40.01-52.00	-	0.06-0.16	0.06-0.16	**0.06-0.16**	-	-	0.06-0.14	0.06-0.14	**0.06-0.14**	-
								52.01-65.00	-	0.06-0.16	0.06-0.16	**0.06-0.16**	-	-	0.06-0.14	0.06-0.14	**0.06-0.14**	-
	P2.1.Z.AN	Low alloy steel	175	4324	180	260	305	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
		Annealed		4334	150	215	250	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	115	165	190	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.2.Z.AN	Low alloy steel	240	4324	180	250	290	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
		Annealed		4334	150	200	225	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	115	175	205	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.5.Z.HT	Low alloy steel	330	4324	90	190	245	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
		Hardened and		4334	85	155	195	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
		tempered		4344	75	125	150	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.6.C.UT	Low alloy steel	200	4324	110	210	265	15.00-18.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
		Cast - untreated		4334	105	175	210	18.01-22.00	-	-	0.06-0.18	**0.06-0.2**	-	-	-	0.06-0.15	**0.06-0.17**	-
				4344	100	140	160	22.01-27.00	-	-	0.06-0.22	**0.06-0.24**	-	-	-	0.06-0.19	**0.06-0.2**	-
								27.01-33.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								33.01-40.00	-	-	0.08-0.28	**0.08-0.3**	-	-	-	0.08-0.24	**0.08-0.26**	-
								40.01-52.00	-	-	0.1-0.28	**0.1-0.3**	-	-	-	0.1-0.24	**0.1-0.26**	-
								52.01-65.00	-	-	0.1-0.28	**0.1-0.3**	-	-	-	0.1-0.24	**0.1-0.26**	-
	P3.0.Z.AN	High alloy steel	200	4324	160	245	290	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
		Annealed		4334	130	200	240	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	100	150	180	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-

CoroDrill® DS20

Cutting data recommendation, metric
4-5xD

					Cutting speed recommendations				Drill length 4xD					Drill length 5xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (mm)	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev
P	P3.0.Z.HT	High alloy steel	380	4324	80	165	210	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
		Hardened and		4334	75	140	175	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
		tempered		4344	70	110	130	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P5.0.Z.AN	Ferritic/martensitic	200	4334	115	185	225	15.00-18.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
		stainless steel		4344	115	155	175	18.01-22.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Annealed		2044	115	150	165	22.01-27.00	0.05-0.15	**0.05-0.15**	0.05-0.15	-	0.05-0.14	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.18	**0.07-0.18**	0.07-0.18	-	0.07-0.16	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14
								40.01-52.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
								52.01-65.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
	P5.0.Z.HT	Ferritic/martensitic	330	4334	75	135	170	15.00-18.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
		stainless steel		4344	70	115	140	18.01-22.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Hardened and		2044	70	115	140	22.01-27.00	0.05-0.15	**0.05-0.15**	0.05-0.15	-	0.05-0.14	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
		tempered						27.01-33.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.18	**0.07-0.18**	0.07-0.18	-	0.07-0.16	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14
								40.01-52.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
								52.01-65.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
M	M1.0.Z.AQ	Austenitic	200	4334	115	185	225	15.00-18.00	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**
		Stainless steel		4344	115	165	190	18.01-22.00	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**
		Annealed/quenched		2044	115	155	180	22.01-27.00	0.05-0.14	0.05-0.14	0.05-0.14	-	**0.05-0.13**	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**
								27.01-33.00	0.07-0.15	0.07-0.15	0.07-0.15	-	**0.07-0.14**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.13**
								33.01-40.00	0.07-0.16	0.07-0.16	0.07-0.16	-	**0.07-0.15**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.14**
								40.01-52.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
								52.01-65.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
	M1.1.Z.AQ	Austenitic	200	4334	115	195	240	15.00-18.00	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**
		Stainless steel		4344	115	175	210	18.01-22.00	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**
		Machinability		2044	115	170	200	22.01-27.00	0.05-0.14	0.05-0.14	0.05-0.14	-	**0.05-0.13**	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**
		improved						27.01-33.00	0.07-0.15	0.07-0.15	0.07-0.15	-	**0.07-0.14**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.13**
								33.01-40.00	0.07-0.16	0.07-0.16	0.07-0.16	-	**0.07-0.15**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.14**
								40.01-52.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
								52.01-65.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
	M2.0.Z.AQ	Super Austenitic	200	4334	80	125	150	15.00-18.00	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**
		(Ni>20%) Stainless		4344	80	110	125	18.01-22.00	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**
		steel		2044	80	110	125	22.01-27.00	0.05-0.14	0.05-0.14	0.05-0.14	-	**0.05-0.13**	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**
		Annealed/quenched						27.01-33.00	0.07-0.15	0.07-0.15	0.07-0.15	-	**0.07-0.14**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.13**
								33.01-40.00	0.07-0.16	0.07-0.16	0.07-0.16	-	**0.07-0.15**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.14**
								40.01-52.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
								52.01-65.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
	M3.1.Z.AQ	Duplex	230	4334	85	125	145	15.00-18.00	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**
		stainless steel		4344	85	115	130	18.01-22.00	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**
		>60% ferrite (N<0.10%)		2044	85	110	125	22.01-27.00	0.05-0.14	0.05-0.14	0.05-0.14	-	**0.05-0.13**	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**
								27.01-33.00	0.07-0.15	0.07-0.15	0.07-0.15	-	**0.07-0.14**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.13**
								33.01-40.00	0.07-0.16	0.07-0.16	0.07-0.16	-	**0.07-0.15**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.14**
								40.01-52.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
								52.01-65.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
	M3.2.Z.AQ	Duplex	260	4334	75	105	120	15.00-18.00	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**
		stainless steel		4344	75	100	115	18.01-22.00	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**	0.05-0.12	0.05-0.12	0.05-0.12	-	**0.05-0.11**
		<60% ferrite (N>0.10%)		2044	75	100	115	22.01-27.00	0.05-0.14	0.05-0.14	0.05-0.14	-	**0.05-0.13**	0.05-0.13	0.05-0.13	0.05-0.13	-	**0.05-0.12**
								27.01-33.00	0.07-0.15	0.07-0.15	0.07-0.15	-	**0.07-0.14**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.13**
								33.01-40.00	0.07-0.16	0.07-0.16	0.07-0.16	-	**0.07-0.15**	0.07-0.14	0.07-0.14	0.07-0.14	-	**0.07-0.14**
								40.01-52.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
								52.01-65.00	0.09-0.16	0.09-0.16	0.09-0.16	-	**0.09-0.15**	0.09-0.14	0.09-0.14	0.09-0.14	-	**0.09-0.14**
S	S2.0.Z.AN	Heat resistant	350	4334	20	40	50	15.00-18.00	0.04-0.08	0.04-0.08	**0.04-0.08**	-	-	0.04-0.07	0.04-0.07	**0.04-0.07**	-	-
	S2.0.Z.AG	super alloys		4344	20	40	50	18.01-22.00	0.04-0.09	0.04-0.09	**0.04-0.09**	-	-	0.04-0.08	0.04-0.08	**0.04-0.08**	-	-
	S2.0.Z.NS	Ni based		2044	20	40	50	22.01-27.00	0.04-0.1	0.04-0.1	**0.04-0.1**	-	-	0.04-0.09	0.04-0.09	**0.04-0.09**	-	-
								27.01-33.00	0.05-0.11	0.05-0.11	**0.05-0.11**	-	-	0.05-0.1	0.05-0.1	**0.05-0.1**	-	-
								33.01-40.00	0.05-0.12	0.05-0.12	**0.05-0.12**	-	-	0.05-0.11	0.05-0.11	**0.05-0.11**	-	-
								40.01-52.00	0.06-0.12	0.06-0.12	**0.06-0.12**	-	-	0.06-0.11	0.06-0.11	**0.06-0.11**	-	-
								52.01-65.00	0.06-0.12	0.06-0.12	**0.06-0.12**	-	-	0.06-0.11	0.06-0.11	**0.06-0.11**	-	-
	S4.2.Z.AN	Heat resistant	330	H13A	40	90	120	15.00-18.00	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-
	S4.3.Z.AG	super alloys		4344	40	90	120	18.01-22.00	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-
		Ti based		2044	40	90	120	22.01-27.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
								27.01-33.00	**0.08-0.17**	0.08-0.17	0.08-0.17	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								33.01-40.00	**0.08-0.18**	0.08-0.18	0.08-0.18	-	-	**0.08-0.15**	0.08-0.15	0.08-0.15	-	-
								40.01-52.00	**0.1-0.18**	0.1-0.18	0.1-0.18	-	-	**0.1-0.15**	0.1-0.15	0.1-0.15	-	-
								52.01-65.00	**0.1-0.18**	0.1-0.18	0.1-0.18	-	-	**0.1-0.15**	0.1-0.15	0.1-0.15	-	-

CoroDrill® DS20

Cutting data recommendation, metric
4-5xD

					Cutting speed recommendations				Drill length 4xD					Drill length 5xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (mm)	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev
K	K1.1.C.NS	Malleable cast iron	200	4324	140	210	245	15.00-18.00	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-	-	0.08-0.13	0.08-0.13	**0.08-0.17**	-
		Low tensile strength		4334	110	170	200	18.01-22.00	-	0.08-0.18	0.08-0.18	**0.08-0.23**	-	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-
				4344	180	165	155	22.01-27.00	-	0.08-0.21	0.08-0.21	**0.08-0.26**	-	-	0.08-0.18	0.08-0.18	**0.08-0.22**	-
								27.01-33.00	-	0.1-0.24	0.1-0.24	**0.1-0.29**	-	-	0.1-0.2	0.1-0.2	**0.1-0.25**	-
								33.01-40.00	-	0.1-0.27	0.1-0.27	**0.1-0.32**	-	-	0.1-0.23	0.1-0.23	**0.1-0.27**	-
								40.01-52.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
								52.01-65.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
	K2.1.C.UT	Grey cast iron	180	4324	210	285	325	15.00-18.00	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-	-	0.08-0.13	0.08-0.13	**0.08-0.17**	-
		Low tensile strength		4334	170	235	270	18.01-22.00	-	0.08-0.18	0.08-0.18	**0.08-0.23**	-	-	0.08-0.15	0.08-0.15	**0.08-0.2**	-
				4344	130	180	205	22.01-27.00	-	0.08-0.21	0.08-0.21	**0.08-0.26**	-	-	0.08-0.18	0.08-0.18	**0.08-0.22**	-
								27.01-33.00	-	0.1-0.24	0.1-0.24	**0.1-0.29**	-	-	0.1-0.2	0.1-0.2	**0.1-0.25**	-
								33.01-40.00	-	0.1-0.27	0.1-0.27	**0.1-0.32**	-	-	0.1-0.23	0.1-0.23	**0.1-0.27**	-
								40.01-52.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
								52.01-65.00	-	0.12-0.27	0.12-0.27	**0.12-0.32**	-	-	0.12-0.23	0.12-0.23	**0.12-0.27**	-
	K2.2.C.UT	Grey cast iron	245	4324	125	205	245	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
		High tensile strength		4334	100	160	195	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
				4344	75	125	150	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
	K3.1.C.UT	Nodular cast iron	155	4324	125	190	225	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
		Ferritic		4334	100	155	185	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
				4344	80	120	145	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
	K3.3.C.UT	Nodular cast iron	265	4324	110	175	210	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
		Pearlitic		4334	90	145	175	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
				4344	70	110	130	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
	K4.2.C.UT	Compacted graphite	230	4324	130	210	250	15.00-18.00	-	0.08-0.13	0.08-0.13	**0.08-0.18**	-	-	0.08-0.11	0.08-0.11	**0.08-0.15**	-
		iron		4334	110	170	200	18.01-22.00	-	0.08-0.16	0.08-0.16	**0.08-0.21**	-	-	0.08-0.14	0.08-0.14	**0.08-0.18**	-
		High tensile strength		4344	85	125	150	22.01-27.00	-	0.08-0.19	0.08-0.19	**0.08-0.24**	-	-	0.08-0.16	0.08-0.16	**0.08-0.2**	-
		(Pearlite>90%)						27.01-33.00	-	0.1-0.22	0.1-0.22	**0.1-0.27**	-	-	0.1-0.19	0.1-0.19	**0.1-0.23**	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	**0.1-0.3**	-	-	0.1-0.21	0.1-0.21	**0.1-0.26**	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
								52.01-65.00	-	0.12-0.25	0.12-0.25	**0.12-0.3**	-	-	0.12-0.21	0.12-0.21	**0.12-0.26**	-
H	H1.3.Z.HA	Extra hard steels	60	4324	30	65	85	15.00-18.00	-	0.06-0.13	**0.06-0.13**	0.06-0.13	-	-	0.06-0.11	**0.06-0.11**	0.06-0.11	-
		Hardened & tempered		4334	30	65	85	18.01-22.00	-	0.06-0.14	**0.06-0.14**	0.06-0.14	-	-	0.06-0.12	**0.06-0.12**	0.06-0.12	-
				4344	30	65	85	22.01-27.00	-	0.06-0.15	**0.06-0.15**	0.06-0.15	-	-	0.06-0.13	**0.06-0.13**	0.06-0.13	-
								27.01-33.00	-	0.08-0.16	**0.08-0.16**	0.08-0.16	-	-	0.08-0.14	**0.08-0.14**	0.08-0.14	-
								33.01-40.00	-	0.08-0.18	**0.08-0.18**	0.08-0.18	-	-	0.08-0.15	**0.08-0.15**	0.08-0.15	-
								40.01-52.00	-	0.1-0.18	**0.1-0.18**	0.1-0.18	-	-	0.1-0.15	**0.1-0.15**	0.1-0.15	-
								52.01-65.00	-	0.1-0.18	**0.1-0.18**	0.1-0.18	-	-	0.1-0.15	**0.1-0.15**	0.1-0.15	-
N	N1.2.Z.AG	Aluminum based alloys	100	H13A	300	365	400	15.00-18.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		AlSi alloys (Si<1%)		4344	300	365	400	18.01-22.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
								22.01-27.00	**0.06-0.2**	0.06-0.2	0.06-0.2	-	-	**0.06-0.17**	0.06-0.17	0.06-0.17	-	-
								27.01-33.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								33.01-40.00	**0.08-0.25**	0.08-0.25	0.08-0.25	-	-	**0.08-0.21**	0.08-0.21	0.08-0.21	-	-
								40.01-52.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
								52.01-65.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
	N1.3.C.UT	Aluminum based alloys	75	H13A	250	350	400	15.00-18.00	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-
		AlSi cast alloys		4344	250	350	400	18.01-22.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		(1%< Si >13%)						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	Aluminum based alloys	90	H13A	250	315	350	15.00-18.00	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-
		AlSi cast and aged		4344	250	315	350	18.01-22.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		alloys						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	-	-
		(1%< Si >13%)						27.01-33.00	**0.08-0.2**	0.08-0.2	0.08-0.2	-	-	**0.08-0.17**	0.08-0.17	0.08-0.17	-	-
								33.01-40.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								40.01-52.00	**0.1-0.22**	0.1-0.22	0.1-0.22	-	-	**0.1-0.19**	0.1-0.19	0.1-0.19	-	-
								52.01-65.00	**0.1-0.22**	0.1-0.22	0.1-0.22	-	-	**0.1-0.19**	0.1-0.19	0.1-0.19	-	-
	N3.3.U.UT	Copper based alloys	110	H13A	250	350	400	15.00-18.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		Free cutting copper		4344	250	350	400	18.01-22.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
		based alloys						22.01-27.00	**0.06-0.2**	0.06-0.2	0.06-0.2	-	-	**0.06-0.17**	0.06-0.17	0.06-0.17	-	-
								27.01-33.00	**0.08-0.22**	0.08-0.22	0.08-0.22	-	-	**0.08-0.19**	0.08-0.19	0.08-0.19	-	-
								33.01-40.00	**0.08-0.25**	0.08-0.25	0.08-0.25	-	-	**0.08-0.21**	0.08-0.21	0.08-0.21	-	-
								40.01-52.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
								52.01-65.00	**0.1-0.25**	0.1-0.25	0.1-0.25	-	-	**0.1-0.21**	0.1-0.21	0.1-0.21	-	-
	N3.2.C.UT	Copper based alloys	90	H13A	180	220	240	15.00-18.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
		Leaded brass and		4344	180	220	240	18.01-22.00	**0.06-0.18**	0.06-0.18	0.06-0.18	-	-	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-
		bronzes (Pb<1%)						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

Cutting data recommendation, metric
6-7xD

					Cutting speed recommendations				Drill length 6xD					Drill length 7xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (mm)	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev
P	P1.0.Z.AN	Unalloyed steel	110	4324	230	305	360	15.00-18.00	0.04-0.06	0.04-0.06	0.04-0.06	-	**0.04-0.08**	0.04-0.05	0.04-0.05	0.04-0.05	-	**0.04-0.07**
		C=0.05-0.10%		4334	210	255	295	18.01-22.00	0.04-0.07	0.04-0.07	0.04-0.07	-	**0.04-0.09**	0.04-0.06	0.04-0.06	0.04-0.06	-	**0.04-0.07**
				4344	190	205	220	22.01-27.00	0.04-0.08	0.04-0.08	0.04-0.08	-	**0.04-0.1**	0.04-0.07	0.04-0.07	0.04-0.07	-	**0.04-0.08**
								27.01-33.00	0.05-0.09	0.05-0.09	0.05-0.09	-	**0.05-0.1**	0.05-0.07	0.05-0.07	0.05-0.07	-	**0.05-0.08**
								33.01-40.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.13**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.1**
								40.01-52.00	0.06-0.1	0.06-0.1	0.06-0.1	-	**0.06-0.13**	0.06-0.08	0.06-0.08	0.06-0.08	-	**0.06-0.1**
								52.01-65.00	0.06-0.1	0.06-0.1	0.06-0.1	-	**0.06-0.13**	0.06-0.08	0.06-0.08	0.06-0.08	-	**0.06-0.1**
	P1.1.Z.AN	Unalloyed steel	125	4324	230	290	335	15.00-18.00	0.04-0.08	0.04-0.08	0.04-0.08	-	**0.04-0.08**	0.04-0.07	0.04-0.07	0.04-0.07	-	**0.04-0.07**
		C=0.05-0.25%		4334	200	245	275	18.01-22.00	0.04-0.09	0.04-0.09	0.04-0.09	-	**0.04-0.09**	0.04-0.07	0.04-0.07	0.04-0.07	-	**0.04-0.07**
				4344	170	190	210	22.01-27.00	0.04-0.1	0.04-0.1	0.04-0.1	-	**0.04-0.1**	0.04-0.08	0.04-0.08	0.04-0.08	-	**0.04-0.08**
								27.01-33.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.1**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.08**
								33.01-40.00	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.13**	0.05-0.09	0.05-0.09	0.05-0.09	-	**0.05-0.1**
								40.01-52.00	0.06-0.11	0.06-0.11	0.06-0.11	-	**0.06-0.13**	0.06-0.09	0.06-0.09	0.06-0.09	-	**0.06-0.1**
								52.01-65.00	0.06-0.11	0.06-0.11	0.06-0.11	-	**0.06-0.13**	0.06-0.09	0.06-0.09	0.06-0.09	-	**0.06-0.1**
	P1.2.Z.AN	Unalloyed steel	190	4324	190	240	275	15.00-18.00	-	**0.05-0.08**	0.06-0.09	0.06-0.1	-	-	**0.05-0.07**	0.06-0.08	0.06-0.09	-
		C=0.25-0.55%		4334	155	195	225	18.01-22.00	-	**0.05-0.09**	0.06-0.1	0.06-0.12	-	-	**0.05-0.08**	0.06-0.09	0.06-0.1	-
				4344	120	150	170	22.01-27.00	-	**0.05-0.12**	0.06-0.13	0.06-0.14	-	-	**0.05-0.1**	0.06-0.11	0.06-0.12	-
								27.01-33.00	-	**0.07-0.14**	0.08-0.16	0.08-0.17	-	-	**0.07-0.12**	0.08-0.13	0.08-0.14	-
								33.01-40.00	-	**0.07-0.16**	0.08-0.17	0.08-0.18	-	-	**0.07-0.13**	0.08-0.14	0.08-0.15	-
								40.01-52.00	-	**0.09-0.16**	0.1-0.17	0.1-0.18	-	-	**0.09-0.13**	0.1-0.14	0.1-0.15	-
								52.01-65.00	-	**0.09-0.16**	0.1-0.17	0.1-0.18	-	-	**0.09-0.13**	0.1-0.14	0.1-0.15	-
	P1.3.Z.AN	Unalloyed steel	190	4324	170	225	260	15.00-18.00	-	0.05-0.08	0.06-0.09	**0.06-0.1**	-	-	0.05-0.07	0.06-0.08	**0.06-0.09**	-
		C=0.55-0.80%		4334	140	185	215	18.01-22.00	-	0.05-0.09	0.06-0.1	**0.06-0.12**	-	-	0.05-0.08	0.06-0.09	**0.06-0.1**	-
				4344	105	140	165	22.01-27.00	-	0.05-0.12	0.06-0.13	**0.06-0.14**	-	-	0.05-0.1	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	0.07-0.14	0.08-0.16	**0.08-0.17**	-	-	0.07-0.12	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	0.07-0.16	0.08-0.17	**0.08-0.18**	-	-	0.07-0.13	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	0.09-0.16	0.1-0.17	**0.1-0.18**	-	-	0.09-0.13	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	0.09-0.16	0.1-0.17	**0.1-0.18**	-	-	0.09-0.13	0.1-0.14	**0.1-0.15**	-
	P1.5.C.UT	Unalloyed steel	150	4324	140	235	295	15.00-18.00	-	0.04-0.08	0.04-0.08	**0.04-0.08**	-	-	0.04-0.07	0.04-0.07	**0.04-0.07**	-
		Cast - untreated		4334	135	200	240	18.01-22.00	-	0.04-0.08	0.04-0.08	**0.04-0.08**	-	-	0.04-0.07	0.04-0.07	**0.04-0.07**	-
				4344	125	160	180	22.01-27.00	-	0.04-0.09	0.04-0.09	**0.04-0.09**	-	-	0.04-0.08	0.04-0.08	**0.04-0.08**	-
								27.01-33.00	-	0.05-0.1	0.05-0.1	**0.05-0.1**	-	-	0.05-0.08	0.05-0.08	**0.05-0.08**	-
								33.01-40.00	-	0.05-0.1	0.05-0.1	**0.05-0.1**	-	-	0.05-0.09	0.05-0.09	**0.05-0.09**	-
								40.01-52.00	-	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.09	0.06-0.09	**0.06-0.09**	-
								52.01-65.00	-	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.09	0.06-0.09	**0.06-0.09**	-
	P2.1.Z.AN	Low alloy steel	175	4324	180	235	275	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
		Annealed		4334	150	195	225	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	115	150	170	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P2.2.Z.AN	Low alloy steel	240	4324	180	225	260	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
		Annealed		4334	150	180	205	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	115	160	185	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P2.5.Z.HT	Low alloy steel	330	4324	90	170	220	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
		Hardened and		4334	85	140	175	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
		tempered		4344	75	115	135	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P2.6.C.UT	Low alloy steel	200	4324	110	190	240	15.00-18.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
		Cast - untreated		4334	105	160	190	18.01-22.00	-	-	0.06-0.12	**0.06-0.13**	-	-	-	0.06-0.1	**0.06-0.11**	-
				4344	100	125	145	22.01-27.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.13**	-
								27.01-33.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								33.01-40.00	-	-	0.08-0.18	**0.08-0.2**	-	-	-	0.08-0.15	**0.08-0.17**	-
								40.01-52.00	-	-	0.1-0.18	**0.1-0.2**	-	-	-	0.1-0.15	**0.1-0.17**	-
								52.01-65.00	-	-	0.1-0.18	**0.1-0.2**	-	-	-	0.1-0.15	**0.1-0.17**	-
	P3.0.Z.AN	High alloy steel	200	4324	160	220	260	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
		Annealed		4334	130	180	215	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
				4344	100	135	160	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-

CoroDrill® DS20

Cutting data recommendation, metric
6-7xD

					Cutting speed recommendations				Drill length 6xD					Drill length 7xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (mm)	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev
P	P3.0.Z.HT	High alloy steel	380	4324	80	150	190	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
		Hardened and		4334	75	125	160	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
		tempered		4344	70	100	115	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P5.0.Z.AN	Ferritic/martensitic	200	4334	115	165	205	15.00-18.00	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08	0.05-0.07	**0.05-0.07**	0.05-0.07	-	0.05-0.07
		stainless steel		4344	115	140	160	18.01-22.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		Annealed		2044	115	135	150	22.01-27.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
								27.01-33.00	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1	0.07-0.09	**0.07-0.09**	0.07-0.09	-	0.07-0.08
								33.01-40.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.1	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								40.01-52.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
								52.01-65.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
	P5.0.Z.HT	Ferritic/martensitic	330	4334	75	120	155	15.00-18.00	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08	0.05-0.07	**0.05-0.07**	0.05-0.07	-	0.05-0.07
		stainless steel		4344	70	105	125	18.01-22.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		Hardened and		2044	70	105	125	22.01-27.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
		tempered						27.01-33.00	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1	0.07-0.09	**0.07-0.09**	0.07-0.09	-	0.07-0.08
								33.01-40.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.1	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								40.01-52.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
								52.01-65.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
M	M1.0.Z.AQ	Austenitic Stainless	200	4334	115	165	205	15.00-18.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.09**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.07**
		steel		4344	115	150	170	18.01-22.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.1**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.08**
		Annealed/quenched		2044	115	140	160	22.01-27.00	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**	0.05-0.09	0.05-0.09	0.05-0.09	-	**0.05-0.08**
								27.01-33.00	0.07-0.12	0.07-0.12	0.07-0.12	-	**0.07-0.11**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.09**
								33.01-40.00	0.07-0.13	0.07-0.13	0.07-0.13	-	**0.07-0.12**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.1**
								40.01-52.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
								52.01-65.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
	M1.1.Z.AQ	Austenitic Stainless	200	4334	115	175	215	15.00-18.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.09**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.07**
		steel		4344	115	160	190	18.01-22.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.1**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.08**
		Machinability		2044	115	155	180	22.01-27.00	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**	0.05-0.09	0.05-0.09	0.05-0.09	-	**0.05-0.08**
		improved						27.01-33.00	0.07-0.12	0.07-0.12	0.07-0.12	-	**0.07-0.11**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.09**
								33.01-40.00	0.07-0.13	0.07-0.13	0.07-0.13	-	**0.07-0.12**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.1**
								40.01-52.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
								52.01-65.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
	M2.0.Z.AQ	Super Austenitic	200	4334	80	115	135	15.00-18.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.09**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.07**
		(Ni>20%) Stainless		4344	80	100	115	18.01-22.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.1**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.08**
		steel		2044	80	100	115	22.01-27.00	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**	0.05-0.09	0.05-0.09	0.05-0.09	-	**0.05-0.08**
		Annealed/quenched						27.01-33.00	0.07-0.12	0.07-0.12	0.07-0.12	-	**0.07-0.11**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.09**
								33.01-40.00	0.07-0.13	0.07-0.13	0.07-0.13	-	**0.07-0.12**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.1**
								40.01-52.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
								52.01-65.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
	M3.1.Z.AQ	Duplex stainless steel	230	4334	85	115	130	15.00-18.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.09**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.07**
		>60% ferrite (N<0.10%)		4344	85	105	115	18.01-22.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.1**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.08**
				2044	85	100	115	22.01-27.00	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**	0.05-0.09	0.05-0.09	0.05-0.09	-	**0.05-0.08**
								27.01-33.00	0.07-0.12	0.07-0.12	0.07-0.12	-	**0.07-0.11**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.09**
								33.01-40.00	0.07-0.13	0.07-0.13	0.07-0.13	-	**0.07-0.12**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.1**
								40.01-52.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
								52.01-65.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
	M3.2.Z.AQ	Duplex stainless steel	260	4334	75	95	110	15.00-18.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.09**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.07**
		<60% ferrite (N>0.10%)		4344	75	90	105	18.01-22.00	0.05-0.1	0.05-0.1	0.05-0.1	-	**0.05-0.1**	0.05-0.08	0.05-0.08	0.05-0.08	-	**0.05-0.08**
				2044	75	90	105	22.01-27.00	0.05-0.11	0.05-0.11	0.05-0.11	-	**0.05-0.1**	0.05-0.09	0.05-0.09	0.05-0.09	-	**0.05-0.08**
								27.01-33.00	0.07-0.12	0.07-0.12	0.07-0.12	-	**0.07-0.11**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.09**
								33.01-40.00	0.07-0.13	0.07-0.13	0.07-0.13	-	**0.07-0.12**	0.07-0.1	0.07-0.1	0.07-0.1	-	**0.07-0.1**
								40.01-52.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
								52.01-65.00	0.09-0.13	0.09-0.13	0.09-0.13	-	**0.09-0.12**	0.09-0.1	0.09-0.1	0.09-0.1	-	**0.09-0.1**
S	S2.0.Z.AN	Heat resistant super	350	4334	20	35	45	15.00-18.00	0.04-0.06	0.04-0.06	**0.04-0.06**	-	-	0.04-0.05	0.04-0.05	**0.04-0.05**	-	-
	S2.0.Z.AG	alloys		4344	20	35	45	18.01-22.00	0.04-0.07	0.04-0.07	**0.04-0.07**	-	-	0.04-0.06	0.04-0.06	**0.04-0.06**	-	-
	S2.0.Z.NS	Ni based		2044	20	35	45	22.01-27.00	0.04-0.08	0.04-0.08	**0.04-0.08**	-	-	0.04-0.07	0.04-0.07	**0.04-0.07**	-	-
								27.01-33.00	0.05-0.09	0.05-0.09	**0.05-0.09**	-	-	0.05-0.07	0.05-0.07	**0.05-0.07**	-	-
								33.01-40.00	0.05-0.1	0.05-0.1	**0.05-0.1**	-	-	0.05-0.08	0.05-0.08	**0.05-0.08**	-	-
								40.01-52.00	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.08	0.06-0.08	**0.06-0.08**	-	-
								52.01-65.00	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.08	0.06-0.08	**0.06-0.08**	-	-
	S4.2.Z.AN	Heat resistant super	330	H13A	40	80	110	15.00-18.00	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
	S4.3.Z.AG	alloys		4344	40	80	110	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
		Ti based		2044	40	80	110	22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-

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

CoroDrill® DS20

Cutting data recommendation, metric
6-7xD

					Cutting speed recommendations				Drill length 6xD					Drill length 7xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (mm)	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev	-S5W f_n mm/rev	-L5W f_n mm/rev	-L6W f_n mm/rev	-M7W f_n mm/rev	-H5W f_n mm/rev
K	K1.1.C.NS	Malleable cast iron	200	4324	140	190	220	15.00-18.00	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-	-	0.08-0.08	0.08-0.08	**0.08-0.11**	-
		Low tensile strength		4334	110	155	180	18.01-22.00	-	0.08-0.12	0.08-0.12	**0.08-0.15**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
				4344	180	150	140	22.01-27.00	-	0.08-0.14	0.08-0.14	**0.08-0.17**	-	-	0.08-0.12	0.08-0.12	**0.08-0.14**	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	**0.1-0.19**	-	-	0.1-0.13	0.1-0.13	**0.1-0.16**	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	**0.1-0.21**	-	-	0.1-0.15	0.1-0.15	**0.1-0.18**	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
								52.01-65.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
	K2.1.C.UT	Grey cast iron	180	4324	210	255	295	15.00-18.00	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-	-	0.08-0.08	0.08-0.08	**0.08-0.11**	-
		Low tensile strength		4334	170	210	245	18.01-22.00	-	0.08-0.12	0.08-0.12	**0.08-0.15**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
				4344	130	160	185	22.01-27.00	-	0.08-0.14	0.08-0.14	**0.08-0.17**	-	-	0.08-0.12	0.08-0.12	**0.08-0.14**	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	**0.1-0.19**	-	-	0.1-0.13	0.1-0.13	**0.1-0.16**	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	**0.1-0.21**	-	-	0.1-0.15	0.1-0.15	**0.1-0.18**	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
								52.01-65.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
	K2.2.C.UT	Grey cast iron	245	4324	125	185	220	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
		High tensile strength		4334	100	145	175	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	75	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	K3.1.C.UT	Nodular cast iron	155	4324	125	170	205	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
		Ferritic		4334	100	140	165	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	80	110	130	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	K3.3.C.UT	Nodular cast iron	265	4324	110	160	190	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
		Pearlitic		4334	90	130	160	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	70	100	115	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	K4.2.C.UT	Compacted graphite	230	4324	130	190	225	15.00-18.00	-	0.08-0.08	0.08-0.08	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
		iron		4334	110	155	180	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
		High tensile strength		4344	85	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
		(Pearlite>90%)						27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
H	H1.3.Z.HA	Extra hard steels	60	4324	30	60	75	15.00-18.00	-	0.06-0.08	**0.06-0.08**	0.06-0.08	-	-	0.06-0.07	**0.06-0.07**	0.06-0.07	-
		Hardened and		4334	30	60	75	18.01-22.00	-	0.06-0.09	**0.06-0.09**	0.06-0.09	-	-	0.06-0.08	**0.06-0.08**	0.06-0.08	-
		tempered		4344	30	60	75	22.01-27.00	-	0.06-0.1	**0.06-0.1**	0.06-0.1	-	-	0.06-0.08	**0.06-0.08**	0.06-0.08	-
								27.01-33.00	-	0.08-0.1	**0.08-0.1**	0.08-0.1	-	-	0.08-0.09	**0.08-0.09**	0.08-0.09	-
								33.01-40.00	-	0.08-0.12	**0.08-0.12**	0.08-0.12	-	-	0.08-0.1	**0.08-0.1**	0.08-0.1	-
								40.01-52.00	-	0.1-0.12	**0.1-0.12**	0.1-0.12	-	-	0.1-0.1	**0.1-0.1**	0.1-0.1	-
								52.01-65.00		0.1-0.12	**0.1-0.12**	0.1-0.12			0.1-0.1	**0.1-0.1**	0.1-0.1	
	N1.2.Z.AG	Aluminum based alloys	100	H13A	300	330	360	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		AlSi alloys (Si<1%)		4344	300	330	360	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
	N1.3.C.UT	Aluminum based alloys	75	H13A	250	315	360	15.00-18.00	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-	**0.06-0.08**	0.06-0.08	0.06-0.08	-	-
		AlSi cast alloys		4344	250	315	360	18.01-22.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		(1%< Si <13%)						22.01-27.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.13**	0.08-0.13	0.08-0.13	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
	N1.3.C.AG	Aluminum based alloys	90	H13A	250	285	315	15.00-18.00	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-	**0.06-0.08**	0.06-0.08	0.06-0.08	-	-
		AlSi cast and aged		4344	250	285	315	18.01-22.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		alloys						22.01-27.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
		(1%< Si >13%)						27.01-33.00	**0.08-0.13**	0.08-0.13	0.08-0.13	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
	N3.3.U.UT	Copper based alloys	110	H13A	250	315	360	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		Free cutting copper		4344	250	315	360	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
		based alloys						22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
	N3.2.C.UT	Copper based alloys	90	H13A	180	200	215	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		Leaded brass and		4344	180	200	215	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
		bronzes (Pb<1%)						22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-

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

CoroDrill® DS20

Cutting data recommendation, inch
4-5xD

					Cutting speed recommendations				Drill length 4xD					Drill length 5xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (inch)	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev
P	P1.0. Z.AN	Unalloyed steel	110	4324	755	1115	1310	0.591-0.709	.002-.003	.002-.003	.002-.003	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.004**
		C=0.05-0.10%		4334	690	935	1065	0.709-0.866	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.004**
				4344	625	740	805	0.866-1.063	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
								1.063-1.299	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.004	.002-.004	.002-.004	-	**.002-.005**
								1.299-1.575	.002-.005	.002-.005	.002-.005	-	**.002-.006**	.002-.004	.002-.004	.002-.004	-	**.002-.006**
								1.575-2.047	.002-.005	.002-.005	.002-.005	-	**.002-.006**	.002-.004	.002-.004	.002-.004	-	**.002-.006**
								2.047-2.559	.002-.005	.002-.005	.002-.005	-	**.002-.006**	.002-.004	.002-.004	.002-.004	-	**.002-.006**
	P1.1.Z.AN	Unalloyed steel	125	4324	755	1055	1215	0.591-0.709	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
		C=0.05-0.25%		4334	655	880	1000	0.709-0.866	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
				4344	560	695	770	0.866-1.063	.002-.005	.002-.005	.002-.005	-	**.002-.005**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
				-				1.063-1.299	.002-.005	.002-.005	.002-.005	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.005**
								1.299-1.575	.002-.006	.002-.006	.002-.006	-	**.002-.006**	.002-.005	.002-.005	.002-.005	-	**.002-.006**
								1.575-2.047	.002-.006	.002-.006	.002-.006	-	**.002-.006**	.002-.005	.002-.005	.002-.005	-	**.002-.006**
								2.047-2.559	.002-.006	.002-.006	.002-.006	-	**.002-.006**	.002-.005	.002-.005	.002-.005	-	**.002-.006**
	P1.2.Z.AN	Unalloyed steel	190	4324	625	870	1000	0.591-0.709	-	**.002-.005**	.002-.006	.002-.006	-	-	**.002-.004**	.002-.005	.002-.005	-
		C=0.25-0.55%		4334	510	710	820	0.709-0.866	-	**.002-.006**	.002-.006	.002-.007	-	-	**.002-.005**	.002-.005	.002-.006	-
				4344	395	545	625	0.866-1.063	-	**.002-.007**	.002-.008	.002-.009	-	-	**.002-.006**	.002-.007	.002-.007	-
								1.063-1.299	-	**.003-.009**	.003-.009	.003-.01	-	-	**.003-.007**	.003-.008	.003-.009	-
								1.299-1.575	-	**.003-.009**	.003-.01	.003-.011	-	-	**.003-.008**	.003-.009	.003-.009	-
								1.575-2.047	-	**.004-.009**	.004-.01	.004-.011	-	-	**.004-.008**	.004-.009	.004-.009	-
								2.047-2.559	-	**.004-.009**	.004-.01	.004-.011	-	-	**.004-.008**	.004-.009	.004-.009	-
	P1.3.Z.AN	Unalloyed steel	190	4324	560	815	950	0.591-0.709	-	.002-.005	.002-.006	**.002-.006**	-	-	.002-.004	.002-.005	**.002-.005**	-
		C=0.55-0.80%		4334	460	670	785	0.709-0.866	-	.002-.006	.002-.006	**.002-.007**	-	-	.002-.005	.002-.005	**.002-.006**	-
				4344	345	515	605	0.866-1.063	-	.002-.007	.002-.008	**.002-.009**	-	-	.002-.006	.002-.007	**.002-.007**	-
								1.063-1.299	-	.003-.009	.003-.009	**.003-.01**	-	-	.003-.007	.003-.008	**.003-.009**	-
								1.299-1.575	-	.003-.009	.003-.01	**.003-.011**	-	-	.003-.008	.003-.009	**.003-.009**	-
								1.575-2.047	-	.004-.009	.004-.01	**.004-.011**	-	-	.004-.008	.004-.009	**.004-.009**	-
								2.047-2.559	-	.004-.009	.004-.01	**.004-.011**	-	-	.004-.008	.004-.009	**.004-.009**	-
	P1.5.C.UT	Unalloyed steel	150	4324	460	855	1065	0.591-0.709	-	.002-.005	.002-.005	**.002-.005**	-	-	.002-.004	.002-.004	**.002-.004**	-
		Cast - untreated		4334	445	720	870	0.709-0.866	-	.002-.005	.002-.005	**.002-.005**	-	-	.002-.004	.002-.004	**.002-.004**	-
				4344	410	570	655	0.866-1.063	-	.002-.006	.002-.006	**.002-.006**	-	-	.002-.005	.002-.005	**.002-.005**	-
								1.063-1.299	-	.002-.006	.002-.006	**.002-.006**	-	-	.002-.005	.002-.005	**.002-.005**	-
								1.299-1.575	-	.002-.006	.002-.006	**.002-.006**	-	-	.002-.005	.002-.005	**.002-.005**	-
								1.575-2.047	-	.002-.006	.002-.006	**.002-.006**	-	-	.002-.005	.002-.005	**.002-.005**	-
								2.047-2.559	-	.002-.006	.002-.006	**.002-.006**	-	-	.002-.005	.002-.005	**.002-.005**	-
	P2.1.Z.AN	Low alloy steel	175	4324	590	855	1000	0.591-0.709	-	-	.002-.006	**.002-.006**	-	-	-	.002-.005	**.002-.005**	-
		Annealed		4334	490	705	820	0.709-0.866	-	-	.002-.006	**.002-.007**	-	-	-	.002-.005	**.002-.006**	-
				4344	375	540	625	0.866-1.063	-	-	.002-.008	**.002-.009**	-	-	-	.002-.007	**.002-.007**	-
								1.063-1.299	-	-	.003-.009	**.003-.01**	-	-	-	.003-.008	**.003-.009**	-
								1.299-1.575	-	-	.003-.01	**.003-.011**	-	-	-	.003-.009	**.003-.009**	-
								1.575-2.047	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
								2.047-2.559	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
	P2.2.Z.AN	Low alloy steel	240	4324	590	825	950	0.591-0.709	-	-	.002-.006	**.002-.006**	-	-	-	.002-.005	**.002-.005**	-
		Annealed		4334	490	655	740	0.709-0.866	-	-	.002-.006	**.002-.007**	-	-	-	.002-.005	**.002-.006**	-
				4344	375	565	670	0.866-1.063	-	-	.002-.008	**.002-.009**	-	-	-	.002-.007	**.002-.007**	-
								1.063-1.299	-	-	.003-.009	**.003-.01**	-	-	-	.003-.008	**.003-.009**	-
								1.299-1.575	-	-	.003-.01	**.003-.011**	-	-	-	.003-.009	**.003-.009**	-
								1.575-2.047	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
								2.047-2.559	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
	P2.5.Z.HT	Low alloy steel	330	4324	295	625	805	0.591-0.709	-	-	.002-.006	**.002-.006**	-	-	-	.002-.005	**.002-.005**	-
		Hardened and		4334	280	515	640	0.709-0.866	-	-	.002-.006	**.002-.007**	-	-	-	.002-.005	**.002-.006**	-
		tempered		4344	245	405	490	0.866-1.063	-	-	.002-.008	**.002-.009**	-	-	-	.002-.007	**.002-.007**	-
								1.063-1.299	-	-	.003-.009	**.003-.01**	-	-	-	.003-.008	**.003-.009**	-
								1.299-1.575	-	-	.003-.01	**.003-.011**	-	-	-	.003-.009	**.003-.009**	-
								1.575-2.047	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
								2.047-2.559	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
	P2.6.C.UT	Low alloy steel	200	4324	360	690	870	0.591-0.709	-	-	.002-.006	**.002-.007**	-	-	-	.002-.005	**.002-.006**	-
		Cast - untreated		4334	345	570	690	0.709-0.866	-	-	.002-.007	**.002-.008**	-	-	-	.002-.006	**.002-.007**	-
				4344	330	455	525	0.866-1.063	-	-	.002-.009	**.002-.009**	-	-	-	.002-.007	**.002-.008**	-
								1.063-1.299	-	-	.003-.01	**.003-.011**	-	-	-	.003-.009	**.003-.009**	-
								1.299-1.575	-	-	.003-.011	**.003-.012**	-	-	-	.003-.009	**.003-.01**	-
								1.575-2.047	-	-	.004-.011	**.004-.012**	-	-	-	.004-.009	**.004-.01**	-
								2.047-2.559	-	-	.004-.011	**.004-.012**	-	-	-	.004-.009	**.004-.01**	-
	P3.0.Z.AN	High alloy steel	200	4324	525	800	950	0.591-0.709	-	-	.002-.006	**.002-.006**	-	-	-	.002-.005	**.002-.005**	-
		Annealed		4334	425	660	785	0.709-0.866	-	-	.002-.006	**.002-.007**	-	-	-	.002-.005	**.002-.006**	-
				4344	330	500	590	0.866-1.063	-	-	.002-.008	**.002-.009**	-	-	-	.002-.007	**.002-.007**	-
								1.063-1.299	-	-	.003-.009	**.003-.01**	-	-	-	.003-.008	**.003-.009**	-
								1.299-1.575	-	-	.003-.01	**.003-.011**	-	-	-	.003-.009	**.003-.009**	-
								1.575-2.047	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
								2.047-2.559	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-

CoroDrill® DS20

Cutting data recommendation, inch
4-5xD

					Cutting speed recommendations				Drill length 4xD					Drill length 5xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (inch)	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev
P	P3.0.Z.HT	High alloy steel	380	4324	260	540	690	0.591-0.709	-	-	.002-.006	**.002-.006**	-	-	-	.002-.005	**.002-.005**	-
		Hardened and		4334	245	460	575	0.709-0.866	-	-	.002-.006	**.002-.007**	-	-	-	.002-.005	**.002-.006**	-
		tempered		4344	230	355	425	0.866-1.063	-	-	.002-.008	**.002-.009**	-	-	-	.002-.007	**.002-.007**	-
								1.063-1.299	-	-	.003-.009	**.003-.01**	-	-	-	.003-.008	**.003-.009**	-
								1.299-1.575	-	-	.003-.01	**.003-.011**	-	-	-	.003-.009	**.003-.009**	-
								1.575-2.047	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
								2.047-2.559	-	-	.004-.01	**.004-.011**	-	-	-	.004-.009	**.004-.009**	-
	P5.0.Z.AN	Ferritic/martensitic	200	4334	375	610	740	0.591-0.709	.002-.005	**.002-.005**	.002-.005	-	.002-.005	.002-.004	**.002-.004**	.002-.004	-	.002-.004
		stainless steel		4344	375	505	575	0.709-0.866	.002-.006	**.002-.006**	.002-.006	-	.002-.005	.002-.005	**.002-.005**	.002-.005	-	.002-.004
		Annealed		2044	375	480	540	0.866-1.063	.002-.006	**.002-.006**	.002-.006	-	.002-.006	.002-.005	**.002-.005**	.002-.005	-	.002-.005
								1.063-1.299	.003-.006	**.003-.006**	.003-.006	-	.003-.006	.003-.005	**.003-.005**	.003-.005	-	.003-.005
								1.299-1.575	.003-.007	**.003-.007**	.003-.007	-	.003-.006	.003-.006	**.003-.006**	.003-.006	-	.003-.005
								1.575-2.047	.004-.007	**.004-.007**	.004-.007	-	.004-.006	.004-.006	**.004-.006**	.004-.006	-	.004-.005
								2.047-2.559	.004-.007	**.004-.007**	.004-.007	-	.004-.006	.004-.006	**.004-.006**	.004-.006	-	.004-.005
	P5.0.Z.HT	Ferritic/martensitic	330	4334	245	450	560	0.591-0.709	.002-.005	**.002-.005**	.002-.005	-	.002-.005	.002-.004	**.002-.004**	.002-.004	-	.002-.004
		stainless steel		4344	230	380	460	0.709-0.866	.002-.006	**.002-.006**	.002-.006	-	.002-.005	.002-.005	**.002-.005**	.002-.005	-	.002-.004
		Hardened and		2044	230	380	460	0.866-1.063	.002-.006	**.002-.006**	.002-.006	-	.002-.006	.002-.005	**.002-.005**	.002-.005	-	.002-.005
		tempered						1.063-1.299	.003-.006	**.003-.006**	.003-.006	-	.003-.006	.003-.005	**.003-.005**	.003-.005	-	.003-.005
								1.299-1.575	.003-.007	**.003-.007**	.003-.007	-	.003-.006	.003-.006	**.003-.006**	.003-.006	-	.003-.005
								1.575-2.047	.004-.007	**.004-.007**	.004-.007	-	.004-.006	.004-.006	**.004-.006**	.004-.006	-	.004-.005
								2.047-2.559	.004-.007	**.004-.007**	.004-.007	-	.004-.006	.004-.006	**.004-.006**	.004-.006	-	.004-.005
M	M1.0.Z.AQ	Austenitic	200	4334	375	610	740	0.591-0.709	.002-.005	.002-.005	.002-.005	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
		Stainless steel		4344	375	540	625	0.709-0.866	.002-.005	.002-.005	.002-.005	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.004**
		Annealed/quenched		2044	375	515	590	0.866-1.063	.002-.006	.002-.006	.002-.006	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.005**
								1.063-1.299	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.005	.003-.005	.003-.005	-	**.003-.005**
								1.299-1.575	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.006	.003-.006	.003-.006	-	**.003-.005**
								1.575-2.047	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
								2.047-2.559	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
	M1.1.Z.AQ	Austenitic	200	4334	375	640	785	0.591-0.709	.002-.005	.002-.005	.002-.005	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
		Stainless steel		4344	375	580	690	0.709-0.866	.002-.005	.002-.005	.002-.005	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.004**
		Machinability		2044	375	555	655	0.866-1.063	.002-.006	.002-.006	.002-.006	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.005**
		improved						1.063-1.299	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.005	.003-.005	.003-.005	-	**.003-.005**
								1.299-1.575	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.006	.003-.006	.003-.006	-	**.003-.005**
								1.575-2.047	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
								2.047-2.559	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
	M2.0.Z.AQ	Super Austenitic	200	4334	260	410	490	0.591-0.709	.002-.005	.002-.005	.002-.005	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
		(Ni>20%) Stainless		4344	260	360	410	0.709-0.866	.002-.005	.002-.005	.002-.005	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.004**
		steel		2044	260	360	410	0.866-1.063	.002-.006	.002-.006	.002-.006	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.005**
		Annealed/quenched						1.063-1.299	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.005	.003-.005	.003-.005	-	**.003-.005**
								1.299-1.575	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.006	.003-.006	.003-.006	-	**.003-.005**
								1.575-2.047	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
								2.047-2.559	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
	M3.1.Z.AQ	Duplex	230	4334	280	405	475	0.591-0.709	.002-.005	.002-.005	.002-.005	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
		stainless steel		4344	280	375	425	0.709-0.866	.002-.005	.002-.005	.002-.005	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.004**
		>60% ferrite (N<0.10%)		2044	280	365	410	0.866-1.063	.002-.006	.002-.006	.002-.006	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.005**
								1.063-1.299	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.005	.003-.005	.003-.005	-	**.003-.005**
								1.299-1.575	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.006	.003-.006	.003-.006	-	**.003-.005**
								1.575-2.047	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
								2.047-2.559	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
	M3.2.Z.AQ	Duplex	260	4334	245	345	395	0.591-0.709	.002-.005	.002-.005	.002-.005	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
		stainless steel		4344	245	330	375	0.709-0.866	.002-.005	.002-.005	.002-.005	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.004**
		<60% ferrite (N>0.10%)		2044	245	330	375	0.866-1.063	.002-.006	.002-.006	.002-.006	-	**.002-.005**	.002-.005	.002-.005	.002-.005	-	**.002-.005**
								1.063-1.299	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.005	.003-.005	.003-.005	-	**.003-.005**
								1.299-1.575	.003-.006	.003-.006	.003-.006	-	**.003-.006**	.003-.006	.003-.006	.003-.006	-	**.003-.005**
								1.575-2.047	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
								2.047-2.559	.004-.006	.004-.006	.004-.006	-	**.004-.006**	.004-.006	.004-.006	.004-.006	-	**.004-.005**
S	S2.0.Z.AN	Heat resistant	350	4334	65	130	165	0.591-0.709	.002-.003	.002-.003	**.002-.003**	-	-	.002-.003	.002-.003	**.002-.003**	-	-
	S2.0.Z.AG	super alloys		4344	65	130	165	0.709-0.866	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-	-
	S2.0.Z.NS	Ni based		2044	65	130	165	0.866-1.063	.002-.004	.002-.004	**.002-.004**	-	-	.002-.004	.002-.004	**.002-.004**	-	-
								1.063-1.299	.002-.004	.002-.004	**.002-.004**	-	-	.002-.004	.002-.004	**.002-.004**	-	-
								1.299-1.575	.002-.005	.002-.005	**.002-.005**	-	-	.002-.004	.002-.004	**.002-.004**	-	-
								1.575-2.047	.002-.005	.002-.005	**.002-.005**	-	-	.002-.004	.002-.004	**.002-.004**	-	-
								2.047-2.559	.002-.005	.002-.005	**.002-.005**	-	-	.002-.004	.002-.004	**.002-.004**	-	-
	S4.2.Z.AN	Heat resistant	330	H13A	130	300	395	0.591-0.709	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
	S4.3.Z.AG	super alloys		4344	130	300	395	0.709-0.866	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		Ti based		2044	130	300	395	0.866-1.063	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
								1.063-1.299	**.003-.007**	.003-.007	.003-.007	-	-	**.003-.006**	.003-.006	.003-.006	-	-
								1.299-1.575	**.003-.007**	.003-.007	.003-.007	-	-	**.003-.006**	.003-.006	.003-.006	-	-
								1.575-2.047	**.004-.007**	.004-.007	.004-.007	-	-	**.004-.006**	.004-.006	.004-.006	-	-
								2.047-2.559	**.004-.007**	.004-.007	.004-.007	-	-	**.004-.006**	.004-.006	.004-.006	-	-

CoroDrill® DS20

Cutting data recommendation, inch
4-5xD

					Cutting speed recommendations				Drill length 4xD					Drill length 5xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (inch)	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev
K	K1.1.C.NS	Malleable cast iron	200	4324	460	685	805	0.591-0.709	-	.003-.006	.003-.006	**.003-.008**	-	-	.003-.005	.003-.005	**.003-.007**	-
		Low tensile strength		4334	360	550	655	0.709-0.866	-	.003-.007	.003-.007	**.003-.009**	-	-	.003-.006	.003-.006	**.003-.008**	-
				4344	590	540	510	0.866-1.063	-	.003-.008	.003-.008	**.003-.01**	-	-	.003-.007	.003-.007	**.003-.009**	-
								1.063-1.299	-	.004-.009	.004-.009	**.004-.011**	-	-	.004-.008	.004-.008	**.004-.01**	-
								1.299-1.575	-	.004-.011	.004-.011	**.004-.013**	-	-	.004-.009	.004-.009	**.004-.011**	-
								1.575-2.047	-	.005-.011	.005-.011	**.005-.013**	-	-	.005-.009	.005-.009	**.005-.011**	-
								2.047-2.559	-	.005-.011	.005-.011	**.005-.013**	-	-	.005-.009	.005-.009	**.005-.011**	-
	K2.1.C.UT	Grey cast iron	180	4324	690	935	1065	0.591-0.709	-	.003-.006	.003-.006	**.003-.008**	-	-	.003-.005	.003-.005	**.003-.007**	-
		Low tensile strength		4334	560	770	885	0.709-0.866	-	.003-.007	.003-.007	**.003-.009**	-	-	.003-.006	.003-.006	**.003-.008**	-
				4344	425	585	670	0.866-1.063	-	.003-.008	.003-.008	**.003-.01**	-	-	.003-.007	.003-.007	**.003-.009**	-
								1.063-1.299	-	.004-.009	.004-.009	**.004-.011**	-	-	.004-.008	.004-.008	**.004-.01**	-
								1.299-1.575	-	.004-.011	.004-.011	**.004-.013**	-	-	.004-.009	.004-.009	**.004-.011**	-
								1.575-2.047	-	.005-.011	.005-.011	**.005-.013**	-	-	.005-.009	.005-.009	**.005-.011**	-
								2.047-2.559	-	.005-.011	.005-.011	**.005-.013**	-	-	.005-.009	.005-.009	**.005-.011**	-
	K2.2.C.UT	Grey cast iron	245	4324	410	665	805	0.591-0.709	-	.003-.005	.003-.005	**.003-.007**	-	-	.003-.004	.003-.004	**.003-.006**	-
		High tensile strength		4334	330	530	640	0.709-0.866	-	.003-.006	.003-.006	**.003-.008**	-	-	.003-.005	.003-.005	**.003-.007**	-
				4344	245	405	490	0.866-1.063	-	.003-.007	.003-.007	**.003-.009**	-	-	.003-.006	.003-.006	**.003-.008**	-
								1.063-1.299	-	.004-.009	.004-.009	**.004-.011**	-	-	.004-.007	.004-.007	**.004-.009**	-
								1.299-1.575	-	.004-.01	.004-.01	**.004-.012**	-	-	.004-.008	.004-.008	**.004-.01**	-
								1.575-2.047	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
								2.047-2.559	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
	K3.1.C.UT	Nodular cast iron	155	4324	410	625	740	0.591-0.709	-	.003-.005	.003-.005	**.003-.007**	-	-	.003-.004	.003-.004	**.003-.006**	-
		Ferritic		4334	330	510	605	0.709-0.866	-	.003-.006	.003-.006	**.003-.008**	-	-	.003-.005	.003-.005	**.003-.007**	-
				4344	260	400	475	0.866-1.063	-	.003-.007	.003-.007	**.003-.009**	-	-	.003-.006	.003-.006	**.003-.008**	-
								1.063-1.299	-	.004-.009	.004-.009	**.004-.011**	-	-	.004-.007	.004-.007	**.004-.009**	-
								1.299-1.575	-	.004-.01	.004-.01	**.004-.012**	-	-	.004-.008	.004-.008	**.004-.01**	-
								1.575-2.047	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
								2.047-2.559	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
	K3.3.C.UT	Nodular cast iron	265	4324	360	575	690	0.591-0.709	-	.003-.005	.003-.005	**.003-.007**	-	-	.003-.004	.003-.004	**.003-.006**	-
		Pearlitic		4334	295	475	575	0.709-0.866	-	.003-.006	.003-.006	**.003-.008**	-	-	.003-.005	.003-.005	**.003-.007**	-
				4344	230	355	425	0.866-1.063	-	.003-.007	.003-.007	**.003-.009**	-	-	.003-.006	.003-.006	**.003-.008**	-
								1.063-1.299	-	.004-.009	.004-.009	**.004-.011**	-	-	.004-.007	.004-.007	**.004-.009**	-
								1.299-1.575	-	.004-.01	.004-.01	**.004-.012**	-	-	.004-.008	.004-.008	**.004-.01**	-
								1.575-2.047	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
								2.047-2.559	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
	K4.2.C.UT	Compacted graphite	230	4324	425	680	820	0.591-0.709	-	.003-.005	.003-.005	**.003-.007**	-	-	.003-.004	.003-.004	**.003-.006**	-
		iron		4334	360	550	655	0.709-0.866	-	.003-.006	.003-.006	**.003-.008**	-	-	.003-.005	.003-.005	**.003-.007**	-
		High tensile strength		4344	280	415	490	0.866-1.063	-	.003-.007	.003-.007	**.003-.009**	-	-	.003-.006	.003-.006	**.003-.008**	-
								1.063-1.299	-	.004-.009	.004-.009	**.004-.011**	-	-	.004-.007	.004-.007	**.004-.009**	-
								1.299-1.575	-	.004-.01	.004-.01	**.004-.012**	-	-	.004-.008	.004-.008	**.004-.01**	-
								1.575-2.047	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
								2.047-2.559	-	.005-.01	.005-.01	**.005-.012**	-	-	.005-.008	.005-.008	**.005-.01**	-
H	H1.3.Z.HA	Extra hard steels	60	4324	100	215	280	0.591-0.709	-	.002-.005	**.002-.005**	.002-.005	-	-	.002-.004	**.002-.004**	.002-.004	-
		Hardened & tempered		4334	100	215	280	0.709-0.866	-	.002-.006	**.002-.006**	.002-.006	-	-	.002-.005	**.002-.005**	.002-.005	-
				4344	100	215	280	0.866-1.063	-	.002-.006	**.002-.006**	.002-.006	-	-	.002-.005	**.002-.005**	.002-.005	-
								1.063-1.299	-	.003-.006	**.003-.006**	.003-.006	-	-	.003-.005	**.003-.005**	.003-.005	-
								1.299-1.575	-	.003-.007	**.003-.007**	.003-.007	-	-	.003-.006	**.003-.006**	.003-.006	-
								1.575-2.047	-	.004-.007	**.004-.007**	.004-.007	-	-	.004-.006	**.004-.006**	.004-.006	-
								2.047-2.559	-	.004-.007	**.004-.007**	.004-.007	-	-	.004-.006	**.004-.006**	.004-.006	-
N	N1.2.Z.AG	Aluminum based alloys	100	H13A	985	1195	1310	0.591-0.709	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		AlSi alloys (Si<1%)		4344	985	1195	1310	0.709-0.866	**.002-.007**	.002-.007	.002-.007	-	-	**.002-.006**	.002-.006	.002-.006	-	-
								0.866-1.063	**.002-.008**	.002-.008	.002-.008	-	-	**.002-.007**	.002-.007	.002-.007	-	-
								1.063-1.299	**.003-.009**	.003-.009	.003-.009	-	-	**.003-.007**	.003-.007	.003-.007	-	-
								1.299-1.575	**.003-.01**	.003-.01	.003-.01	-	-	**.003-.008**	.003-.008	.003-.008	-	-
								1.575-2.047	**.004-.01**	.004-.01	.004-.01	-	-	**.004-.008**	.004-.008	.004-.008	-	-
								2.047-2.559	**.004-.01**	.004-.01	.004-.01	-	-	**.004-.008**	.004-.008	.004-.008	-	-
	N1.3.C.UT	Aluminum based alloys	75	H13A	820	1140	1310	0.591-0.709	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		AlSi cast alloys		4344	820	1140	1310	0.709-0.866	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		(1%< Si >13%)						0.866-1.063	**.002-.007**	.002-.007	.002-.007	-	-	**.002-.006**	.002-.006	.002-.006	-	-
								1.063-1.299	**.003-.008**	.003-.008	.003-.008	-	-	**.003-.007**	.003-.007	.003-.007	-	-
								1.299-1.575	**.003-.009**	.003-.009	.003-.009	-	-	**.003-.007**	.003-.007	.003-.007	-	-
								1.575-2.047	**.004-.009**	.004-.009	.004-.009	-	-	**.004-.007**	.004-.007	.004-.007	-	-
								2.047-2.559	**.004-.009**	.004-.009	.004-.009	-	-	**.004-.007**	.004-.007	.004-.007	-	-
	N1.3.C.AG	Aluminum based alloys	90	H13A	820	1035	1150	0.591-0.709	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		AlSi cast and aged		4344	820	1035	1150	0.709-0.866	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		alloys						0.866-1.063	**.002-.007**	.002-.007	.002-.007	-	-	**.002-.006**	.002-.006	.002-.006	-	-
		(1%< Si >13%)						1.063-1.299	**.003-.008**	.003-.008	.003-.008	-	-	**.003-.007**	.003-.007	.003-.007	-	-
								1.299-1.575	**.003-.009**	.003-.009	.003-.009	-	-	**.003-.007**	.003-.007	.003-.007	-	-
								1.575-2.047	**.004-.009**	.004-.009	.004-.009	-	-	**.004-.007**	.004-.007	.004-.007	-	-
								2.047-2.559	**.004-.009**	.004-.009	.004-.009	-	-	**.004-.007**	.004-.007	.004-.007	-	-
	N3.3.U.UT	Copper based alloys	110	H13A	820	1140	1310	0.591-0.709	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		Free cutting copper		4344	820	1140	1310	0.709-0.866	**.002-.007**	.002-.007	.002-.007	-	-	**.002-.006**	.002-.006	.002-.006	-	-
		based alloys						0.866-1.063	**.002-.008**	.002-.008	.002-.008	-	-	**.002-.007**	.002-.007	.002-.007	-	-
								1.063-1.299	**.003-.009**	.003-.009	.003-.009	-	-	**.003-.007**	.003-.007	.003-.007	-	-
								1.299-1.575	**.003-.01**	.003-.01	.003-.01	-	-	**.003-.008**	.003-.008	.003-.008	-	-
								1.575-2.047	**.004-.01**	.004-.01	.004-.01	-	-	**.004-.008**	.004-.008	.004-.008	-	-
								2.047-2.559	**.004-.01**	.004-.01	.004-.01	-	-	**.004-.008**	.004-.008	.004-.008	-	-
	N3.2.C.UT	Copper based alloys	90	H13A	590	715	785	0.591-0.709	**.002-.006**	.002-.006	.002-.006	-	-	**.002-.005**	.002-.005	.002-.005	-	-
		Leaded brass and		4344	590	715	785	0.709-0.866	**.002-.007**	.002-.007	.002-.007	-	-	**.002-.006**	.002-.006	.002-.006	-	-
		bronzes (Pb<1%)						0.866-1.063	**.002-.008**	.002-.008	.002-.008	-	-	**.002-.007**	.002-.007	.002-.007	-	-
								1.063-1.299	**.003-.009**	.003-.009	.003-.009	-	-	**.003-.007**	.003-.007	.003-.007	-	-
								1.299-1.575	**.003-.01**	.003-.01	.003-.01	-	-	**.003-.008**	.003-.008	.003-.008	-	-
								1.575-2.047	**.004-.01**	.004-.01	.004-.01	-	-	**.004-.008**	.004-.008	.004-.008	-	-
								2.047-2.559	**.004-.01**	.004-.01	.004-.01	-	-	**.004-.008**	.004-.008	.004-.008	-	-

CoroDrill® DS20

Cutting data recommendation, inch
6-7xD

					Cutting speed recommendations				Drill length 6xD					Drill length 7xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (inch)	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev
P	P1.0.Z.AN	Unalloyed steel	110	4324	755	1005	1180	0.591-0.709	.002-.003	.002-.003	.002-.003	-	**.002-.003**	.002-.002	.002-.002	.002-.002	-	**.002-.003**
		C=0.05-0.10%		4334	690	840	960	0.709-0.866	.002-.003	.002-.003	.002-.003	-	**.002-.003**	.002-.002	.002-.002	.002-.002	-	**.002-.003**
				4344	625	665	725	0.866-1.063	.002-.003	.002-.003	.002-.003	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
								1.063-1.299	.002-.003	.002-.003	.002-.003	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
								1.299-1.575	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.003	.002-.003	.002-.003	-	**.002-.004**
								1.575-2.047	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.003	.002-.003	.002-.003	-	**.002-.004**
								2.047-2.559	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.003	.002-.003	.002-.003	-	**.002-.004**
	P1.1.Z.AN	Unalloyed steel	125	4324	755	950	1095	0.591-0.709	.002-.003	.002-.003	.002-.003	-	**.002-.003**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		C=0.05-0.25%		4334	655	790	900	0.709-0.866	.002-.003	.002-.003	.002-.003	-	**.002-.003**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
				4344	560	625	695	0.866-1.063	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
								1.063-1.299	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
								1.299-1.575	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
								1.575-2.047	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
								2.047-2.559	.002-.004	.002-.004	.002-.004	-	**.002-.005**	.002-.004	.002-.004	.002-.004	-	**.002-.004**
	P1.2.Z.AN	Unalloyed steel	190	4324	625	785	900	0.591-0.709	-	**.002-.003**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-
		C=0.25-0.55%		4334	510	640	740	0.709-0.866	-	**.002-.004**	.002-.004	.002-.005	-	-	**.002-.003**	.002-.003	.002-.004	-
				4344	395	490	565	0.866-1.063	-	**.002-.005**	.002-.005	.002-.006	-	-	**.002-.004**	.002-.004	.002-.005	-
								1.063-1.299	-	**.003-.006**	.003-.006	.003-.007	-	-	**.003-.005**	.003-.005	.003-.006	-
								1.299-1.575	-	**.003-.006**	.003-.007	.003-.007	-	-	**.003-.005**	.003-.006	.003-.006	-
								1.575-2.047	-	**.004-.006**	.004-.007	.004-.007	-	-	**.004-.005**	.004-.006	.004-.006	-
								2.047-2.559	-	**.004-.006**	.004-.007	.004-.007	-	-	**.004-.005**	.004-.006	.004-.006	-
	P1.3.Z.AN	Unalloyed steel	190	4324	560	735	855	0.591-0.709	-	.002-.003	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
		C=0.55-0.80%		4334	460	605	705	0.709-0.866	-	.002-.004	.002-.004	**.002-.005**	-	-	.002-.003	.002-.003	**.002-.004**	-
				4344	345	465	545	0.866-1.063	-	.002-.005	.002-.005	**.002-.006**	-	-	.002-.004	.002-.004	**.002-.005**	-
								1.063-1.299	-	.003-.006	.003-.006	**.003-.007**	-	-	.003-.005	.003-.005	**.003-.006**	-
								1.299-1.575	-	.003-.006	.003-.007	**.003-.007**	-	-	.003-.005	.003-.006	**.003-.006**	-
								1.575-2.047	-	.004-.006	.004-.007	**.004-.007**	-	-	.004-.005	.004-.006	**.004-.006**	-
								2.047-2.559	-	.004-.006	.004-.007	**.004-.007**	-	-	.004-.005	.004-.006	**.004-.006**	-
	P1.5.C.UT	Unalloyed steel	150	4324	460	770	960	0.591-0.709	-	.002-.003	.002-.003	**.002-.003**	-	-	.002-.003	.002-.003	**.002-.003**	-
		Cast - untreated		4334	445	650	785	0.709-0.866	-	.002-.003	.002-.003	**.002-.003**	-	-	.002-.003	.002-.003	**.002-.003**	-
				4344	410	515	590	0.866-1.063	-	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
								1.063-1.299	-	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
								1.299-1.575	-	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
								1.575-2.047	-	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
								2.047-2.559	-	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
	P2.1.Z.AN	Low alloy steel	175	4324	590	770	900	0.591-0.709	-	-	.002-.004	**.002-.004**	-	-	-	.002-.003	**.002-.003**	-
		Annealed		4334	490	635	740	0.709-0.866	-	-	.002-.004	**.002-.005**	-	-	-	.002-.003	**.002-.004**	-
				4344	375	485	565	0.866-1.063	-	-	.002-.005	**.002-.006**	-	-	-	.002-.004	**.002-.005**	-
								1.063-1.299	-	-	.003-.006	**.003-.007**	-	-	-	.003-.005	**.003-.006**	-
								1.299-1.575	-	-	.003-.007	**.003-.007**	-	-	-	.003-.006	**.003-.006**	-
								1.575-2.047	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
								2.047-2.559	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
	P2.2.Z.AN	Low alloy steel	240	4324	590	745	855	0.591-0.709	-	-	.002-.004	**.002-.004**	-	-	-	.002-.003	**.002-.003**	-
		Annealed		4334	490	590	665	0.709-0.866	-	-	.002-.004	**.002-.005**	-	-	-	.002-.003	**.002-.004**	-
				4344	375	510	605	0.866-1.063	-	-	.002-.005	**.002-.006**	-	-	-	.002-.004	**.002-.005**	-
								1.063-1.299	-	-	.003-.006	**.003-.007**	-	-	-	.003-.005	**.003-.006**	-
								1.299-1.575	-	-	.003-.007	**.003-.007**	-	-	-	.003-.006	**.003-.006**	-
								1.575-2.047	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
								2.047-2.559	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
	P2.5.Z.HT	Low alloy steel	330	4324	295	565	725	0.591-0.709	-	-	.002-.004	**.002-.004**	-	-	-	.002-.003	**.002-.003**	-
		Hardened and		4334	280	465	575	0.709-0.866	-	-	.002-.004	**.002-.005**	-	-	-	.002-.003	**.002-.004**	-
		tempered		4344	245	365	440	0.866-1.063	-	-	.002-.005	**.002-.006**	-	-	-	.002-.004	**.002-.005**	-
								1.063-1.299	-	-	.003-.006	**.003-.007**	-	-	-	.003-.005	**.003-.006**	-
								1.299-1.575	-	-	.003-.007	**.003-.007**	-	-	-	.003-.006	**.003-.006**	-
								1.575-2.047	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
								2.047-2.559	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
	P2.6.C.UT	Low alloy steel	200	4324	360	620	785	0.591-0.709	-	-	.002-.004	**.002-.005**	-	-	-	.002-.003	**.002-.004**	-
		Cast - untreated		4334	345	515	620	0.709-0.866	-	-	.002-.005	**.002-.005**	-	-	-	.002-.004	**.002-.004**	-
				4344	330	410	475	0.866-1.063	-	-	.002-.006	**.002-.006**	-	-	-	.002-.005	**.002-.005**	-
								1.063-1.299	-	-	.003-.007	**.003-.007**	-	-	-	.003-.006	**.003-.006**	-
								1.299-1.575	-	-	.003-.007	**.003-.008**	-	-	-	.003-.006	**.003-.006**	-
								1.575-2.047	-	-	.004-.007	**.004-.008**	-	-	-	.004-.006	**.004-.006**	-
								2.047-2.559	-	-	.004-.007	**.004-.008**	-	-	-	.004-.006	**.004-.006**	-
	P3.0.Z.AN	High alloy steel	200	4324	525	720	855	0.591-0.709	-	-	.002-.004	**.002-.004**	-	-	-	.002-.003	**.002-.003**	-
		Annealed		4334	425	595	705	0.709-0.866	-	-	.002-.004	**.002-.005**	-	-	-	.002-.003	**.002-.004**	-
				4344	330	450	530	0.866-1.063	-	-	.002-.005	**.002-.006**	-	-	-	.002-.004	**.002-.005**	-
								1.063-1.299	-	-	.003-.006	**.003-.007**	-	-	-	.003-.005	**.003-.006**	-
								1.299-1.575	-	-	.003-.007	**.003-.007**	-	-	-	.003-.006	**.003-.006**	-
								1.575-2.047	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
								2.047-2.559	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-

CoroDrill® DS20

Cutting data recommendation, inch
6-7xD

					Cutting speed recommendations				Drill length 6xD					Drill length 7xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (inch)	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev
P	P3.0.Z.HT	High alloy steel	380	4324	260	485	620	0.591-0.709	-	-	.002-.004	**.002-.004**	-	-	-	.002-.003	**.002-.003**	-
		Hardened and		4334	245	415	520	0.709-0.866	-	-	.002-.004	**.002-.005**	-	-	-	.002-.003	**.002-.004**	-
		tempered		4344	230	320	385	0.866-1.063	-	-	.002-.005	**.002-.006**	-	-	-	.002-.004	**.002-.005**	-
								1.063-1.299	-	-	.003-.006	**.003-.007**	-	-	-	.003-.005	**.003-.006**	-
								1.299-1.575	-	-	.003-.007	**.003-.007**	-	-	-	.003-.006	**.003-.006**	-
								1.575-2.047	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
								2.047-2.559	-	-	.004-.007	**.004-.007**	-	-	-	.004-.006	**.004-.006**	-
	P5.0.Z.AN	Ferritic/martensitic	200	4334	375	550	665	0.591-0.709	.002-.003	**.002-.003**	.002-.003	-	.002-.003	.002-.003	**.002-.003**	.002-.003	-	.002-.003
		stainless steel		4344	375	455	520	0.709-0.866	.002-.004	**.002-.004**	.002-.004	-	.002-.003	.002-.003	**.002-.003**	.002-.003	-	.002-.003
		Annealed		2044	375	430	485	0.866-1.063	.002-.004	**.002-.004**	.002-.004	-	.002-.004	.002-.003	**.002-.003**	.002-.003	-	.002-.003
								1.063-1.299	.003-.004	**.003-.004**	.003-.004	-	.003-.004	.003-.003	**.003-.003**	.003-.003	-	.003-.003
								1.299-1.575	.003-.005	**.003-.005**	.003-.005	-	.003-.004	.003-.004	**.003-.004**	.003-.004	-	.003-.003
								1.575-2.047	.004-.005	**.004-.005**	.004-.005	-	.004-.004	.004-.004	**.004-.004**	.004-.004	-	.004-.003
								2.047-2.559	.004-.005	**.004-.005**	.004-.005	-	.004-.004	.004-.004	**.004-.004**	.004-.004	-	.004-.003
	P5.0.Z.HT	Ferritic/martensitic	330	4334	245	405	505	0.591-0.709	.002-.003	**.002-.003**	.002-.003	-	.002-.003	.002-.003	**.002-.003**	.002-.003	-	.002-.003
		stainless steel		4344	230	340	415	0.709-0.866	.002-.004	**.002-.004**	.002-.004	-	.002-.003	.002-.003	**.002-.003**	.002-.003	-	.002-.003
		Hardened and		2044	230	340	415	0.866-1.063	.002-.004	**.002-.004**	.002-.004	-	.002-.004	.002-.003	**.002-.003**	.002-.003	-	.002-.003
		tempered						1.063-1.299	.003-.004	**.003-.004**	.003-.004	-	.003-.004	.003-.003	**.003-.003**	.003-.003	-	.003-.003
								1.299-1.575	.003-.005	**.003-.005**	.003-.005	-	.003-.004	.003-.004	**.003-.004**	.003-.004	-	.003-.003
								1.575-2.047	.004-.005	**.004-.005**	.004-.005	-	.004-.004	.004-.004	**.004-.004**	.004-.004	-	.004-.003
								2.047-2.559	.004-.005	**.004-.005**	.004-.005	-	.004-.004	.004-.004	**.004-.004**	.004-.004	-	.004-.003
M	M1.0.Z.AQ	Austenitic Stainless	200	4334	375	550	665	0.591-0.709	.002-.004	.002-.004	.002-.004	-	**.002-.003**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		steel		4344	375	485	565	0.709-0.866	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		Annealed/quenched		2044	375	465	530	0.866-1.063	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.003**
								1.063-1.299	.003-.005	.003-.005	.003-.005	-	**.003-.004**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.299-1.575	.003-.005	.003-.005	.003-.005	-	**.003-.005**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.575-2.047	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
								2.047-2.559	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
	M1.1.Z.AQ	Austenitic Stainless	200	4334	375	575	705	0.591-0.709	.002-.004	.002-.004	.002-.004	-	**.002-.003**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		steel		4344	375	520	620	0.709-0.866	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		Machinability		2044	375	500	590	0.866-1.063	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.003**
		improved						1.063-1.299	.003-.005	.003-.005	.003-.005	-	**.003-.004**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.299-1.575	.003-.005	.003-.005	.003-.005	-	**.003-.005**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.575-2.047	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
								2.047-2.559	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
	M2.0.Z.AQ	Super Austenitic	200	4334	260	370	440	0.591-0.709	.002-.004	.002-.004	.002-.004	-	**.002-.003**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		(Ni>20%) Stainless		4344	260	325	370	0.709-0.866	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		steel		2044	260	325	370	0.866-1.063	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.003**
		Annealed/quenched						1.063-1.299	.003-.005	.003-.005	.003-.005	-	**.003-.004**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.299-1.575	.003-.005	.003-.005	.003-.005	-	**.003-.005**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.575-2.047	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
								2.047-2.559	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
	M3.1.Z.AQ	Duplex stainless steel	230	4334	280	365	430	0.591-0.709	.002-.004	.002-.004	.002-.004	-	**.002-.003**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		>60% ferrite (N<0.10%)		4344	280	340	385	0.709-0.866	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
				2044	280	330	370	0.866-1.063	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.003**
								1.063-1.299	.003-.005	.003-.005	.003-.005	-	**.003-.004**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.299-1.575	.003-.005	.003-.005	.003-.005	-	**.003-.005**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.575-2.047	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
								2.047-2.559	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
	M3.2.Z.AQ	Duplex stainless steel	260	4334	245	310	355	0.591-0.709	.002-.004	.002-.004	.002-.004	-	**.002-.003**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
		<60% ferrite (N>0.10%)		4344	245	295	340	0.709-0.866	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.003	.002-.003	.002-.003	-	**.002-.003**
				2044	245	295	340	0.866-1.063	.002-.004	.002-.004	.002-.004	-	**.002-.004**	.002-.004	.002-.004	.002-.004	-	**.002-.003**
								1.063-1.299	.003-.005	.003-.005	.003-.005	-	**.003-.004**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.299-1.575	.003-.005	.003-.005	.003-.005	-	**.003-.005**	.003-.004	.003-.004	.003-.004	-	**.003-.004**
								1.575-2.047	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
								2.047-2.559	.004-.005	.004-.005	.004-.005	-	**.004-.005**	.004-.004	.004-.004	.004-.004	-	**.004-.004**
S	S2.0.Z.AN	Heat resistant super	350	4334	65	115	150	0.591-0.709	.002-.003	.002-.003	**.002-.003**	-	-	.002-.002	.002-.002	**.002-.002**	-	-
	S2.0.Z.AG	alloys		4344	65	115	150	0.709-0.866	.002-.003	.002-.003	**.002-.003**	-	-	.002-.002	.002-.002	**.002-.002**	-	-
	S2.0.Z.NS	Ni based		2044	65	115	150	0.866-1.063	.002-.003	.002-.003	**.002-.003**	-	-	.002-.003	.002-.003	**.002-.003**	-	-
								1.063-1.299	.002-.003	.002-.003	**.002-.003**	-	-	.002-.003	.002-.003	**.002-.003**	-	-
								1.299-1.575	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-	-
								1.575-2.047	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-	-
								2.047-2.559	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-	-
	S4.2.Z.AN	Heat resistant super	330	H13A	130	270	355	0.591-0.709	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.004**	.002-.004	.002-.004	-	-
	S4.3.Z.AG	alloys		4344	130	270	355	0.709-0.866	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
		Ti based		2044	130	270	355	0.866-1.063	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
								1.063-1.299	**.003-.005**	.003-.005	.003-.005	-	-	**.003-.004**	.003-.004	.003-.004	-	-
								1.299-1.575	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.575-2.047	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
								2.047-2.559	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-

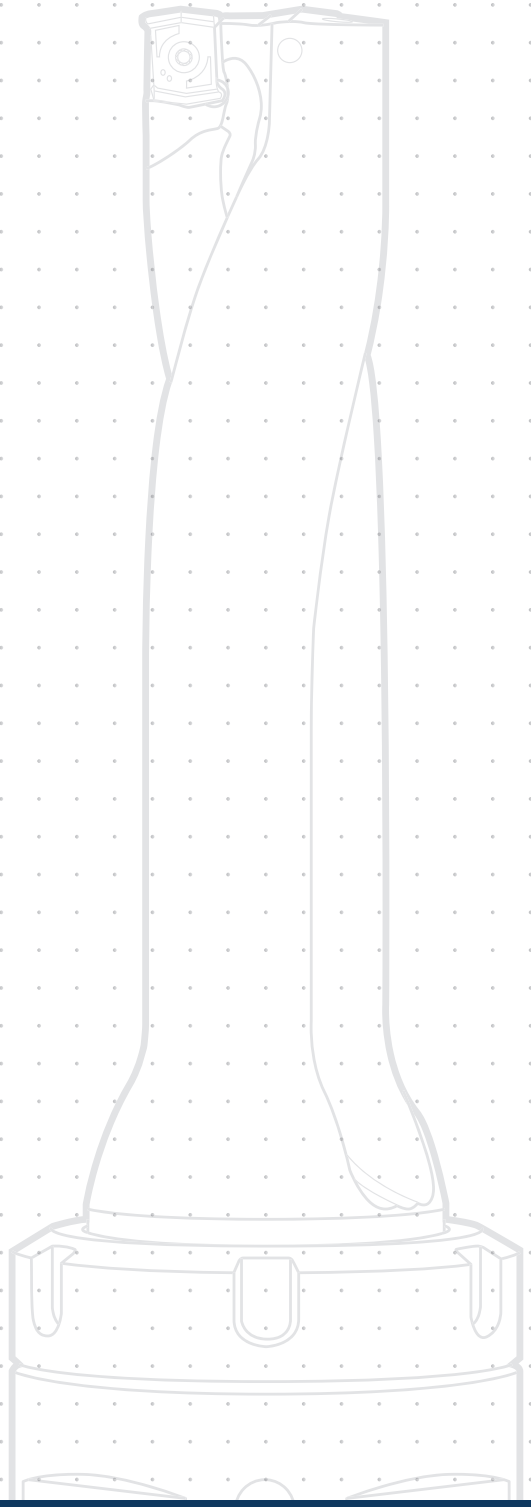
Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.002 in/rev.

CoroDrill® DS20

Cutting data recommendation, inch
6-7xD

					Cutting speed recommendations				Drill length 6xD					Drill length 7xD				
ISO	MC-Nr.	Material	HB	Grade	Min.	Recom.	Max.	Drill diameter (inch)	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev	-S5W f_n in/rev	-L5W f_n in/rev	-L6W f_n in/rev	-M7W f_n in/rev	-H5W f_n in/rev
K	K1.1.C.NS	Malleable cast iron	200	4324	460	615	725	0.591-0.709	-	.003-.004	.003-.004	.003-.005	-	-	.003-.003	.003-.003	.003-.004	-
		Low tensile strength		4334	360	495	590	0.709-0.866	-	.003-.005	.003-.005	.003-.006	-	-	.003-.004	.003-.004	.003-.005	-
				4344	590	485	460	0.866-1.063	-	.003-.005	.003-.005	.003-.007	-	-	.003-.005	.003-.005	.003-.006	-
								1.063-1.299	-	.004-.006	.004-.006	.004-.007	-	-	.004-.005	.004-.005	.004-.006	-
								1.299-1.575	-	.004-.007	.004-.007	.004-.008	-	-	.004-.006	.004-.006	.004-.007	-
								1.575-2.047	-	.005-.007	.005-.007	.005-.008	-	-	.005-.006	.005-.006	.005-.007	-
								2.047-2.559	-	.005-.007	.005-.007	.005-.008	-	-	.005-.006	.005-.006	.005-.007	-
	K2.1.C.UT	Grey cast iron	180	4324	690	840	960	0.591-0.709	-	.003-.004	.003-.004	.003-.005	-	-	.003-.003	.003-.003	.003-.004	-
		Low tensile strength		4334	560	695	795	0.709-0.866	-	.003-.005	.003-.005	.003-.006	-	-	.003-.004	.003-.004	.003-.005	-
				4344	425	525	605	0.866-1.063	-	.003-.005	.003-.005	.003-.007	-	-	.003-.005	.003-.005	.003-.006	-
								1.063-1.299	-	.004-.006	.004-.006	.004-.007	-	-	.004-.005	.004-.005	.004-.006	-
								1.299-1.575	-	.004-.007	.004-.007	.004-.008	-	-	.004-.006	.004-.006	.004-.007	-
								1.575-2.047	-	.005-.007	.005-.007	.005-.008	-	-	.005-.006	.005-.006	.005-.007	-
								2.047-2.559	-	.005-.007	.005-.007	.005-.008	-	-	.005-.006	.005-.006	.005-.007	-
	K2.2.C.UT	Grey cast iron	245	4324	410	600	725	0.591-0.709	-	.003-.003	.003-.003	.003-.005	-	-	.003-.003	.003-.003	.003-.004	-
		High tensile strength		4334	330	475	575	0.709-0.866	-	.003-.004	.003-.004	.003-.005	-	-	.003-.003	.003-.003	.003-.005	-
				4344	245	365	440	0.866-1.063	-	.003-.005	.003-.005	.003-.006	-	-	.003-.004	.003-.004	.003-.005	-
								1.063-1.299	-	.004-.006	.004-.006	.004-.007	-	-	.004-.005	.004-.005	.004-.006	-
								1.299-1.575	-	.004-.006	.004-.006	.004-.008	-	-	.004-.005	.004-.005	.004-.006	-
								1.575-2.047	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
								2.047-2.559	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
	K3.1.C.UT	Nodular cast iron	155	4324	410	565	665	0.591-0.709	-	.003-.003	.003-.003	.003-.005	-	-	.003-.003	.003-.003	.003-.004	-
		Ferritic		4334	330	460	545	0.709-0.866	-	.003-.004	.003-.004	.003-.005	-	-	.003-.003	.003-.003	.003-.005	-
				4344	260	360	430	0.866-1.063	-	.003-.005	.003-.005	.003-.006	-	-	.003-.004	.003-.004	.003-.005	-
								1.063-1.299	-	.004-.006	.004-.006	.004-.007	-	-	.004-.005	.004-.005	.004-.006	-
								1.299-1.575	-	.004-.006	.004-.006	.004-.008	-	-	.004-.005	.004-.005	.004-.006	-
								1.575-2.047	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
								2.047-2.559	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
	K3.3.C.UT	Nodular cast iron	265	4324	360	520	620	0.591-0.709	-	.003-.003	.003-.003	.003-.005	-	-	.003-.003	.003-.003	.003-.004	-
		Pearlitic		4334	295	430	520	0.709-0.866	-	.003-.004	.003-.004	.003-.005	-	-	.003-.003	.003-.003	.003-.005	-
				4344	230	320	385	0.866-1.063	-	.003-.005	.003-.005	.003-.006	-	-	.003-.004	.003-.004	.003-.005	-
								1.063-1.299	-	.004-.006	.004-.006	.004-.007	-	-	.004-.005	.004-.005	.004-.006	-
								1.299-1.575	-	.004-.006	.004-.006	.004-.008	-	-	.004-.005	.004-.005	.004-.006	-
								1.575-2.047	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
								2.047-2.559	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
	K4.2.C.UT	Compacted graphite	230	4324	425	610	740	0.591-0.709	-	.003-.003	.003-.003	.003-.005	-	-	.003-.003	.003-.003	.003-.004	-
		iron		4334	360	495	590	0.709-0.866	-	.003-.004	.003-.004	.003-.005	-	-	.003-.003	.003-.003	.003-.005	-
		High tensile strength		4344	280	375	440	0.866-1.063	-	.003-.005	.003-.005	.003-.006	-	-	.003-.004	.003-.004	.003-.005	-
		(Pearlite>90%)						1.063-1.299	-	.004-.006	.004-.006	.004-.007	-	-	.004-.005	.004-.005	.004-.006	-
								1.299-1.575	-	.004-.006	.004-.006	.004-.008	-	-	.004-.005	.004-.005	.004-.006	-
								1.575-2.047	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
								2.047-2.559	-	.005-.006	.005-.006	.005-.008	-	-	.005-.005	.005-.005	.005-.006	-
H	H1.3.Z.HA	Extra hard steels	60	4324	100	195	250	0.591-0.709	-	.002-.003	.002-.003	**.002-.003**	-	-	.002-.003	.002-.003	**.002-.003**	-
		Hardened and		4334	100	195	250	0.709-0.866	-	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
		tempered		4344	100	195	250	0.866-1.063	-	.002-.004	.002-.004	**.002-.004**	-	-	.002-.003	.002-.003	**.002-.003**	-
								1.063-1.299	-	.003-.004	.003-.004	**.003-.004**	-	-	.003-.003	.003-.003	**.003-.003**	-
								1.299-1.575	-	.003-.005	.003-.005	**.003-.005**	-	-	.003-.004	.003-.004	**.003-.004**	-
								1.575-2.047	-	.004-.005	.004-.005	**.004-.005**	-	-	.004-.004	.004-.004	**.004-.004**	-
								2.047-2.559	-	.004-.005	.004-.005	**.004-.005**	-		.004-.004	.004-.004	**.004-.004**	-
	N1.2.Z.AG	Aluminum based alloys	100	H13A	985	1075	1180	0.591-0.709	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-	-
		AlSi alloys (Si<1%)		4344	985	1075	1180	0.709-0.866	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
								0.866-1.063	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
								1.063-1.299	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.299-1.575	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.575-2.047	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
								2.047-2.559	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
	N1.3.C.UT	Aluminum based alloys	75	H13A	820	1025	1180	0.591-0.709	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-	-
		AlSi cast alloys		4344	820	1025	1180	0.709-0.866	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-	-
		(1%< Si <13%)						0.866-1.063	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
								1.063-1.299	**.003-.005**	.003-.005	.003-.005	-	-	**.003-.004**	.003-.004	.003-.004	-	-
								1.299-1.575	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.575-2.047	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
								2.047-2.559	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
	N1.3.C.AG	Aluminum based alloys	90	H13A	820	930	1035	0.591-0.709	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-	-
		AlSi cast and aged		4344	820	930	1035	0.709-0.866	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-	-
		alloys						0.866-1.063	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
		(1%< Si >13%)						1.063-1.299	**.003-.005**	.003-.005	.003-.005	-	-	**.003-.004**	.003-.004	.003-.004	-	-
								1.299-1.575	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.575-2.047	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
								2.047-2.559	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
	N3.3.U.UT	Copper based alloys	110	H13A	820	1025	1180	0.591-0.709	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-	-
		Free cutting copper		4344	820	1025	1180	0.709-0.866	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
		based alloys						0.866-1.063	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
								1.063-1.299	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.299-1.575	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.575-2.047	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
								2.047-2.559	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
	N3.2.C.UT	Copper based alloys	90	H13A	590	645	705	0.591-0.709	**.002-.004**	.002-.004	.002-.004	-	-	**.002-.003**	.002-.003	.002-.003	-	-
		Leaded brass and		4344	590	645	705	0.709-0.866	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
		bronzes (Pb<1%)						0.866-1.063	**.002-.005**	.002-.005	.002-.005	-	-	**.002-.004**	.002-.004	.002-.004	-	-
								1.063-1.299	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.299-1.575	**.003-.006**	.003-.006	.003-.006	-	-	**.003-.005**	.003-.005	.003-.005	-	-
								1.575-2.047	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-
								2.047-2.559	**.004-.006**	.004-.006	.004-.006	-	-	**.004-.005**	.004-.005	.004-.005	-	-

Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.002 in/rev.



THOMAS SKINNER

WESTERN CANADA'S LEADING DISTRIBUTOR OF MACHINE TOOLS & CONSUMABLE TOOLS

Click to submit your inquiry and receive additional information.
You can also call **1-800-567 2131**, or email us at **tss@tskinner.com**

*Limited quantities available. Only while supplies last.

www.thomasskinner.com