SANDVIK Coromant

2020

Solid round tools

MILLING
DRILLING
TAPPING
REAMING

Let us introduce our new catalogs

The catalog consists of two volumes: Rotating tools and Turning tools. In total, over 20,000 standard products released before April 2017 are included.

Turning Tools – General Turning, Parting and Grooving, Thread Turning, Multi-functional Tools, Tool Holding, and Turning Tool Adapters

Rotating Tools – Indexable Milling, Indexable Drilling, Boring, and Rotating Tool Adapters

For our offer of round tools, please see our **Solid Round Tools catalog**.

Use the product overviews to find your area of interest, and a reference will take you to the actual ordering page. The ordering page will then take you to related products, such as holders and inserts, if you follow the references at the bottom of the page.

Our total offer of approximately 55,000 standard products can be found at www.sandvik.coromant.com. If none of these products fit your requirements, we have a wide range of products that can be tailored upon your request.

Please note that product data can change over time. Please visit www.sandvik.coromant.com to be sure of getting the latest measurements and tolerances, get detailed cutting data, and order all available products and spare parts.

Explanation of reference symbols:

- Hole size recommendations
- Cutting data
- Grade description
- Explanation of ISO 13399 parameters
- Code key
- Coolant information
- Reconditioning
- Information

★	First Choice
☆	Good choice
	Not available

Our product portfolio

Everything we do is about supporting workflow, efficiency, and productivity. From experience, we know that this requires different solutions for different customers on different occasions. There is no one size fits all solution. Our solid round tools offer includes three clear-cut solutions to meet your needs.

Versatile solutions

A complete range of high performance products that offer high flexibility and cost efficiency.

Optimized solutions

A unique line of refined tools for specific needs that provide extreme efficiency, reliability, and durability.

Customized solutions

Tailor Made and Advanced Engineered products individually designed to meet the highest demands on performance.

How to find the right product

1. Select application type
2. Select the section of our portfolio depending on your demands

- One tool for many materials
- A robust tool for various applications
- Ideal for small batch and varied production

- Tool dedicated for specific material
- Tool refined for specific application
- Ideal for medium to large batch production

- A unique tool customized for your application
- Advanced application knowledge and expert advice
- Tool that is not available in the standard offer

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D Reaming

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Versatile

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O
Optimized

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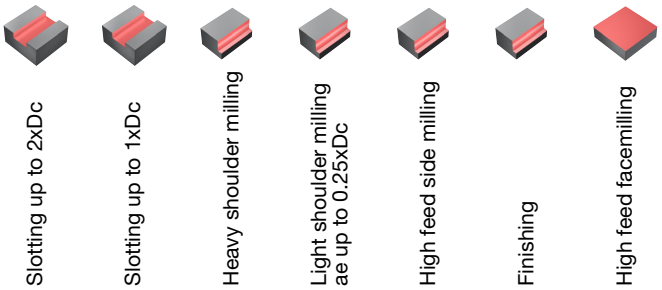
C
Customized

E2

CoroMill® Plura - Optimized

O
Optimized

First choice for optimized roughing and finishing with CoroMill® Plura



Tool	Page	Material
Heavy duty (HD) in steel	A40-A47	P K
Heavy duty (HD) in stainless steel	A48-A52	M
Large chip removal (ALU)	A86-A92	N
Stable multi-operations (VFD) in Ni alloys	A78-A80	S
Hard part milling	A82-A84	P H
High feed side milling (HFS) in steel	A54	P K
High feed side milling (HFS) in stainless steel	A55-A58	M
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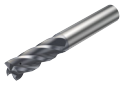
Finishing (FSF)	A100-A104	P M K S H
High feed face milling (HFF)	A66-A68	P M K S H
High speed roughing (CER) in Ni alloys	A140	S

Operation symbols

Shoulder milling	Edging applications	Pocket milling	Slot milling	Plunge milling	Ramping
Face milling	Profile milling	Thread milling	Helical interpolation	Chamfering inside	Chamfering outside

CoroMill® Plura - Optimized

	Heavy duty milling			High-feed side milling				Stable multi-operations milling
O								
Material	For steel	For steel	For stainless steel	For titanium alloys	For nickel-based alloys	For steel and stainless steel	For stainless steel	For nickel-based alloys
ISO application area	P K	P K	M S	S	S	P M K S	M S	S
D_c mm	6.00 - 25.00	2.00 - 25.00	6.00 - 25.00	4.00 - 32.00	4.00 - 25.00	2.00 - 25.00	2.00 - 25.00	2.00 - 16.00
D_c inch	.250 - .750	.125 - .750	.250 - 750	.188 - 1.250	-	.250 - 1.000	–	
APMX/DC	2.10 - 2.50	2.10 - 2.50	2.10 - 2.50	2.10 - 2.50	2.10 - 2.50	1.80 - 4.00	1.80 - 3.50	1.90 - 2.40
ZEFP	5	4	4	4, 5, 6	4, 5	4	4	3, 4
RE mm	0.50 - 2.00	0.20 - 2.00	0.50 - 6.35	0.50 - 4.00	0.50 - 6.35	-	0.50 - 4.00	0.20 - 2.00
RE inch	.015 - .060	.015 - .060	.015 - .190	.030 - .120	-	-	-	-
CHW mm	0.10 - 0.25	-	0.10 - 0.25	-	-	0.15 - 0.20	0.15 - 0.20	0.10
CHW inch	.004 - .010	–	.004 - .010	–	–	.004 - .010	–	
Shank	Cylindrical	Cylindrical	Cylindrical	Cylindrical Weldon iLock	Cylindrical Weldon iLock	Cylindrical Weldon	Cylindrical	Cylindrical Weldon
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANTDIN 6527 L	DIN 6527 L	DIN 6527 L
Grade	1730	1730	1740	1745	1710	1630, 1740	1640	1725
Internal coolant	✗	✗	✓	✓	✗	✗	✗	✓
External coolant	✓	✓	✗	✓	✓	✓	✓	✓
Page	A40-A43	A44-A47	A48-A52	A59-A62	A63-A64	A54-A56	A57-A58	A78-A80

	High feed facemilling		Hard part milling	Large chip removal		Finishing		High speed roughing
O								
Material	For steel and hardened steel with hardness ≤ 63 HRc	For stainless steel and steel with hardness ≤ 48 HRc	For hardened steel with hardness 43 ≤ HRc ≤ 63	For non-ferrous material	For non-ferrous material with silicon content > 9%	For hardened steel with hardness 43 ≤ HRc ≤ 63	For stainless steel and steel with hardness ≤ 48 HRc	For nickel-based alloys
ISO application area	P H	P M K S	P H	N	N O	P H	P M K S	S
D_c mm	4.00 - 20.00	4.00 - 20.00	2.00 - 16.00	2.00 - 20.00	1.00 - 16.00	3.00 - 20.00	3.00 - 20.00	10.00 - 12.00
D_c inch	–	–	.125 - .375	–	–	.250 - .750	.063 - .750	-
APMX/DC	2.25 - 2.75	1.00 - 2.75	1.00	1.00 - 4.10	1.00	1.80 - 4.50	1.90 - 2.80	0.75
ZEFP	4	4	2, 4	1, 2	2, 4	4, 6, 8, 10, 12, 14, 16	4, 5, 6, 8	4, 6
RE mm	0.50 - 2.00	0.50 - 2.00	0.20 - 3.00	0.15 - 2.50	-	0.50 - 2.00	–	1.50 - 6.00
RE inch	-	-	.031 - .063	-	-	-	.016 - .125	-
CHW mm	-	-	-	0.10 - 0.15	0.10 - 0.15	0.10 - 0.15	0.10 - 0.15	-
CHW inch	–	–	–	–	–	-	–	–
Shank	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical
BSG	COROMANT	COROMANT DIN 6527 L	COROMANT	COROMANT DIN 6527 L	COROMANT	COROMANT DIN 6527 L	COROMANT DIN 6527 L	COROMANT
Grade	1610	1620	1610	H10F, 1630	N20C	1610	1620	6060
Internal coolant	✗	✗	✗	✗	✗	✗	✗	✗
External coolant	✓	✓	✓	✓	✓	✓	✓	✓
Page	A66	A67-A68	A82-A84	A86-A91	A92	A100-A101	A103-A104	A140

CoroMill® Plura - Optimized

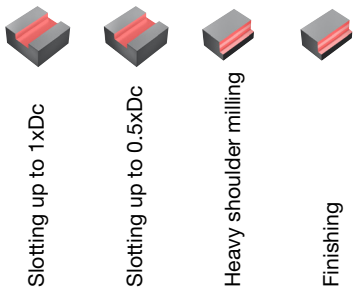
	Optimized roughing in multi-operations and difficult chip evacuation conditions					Other milling operations		
	Stable multi-operations milling		Roughing with chip breaker			Micromilling	Ball nose end mill for micromilling	
Material	For steel and hardened steel with hardness ≤ 63 HRc	For stainless steel and steel with hardness ≤ 48 HRc	For ISO S materials	For non-ferrous material	For steel with hardness ≤ 48 HRc	For multi-material with hardness ≤ 63 HRc	For multi-material with hardness ≤ 63 HRc	For hardened steel with hardness 43 ≤ HRc ≤ 63
ISO application area	P H	P M K S	M S	N	P M K S	P M K N S H	P M K N S H	H
D_c mm	2.00 - 20.00	2.00 - 25.00	6.00 - 25.00	6.00 - 25.00	6.00 - 25.00	0.40 - 1.00	0.40 - 1.00	0.20 - 2.50
D_c inch	.187 - .750	.187 - .750	–	–	–	–	–	–
APMX/DC	1.90 - 3.20	1.90 - 2.00	1.80 - 2.40	1.00 - 2.40	1.00 - 2.40	1.00	1.00	0.60 - 0.90
ZEFP	3, 4	3, 4, 5	4, 5	3	3, 4, 5, 6, 8	2	2	2
RE mm	0.50 - 4.00	0.20 - 6.35	–	–	0.35 - 4.00	–	0.20 - 0.50	0.10 - 1.25
RE inch	.016 - .063	.016 - .063	-	-	–	-	-	-
CHW mm	0.10 - 0.15	0.10 - 0.15	0.10 - 0.15	0.45 - 0.90	–	–	–	–
CHW inch	–	–	–	–	–	–	–	–
Shank	Cylindrical	Cylindrical Weldon iLock	Weldon	Cylindrical	Cylindrical Weldon	Cylindrical	Cylindrical	Cylindrical
BSG	COROMANT	COROMANT DIN 6527 L	DIN 6527 L	COROMANT DIN 6527 L	DIN 6527 K DIN 6527 L	COROMANT	COROMANT	COROMANT
Grade	1620	1620, 1630, 1640	1620	H10F	1640	1620	1620	1700
Internal coolant	✗	✓	✗	✗	✗	✗	✗	✗
External coolant	✓	✓	✓	✓	✓	✓	✓	✓
Page	A70-A71	A72-A77	A94	A95	A96-A97	A106	A108-A109	A110

	Other milling operations						Thread milling	
	Ball nose end mill for profiling					Edging applications	Internal threads	Internal and external threads
Material	For non-ferrous material	For non-ferrous material with silicon content > 9%	For steel and hardened steel with hardness ≤ 63 HRc	For hardened steel with hardness 43 ≤ HRc ≤ 63	For stainless steel and steel with hardness ≤ 48 HRc	For composite materials	Thread forms: M 60°, MF 60°, MJ 60°, UN 60°, UNC/UNF 60°, NPT 60°, NPTF 60°	Thread form: G
ISO application area	N	N O	P M K S H	P H	P M K N S H	O	P M K N S H O	P M K N S H
D_c mm	2.00 - 16.00	1.00 - 12.00	1.00 - 16.00	1.00 - 16.00	4.00 - 16.00	4.00 - 16.00	1.20 - 25.00	–
D_c inch	–	–	.063 - .500	.063 - .500	–	.250 - .625	.053 - .783	.236 - .984
APMX/DC	1.30 - 3.00	1.70 - 3.00	1.00 - 2.00	1.50 - 1.70	1.40 - 10.00	2.50 - 3.00	-	-
ZEFP	2	2	2	2, 4	2, 3, 4	5, 6, 7, 9, 11	3, 4, 5, 6	3, 4, 5
RE mm	1.00 - 8.00	0.50 - 6.00	0.50 - 8.00	0.50 - 8.00	2.00 - 8.00	–	–	–
RE inch	–	–	.031 - .250	.031 - .250	–	–	–	–
CHW mm	–	–	–	–	–	–	–	–
CHW inch	–	–	–	–	–	–	–	–
Shank	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical	Cylindrical Weldon	Weldon
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT
Grade	H10F	N20C	1610, 1620, P10	1700, 1610	1620, 1630	O10A, 1630, O12M, O10M	1630, 1620, H07F, 1610	1630
Internal coolant	✗	✗	✗	✗	✗	✗	✓	✗
External coolant	✓	✓	✓	✓	✓	✓	✓	✓
Page	A112-A113	A114	A115-A116	A118-A120	A117	A122-A126	A128-A131	A138

CoroMill® Plura - Versatile

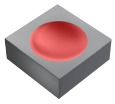
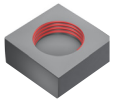
V
Versatile

First choice for versatile roughing and finishing with CoroMill® Plura



Slotting up to 1xDc	Slotting up to 0.5xDc	Heavy shoulder milling	Finishing	Tool	Page	Material
■	■			Heavy roughing (two flutes)	A12-A24	P M K S
	■	■		Heavy roughing (three flutes)	A12-A24	P M K S
	■	■	■	Medium roughing (four flutes)	A27-A28	P M K S

Operation symbols

Shoulder milling	Edging applications	Pocket milling	Slot milling	Plunge milling	Ramping
Face milling	Profile milling 	Thread milling 	Helical interpolation	Chamfering inside	Chamfering outside

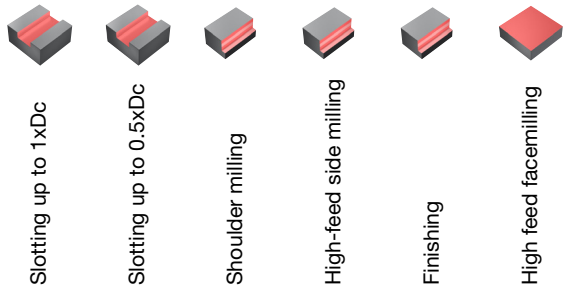
CoroMill® Plura - Versatile

	Heavy roughing	Medium roughing	Roughing with chip breaker	Ball nose mill for profiling	Chamfer milling
Material	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc
ISO application area	P M K S	P M K S	P M K S	P M K S	P M K N S H
D_c mm D_c inch	1.00 - 25.00 .125 - 1.000	2.00 - 25.00 .125 - 1.000	6.00 - 20.00 .250 - 1.000	1.00 - 20.00 .063 - .750	1.00 - 8.00 .047 - .248
APMX/DC	1.0 - 4.8	1.4 - 3.7	1.8 - 3.4	1.4 - 3.0	0.1 - 0.8
ZEFP	2, 3, 4	3, 4	4	2, 4	2, 3, 4, 5, 6
RE mm RE inch	- -	- -	- -	0.50 - 10.00 .031 - .375	- -
CHW mm CHW inch	0.00 - 0.30 .000 - .012	0.00 - 0.20 .000 - .010	0.35 - 0.63 .014 - .031	- -	- -
Shank	Cylindrical Weldon	Weldon	Cylindrical Weldon	Cylindrical	Cylindrical
BSG	DIN 6527 K DIN 6527 L COROMANT	DIN 6527 L	DIN 6527 L COROMANT	COROMANT	COROMANT
Grade	1630	1620, 1630	1640	1620, 1630	1620
Internal coolant	✗	✗	✗	✗	✗
External coolant	✓	✓	✓	✓	✓
Page	A12-A24	A26-A28	A30	A32-A34	A36-A37

CoroMill® 316

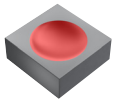
O
Optimized

First choice for roughing and finishing with CoroMill® 316



Tool	Page	Material
Heavy duty (HD) for steel and stainless steel	A143-A145	P M
Stable multi-operations (VFD)	A147-A149	P M
Large chip removal (ALU)	A158	N
High feed side milling (HFS) in titanium alloys	A151	S
Finishing (FSF)	A165-A166	P M
High feed face milling (HFF)	A153-A154	P M
High speed roughing (CER) in Ni alloys	A172	S

Operation symbols

Shoulder milling	Edging applications	Pocket milling	Slot milling	Plunge milling	Ramping
Face milling	Profile milling 	Thread milling	Helical interpolation	Chamfering inside	Chamfering outside

CoroMill® 316

	Heavy duty milling	High-feed side milling	Stable multi-operations milling	High speed roughing	High feed facemilling	High chip load milling
Material	For stainless steel and steel with hardness ≤ 48 HRc	For titanium alloys	For multi-material with hardness ≤ 48 HRc	For nickel-based alloys	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc
ISO application area	P M K S	S	P M K S	S	P M K S	P M K S
D_c mm	10.00 - 25.00	10.00 - 25.00	10.00 - 25.00	10.00 - 12.00	10.00 - 25.00	10.00 - 16.00
D_c inch	.375 - 1.000	.375 - 1.000	.375 - 1.000	-	.375 - .750	-
APMX/DC	1.20	1.50	0.52 - 0.63	0.58 - 0.70	0.52 - 0.60	0.80 - 0.84
DCX mm	-	-	-	-	-	-
DCX inch	-	-	-	-	-	-
CHW mm	0.15 - 0.25	-	-	-	-	-
CHW inch	-	-	-	-	-	-
RE mm	0.50 - 4.00	0.50 - 4.00	0.50 - 4.00	2.00	1.50 - 3.00	0.50 - 3.00
RE inch	.015 - .250	.030 - .120	.015 - .250	-	.060 - .080	-
ZEFP	4	6	3, 4, 5	4, 6	3, 4, 5	2
KAPR	-	-	-	-	-	-
Shank	Coromant EH	Coromant EH	Coromant EH	Coromant EH	Coromant EH	Coromant EH
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT
Grade	1730	1745	1730	6060	1730	1730
Internal coolant	✗	✗	✓	✗	✓	✗
External coolant	✓	✓	✓	✓	✓	✓
Page	A143-A145	A151	A147-A149	A172	A153-A154	A156

	Large chip removal	Roughing with chip breaker	Profiling	Finishing	Chamfer milling
Material	For non-ferrous material	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc	For multi-material with hardness ≤ 48 HRc
ISO application area	N	P M K S	P M K S	P M K S	P M K S
D_c mm	10.00 - 25.00	10.00 - 25.00	10.00 - 25.00	10.00 - 25.00	1.50 - 8.00
D_c inch	-	.375 - 1.000	.375 - 1.000	.375 - 1.000	.059 - .276
APMX/DC	0.52 - 0.55	0.52 - 0.56	0.52 - 0.56	0.52 - 0.56	0.52 - 0.56
DCX mm	-	-	-	-	10.00 - 25.00
DCX inch	-	-	-	-	.375 - .750
CHW mm	0.10 - 0.15	-	-	0.10 - 0.15	-
CHW inch	-	-	-	-	-
RE mm	1.00 - 4.00	0.40	5.00 - 12.50	1.00 - 1.50	-
RE inch	-	.016 - .062	.187 - .500	.015 - .062	-
ZEFP	3	4, 5, 6, 8	2, 4	6, 8, 10, 12	2, 4, 6, 8
KAPR	-	-	-	-	15°, 30°, 45°, 49°,60°
Shank	Coromant EH	Coromant EH	Coromant EH	Coromant EH	Coromant EH
BSG	COROMANT	COROMANT	COROMANT	COROMANT	COROMANT
Grade	H10F	1730	1730	1730	1730
Internal coolant	✗	✗	✗	✗	✗
External coolant	✓	✓	✓	✓	✓
Page	A158	A160	A162-A163	A165-A166	A168-A170

CoroMill® Plura - Versatile

High performance end mills with high flexibility and cost efficiency

Versatile tools designed for high performance and secure machining in a variety of materials, applications, component sizes and shapes, allowing maximum machine utilization.

V C

Application

- Heavy roughing
- Medium roughing
- Roughing with chip breaker
- Profiling
- Chamfer milling

ISO application area:

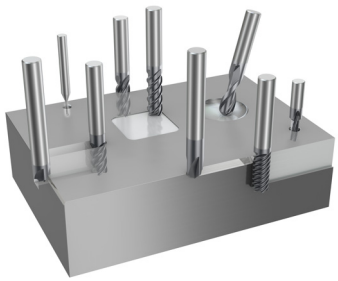
P M K N S H

For the highest machine utilization in various components and for variable production, you need tools with the highest precision, robustness, and versatility. When precision, stability, and cost-efficient machining is paramount, a CoroMill® Plura versatile end mill is your first choice.

www.sandvik.coromant.com/coromillplura

Product range

- Selected high-quality grades for all materials and conditions
- Robust geometries designed to adapt in different milling applications
- Cylindrical and Weldon shank options
- Straight, with and without chip-dividing cutting edge tool shapes
- Ball nose tools and chamfering tools
- Can be reconditioned up to three times to its original specifications



E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for heavy roughing

When to use

Two flutes or three flutes

Key slot

Flutes designed for large chip space

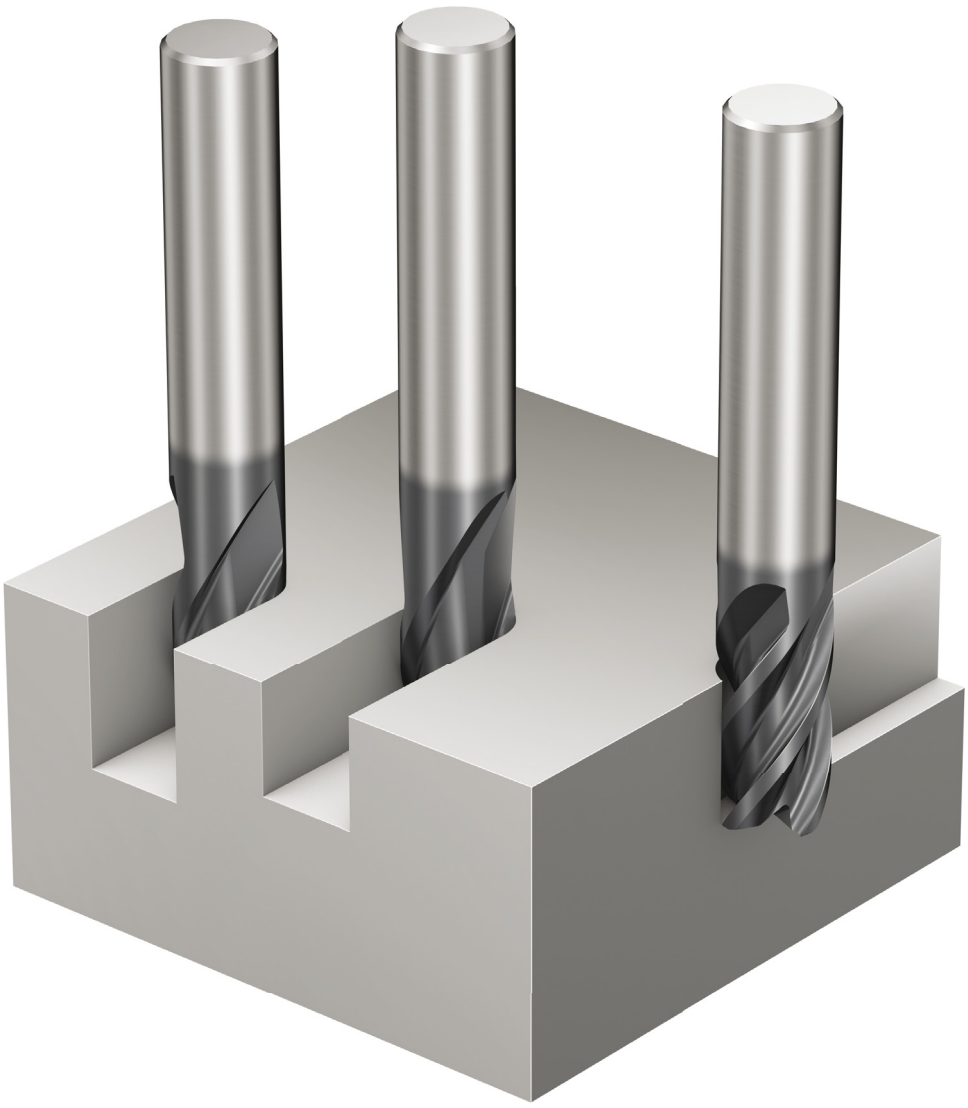
Reliefs designed for stability

Four flutes

More stability thanks to a larger core

Optimal for shoulder milling

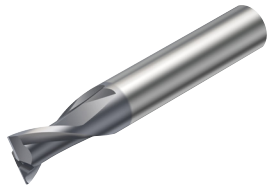
ISO material	P	M	K	N	S
Grade	1630	1620			
Shank	Cylindrical	Weldon			

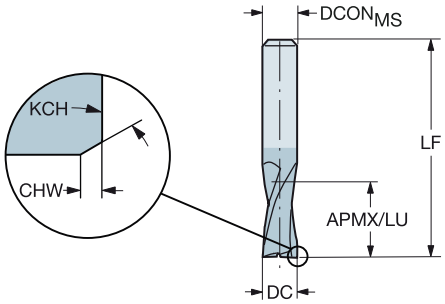


CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

FHA 30°
BSG DIN 6527 K
TCDCON h6





Metric version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCONMS	LF
1.0	3	3.5			3.5	2	1P220-0100-XA	★	★	★	★	3.0	38.0
1.5	3	3.5			3.5	2	1P220-0150-XA	★	★	★	★	3.0	38.0
1.8	6	3.5			3.5	2	1P220-0180-XA	★	★	★	★	6.0	50.0
2.0	6	3.5			3.5	2	1P220-0200-XA	★	★	★	★	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	2	1P220-0250-XA	★	★	★	★	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	2	1P220-0280-XA	★	★	★	★	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	2	1P220-0300-XA	★	★	★	★	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	2	1P220-0350-XA	★	★	★	★	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	2	1P220-0380-XA	★	★	★	★	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	2	1P220-0400-XA	★	★	★	★	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	2	1P220-0450-XA	★	★	★	★	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	2	1P220-0480-XA	★	★	★	★	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	2	1P220-0500-XA	★	★	★	★	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	2	1P220-0575-XA	★	★	★	★	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	2	1P220-0600-XA	★	★	★	★	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	2	1P220-0675-XA	★	★	★	★	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	2	1P220-0700-XA	★	★	★	★	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	2	1P220-0775-XA	★	★	★	★	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	2	1P220-0800-XA	★	★	★	★	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	2	1P220-0900-XA	★	★	★	★	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	2	1P220-0970-XA	★	★	★	★	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	2	1P220-1000-XA	★	★	★	★	10.0	66.0
12.0	12	12.5	0.20	45°	12.5	2	1P220-1200-XA	★	★	★	★	12.0	73.0
14.0	14	14.5	0.20	45°	14.5	2	1P220-1400-XA	★	★	★	★	14.0	75.0
16.0	16	16.5	0.20	45°	16.5	2	1P220-1600-XA	★	★	★	★	16.0	82.0
18.0	18	18.5	0.20	45°	18.5	2	1P220-1800-XA	★	★	★	★	18.0	84.0
20.0	20	20.5	0.30	45°	20.5	2	1P220-2000-XA	★	★	★	★	20.0	92.0

Inch version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, inch DCONMS	LF
.125	1/8	.172	.003	45°	.172	2	1P220-0318-XA	★	★	★	★	.125	1.500
.188	3/16	.250	.005	45°	.250	2	1P220-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.313	.005	45°	.313	2	1P220-0635-XA	★	★	★	★	.250	2.000
.375	3/8	.469	.008	45°	.469	2	1P220-0953-XA	★	★	★	★	.375	2.500
.500	1/2	.625	.008	45°	.625	2	1P220-1270-XA	★	★	★	★	.500	3.000
.625	5/8	.750	.008	45°	.750	2	1P220-1588-XA	★	★	★	★	.625	3.000
.750	3/4	1.000	.012	45°	1.000	2	1P220-1905-XA	★	★	★	★	.750	4.000
1.000	1	1.250	.012	45°	1.250	2	1P220-2540-XA	★	★	★	★	1.000	4.000

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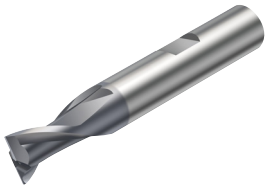
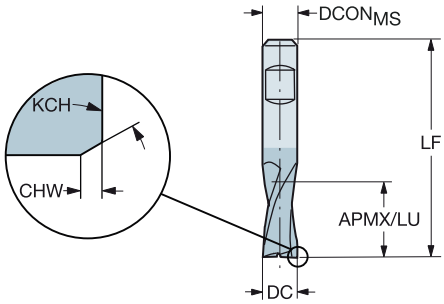
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	DIN 6527 K
TCDCON	h6





Metric version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCONMS	LF
1.8	6	3.5			3.5	2	1P220-0180-XB	★	★	★	★	6.0	50.0
2.0	6	3.5			3.5	2	1P220-0200-XB	★	★	★	★	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	2	1P220-0250-XB	★	★	★	★	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	2	1P220-0280-XB	★	★	★	★	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	2	1P220-0300-XB	★	★	★	★	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	2	1P220-0350-XB	★	★	★	★	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	2	1P220-0380-XB	★	★	★	★	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	2	1P220-0400-XB	★	★	★	★	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	2	1P220-0480-XB	★	★	★	★	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	2	1P220-0500-XB	★	★	★	★	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	2	1P220-0575-XB	★	★	★	★	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	2	1P220-0600-XB	★	★	★	★	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	2	1P220-0675-XB	★	★	★	★	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	2	1P220-0700-XB	★	★	★	★	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	2	1P220-0775-XB	★	★	★	★	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	2	1P220-0800-XB	★	★	★	★	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	2	1P220-0900-XB	★	★	★	★	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	2	1P220-0970-XB	★	★	★	★	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	2	1P220-1000-XB	★	★	★	★	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	2	1P220-1170-XB	★	★	★	★	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	2	1P220-1200-XB	★	★	★	★	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	2	1P220-1370-XB	★	★	★	★	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	2	1P220-1400-XB	★	★	★	★	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	2	1P220-1570-XB	★	★	★	★	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	2	1P220-1600-XB	★	★	★	★	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	2	1P220-1770-XB	★	★	★	★	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	2	1P220-1800-XB	★	★	★	★	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	2	1P220-1970-XB	★	★	★	★	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	2	1P220-2000-XB	★	★	★	★	20.0	92.0

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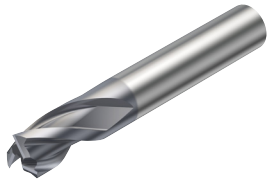
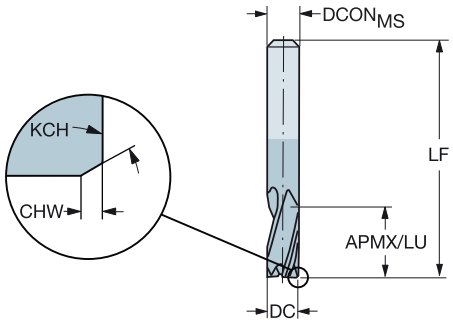
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	DIN 6527 K
TCDC	e8
TCDCON	h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
1.0	3	3.5			3.5	3	1P221-0100-XA	★	★	★	★	3.0	38.0
1.5	3	3.5			3.5	3	1P221-0150-XA	★	★	★	★	3.0	38.0
1.8	6	3.5			3.5	3	1P221-0180-XA	★	★	★	★	6.0	50.0
2.0	6	3.5			3.5	3	1P221-0200-XA	★	★	★	★	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	3	1P221-0250-XA	★	★	★	★	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	3	1P221-0280-XA	★	★	★	★	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	3	1P221-0300-XA	★	★	★	★	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	3	1P221-0350-XA	★	★	★	★	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	3	1P221-0380-XA	★	★	★	★	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	3	1P221-0400-XA	★	★	★	★	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	3	1P221-0450-XA	★	★	★	★	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	3	1P221-0480-XA	★	★	★	★	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	3	1P221-0500-XA	★	★	★	★	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	3	1P221-0575-XA	★	★	★	★	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	3	1P221-0600-XA	★	★	★	★	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	3	1P221-0675-XA	★	★	★	★	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	3	1P221-0700-XA	★	★	★	★	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	3	1P221-0775-XA	★	★	★	★	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	3	1P221-0800-XA	★	★	★	★	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	3	1P221-0900-XA	★	★	★	★	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	3	1P221-0970-XA	★	★	★	★	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	3	1P221-1000-XA	★	★	★	★	10.0	66.0
12.0	12	12.5	0.20	45°	12.5	3	1P221-1200-XA	★	★	★	★	12.0	73.0
14.0	14	14.5	0.20	45°	14.5	3	1P221-1400-XA	★	★	★	★	14.0	75.0
16.0	16	16.5	0.20	45°	16.5	3	1P221-1600-XA	★	★	★	★	16.0	82.0
18.0	18	18.5	0.20	45°	18.5	3	1P221-1800-XA	★	★	★	★	18.0	84.0
20.0	20	20.5	0.30	45°	20.5	3	1P221-2000-XA	★	★	★	★	20.0	92.0

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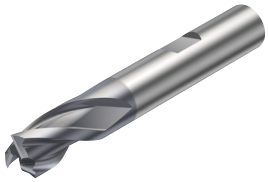
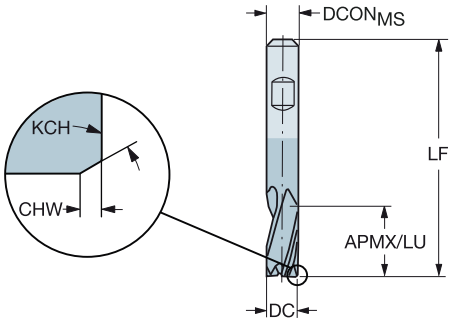
SANDVIK Coromant

CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	DIN 6527 K
TCDC	e8
TCDCON	h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
1.8	6	3.5			3.5	3	1P221-0180-XB	★	★	★	★	6.0	50.0
2.0	6	3.5			3.5	3	1P221-0200-XB	★	★	★	★	6.0	50.0
2.5	6	3.5	0.08	45°	3.5	3	1P221-0250-XB	★	★	★	★	6.0	50.0
2.8	6	4.5	0.08	45°	4.5	3	1P221-0280-XB	★	★	★	★	6.0	50.0
3.0	6	4.5	0.08	45°	4.5	3	1P221-0300-XB	★	★	★	★	6.0	50.0
3.5	6	4.5	0.08	45°	4.5	3	1P221-0350-XB	★	★	★	★	6.0	50.0
3.8	6	5.5	0.08	45°	5.5	3	1P221-0380-XB	★	★	★	★	6.0	54.0
4.0	6	5.5	0.13	45°	5.5	3	1P221-0400-XB	★	★	★	★	6.0	54.0
4.5	6	5.5	0.13	45°	5.5	3	1P221-0450-XB	★	★	★	★	6.0	54.0
4.8	6	6.5	0.13	45°	6.5	3	1P221-0480-XB	★	★	★	★	6.0	54.0
5.0	6	6.5	0.13	45°	6.5	3	1P221-0500-XB	★	★	★	★	6.0	54.0
5.8	6	7.5	0.13	45°	7.5	3	1P221-0575-XB	★	★	★	★	6.0	54.0
6.0	6	7.5	0.13	45°	7.5	3	1P221-0600-XB	★	★	★	★	6.0	54.0
6.8	8	8.5	0.13	45°	8.5	3	1P221-0675-XB	★	★	★	★	8.0	58.0
7.0	8	8.5	0.13	45°	8.5	3	1P221-0700-XB	★	★	★	★	8.0	58.0
7.8	8	9.5	0.13	45°	9.5	3	1P221-0775-XB	★	★	★	★	8.0	58.0
8.0	8	9.5	0.20	45°	9.5	3	1P221-0800-XB	★	★	★	★	8.0	58.0
9.0	10	10.5	0.20	45°	10.5	3	1P221-0900-XB	★	★	★	★	10.0	66.0
9.7	10	11.5	0.20	45°	11.5	3	1P221-0970-XB	★	★	★	★	10.0	66.0
10.0	10	11.5	0.20	45°	11.5	3	1P221-1000-XB	★	★	★	★	10.0	66.0
11.7	12	12.5	0.20	45°	12.5	3	1P221-1170-XB	★	★	★	★	12.0	73.0
12.0	12	12.5	0.20	45°	12.5	3	1P221-1200-XB	★	★	★	★	12.0	73.0
13.7	14	14.5	0.20	45°	14.5	3	1P221-1370-XB	★	★	★	★	14.0	75.0
14.0	14	14.5	0.20	45°	14.5	3	1P221-1400-XB	★	★	★	★	14.0	75.0
15.7	16	16.5	0.20	45°	16.5	3	1P221-1570-XB	★	★	★	★	16.0	82.0
16.0	16	16.5	0.20	45°	16.5	3	1P221-1600-XB	★	★	★	★	16.0	82.0
17.7	18	18.5	0.20	45°	18.5	3	1P221-1770-XB	★	★	★	★	18.0	84.0
18.0	18	18.5	0.20	45°	18.5	3	1P221-1800-XB	★	★	★	★	18.0	84.0
19.7	20	20.5	0.30	45°	20.5	3	1P221-1970-XB	★	★	★	★	20.0	92.0
20.0	20	20.5	0.30	45°	20.5	3	1P221-2000-XB	★	★	★	★	20.0	92.0

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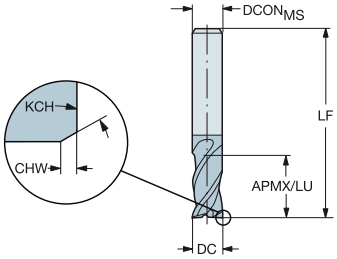
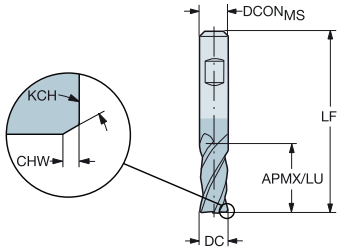
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

	1P222-XA	1P222-XB
FHA	35°	35°
BSG	DIN 6527 K	DIN 6527 K
TCDC	h10	h10
TCDCON	h6	h6





Metric version

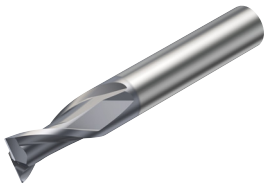
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	$DCON_{MS}$	LF
												Dimensions, mm	
2.0	6	4.5			4.5	4	1P222-0200-XB	★	★	★	★	6.0	50.0
	6	4.5			4.5	4	1P222-0200-XA	★	★	★	★	6.0	50.0
3.0	6	5.5	0.08	45°	5.0	4	1P222-0300-XB	★	★	★	★	6.0	50.0
	6	5.5	0.08	45°	5.5	4	1P222-0300-XA	★	★	★	★	6.0	50.0
4.0	6	8.5	0.13	45°	8.5	4	1P222-0400-XB	★	★	★	★	6.0	54.0
	6	8.5	0.13	45°	8.5	4	1P222-0400-XA	★	★	★	★	6.0	54.0
5.0	6	9.5	0.13	45°	9.5	4	1P222-0500-XB	★	★	★	★	6.0	54.0
	6	9.5	0.13	45°	9.5	4	1P222-0500-XA	★	★	★	★	6.0	54.0
6.0	6	10.5	0.13	45°	10.5	4	1P222-0600-XB	★	★	★	★	6.0	54.0
	6	10.5	0.13	45°	10.5	4	1P222-0600-XA	★	★	★	★	6.0	54.0
7.0	8	11.5	0.13	45°	11.5	4	1P222-0700-XA	★	★	★	★	8.0	58.0
8.0	8	12.5	0.13	45°	12.5	4	1P222-0800-XB	★	★	★	★	8.0	58.0
	8	12.5	0.13	45°	12.5	4	1P222-0800-XA	★	★	★	★	8.0	58.0
10.0	10	14.5	0.20	45°	14.5	4	1P222-1000-XB	★	★	★	★	10.0	66.0
	10	14.5	0.20	45°	14.5	4	1P222-1000-XA	★	★	★	★	10.0	66.0
12.0	12	16.5	0.20	45°	16.5	4	1P222-1200-XB	★	★	★	★	12.0	73.0
	12	16.5	0.20	45°	16.5	4	1P222-1200-XA	★	★	★	★	12.0	73.0
16.0	16	22.5	0.20	45°	22.5	4	1P222-1600-XB	★	★	★	★	16.0	82.0
	16	22.5	0.20	45°	22.5	4	1P222-1600-XA	★	★	★	★	16.0	82.0
20.0	20	26.5	0.30	45°	26.5	4	1P222-2000-XB	★	★	★	★	20.0	92.0
	20	26.5	0.30	45°	26.5	4	1P222-2000-XA	★	★	★	★	20.0	92.0
25.0	25	32.5	0.30	45°	32.5	4	1P222-2500-XA	★	★	★	★	25.0	121.0

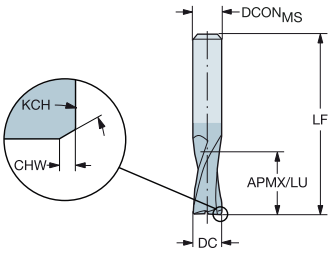
A176 A194 E9 E22 E14

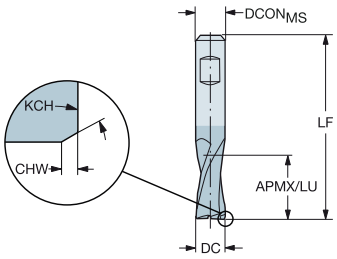
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

	1P230-XA	1P230-XB
FHA	30°	30°
BSG	DIN 6527 L	DIN 6527 L
TCDCON	h6	h6







Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
1.0	3	4.5			4.5	2	1P230-0100-XA	★	★	★	★	3.0	38.0
1.5	3	4.5			4.5	2	1P230-0150-XA	★	★	★	★	3.0	38.0
2.0	6	6.5			6.5	2	1P230-0200-XB	★	★	★	★	6.0	57.0
	6	6.5			6.5	2	1P230-0200-XA	★	★	★	★	6.0	57.0
2.5	6	7.5	0.08	45°	7.5	2	1P230-0250-XB	★	★	★	★	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0250-XA	★	★	★	★	6.0	57.0
3.0	6	7.5	0.08	45°	7.5	2	1P230-0300-XB	★	★	★	★	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0300-XA	★	★	★	★	6.0	57.0
3.5	6	7.5	0.08	45°	7.5	2	1P230-0350-XB	★	★	★	★	6.0	57.0
	6	7.5	0.08	45°	7.5	2	1P230-0350-XA	★	★	★	★	6.0	57.0
4.0	6	8.5	0.13	45°	8.5	2	1P230-0400-XB	★	★	★	★	6.0	57.0
	6	8.5	0.13	45°	8.5	2	1P230-0400-XA	★	★	★	★	6.0	57.0
4.5	6	8.5	0.13	45°	8.5	2	1P230-0450-XB	★	★	★	★	6.0	57.0
	6	8.5	0.13	45°	8.5	2	1P230-0450-XA	★	★	★	★	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	2	1P230-0500-XB	★	★	★	★	6.0	57.0
	6	10.5	0.13	45°	10.5	2	1P230-0500-XA	★	★	★	★	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	2	1P230-0600-XB	★	★	★	★	6.0	57.0
	6	10.5	0.13	45°	10.5	2	1P230-0600-XA	★	★	★	★	6.0	57.0
7.0	8	13.5	0.13	45°	13.5	2	1P230-0700-XB	★	★	★	★	8.0	63.0
	8	13.5	0.20	45°	13.5	2	1P230-0700-XA	★	★	★	★	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	2	1P230-0800-XB	★	★	★	★	8.0	63.0
	8	16.5	0.20	45°	16.5	2	1P230-0800-XA	★	★	★	★	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	2	1P230-0900-XB	★	★	★	★	10.0	72.0
	10	16.5	0.20	45°	16.5	2	1P230-0900-XA	★	★	★	★	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	2	1P230-1000-XB	★	★	★	★	10.0	72.0
	10	19.5	0.20	45°	19.5	2	1P230-1000-XA	★	★	★	★	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	2	1P230-1100-XB	★	★	★	★	12.0	83.0
	12	22.5	0.20	45°	22.5	2	1P230-1100-XA	★	★	★	★	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	2	1P230-1200-XB	★	★	★	★	12.0	83.0
	12	22.5	0.20	45°	22.5	2	1P230-1200-XA	★	★	★	★	12.0	83.0
14.0	14	22.5	0.20	45°	22.5	2	1P230-1400-XB	★	★	★	★	14.0	83.0
	14	22.5	0.20	45°	22.5	2	1P230-1400-XA	★	★	★	★	14.0	83.0
16.0	16	26.5	0.20	45°	26.5	2	1P230-1600-XB	★	★	★	★	16.0	92.0
	16	26.5	0.20	45°	26.5	2	1P230-1600-XA	★	★	★	★	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	2	1P230-1800-XB	★	★	★	★	18.0	92.0
	18	26.5	0.20	45°	26.5	2	1P230-1800-XA	★	★	★	★	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	2	1P230-2000-XB	★	★	★	★	20.0	104.0
	20	32.5	0.30	45°	32.5	2	1P230-2000-XA	★	★	★	★	20.0	104.0

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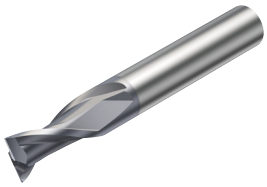
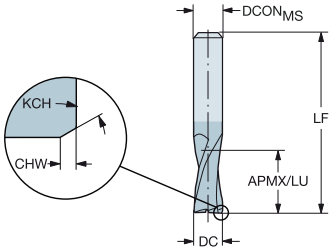
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	DIN 6527 L
TCDCON	h6





Inch version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, inch $DCON_{MS}$	LF
.125	1/8	.313	.003	45°	.313	2	1P230-0318-XA	★	★	★	★	.125	1.500
.188	3/16	.406	.005	45°	.406	2	1P230-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.453	.005	45°	.453	2	1P230-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.687	.008	45°	.687	2	1P230-0953-XA	★	★	★	★	.375	2.500
.500	1/2	.937	.008	45°	.937	2	1P230-1270-XA	★	★	★	★	.500	3.000
.625	5/8	1.125	.008	45°	1.125	2	1P230-1588-XA	★	★	★	★	.625	3.500
.750	3/4	1.219	.012	45°	1.219	2	1P230-1905-XA	★	★	★	★	.750	4.000
1.000	1	1.625	.012	45°	1.625	2	1P230-2540-XA	★	★	★	★	1.000	5.000

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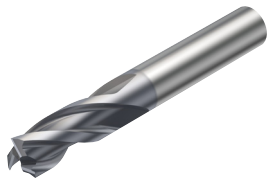
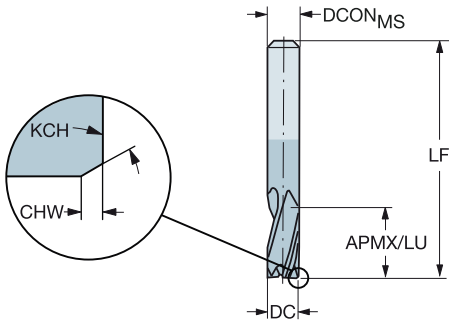
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	DIN 6527 L
TCDCON	h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
1.0	3	4.5			4.5	3	1P231-0100-XA	★	★	★	★	3.0	38.0
1.5	3	4.5			4.5	3	1P231-0150-XA	★	★	★	★	3.0	38.0
2.0	6	6.5			6.5	3	1P231-0200-XA	★	★	★	★	6.0	57.0
2.5	6	7.5	0.08	45°	7.5	3	1P231-0250-XA	★	★	★	★	6.0	57.0
3.0	6	7.5	0.08	45°	7.5	3	1P231-0300-XA	★	★	★	★	6.0	57.0
3.5	6	7.5	0.08	45°	7.5	3	1P231-0350-XA	★	★	★	★	6.0	57.0
4.0	6	8.5	0.13	45°	8.5	3	1P231-0400-XA	★	★	★	★	6.0	57.0
4.5	6	8.5	0.13	45°	8.5	3	1P231-0450-XA	★	★	★	★	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	3	1P231-0500-XA	★	★	★	★	6.0	57.0
5.5	6	10.5	0.13	45°	10.5	3	1P231-0550-XA	★	★	★	★	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	3	1P231-0600-XA	★	★	★	★	6.0	57.0
6.5	8	13.5	0.13	45°	13.5	3	1P231-0650-XA	★	★	★	★	8.0	63.0
7.0	8	13.5	0.13	45°	13.5	3	1P231-0700-XA	★	★	★	★	8.0	63.0
7.5	8	16.5	0.13	45°	16.5	3	1P231-0750-XA	★	★	★	★	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	3	1P231-0800-XA	★	★	★	★	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	3	1P231-0900-XA	★	★	★	★	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	3	1P231-1000-XA	★	★	★	★	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	3	1P231-1100-XA	★	★	★	★	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	3	1P231-1200-XA	★	★	★	★	12.0	83.0
13.0	14	22.5	0.20	45°	22.5	3	1P231-1300-XA	★	★	★	★	14.0	83.0
14.0	14	22.5	0.20	45°	22.5	3	1P231-1400-XA	★	★	★	★	14.0	83.0
15.0	16	26.5	0.20	45°	26.5	3	1P231-1500-XA	★	★	★	★	16.0	92.0
16.0	16	26.5	0.20	45°	26.5	3	1P231-1600-XA	★	★	★	★	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	3	1P231-1800-XA	★	★	★	★	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	3	1P231-2000-XA	★	★	★	★	20.0	104.0

Inch version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, inch DCON$_{MS}$	LF
.125	1/8	.313	.003	45°	.313	3	1P231-0318-XA	★	★	★	★	.125	1.500
.188	3/16	.406	.005	45°	.406	3	1P231-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.453	.005	45°	.453	3	1P231-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.687	.008	45°	.687	3	1P231-0953-XA	★	★	★	★	.375	2.500
.500	1/2	.937	.008	45°	.937	3	1P231-1270-XA	★	★	★	★	.500	3.000
.625	5/8	1.125	.008	45°	1.125	3	1P231-1588-XA	★	★	★	★	.625	3.500
.750	3/4	1.219	.012	45°	1.219	3	1P231-1905-XA	★	★	★	★	.750	4.000
1.000	1	1.625	.012	45°	1.625	3	1P231-2540-XA	★	★	★	★	1.000	5.000

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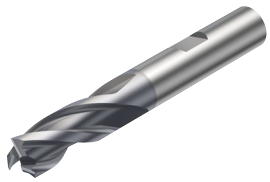
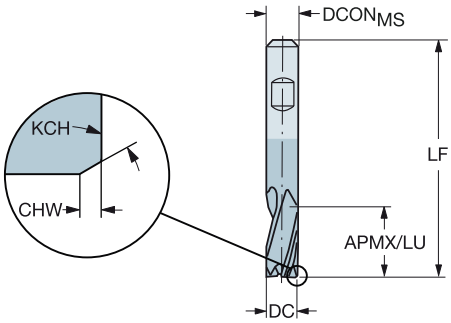
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

FHA 30°
BSG DIN 6527 L
TCDCON h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
4.5	6	8.5	0.13	45°	8.5	3	1P231-0450-XB	★	★	★	★	6.0	57.0
5.0	6	10.5	0.13	45°	10.5	3	1P231-0500-XB	★	★	★	★	6.0	57.0
5.5	6	10.5	0.13	45°	10.5	3	1P231-0550-XB	★	★	★	★	6.0	57.0
6.0	6	10.5	0.13	45°	10.5	3	1P231-0600-XB	★	★	★	★	6.0	57.0
6.5	8	13.5	0.13	45°	13.5	3	1P231-0650-XB	★	★	★	★	8.0	63.0
7.0	8	13.5	0.13	45°	13.5	3	1P231-0700-XB	★	★	★	★	8.0	63.0
7.5	8	16.5	0.13	45°	16.5	3	1P231-0750-XB	★	★	★	★	8.0	63.0
8.0	8	16.5	0.20	45°	16.5	3	1P231-0800-XB	★	★	★	★	8.0	63.0
9.0	10	16.5	0.20	45°	16.5	3	1P231-0900-XB	★	★	★	★	10.0	72.0
10.0	10	19.5	0.20	45°	19.5	3	1P231-1000-XB	★	★	★	★	10.0	72.0
11.0	12	22.5	0.20	45°	22.5	3	1P231-1100-XB	★	★	★	★	12.0	83.0
12.0	12	22.5	0.20	45°	22.5	3	1P231-1200-XB	★	★	★	★	12.0	83.0
13.0	14	22.5	0.20	45°	22.5	3	1P231-1300-XB	★	★	★	★	14.0	83.0
14.0	14	22.5	0.20	45°	22.5	3	1P231-1400-XB	★	★	★	★	14.0	83.0
15.0	16	26.5	0.20	45°	26.5	3	1P231-1500-XB	★	★	★	★	16.0	92.0
16.0	16	26.5	0.20	45°	26.5	3	1P231-1600-XB	★	★	★	★	16.0	92.0
18.0	18	26.5	0.20	45°	26.5	3	1P231-1800-XB	★	★	★	★	18.0	92.0
20.0	20	32.5	0.30	45°	32.5	3	1P231-2000-XB	★	★	★	★	20.0	104.0

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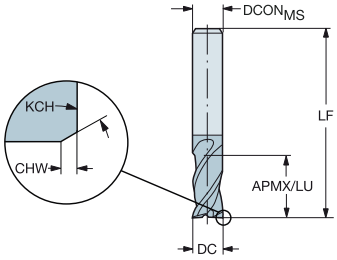
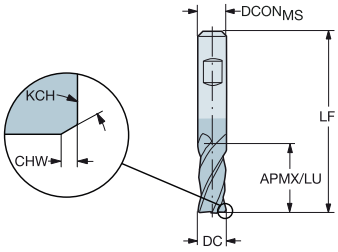
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

	1P240-XA	1P240-XB
FHA	35°	35°
BSG	DIN 6527 L	DIN 6527 L
TCDC	h10	h10
TCDCON	h6	h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
2.0	6	7.5			7.5	4	1P240-0200-XA	★	★	★	★	6.0	57.0
3.0	6	8.5	0.08	45°	8.5	4	1P240-0300-XA	★	★	★	★	6.0	57.0
3.5	6	10.5	0.08	45°	10.5	4	1P240-0350-XA	★	★	★	★	6.0	57.0
4.0	6	11.5	0.13	45°	11.5	4	1P240-0400-XB	★	★	★	★	6.0	57.0
	6	11.5	0.13	45°	11.5	4	1P240-0400-XA	★	★	★	★	6.0	57.0
4.5	6	11.5	0.13	45°	11.5	4	1P240-0450-XB	★	★	★	★	6.0	57.0
	6	11.5	0.13	45°	11.5	4	1P240-0450-XA	★	★	★	★	6.0	57.0
5.0	6	13.5	0.13	45°	13.5	4	1P240-0500-XB	★	★	★	★	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0500-XA	★	★	★	★	6.0	57.0
5.5	6	13.5	0.13	45°	13.5	4	1P240-0550-XB	★	★	★	★	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0550-XA	★	★	★	★	6.0	57.0
6.0	6	13.5	0.13	45°	13.5	4	1P240-0600-XB	★	★	★	★	6.0	57.0
	6	13.5	0.13	45°	13.5	4	1P240-0600-XA	★	★	★	★	6.0	57.0
6.5	8	16.5	0.13	45°	16.5	4	1P240-0650-XA	★	★	★	★	8.0	63.0
7.0	8	16.5	0.13	45°	16.5	4	1P240-0700-XB	★	★	★	★	8.0	63.0
	8	16.5	0.13	45°	16.5	4	1P240-0700-XA	★	★	★	★	8.0	63.0
8.0	8	19.5	0.13	45°	19.5	4	1P240-0800-XB	★	★	★	★	8.0	63.0
	8	19.5	0.13	45°	19.5	4	1P240-0800-XA	★	★	★	★	8.0	63.0
9.0	10	19.5	0.13	45°	19.5	4	1P240-0900-XA	★	★	★	★	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	4	1P240-1000-XB	★	★	★	★	10.0	72.0
	10	22.5	0.20	45°	22.5	4	1P240-1000-XA	★	★	★	★	10.0	72.0
12.0	12	26.5	0.20	45°	26.5	4	1P240-1200-XB	★	★	★	★	12.0	83.0
	12	26.5	0.20	45°	26.5	4	1P240-1200-XA	★	★	★	★	12.0	83.0
14.0	14	26.5	0.20	45°	26.5	4	1P240-1400-XB	★	★	★	★	14.0	83.0
	14	26.5	0.20	45°	26.5	4	1P240-1400-XA	★	★	★	★	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	4	1P240-1600-XB	★	★	★	★	16.0	92.0
	16	32.5	0.20	45°	32.5	4	1P240-1600-XA	★	★	★	★	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	4	1P240-1800-XB	★	★	★	★	18.0	92.0
	18	32.5	0.20	45°	32.5	4	1P240-1800-XA	★	★	★	★	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	4	1P240-2000-XB	★	★	★	★	20.0	104.0
	20	38.5	0.30	45°	38.5	4	1P240-2000-XA	★	★	★	★	20.0	104.0
25.0	25	45.5	0.30	45°	45.5	4	1P240-2500-XB	★	★	★	★	25.0	121.0
	25	45.5	0.30	45°	45.5	4	1P240-2500-XA	★	★	★	★	25.0	121.0

Inch version

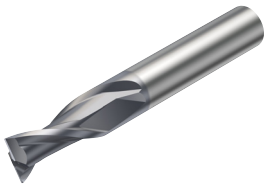
DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, inch DCON$_{MS}$	LF
.125	1/8	.359	.003	45°	.359	4	1P240-0318-XA	★	★	★	★	.125	1.500
.188	3/16	.547	.005	45°	.547	4	1P240-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.562	.005	45°	.562	4	1P240-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.844	.008	45°	.844	4	1P240-0953-XA	★	★	★	★	.375	3.000
.500	1/2	1.125	.008	45°	1.125	4	1P240-1270-XA	★	★	★	★	.500	3.500
.625	5/8	1.313	.008	45°	1.313	4	1P240-1588-XA	★	★	★	★	.625	4.000
.750	3/4	1.437	.012	45°	1.437	4	1P240-1905-XA	★	★	★	★	.750	4.000
1.000	1	1.828	.012	45°	1.828	4	1P240-2540-XA	★	★	★	★	1.000	5.000

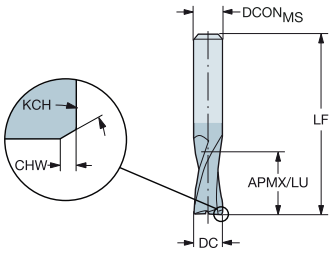
A176 A194 E9 E22 E14

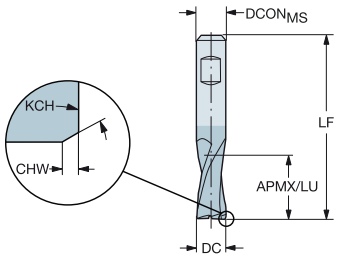
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

	1P250-XA	1P250-XB
FHA	30°	30°
BSG	COROMANT	COROMANT
TCDCON	h6	h6







Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	DCON$_{MS}$	LF
												Dimensions, mm	
2.0	6	8.5			8.5	2	1P250-0200-XA	★	★	★	★	6.0	57.0
2.5	6	12.5	0.08	45°	12.5	2	1P250-0250-XA	★	★	★	★	6.0	57.0
3.0	6	12.5	0.08	45°	12.5	2	1P250-0300-XA	★	★	★	★	6.0	57.0
4.0	6	14.5	0.13	45°	14.5	2	1P250-0400-XB	★	★	★	★	6.0	57.0
	6	14.5	0.13	45°	14.5	2	1P250-0400-XA	★	★	★	★	6.0	57.0
5.0	6	16.5	0.13	45°	16.5	2	1P250-0500-XB	★	★	★	★	6.0	57.0
	6	16.5	0.13	45°	16.5	2	1P250-0500-XA	★	★	★	★	6.0	57.0
6.0	6	19.5	0.13	45°	19.5	2	1P250-0600-XB	★	★	★	★	6.0	57.0
	6	19.5	0.13	45°	19.5	2	1P250-0600-XA	★	★	★	★	6.0	57.0
7.0	8	19.5	0.13	45°	19.5	2	1P250-0700-XA	★	★	★	★	8.0	63.0
8.0	8	19.5	0.20	45°	19.5	2	1P250-0800-XB	★	★	★	★	8.0	63.0
	8	19.5	0.20	45°	19.5	2	1P250-0800-XA	★	★	★	★	8.0	63.0
9.0	10	21.5	0.20	45°	21.5	2	1P250-0900-XB	★	★	★	★	10.0	72.0
	10	21.5	0.20	45°	21.5	2	1P250-0900-XA	★	★	★	★	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	2	1P250-1000-XB	★	★	★	★	10.0	72.0
	10	22.5	0.20	45°	22.5	2	1P250-1000-XA	★	★	★	★	10.0	72.0
12.0	12	25.5	0.20	45°	25.5	2	1P250-1200-XB	★	★	★	★	12.0	83.0
	12	25.5	0.20	45°	25.5	2	1P250-1200-XA	★	★	★	★	12.0	83.0
14.0	14	30.5	0.20	45°	30.5	2	1P250-1400-XA	★	★	★	★	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	2	1P250-1600-XB	★	★	★	★	16.0	92.0
	16	32.5	0.20	45°	32.5	2	1P250-1600-XA	★	★	★	★	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	2	1P250-1800-XB	★	★	★	★	18.0	92.0
	18	32.5	0.20	45°	32.5	2	1P250-1800-XA	★	★	★	★	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	2	1P250-2000-XB	★	★	★	★	20.0	104.0
	20	38.5	0.30	45°	38.5	2	1P250-2000-XA	★	★	★	★	20.0	104.0

Inch version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	DCON$_{MS}$	LF
												Dimensions, inch	
.125	1/8	.359	.003	45°	.359	2	1P250-0318-XA	★	★	★	★	.125	1.500
.188	3/16	.687	.005	45°	.687	2	1P250-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.813	.005	45°	.813	2	1P250-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.875	.008	45°	.875	2	1P250-0953-XA	★	★	★	★	.375	3.000
.500	1/2	1.188	.008	45°	1.188	2	1P250-1270-XA	★	★	★	★	.500	3.500
.625	5/8	1.484	.008	45°	1.484	2	1P250-1588-XA	★	★	★	★	.625	4.000
.750	3/4	1.687	.012	45°	1.687	2	1P250-1905-XA	★	★	★	★	.750	4.000
1.000	1	2.250	.012	45°	2.250	2	1P250-2540-XA	★	★	★	★	1.000	5.000

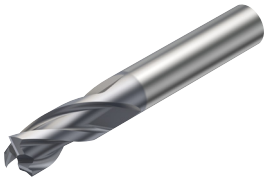
A176 A194 E9 E22 E14

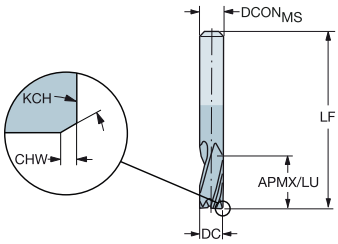
SANDVIK Coromant

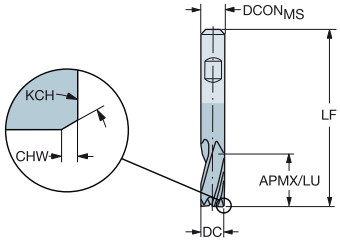
CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

	1P251-XA	1P251-XB
FHA	30°	30°
BSG	COROMANT	COROMANT
TCDCON	h6	h6







Metric version

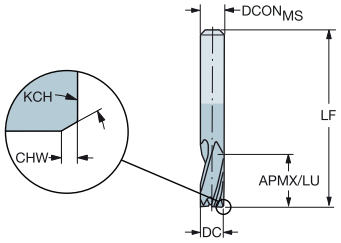
DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
2.0	6	8.5			8.5	3	1P251-0200-XA	★	★	★	★	6.0	57.0
2.5	6	12.5	0.08	45°	12.5	3	1P251-0250-XA	★	★	★	★	6.0	57.0
3.0	6	12.5	0.08	45°	12.5	3	1P251-0300-XA	★	★	★	★	6.0	57.0
4.0	6	14.5	0.13	45°	14.5	3	1P251-0400-XB	★	★	★	★	6.0	57.0
	6	14.5	0.13	45°	14.5	3	1P251-0400-XA	★	★	★	★	6.0	57.0
5.0	6	16.5	0.13	45°	16.5	3	1P251-0500-XB	★	★	★	★	6.0	57.0
	6	16.5	0.13	45°	16.5	3	1P251-0500-XA	★	★	★	★	6.0	57.0
6.0	6	19.5	0.13	45°	19.5	3	1P251-0600-XB	★	★	★	★	6.0	57.0
	6	19.5	0.13	45°	19.5	3	1P251-0600-XA	★	★	★	★	6.0	57.0
7.0	8	19.5	0.13	45°	19.5	3	1P251-0700-XA	★	★	★	★	8.0	63.0
8.0	8	19.5	0.20	45°	19.5	3	1P251-0800-XB	★	★	★	★	8.0	63.0
	8	19.5	0.20	45°	19.5	3	1P251-0800-XA	★	★	★	★	8.0	63.0
9.0	10	21.5	0.20	45°	21.5	3	1P251-0900-XA	★	★	★	★	10.0	72.0
10.0	10	22.5	0.20	45°	22.5	3	1P251-1000-XB	★	★	★	★	10.0	72.0
	10	22.5	0.20	45°	22.5	3	1P251-1000-XA	★	★	★	★	10.0	72.0
12.0	12	25.5	0.20	45°	25.5	3	1P251-1200-XB	★	★	★	★	12.0	83.0
	12	25.5	0.20	45°	25.5	3	1P251-1200-XA	★	★	★	★	12.0	83.0
14.0	14	30.5	0.20	45°	30.5	3	1P251-1400-XA	★	★	★	★	14.0	83.0
16.0	16	32.5	0.20	45°	32.5	3	1P251-1600-XB	★	★	★	★	16.0	92.0
	16	32.5	0.20	45°	32.5	3	1P251-1600-XA	★	★	★	★	16.0	92.0
18.0	18	32.5	0.20	45°	32.5	3	1P251-1800-XB	★	★	★	★	18.0	92.0
	18	32.5	0.20	45°	32.5	3	1P251-1800-XA	★	★	★	★	18.0	92.0
20.0	20	38.5	0.30	45°	38.5	3	1P251-2000-XB	★	★	★	★	20.0	104.0
	20	38.5	0.30	45°	38.5	3	1P251-2000-XA	★	★	★	★	20.0	104.0

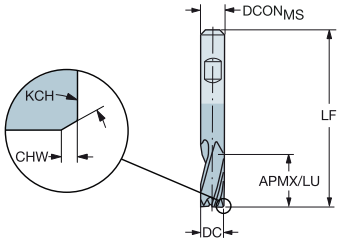
A176 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for heavy roughing

For multi-material with hardness ≤ 48 HRc

	1P260-XA	1P260-XB
FHA	30°	30°
BSG	COROMANT	COROMANT
TCDC	h10	h10
TCDCON	h6	h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm DCON$_{MS}$	LF
1.0	3	4.0			4.0	3	1P260-0100-XA	★	★	★	★	3.0	38.0
1.5	3	6.0			6.0	3	1P260-0150-XA	★	★	★	★	3.0	38.0
2.0	3	8.0			8.0	3	1P260-0200-XA	★	★	★	★	3.0	38.0
3.0	3	12.0			12.0	3	1P260-0300-XA	★	★	★	★	3.0	38.0
4.0	4	14.0			14.0	3	1P260-0400-XA	★	★	★	★	4.0	50.0
5.0	6	16.0			16.0	3	1P260-0500-XB	★	★	★	★	6.0	57.0
	6	16.0			16.0	3	1P260-0500-XA	★	★	★	★	6.0	57.0
6.0	6	22.0			22.0	3	1P260-0600-XB	★	★	★	★	6.0	65.0
	6	22.0			22.0	3	1P260-0600-XA	★	★	★	★	6.0	65.0
8.0	8	28.0			28.0	3	1P260-0800-XB	★	★	★	★	8.0	80.0
	8	28.0			28.0	3	1P260-0800-XA	★	★	★	★	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	3	1P260-1000-XB	★	★	★	★	10.0	100.0
	10	32.0	0.10	45°	32.0	3	1P260-1000-XA	★	★	★	★	10.0	100.0
12.0	12	38.0	0.10	45°	38.0	3	1P260-1200-XB	★	★	★	★	12.0	100.0
	12	38.0	0.10	45°	38.0	3	1P260-1200-XA	★	★	★	★	12.0	100.0
16.0	16	50.0	0.15	45°	50.0	3	1P260-1600-XB	★	★	★	★	16.0	115.0
	16	50.0	0.15	45°	50.0	3	1P260-1600-XA	★	★	★	★	16.0	115.0
20.0	20	50.0	0.15	45°	50.0	3	1P260-2000-XB	★	★	★	★	20.0	125.0
	20	50.0	0.15	45°	50.0	3	1P260-2000-XA	★	★	★	★	20.0	125.0

Inch version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, inch DCON$_{MS}$	LF
.125	1/8	.500			.500	3	1P260-0318-XA	★	★	★	★	.125	2.000
.188	3/16	.625			.625	3	1P260-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.937			.937	3	1P260-0635-XA	★	★	★	★	.250	2.500
.375	3/8	1.219	.004	45°	1.219	3	1P260-0953-XA	★	★	★	★	.375	3.000
.500	1/2	1.594	.004	45°	1.594	3	1P260-1270-XA	★	★	★	★	.500	3.500
.625	5/8	1.938	.006	45°	1.938	3	1P260-1588-XA	★	★	★	★	.625	4.000
.750	3/4	2.313	.006	45°	2.313	3	1P260-1905-XA	★	★	★	★	.750	5.000
1.000	1	2.500	.010	45°	2.500	3	1P260-2540-XA	★	★	★	★	1.000	6.000

A176 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for medium roughing

When to use

When a smooth cut is needed

For soft materials, with an optimized sharp geometry

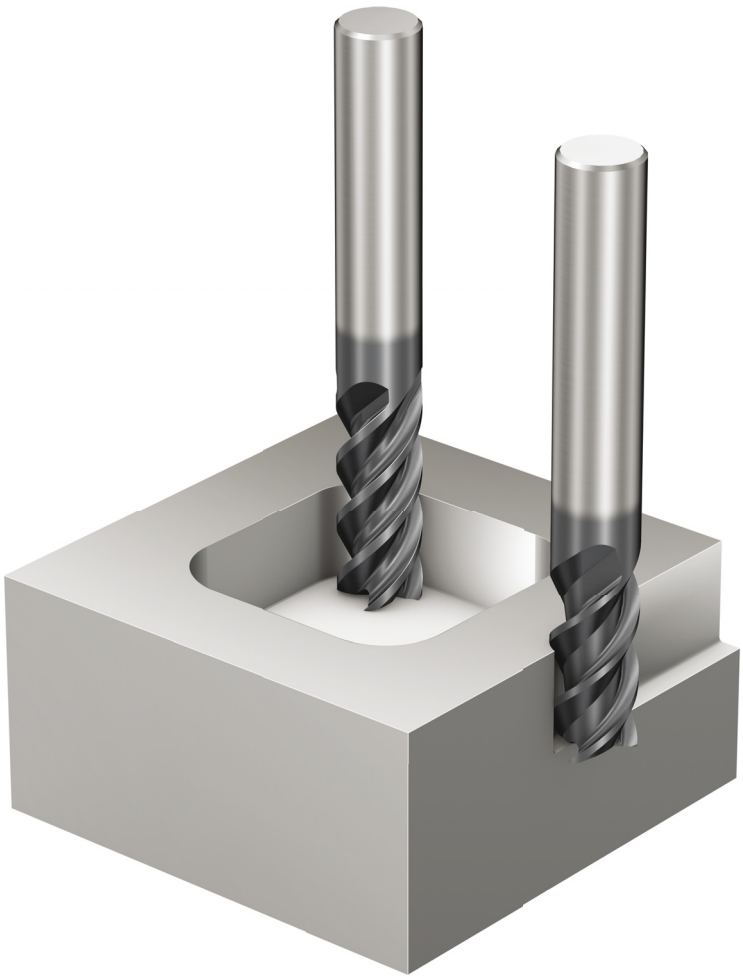
Problem solver for ramping operations

4 flutes - Good for finishing operations

ISO material	P	M	K	S
Grade	1620	1630		
Shank	Weldon		Cylindrical	

Product range

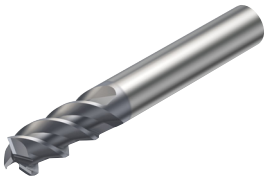
For multi-material with hardness ≤ 48 HRc

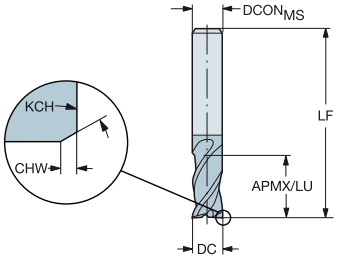


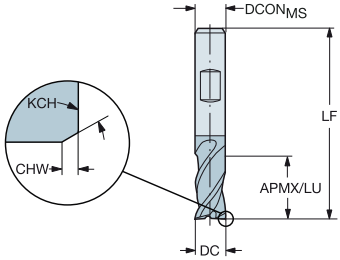
CoroMill® Plura solid carbide end mill for medium roughing

For multi-material with hardness ≤ 48 HRc

	1P330-XA	1P330-XB
FHA	45°	45°
BSG	DIN 6527 L	DIN 6527 L
TCDC	h10	h10
TCDCON	h6	h6







Metric version

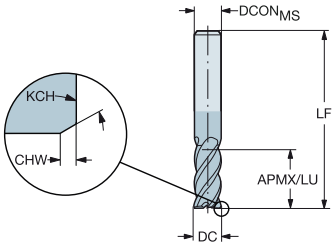
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm $DCON_{MS}$	LF
2.0	6	6.0			6.0	3	1P330-0200-XB	★	★	★	★	6.0	57.0
	6	6.0			6.0	3	1P330-0200-XA	★	★	★	★	6.0	57.0
3.0	6	7.0			7.0	3	1P330-0300-XB	★	★	★	★	6.0	57.0
	6	7.0			7.0	3	1P330-0300-XA	★	★	★	★	6.0	57.0
4.0	6	8.0	0.10	45°	8.0	3	1P330-0400-XB	★	★	★	★	6.0	57.0
	6	8.0	0.10	45°	8.0	3	1P330-0400-XA	★	★	★	★	6.0	57.0
5.0	6	10.0	0.10	45°	10.0	3	1P330-0500-XB	★	★	★	★	6.0	57.0
	6	10.0	0.10	45°	10.0	3	1P330-0500-XA	★	★	★	★	6.0	57.0
6.0	6	10.0	0.10	45°	10.0	3	1P330-0600-XB	★	★	★	★	6.0	57.0
	6	10.0	0.10	45°	10.0	3	1P330-0600-XA	★	★	★	★	6.0	57.0
7.0	8	13.0	0.10	45°	13.0	3	1P330-0700-XA	★	★	★	★	8.0	63.0
8.0	8	16.0	0.10	45°	16.0	3	1P330-0800-XB	★	★	★	★	8.0	63.0
	8	16.0	0.10	45°	16.0	3	1P330-0800-XA	★	★	★	★	8.0	63.0
9.0	10	16.0	0.10	45°	16.0	3	1P330-0900-XB	★	★	★	★	10.0	72.0
	10	16.0	0.10	45°	16.0	3	1P330-0900-XA	★	★	★	★	10.0	72.0
10.0	10	19.0	0.10	45°	19.0	3	1P330-1000-XB	★	★	★	★	10.0	72.0
	10	19.0	0.10	45°	19.0	3	1P330-1000-XA	★	★	★	★	10.0	72.0
12.0	12	22.0	0.10	45°	22.0	3	1P330-1200-XB	★	★	★	★	12.0	83.0
	12	22.0	0.10	45°	22.0	3	1P330-1200-XA	★	★	★	★	12.0	83.0
14.0	14	22.0	0.15	45°	22.0	3	1P330-1400-XB	★	★	★	★	14.0	83.0
	14	22.0	0.15	45°	22.0	3	1P330-1400-XA	★	★	★	★	14.0	83.0
16.0	16	26.0	0.15	45°	26.0	3	1P330-1600-XB	★	★	★	★	16.0	92.0
	16	26.0	0.15	45°	26.0	3	1P330-1600-XA	★	★	★	★	16.0	92.0
18.0	18	26.0	0.15	45°	26.0	3	1P330-1800-XB	★	★	★	★	18.0	92.0
	18	26.0	0.15	45°	26.0	3	1P330-1800-XA	★	★	★	★	18.0	92.0
20.0	20	32.0	0.15	45°	32.0	3	1P330-2000-XB	★	★	★	★	20.0	104.0
	20	32.0	0.15	45°	32.0	3	1P330-2000-XA	★	★	★	★	20.0	104.0

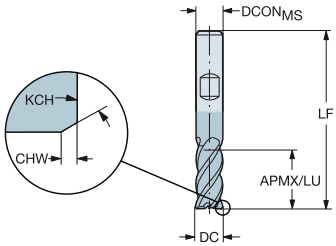
A176 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for medium roughing

For multi-material with hardness ≤ 48 HRc

	1P341-XA	1P341-XB
FHA	45°	45°
BSG	DIN 6527 L	DIN 6527 L
TCDC	h10	h10
TCDCON	h6	h6





Metric version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	P 1630	M 1620	M 1630	K 1620	K 1630	S 1620	S 1630	$DCON_{MS}$	LF
2.0	6	7.0			7.0	4	1P341-0200-XA	★	★	★	★	★	★	★	★	6.0	57.0
3.0	6	8.0			8.0	4	1P341-0300-XA	★	★	★	★	★	★	★	★	6.0	57.0
4.0	6	11.0	0.10	45°	11.0	4	1P341-0400-XA	★	★	★	★	★	★	★	★	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	4	1P341-0500-XA	★	★	★	★	★	★	★	★	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	4	1P341-0600-XB		★		★		★		★	6.0	57.0
	6	13.0	0.10	45°	13.0	4	1P341-0600-XA	★	★	★	★	★	★	★	★	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	4	1P341-0800-XB		★		★		★		★	8.0	63.0
	8	19.0	0.10	45°	19.0	4	1P341-0800-XA	★	★	★	★	★	★	★	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	4	1P341-1000-XB		★		★		★		★	10.0	72.0
	10	22.0	0.10	45°	22.0	4	1P341-1000-XA	★	★	★	★	★	★	★	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	4	1P341-1200-XB		★		★		★		★	12.0	83.0
	12	26.0	0.10	45°	26.0	4	1P341-1200-XA	★	★	★	★	★	★	★	★	12.0	83.0
14.0	14	26.0	0.15	45°	26.0	4	1P341-1400-XB		★		★		★		★	14.0	83.0
	14	26.0	0.15	45°	26.0	4	1P341-1400-XA	★	★	★	★	★	★	★	★	14.0	83.0
16.0	16	32.0	0.15	45°	32.0	4	1P341-1600-XB		★		★		★		★	16.0	92.0
	16	32.0	0.15	45°	32.0	4	1P341-1600-XA	★	★	★	★	★	★	★	★	16.0	92.0
18.0	18	32.0	0.15	45°	32.0	5	1P341-1800-XA	★	★	★	★	★	★	★	★	18.0	92.0
20.0	20	38.0	0.15	45°	38.0	5	1P341-2000-XB		★		★		★		★	20.0	104.0
	20	38.0	0.15	45°	38.0	5	1P341-2000-XA	★	★	★	★	★	★	★	★	20.0	104.0

Inch version

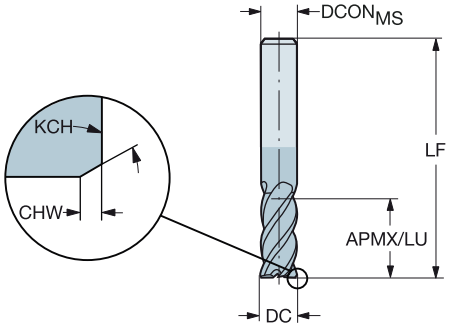
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	$DCON_{MS}$	LF
.125	1/8	.313			.313	4	1P341-0318-XA	★	★	★	★	.125	1.500
.188	3/16	.469	.004	45°	.469	4	1P341-0476-XA	★	★	★	★	.188	2.000
.250	1/4	.531	.004	45°	.531	4	1P341-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.844	.006	45°	.844	4	1P341-0953-XA	★	★	★	★	.375	3.000
.500	1/2	1.094	.006	45°	1.094	4	1P341-1270-XA	★	★	★	★	.500	3.500
.625	5/8	1.313	.010	45°	1.313	5	1P341-1588-XA	★	★	★	★	.625	4.000
.750	3/4	1.563	.010	45°	1.563	5	1P341-1905-XA	★	★	★	★	.750	4.000
1.000	1	2.094	.010	45°	2.094	5	1P341-2540-XA	★	★	★	★	1.000	5.000

A176 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for medium roughing

For multi-material with hardness ≤ 48 HRc

FHA	45°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm DCONMS	LF
6.0	6	22.0	0.10	45°	22.0	4	1P360-0600-XA	★	★	★	★	6.0	65.0
8.0	8	28.0	0.10	45°	28.0	4	1P360-0800-XA	★	★	★	★	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	4	1P360-1000-XA	★	★	★	★	10.0	100.0
12.0	12	40.0	0.10	45°	40.0	4	1P360-1200-XA	★	★	★	★	12.0	100.0
14.0	14	50.0	0.15	45°	50.0	4	1P360-1400-XA	★	★	★	★	14.0	104.0
16.0	16	50.0	0.15	45°	50.0	5	1P360-1600-XA	★	★	★	★	16.0	115.0
20.0	20	55.0	0.15	45°	55.0	5	1P360-2000-XA	★	★	★	★	20.0	125.0
	20	75.0	0.15	45°	75.0	6	1P370-2000-XA	★	★	★	★	20.0	145.0
25.0	25	90.0	0.15	45°	90.0	8	1P360-2500-XA	★	★	★	★	25.0	153.0

Inch version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, inch DCONMS	LF
.125	1/8	.500	.004	45°	.500	4	1P360-0318-XA	★	★	★	★	.125	2.000
.188	3/16	.750	.004	45°	.750	4	1P360-0476-XA	★	★	★	★	.188	2.500
.250	1/4	.875	.004	45°	.875	4	1P360-0635-XA	★	★	★	★	.250	2.500
.375	3/8	1.219	.004	45°	1.219	4	1P360-0953-XA	★	★	★	★	.375	4.000
.500	1/2	1.687	.006	45°	1.687	4	1P360-1270-XA	★	★	★	★	.500	4.000
.625	5/8	2.000	.006	45°	2.000	5	1P360-1588-XA	★	★	★	★	.625	5.000
.750	3/4	2.344	.006	45°	2.344	5	1P360-1905-XA	★	★	★	★	.750	5.000
1.000	1	3.609	.010	45°	3.609	8	1P360-2540-XA	★	★	★	★	1.000	7.000

A176 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for roughing with chip breaker

When to use

When small chip size is needed

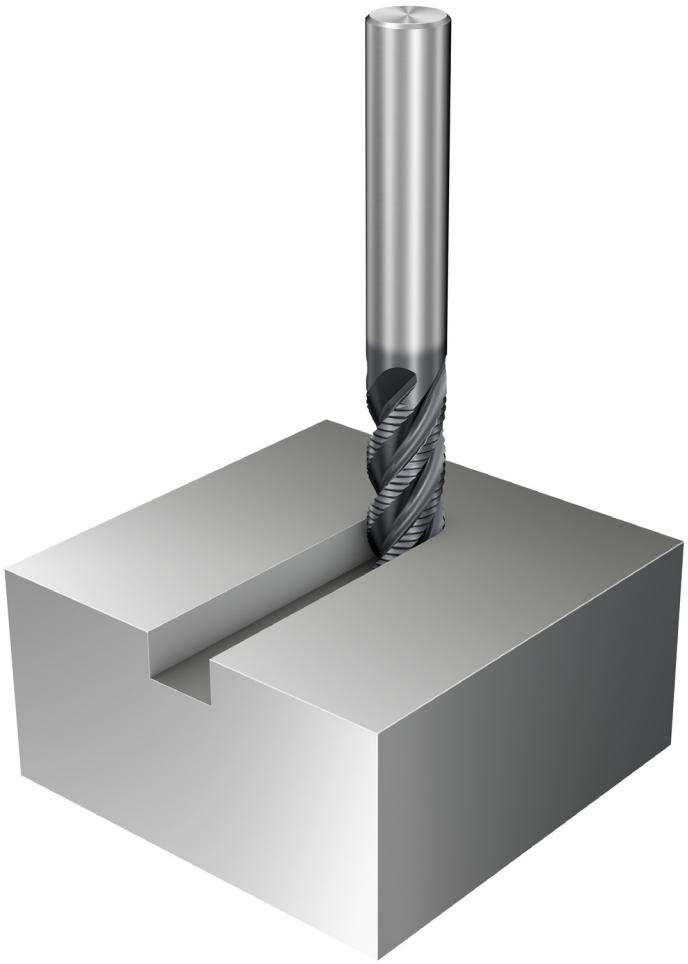
Problem solver in unstable conditions

ISO material	P	M	K	S
Grade	1640			
Shank	Cylindrical	Weldon		

Product range

For stainless steel and steel

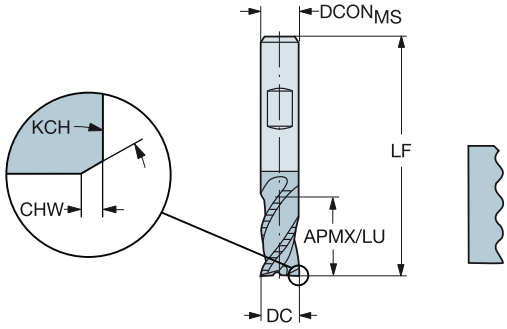
For ISO S materials



CoroMill® Plura solid carbide end mill for roughing with chip breaker

For multi-material with hardness ≤ 48 HRc

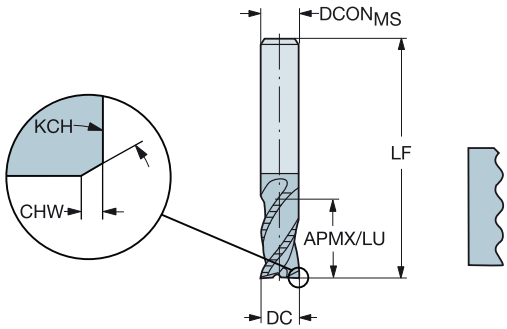
FHA 37°
BSG DIN 6527 L
TCDC h12
TCDCON h6



Metric version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1640	M 1640	K 1640	S 1640	Dimensions, mm DCONMS	LF
6.0	6	13.0	0.50	55°	13.0	4	1P340-0600-XB	★	★	★	★	6.0	57.0
8.0	8	19.0	0.64	55°	19.0	4	1P340-0800-XB	★	★	★	★	8.0	63.0
10.0	10	22.0	0.71	55°	22.0	4	1P340-1000-XB	★	★	★	★	10.0	72.0
12.0	12	26.0	0.71	55°	26.0	4	1P340-1200-XB	★	★	★	★	12.0	83.0
14.0	14	26.0	0.71	55°	26.0	4	1P340-1400-XB	★	★	★	★	14.0	83.0
16.0	16	32.0	0.79	55°	32.0	4	1P340-1600-XB	★	★	★	★	16.0	92.0
18.0	18	32.0	0.71	55°	32.0	4	1P340-1800-XB	★	★	★	★	18.0	92.0
20.0	20	38.0	0.89	55°	38.0	4	1P340-2000-XB	★	★	★	★	20.0	104.0

FHA 37°
BSG INTERNAL
TCDC h12
TCDCON h6



Inch version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1640	M 1640	K 1640	S 1640	Dimensions, inch DCONMS	LF
.250	1/4	.531	.020	55°	.531	4	1P340-0635-XA	★	★	★	★	.250	2.500
.375	3/8	.844	.026	55°	.844	4	1P340-0953-XA	★	★	★	★	.375	3.000
.500	1/2	1.094	.028	55°	1.094	4	1P340-1270-XA	★	★	★	★	.500	3.500
.625	5/8	1.313	.028	55°	1.313	4	1P340-1588-XA	★	★	★	★	.625	4.000
.750	3/4	1.563	.031	55°	1.563	4	1P340-1905-XA	★	★	★	★	.750	4.000
1.000	1	2.094	.044	55°	2.094	4	1P340-2540-XA	★	★	★	★	1.000	5.000

A176 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide ball nose mill for profiling

When to use

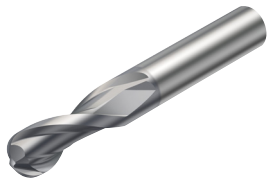
Profiling operations in different shapes: simply choose the right grade and shape for your operation

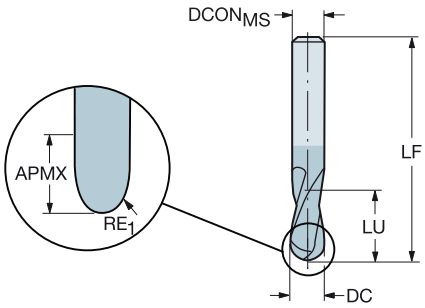
ISO material	P M K S
Grade	1630 1620
Shank	Cylindrical

CoroMill® Plura solid carbide ball nose mill for profiling

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	COROMANT
TCDC	h7
TCDCON	h5
PSIR	0°





Metric version

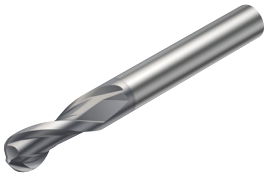
DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm DCON$_{MS}$	LF
1.0	3	3.0	0.50	3.0	2	1B230-0100-XA	★	★	★	★	3.0	38.0
1.5	3	3.0	0.75	3.0	2	1B230-0150-XA	★	★	★	★	3.0	38.0
2.0	3	6.0	1.00	6.0	2	1B230-0200-XA	★	★	★	★	3.0	38.0
2.5	3	7.0	1.25	7.0	2	1B230-0250-XA	★	★	★	★	3.0	38.0
3.0	3	7.0	1.50	7.0	2	1B230-0300-XA	★	★	★	★	3.0	38.0
4.0	6	8.0	2.00	8.0	2	1B230-0400-XA	★	★	★	★	6.0	57.0
5.0	6	10.0	2.50	10.0	2	1B230-0500-XA	★	★	★	★	6.0	57.0
6.0	6	10.0	3.00	10.0	2	1B230-0600-XA	★	★	★	★	6.0	57.0
7.0	8	13.0	3.50	13.0	2	1B230-0700-XA	★	★	★	★	8.0	63.0
8.0	8	16.0	4.00	16.0	2	1B230-0800-XA	★	★	★	★	8.0	63.0
9.0	10	16.0	4.50	16.0	2	1B230-0900-XA	★	★	★	★	10.0	72.0
10.0	10	19.0	5.00	19.0	2	1B230-1000-XA	★	★	★	★	10.0	72.0
12.0	12	22.0	6.00	22.0	2	1B230-1200-XA	★	★	★	★	12.0	83.0
14.0	14	22.0	7.00	22.0	2	1B230-1400-XA	★	★	★	★	14.0	83.0
16.0	16	26.0	8.00	26.0	2	1B230-1600-XA	★	★	★	★	16.0	92.0
18.0	18	26.0	9.00	26.0	2	1B230-1800-XA	★	★	★	★	18.0	92.0
20.0	20	32.0	10.00	32.0	2	1B230-2000-XA	★	★	★	★	20.0	104.0

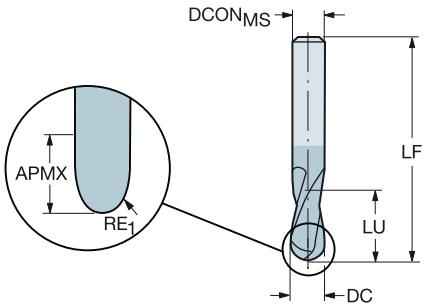
A177 A194 E9 E22 E14

CoroMill® Plura solid carbide ball nose mill for profiling

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°





Inch version

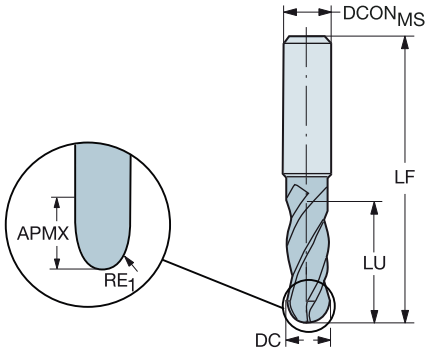
DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, inch DCON$_{MS}$	LF
.063	1/4	.125	.031	.125	2	1B231-0159-XA	★	★	★	★	.250	3.000
	1/4	.125	.031	.125	2	1B232-0159-XA	★	★	★	★	.250	2.000
.094	1/4	.188	.047	.188	2	1B231-0238-XA	★	★	★	★	.250	3.000
	1/4	.188	.047	.188	2	1B232-0238-XA	★	★	★	★	.250	2.000
.125	1/4	.250	.063	.250	2	1B231-0318-XA	★	★	★	★	.250	3.000
	1/4	.250	.063	.250	2	1B232-0318-XA	★	★	★	★	.250	2.000
.156	1/4	.313	.078	.313	2	1B231-0397-XA	★	★	★	★	.250	3.000
	1/4	.313	.078	.313	2	1B232-0397-XA	★	★	★	★	.250	2.000
.187	1/4	.375	.094	.375	2	1B231-0476-XA	★	★	★	★	.250	3.000
	1/4	.375	.094	.375	2	1B232-0476-XA	★	★	★	★	.250	2.000
.250	1/4	.500	.125	.500	2	1B231-0635-XA	★	★	★	★	.250	3.000
	1/4	.500	.125	.500	2	1B232-0635-XA	★	★	★	★	.250	2.000
.313	3/8	.625	.156	.625	2	1B231-0794-XA	★	★	★	★	.375	3.500
	3/8	.625	.156	.625	2	1B232-0794-XA	★	★	★	★	.375	2.500
.375	3/8	.750	.188	.750	2	1B231-0953-XA	★	★	★	★	.375	3.500
	3/8	.750	.188	.750	2	1B232-0953-XA	★	★	★	★	.375	2.500
.500	1/2	1.000	.250	1.000	2	1B231-1270-XA	★	★	★	★	.500	4.000
	1/2	1.000	.250	1.000	2	1B232-1270-XA	★	★	★	★	.500	3.000
.625	5/8	1.250	.313	1.250	2	1B232-1588-XA	★	★	★	★	.625	3.500
.750	3/4	1.500	.375	1.500	2	1B232-1905-XA	★	★	★	★	.750	4.000

A177 A194 E9 E22 E14

CoroMill® Plura solid carbide ball nose mill for profiling

For multi-material with hardness ≤ 48 HRc

FHA	30°
BSG	COROMANT
TCDC	h8
TCDCON	h6
PSIR	0°



Metric version

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm $DCON_{MS}$	LF
3.0	6	8.0	1.50	8.0	4	1B240-0300-XA	★	★	★	★	6.0	80.0
4.0	6	11.0	2.00	11.0	4	1B240-0400-XA	★	★	★	★	6.0	80.0
5.0	6	13.0	2.50	13.0	4	1B240-0500-XA	★	★	★	★	6.0	80.0
6.0	6	13.0	3.00	13.0	4	1B240-0600-XA	★	★	★	★	6.0	80.0
7.0	8	16.0	3.50	16.0	4	1B240-0700-XA	★	★	★	★	8.0	100.0
8.0	8	19.0	4.00	19.0	4	1B240-0800-XA	★	★	★	★	8.0	100.0
10.0	10	22.0	5.00	22.0	4	1B240-1000-XA	★	★	★	★	10.0	100.0
12.0	12	26.0	6.00	26.0	4	1B240-1200-XA	★	★	★	★	12.0	100.0
16.0	16	32.0	8.00	32.0	4	1B240-1600-XA	★	★	★	★	16.0	100.0
20.0	20	38.0	10.00	38.0	4	1B240-2000-XA	★	★	★	★	20.0	125.0

Inch version

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, inch $DCON_{MS}$	LF
.063	1/4	.125	.031	.125	4	1B240-0159-XA	★	★	★	★	.250	3.000
.094	1/4	.188	.047	.188	4	1B240-0238-XA	★	★	★	★	.250	3.000
.125	1/4	.250	.063	.250	4	1B240-0318-XA	★	★	★	★	.250	3.000
.156	1/4	.313	.078	.313	4	1B240-0397-XA	★	★	★	★	.250	3.000
.187	1/4	.375	.094	.375	4	1B240-0476-XA	★	★	★	★	.250	3.000
.250	1/4	.500	.125	.500	4	1B240-0635-XA	★	★	★	★	.250	3.000
.313	3/8	.625	.156	.625	4	1B240-0794-XA	★	★	★	★	.375	3.500
.375	3/8	.750	.188	.750	4	1B240-0953-XA	★	★	★	★	.375	3.500
.500	1/2	1.000	.250	1.000	4	1B240-1270-XA	★	★	★	★	.500	4.000

A177 A194 E9 E22 E14

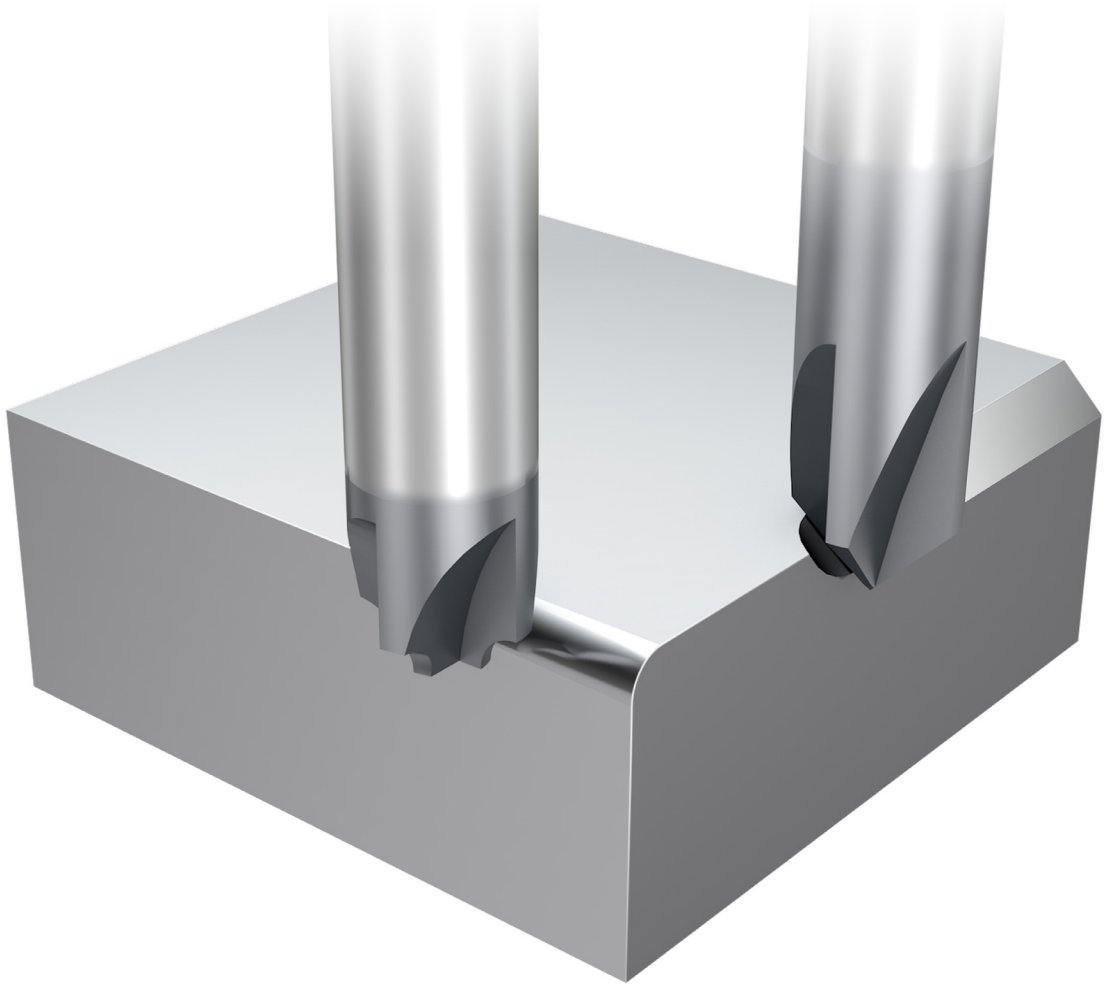
CoroMill® Plura solid carbide end mill for chamfer milling

When to use

Chamfering with the same tool in multiple materials

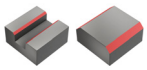
45-degree and 60-degree chamfer angles

ISO material	P	M	K	S	H
Grade	1620				
Shank	Cylindrical	Weldon			



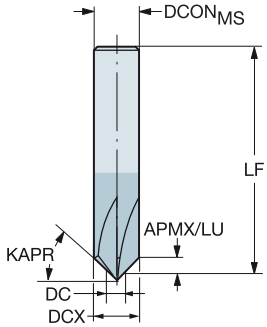
CoroMill® Plura solid carbide end mill for chamfer milling

For multi-material with hardness ≤ 48 HRc

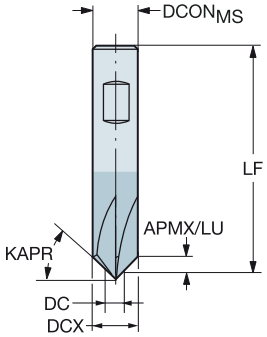


BSG
TCDCON

1C050-XA
COROMANT
h6



1C050-XB
COROMANT
h6



Metric version

KAPR	CZC_{MS}	APMX	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	H 1620	Dimensions, mm $DCON_{MS}$	DC	DCX	LF
45°	10.0	4.25	4.25	4	1C050-0150-045-XB	★	★	★	★	★	10.00	1.50	10.0	99.20
45°	12.0	4.50	4.50	6	1C050-0300-045-XB	★	★	★	★	★	12.00	3.00	12.0	81.50
45°	6.0	2.50	2.50	4	1C050-0100-045-XA	★	★	★	★	★	6.00	1.00	6.0	56.50
45°	8.0	3.00	3.00	5	1C050-0200-045-XA	★	★	★	★	★	8.00	2.00	8.0	79.00
45°	10.0	4.25	4.25	4	1C050-0150-045-XA	★	★	★	★	★	10.00	1.50	10.0	99.20
45°	12.0	4.50	4.50	6	1C050-0300-045-XA	★	★	★	★	★	12.00	3.00	12.0	81.50
60°	10.0	7.35	7.35	4	1C050-0150-060-XB	★	★	★	★	★	10.00	1.50	10.0	98.70
60°		7.35	7.35	4	1C050-0150-060-XA	★	★	★	★	★	10.00	1.50	10.0	98.70

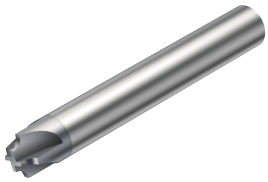
A178 A194 E9 E22 E14

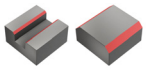
CoroMill® Plura solid carbide end mill for chamfer milling

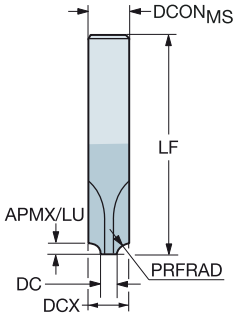
For multi-material with hardness ≤ 48 HRc

BSG
TCDCON

COROMANT
h6







Metric version

PRFRAD	CZC$_{MS}$	APMX	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	H 1620	Dimensions, mm DCON$_{MS}$	DC	DCX	LF
0.5	6.0	0.50	0.50	3	1U000-0400-050-XA	★	★	★	★	★	6.00	4.00	6.0	57.00
0.8		0.75	0.75	3	1U000-0400-075-XA	★	★	★	★	★	6.00	4.00	6.0	57.00
1.0	8.0	1.00	1.00	4	1U000-0400-100-XA	★	★	★	★	★	8.00	4.00	8.0	63.00
1.5		1.50	1.50	4	1U000-0400-150-XA	★	★	★	★	★	8.00	4.00	8.0	63.00
2.0	10.0	2.00	2.00	4	1U000-0500-200-XA	★	★	★	★	★	10.00	5.00	10.0	72.00
2.5		2.50	2.50	4	1U000-0500-250-XA	★	★	★	★	★	10.00	5.00	10.0	72.00
3.0	12.0	3.00	3.00	4	1U000-0500-300-XA	★	★	★	★	★	12.00	5.00	12.0	83.00
4.0	14.0	4.00	4.00	4	1U000-0600-400-XA	★	★	★	★	★	14.00	6.00	14.0	83.00
5.0	16.0	5.00	5.00	4	1U000-0600-500-XA	★	★	★	★	★	16.00	6.00	16.0	92.00
6.0	20.0	6.00	6.00	4	1U000-0800-600-XA	★	★	★	★	★	20.00	8.00	20.0	104.00

Inch version

PRFRAD	CZC$_{MS}$	APMX	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	H 1620	Dimensions, inch DCON$_{MS}$	DC	DCX	LF
.031	1/8	.031	.031	2	1U000-0119-079-XA	★	★	★	★	★	.125	.047	.125	1.500
.062	1/4	.062	.062	3	1U000-0160-158-XA	★	★	★	★	★	.250	.063	.250	2.000
.094	3/8	.094	.094	3	1U000-0160-238-XA	★	★	★	★	★	.375	.063	.313	2.500
.125	1/2	.125	.125	4	1U000-0630-318-XA	★	★	★	★	★	.500	.248	.500	3.000
.188	5/8	.188	.188	4	1U000-0630-476-XA	★	★	★	★	★	.625	.248	.625	3.500

A178 A194 E9 E22 E14

CoroMill® Plura - Optimized

Top-performing end mills for specific materials and applications

Optimized tools with geometries and grades for specific materials and applications, maximizing production output per time unit.

O C

Application

- Heavy duty milling
- High Feed Side Milling
- Stable multi-operations milling
- Large chip removal
- Hard part milling
- Composite milling
- Finishing
- Micromilling
- High feed face milling
- Profile milling
- Roughing with chip breaker
- Turn milling
- Thread milling

ISO application area:

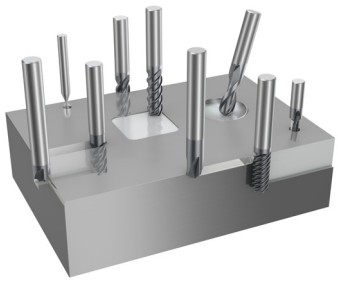
P M K N S H O

For your most quality-demanding components and difficult applications you need the highest quality tools. When close tolerances and efficient machining is paramount, a CoroMill® Plura optimized solid end mill is your choice.

www.sandvik.coromant.com/coromillplura

Product range

- Perfect combination of a specific high-quality grade and a sophisticated geometry for a specific material and application
- Cylindrical and Weldon shank options
- Straight, spherical, and conical ball nose tools
- Roughing tools with and without chip-dividing geometry
- With and without neck, undersized shanks available
- Tools with internal coolant available
- Can be reconditioned up to three times to its original specifications



E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for heavy duty milling

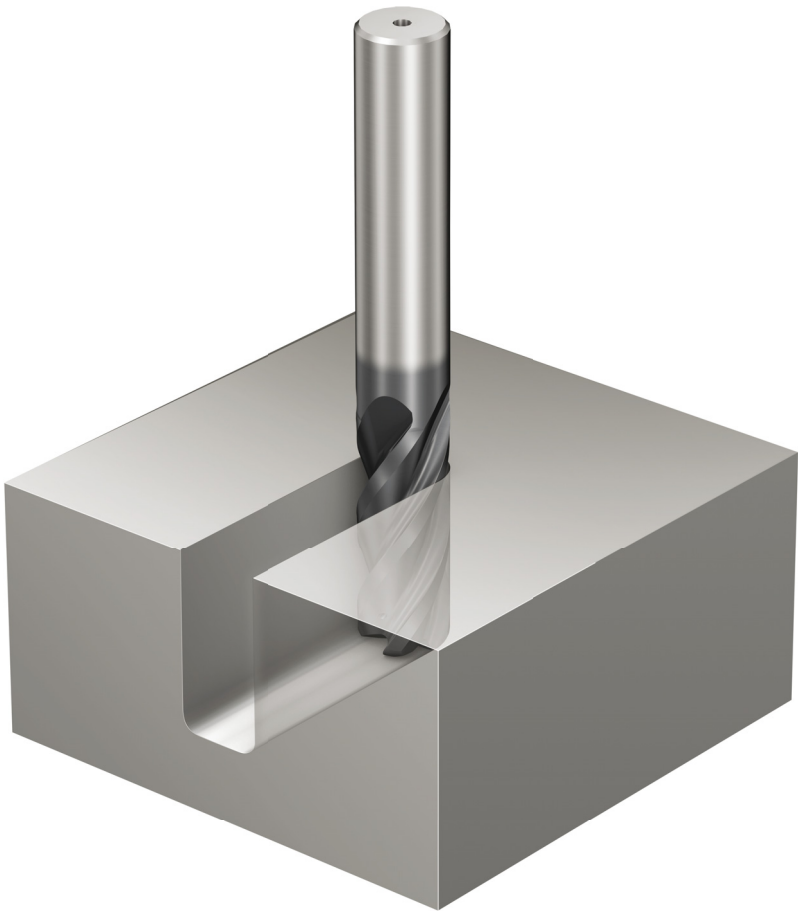
When to use

First choice for roughing in steel and stainless steel with the highest productivity
2xD full slot capabilities and excellent ramping capabilities

ISO material	P	K	M	S
Grade	1730		1740	
Shank	Cylindrical		Weldon	

Product range

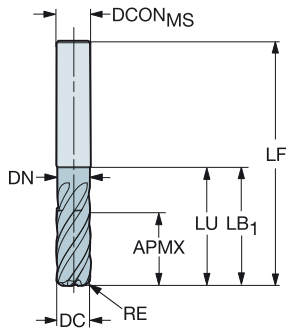
For stainless steel and steel



CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	$DCON_{MS}$	LF	DN	LB_1
									Dimensions, mm			
6.0	6	13.0	0.50	20.0	5	2F342-0600-050-PC	★	☆	6.0	57.0	5.7	20.0
	6	13.0	1.00	20.0	5	2F342-0600-100-PC	★	☆	6.0	57.0	5.7	20.0
8.0	8	18.0	0.50	25.0	5	2F342-0800-050-PC	★	☆	8.0	63.0	7.6	25.0
	8	18.0	1.00	25.0	5	2F342-0800-100-PC	★	☆	8.0	63.0	7.6	25.0
	8	18.0	2.00	25.0	5	2F342-0800-200-PC	★	☆	8.0	63.0	7.6	25.0
10.0	10	22.0	0.50	30.0	5	2F342-1000-050-PC	★	☆	10.0	72.0	9.5	30.0
	10	22.0	1.00	30.0	5	2F342-1000-100-PC	★	☆	10.0	72.0	9.5	30.0
	10	22.0	2.00	30.0	5	2F342-1000-200-PC	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.50	36.0	5	2F342-1200-050-PC	★	☆	12.0	83.0	11.4	36.0
	12	26.0	1.00	36.0	5	2F342-1200-100-PC	★	☆	12.0	83.0	11.4	36.0
	12	26.0	2.00	36.0	5	2F342-1200-200-PC	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.50	42.0	5	2F342-1600-050-PC	★	☆	16.0	92.0	15.2	42.0
	16	34.0	1.00	42.0	5	2F342-1600-100-PC	★	☆	16.0	92.0	15.2	42.0
	16	34.0	2.00	42.0	5	2F342-1600-200-PC	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	1.00	52.0	5	2F342-2000-100-PC	★	☆	20.0	104.0	19.0	52.0
	20	42.0	2.00	52.0	5	2F342-2000-200-PC	★	☆	20.0	104.0	19.0	52.0

Inch version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	$DCON_{MS}$	LF	DN	LB_1
									Dimensions, inch			
.250	1/4	.626	.015	.937	5	2F342-0635-038-PC	★	☆	.250	2.500	.237	.937
	1/4	.626	.030	.937	5	2F342-0635-076-PC	★	☆	.250	2.500	.237	.937
.313	5/16	.752	.015	1.063	5	2F342-0794-038-PC	★	☆	.313	2.500	.297	1.063
	5/16	.752	.030	1.063	5	2F342-0794-076-PC	★	☆	.313	2.500	.297	1.063
.375	3/8	.878	.015	1.250	5	2F342-0953-038-PC	★	☆	.375	3.000	.356	1.250
	3/8	.878	.030	1.250	5	2F342-0953-076-PC	★	☆	.375	3.000	.356	1.250
.438	7/16	1.000	.015	1.438	5	2F342-1111-038-PC	★	☆	.438	3.500	.416	1.438
	7/16	1.000	.030	1.437	5	2F342-1111-076-PC	★	☆	.438	3.500	.416	1.438
.500	1/2	1.126	.015	1.438	5	2F342-1270-038-PC	★	☆	.500	3.500	.475	1.438
	1/2	1.126	.030	1.438	5	2F342-1270-076-PC	★	☆	.500	3.500	.475	1.438
	1/2	1.126	.060	1.438	5	2F342-1270-152-PC	★	☆	.500	3.500	.475	1.438
.625	5/8	1.315	.030	1.625	5	2F342-1588-076-PC	★	☆	.625	3.500	.594	1.626
	5/8	1.315	.060	1.625	5	2F342-1588-152-PC	★	☆	.625	3.500	.594	1.626
.750	3/4	1.626	.030	1.937	5	2F342-1905-076-PC	★	☆	.750	4.000	.713	1.937
	3/4	1.626	.060	1.937	5	2F342-1905-152-PC	★	☆	.750	4.000	.713	1.937

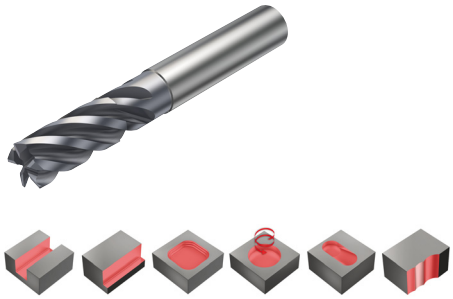
A179 A194 E9 E22 E14

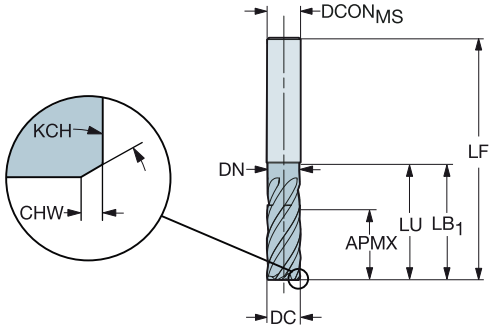
SANDVIK Coromant

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	DCON$_{MS}$	LF	DN	LB$_1$
										Dimensions, mm			
6.0	6	13.0	0.10	45°	20.0	5	2N342-0600-PC	★	☆	6.0	57.0	5.7	20.0
8.0	8	18.0	0.15	45°	25.0	5	2N342-0800-PC	★	☆	8.0	63.0	7.6	25.0
10.0	10	22.0	0.15	45°	30.0	5	2N342-1000-PC	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.15	45°	36.0	5	2N342-1200-PC	★	☆	12.0	83.0	11.4	36.0
14.0	14	30.0	0.15	45°	38.0	5	2N342-1400-PC	★	☆	14.0	83.0	13.3	38.0
16.0	16	34.0	0.25	45°	42.0	5	2N342-1600-PC	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	0.25	45°	52.0	5	2N342-2000-PC	★	☆	20.0	104.0	19.0	52.0
25.0	25	52.0	0.25	45°	63.0	5	2N342-2500-PC	★	☆	25.0	121.0	24.0	63.0

Inch version

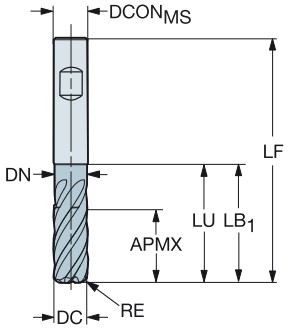
DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	DCON$_{MS}$	LF	DN	LB$_1$
										Dimensions, inch			
6.4	1/4	15.9	0.10	45°	23.8	5	2N342-0635-PC	★	☆	6.4	63.5	6.0	23.8
7.9	5/16	19.1	0.10	45°	27.0	5	2N342-0794-PC	★	☆	7.9	63.5	7.6	27.0
9.5	3/8	22.3	0.15	45°	31.8	5	2N342-0953-PC	★	☆	9.5	76.2	9.0	31.8
12.7	1/2	28.6	0.15	45°	36.5	5	2N342-1270-PC	★	☆	12.7	88.9	12.1	36.5
15.9	5/8	33.4	0.25	45°	41.3	5	2N342-1588-PC	★	☆	15.9	88.9	15.1	41.3
19.1	3/4	41.3	0.25	45°	49.2	5	2N342-1905-PC	★	☆	19.1	101.6	18.1	49.2

A179 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	DCON$_{MS}$	LF	DN	LB$_1$
10.0	10	22.0	0.50	30.0	5	2F342-1000-050-PD	★	☆	10.0	72.0	9.5	30.0
	10	22.0	1.00	30.0	5	2F342-1000-100-PD	★	☆	10.0	72.0	9.5	30.0
	10	22.0	2.00	30.0	5	2F342-1000-200-PD	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.50	36.0	5	2F342-1200-050-PD	★	☆	12.0	83.0	11.4	36.0
	12	26.0	1.00	36.0	5	2F342-1200-100-PD	★	☆	12.0	83.0	11.4	36.0
	12	26.0	2.00	36.0	5	2F342-1200-200-PD	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.50	42.0	5	2F342-1600-050-PD	★	☆	16.0	92.0	15.2	42.0
	16	34.0	1.00	42.0	5	2F342-1600-100-PD	★	☆	16.0	92.0	15.2	42.0
	16	34.0	2.00	42.0	5	2F342-1600-200-PD	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	1.00	52.0	5	2F342-2000-100-PD	★	☆	20.0	104.0	19.0	52.0
	20	42.0	2.00	52.0	5	2F342-2000-200-PD	★	☆	20.0	104.0	19.0	52.0

Dimensions, mm

Inch version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1730	K 1730	DCON$_{MS}$	LF	DN	LB$_1$
.625	5/8	1.315	.030	1.625	5	2F342-1588-076-PD	★	☆	.625	3.500	.594	1.626
	5/8	1.315	.060	1.625	5	2F342-1588-152-PD	★	☆	.625	3.500	.594	1.626
.750	3/4	1.626	.030	1.937	5	2F342-1905-076-PD	★	☆	.750	4.000	.713	1.937
	3/4	1.626	.060	1.937	5	2F342-1905-152-PD	★	☆	.750	4.000	.713	1.937

Dimensions, inch

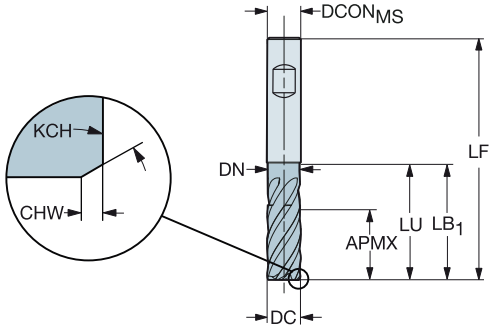
A179 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	DCON$_{MS}$	LF	DN	LB$_1$
								Dimensions, mm					
10.0	10	22.0	0.15	45°	30.0	5	2N342-1000-PD	★	☆	10.0	72.0	9.5	30.0
12.0	12	26.0	0.15	45°	36.0	5	2N342-1200-PD	★	☆	12.0	83.0	11.4	36.0
16.0	16	34.0	0.25	45°	42.0	5	2N342-1600-PD	★	☆	16.0	92.0	15.2	42.0
20.0	20	42.0	0.25	45°	52.0	5	2N342-2000-PD	★	☆	20.0	104.0	19.0	52.0
25.0	25	52.0	0.25	45°	63.0	5	2N342-2500-PD	★	☆	25.0	121.0	24.0	63.0

Inch version

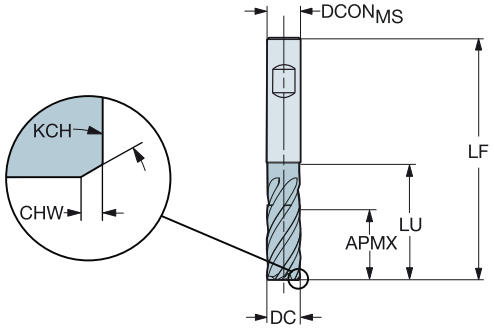
DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1730	K 1730	DCON$_{MS}$	LF	DN	LB$_1$
								Dimensions, inch					
.625	5/8	1.315	.010	45°	1.625	5	2N342-1588-PD	★	☆	.625	3.500	.594	1.625
.750	3/4	1.626	.010	45°	1.937	5	2N342-1905-PD	★	☆	.750	4.000	.713	1.937

A179 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

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

Inch version

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

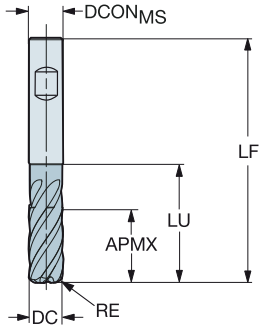
A179 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

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

Dimensions, mm

Inch version

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

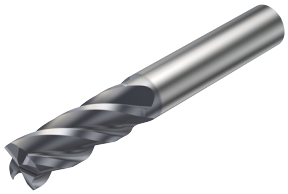
Dimensions, inch

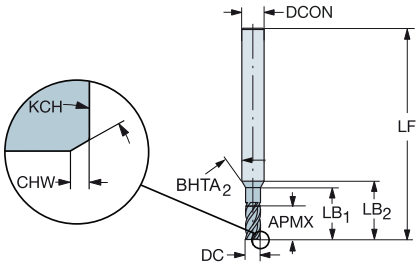
A179 A194 E9 E22 E14

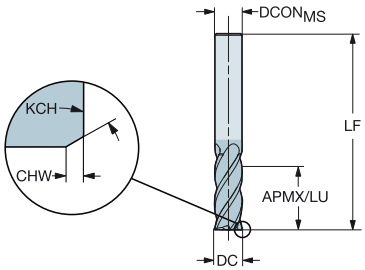
CoroMill® Plura solid carbide end mill for heavy duty milling

For steel

	2P342-PA (1)	2P342-PA (2)
BSG	COROMANT	COROMANT
TCDC	h10	h10
TCDCON	h6	h6







Metric version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	FHA	DSGN	Ordering code	P 1730	K 1730	Dimensions, mm $DCON_{MS}$	LF	LB_1	LB_2	$BHTA_2$
2.0	6	5.0	0.05	45°	5.0	4	38°	1	2P342-0200-PA	★	☆	6.0	57.0	10.0	13.5	30°
3.0	6	7.0	0.10	45°	7.0	4	38°	1	2P342-0300-PA	★	☆	6.0	57.0	13.0	15.6	30°
4.0	6	9.0	0.10	45°	9.0	4	38°	1	2P342-0400-PA	★	☆	6.0	57.0	14.0	15.7	30°
5.0	6	11.0	0.10	45°	11.0	4	38°	1	2P342-0500-PA	★	☆	6.0	57.0	16.0	16.9	30°
6.0	6	13.0	0.10	45°	13.0	4	38°	2	2P342-0600-PA	★	☆	6.0	57.0			
8.0	8	18.0	0.15	45°	18.0	4	38°	2	2P342-0800-PA	★	☆	8.0	63.0			
10.0	10	22.0	0.15	45°	22.0	4	42°	2	2P342-1000-PA	★	☆	10.0	72.0			
12.0	12	26.0	0.15	45°	26.0	4	42°	2	2P342-1200-PA	★	☆	12.0	83.0			
14.0	14	30.0	0.15	45°	30.0	4	42°	2	2P342-1400-PA	★	☆	14.0	83.0			
16.0	16	34.0	0.25	45°	34.0	4	42°	2	2P342-1600-PA	★	☆	16.0	92.0			
20.0	20	42.0	0.25	45°	42.0	4	42°	2	2P342-2000-PA	★	☆	20.0	104.0			
25.0	25	52.0	0.25	45°	52.0	4	42°	2	2P342-2500-PA	★	☆	25.0	121.0			

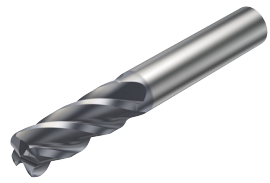
Inch version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	FHA	DSGN	Ordering code	P 1730	K 1730	Dimensions, inch $DCON_{MS}$	LF
.125	1/8	.313	.004	45°	.313	4	38°	2	2P342-0318-PA	★	☆	.125	1.500
.187	3/16	.438	.004	45°	.438	4	38°	2	2P342-0476-PA	★	☆	.188	2.000
.250	1/4	.625	.004	45°	.625	4	38°	2	2P342-0635-PA	★	☆	.250	2.500
.313	5/16	.750	.004	45°	.750	4	38°	2	2P342-0794-PA	★	☆	.313	2.500
.375	3/8	.875	.006	45°	.875	4	42°	2	2P342-0953-PA	★	☆	.375	2.500
.500	1/2	1.125	.006	45°	1.125	4	42°	2	2P342-1270-PA	★	☆	.500	3.000
.625	5/8	1.313	.010	45°	1.313	4	42°	2	2P342-1588-PA	★	☆	.625	3.500
.750	3/4	1.625	.010	45°	1.625	4	42°	2	2P342-1905-PA	★	☆	.750	4.000

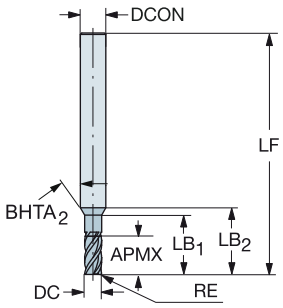
A179 A194 E9 E22 E14

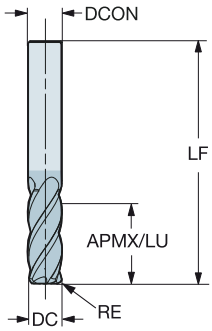
CoroMill® Plura solid carbide end mill for heavy duty milling

For steel



	2S342-PA (1)	2S342-PA (2)
BSG	COROMANT	COROMANT
TCDC	h10	h10
TCDCON	h6	h6





Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	FHA	DSGN	Ordering code	P 1730	K 1730	Dimensions, mm $DCON_{MS}$	LF	LB_1	LB_2	$BHTA_2$
3.0	6	7.0	0.20	7.0	4	38°	1	2S342-0300-020-PA	★	☆	6.0	57.0	13.0	15.6	30°
	6	7.0	0.50	7.0	4	38°	1	2S342-0300-050-PA	★	☆	6.0	57.0	13.0	15.6	30°
4.0	6	9.0	0.20	9.0	4	38°	1	2S342-0400-020-PA	★	☆	6.0	57.0	14.0	15.7	30°
	6	9.0	0.50	9.0	4	38°	1	2S342-0400-050-PA	★	☆	6.0	57.0	14.0	15.7	30°
5.0	6	11.0	0.50	11.0	4	38°	1	2S342-0500-050-PA	★	☆	6.0	57.0	16.0	16.9	30°
	6	11.0	1.00	11.0	4	38°	1	2S342-0500-100-PA	★	☆	6.0	57.0	16.0	16.9	30°
6.0	6	13.0	0.50	13.0	4	38°	2	2S342-0600-050-PA	★	☆	6.0	57.0			
	6	13.0	1.00	13.0	4	38°	2	2S342-0600-100-PA	★	☆	6.0	57.0			
8.0	8	18.0	0.50	18.0	4	38°	2	2S342-0800-050-PA	★	☆	8.0	63.0			
	8	18.0	1.00	18.0	4	38°	2	2S342-0800-100-PA	★	☆	8.0	63.0			
	8	18.0	2.00	18.0	4	38°	2	2S342-0800-200-PA	★	☆	8.0	63.0			
10.0	10	22.0	0.50	22.0	4	42°	2	2S342-1000-050-PA	★	☆	10.0	72.0			
	10	22.0	1.00	22.0	4	42°	2	2S342-1000-100-PA	★	☆	10.0	72.0			
	10	22.0	2.00	22.0	4	42°	2	2S342-1000-200-PA	★	☆	10.0	72.0			
12.0	12	26.0	0.50	26.0	4	42°	2	2S342-1200-050-PA	★	☆	12.0	83.0			
	12	26.0	1.00	26.0	4	42°	2	2S342-1200-100-PA	★	☆	12.0	83.0			
	12	26.0	2.00	26.0	4	42°	2	2S342-1200-200-PA	★	☆	12.0	83.0			
16.0	16	34.0	0.50	34.0	4	42°	2	2S342-1600-050-PA	★	☆	16.0	92.0			
	16	34.0	1.00	34.0	4	42°	2	2S342-1600-100-PA	★	☆	16.0	92.0			
	16	34.0	2.00	34.0	4	42°	2	2S342-1600-200-PA	★	☆	16.0	92.0			
20.0	20	42.0	1.00	42.0	4	42°	2	2S342-2000-100-PA	★	☆	20.0	104.0			
	20	42.0	2.00	42.0	4	42°	2	2S342-2000-200-PA	★	☆	20.0	104.0			

Inch version

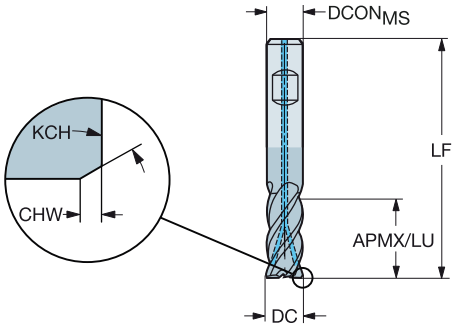
DC	CZC_{MS}	APMX	RE	LU	ZEFP	FHA	DSGN	Ordering code	P 1730	K 1730	Dimensions, inch $DCON_{MS}$	LF
.125	1/8	.313	.015	.313	4	38°	2	2S342-0318-038-PA	★	☆	.125	1.500
.187	3/16	.438	.015	.438	4	38°	2	2S342-0476-038-PA	★	☆	.188	2.000
.250	1/4	.625	.015	.625	4	38°	2	2S342-0635-038-PA	★	☆	.250	2.500
	1/4	.625	.030	.625	4	38°	2	2S342-0635-076-PA	★	☆	.250	2.500
.313	5/16	.750	.015	.750	4	38°	2	2S342-0794-038-PA	★	☆	.313	2.500
	5/16	.750	.030	.750	4	38°	2	2S342-0794-076-PA	★	☆	.313	2.500
.375	3/8	.875	.015	.875	4	42°	2	2S342-0953-038-PA	★	☆	.375	2.500
	3/8	.875	.030	.875	4	42°	2	2S342-0953-076-PA	★	☆	.375	2.500
.438	7/16	1.000	.015	1.000	4	42°	2	2S342-1111-038-PA	★	☆	.438	2.750
	7/16	1.000	.030	1.000	4	42°	2	2S342-1111-076-PA	★	☆	.438	2.750
.500	1/2	1.125	.015	1.125	4	42°	2	2S342-1270-038-PA	★	☆	.500	3.000
	1/2	1.125	.030	1.125	4	42°	2	2S342-1270-076-PA	★	☆	.500	3.000
	1/2	1.125	.060	1.125	4	42°	2	2S342-1270-152-PA	★	☆	.500	3.000
.625	5/8	1.313	.030	1.313	4	42°	2	2S342-1588-076-PA	★	☆	.625	3.500
	5/8	1.315	.060	1.315	4	42°	2	2S342-1588-152-PA	★	☆	.625	3.500
.750	3/4	1.625	.030	1.625	4	42°	2	2S342-1905-076-PA	★	☆	.750	4.000
	3/4	1.625	.060	1.625	4	42°	2	2S342-1905-152-PA	★	☆	.750	4.000

A179 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

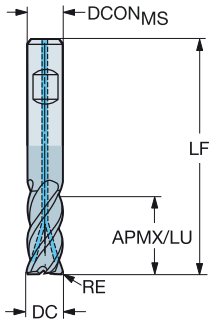
DC	CZC_{MS}	APMX	CHW	KCH	LU	CXSC	ZEFP	Ordering code	M 1740	S 1740	Dimensions, mm $DCON_{MS}$	LF
10.0	10	22.0	0.15	45°	22.0	3	4	2P342-1000-CMB	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	3	4	2P342-1200-CMB	★	☆	12.0	83.0
16.0	16	34.0	0.25	45°	34.0	3	4	2P342-1600-CMB	★	☆	16.0	97.0
20.0	20	42.0	0.25	45°	42.0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

A179 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

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

Inch version

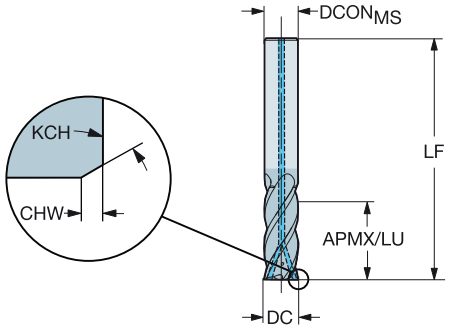
DC	CZCMS	APMX	RE	LU	CNSC	CXSC	ZEFP	FHA	Ordering code	M 1740	S 1740	DCONMS	LF
.625	5/8	1.313	.030	1.313	1	4	4	38°	2S342-1588-076CMB	★	☆	.625	3.780
	5/8	1.313	.060	1.313	1	4	4	38°	2S342-1588-152CMB	★	☆	.625	3.780
	5/8	1.313	.090	1.313	1	4	4	38°	2S342-1588-229CMB	★	☆	.625	3.780
	5/8	1.313	.120	1.313	1	4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

A179 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC_{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Ordering code	M 1740	S 1740	$DCON_{MS}$	LF
6.0	6	13.0	0.10	45°	13.0	1	3	4	2P342-0600-CMA	★	☆	6.0	57.0
8.0	8	18.0	0.15	45°	18.0	1	3	4	2P342-0800-CMA	★	☆	8.0	63.0
10.0	10	22.0	0.15	45°	22.0	1	3	4	2P342-1000-CMA	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	1	3	4	2P342-1200-CMA	★	☆	12.0	83.0
16.0	16	34.0	0.25	45°	34.0	1	3	4	2P342-1600-CMA	★	☆	16.0	92.0
20.0	20	42.0	0.25	45°	42.0	1	3	4	2P342-2000-CMA	★	☆	20.0	104.0
25.0	25	52.0	0.25	45°	52.0	1	3	4	2P342-2500-CMA	★	☆	25.0	121.0

Inch version

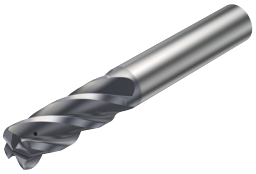
DC	CZC_{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Ordering code	M 1740	S 1740	$DCON_{MS}$	LF
.250	1/4	.625	.004	45°	.625	1	3	4	2P342-0635-CMA	★	☆	.250	2.500
.313	5/16	.750	.004	45°	.750	1	3	4	2P342-0794-CMA	★	☆	.313	2.500
.375	3/8	.875	.006	45°	.875	1	3	4	2P342-0953-CMA	★	☆	.375	2.500
.500	1/2	1.125	.006	45°	1.125	1	3	4	2P342-1270-CMA	★	☆	.500	3.000
.625	5/8	1.313	.010	45°	1.313	1	3	4	2P342-1588-CMA	★	☆	.625	3.500
.750	3/4	1.625	.010	45°	1.625	1	3	4	2P342-1905-CMA	★	☆	.750	4.000

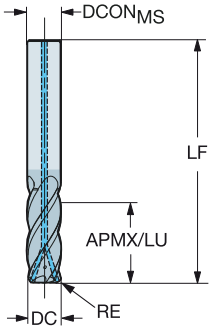
A179 A194 E9 E22 E28 E14

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

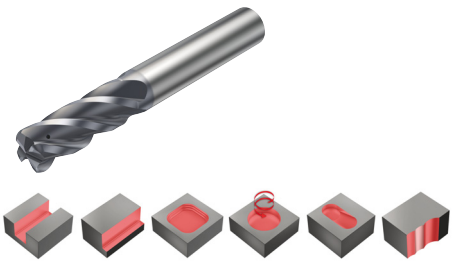
DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	M 1740	S 1740	Dimensions, mm $DCON_{MS}$	LF
6.0	6	13.0	0.50	13.0	1	3	4	2S342-0600-050CMA	★	☆	6.0	57.0
	6	13.0	1.00	13.0	1	3	4	2S342-0600-100CMA	★	☆	6.0	57.0
8.0	8	18.0	0.50	18.0	1	3	4	2S342-0800-050CMA	★	☆	8.0	63.0
	8	18.0	1.00	18.0	1	3	4	2S342-0800-100CMA	★	☆	8.0	63.0
	8	18.0	1.50	18.0	1	3	4	2S342-0800-150CMA	★	☆	8.0	63.0
	8	18.0	2.00	18.0	1	3	4	2S342-0800-200CMA	★	☆	8.0	63.0
10.0	10	22.0	0.50	22.0	1	3	4	2S342-1000-050CMA	★	☆	10.0	72.0
	10	22.0	1.00	22.0	1	3	4	2S342-1000-100CMA	★	☆	10.0	72.0
	10	22.0	1.50	22.0	1	3	4	2S342-1000-150CMA	★	☆	10.0	72.0
	10	22.0	2.00	22.0	1	3	4	2S342-1000-200CMA	★	☆	10.0	72.0
	10	22.0	3.00	22.0	1	3	4	2S342-1000-300CMA	★	☆	10.0	72.0
12.0	12	26.0	0.50	26.0	1	3	4	2S342-1200-050CMA	★	☆	12.0	83.0
	12	26.0	1.00	26.0	1	3	4	2S342-1200-100CMA	★	☆	12.0	83.0
	12	26.0	1.50	26.0	1	3	4	2S342-1200-150CMA	★	☆	12.0	83.0
	12	26.0	2.00	26.0	1	3	4	2S342-1200-200CMA	★	☆	12.0	83.0
	12	26.0	3.00	26.0	1	3	4	2S342-1200-300CMA	★	☆	12.0	83.0
16.0	16	34.0	0.50	34.0	1	3	4	2S342-1600-050CMA	★	☆	16.0	92.0
	16	34.0	1.00	34.0	1	3	4	2S342-1600-100CMA	★	☆	16.0	92.0
	16	34.0	2.00	34.0	1	3	4	2S342-1600-200CMA	★	☆	16.0	92.0
	16	34.0	3.00	34.0	1	3	4	2S342-1600-300CMA	★	☆	16.0	92.0
	16	34.0	4.00	34.0	1	3	4	2S342-1600-400CMA	★	☆	16.0	92.0
	16	34.0	5.00	34.0	1	3	4	2S342-1600-500CMA	★	☆	16.0	92.0
20.0	20	42.0	1.00	42.0	1	3	4	2S342-2000-100CMA	★	☆	20.0	104.0
	20	42.0	2.00	42.0	1	3	4	2S342-2000-200CMA	★	☆	20.0	104.0
	20	42.0	3.00	42.0	1	3	4	2S342-2000-300CMA	★	☆	20.0	104.0
	20	42.0	4.00	42.0	1	3	4	2S342-2000-400CMA	★	☆	20.0	104.0
	20	42.0	5.00	42.0	1	3	4	2S342-2000-500CMA	★	☆	20.0	104.0
	20	42.0	6.35	42.0	1	3	4	2S342-2000-635CMA	★	☆	20.0	104.0

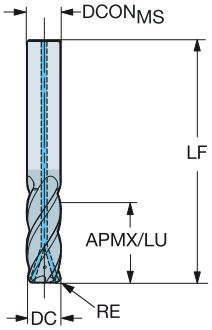
A179 A194 E9 E22 E28 E14

CoroMill® Plura solid carbide end mill for heavy duty milling

For stainless steel

FHA	38°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Inch version

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	M 1740	S 1740	Dimensions, inch $DCON_{MS}$	LF
.250	1/4	.625	.015	.625	1	3	4	2S342-0635-038CMA	★	☆	.250	2.500
	1/4	.625	.030	.625	1	3	4	2S342-0635-076CMA	★	☆	.250	2.500
.313	5/16	.750	.015	.750	1	3	4	2S342-0794-038CMA	★	☆	.313	2.500
.375	3/8	.875	.015	.875	1	3	4	2S342-0953-038CMA	★	☆	.375	2.500
	3/8	.875	.030	.875	1	3	4	2S342-0953-076CMA	★	☆	.375	2.500
	3/8	.875	.060	.875	1	3	4	2S342-0953-152CMA	★	☆	.375	2.500
.500	1/2	1.125	.015	1.125	1	3	4	2S342-1270-038CMA	★	☆	.500	3.000
	1/2	1.125	.030	1.125	1	3	4	2S342-1270-076CMA	★	☆	.500	3.000
	1/2	1.125	.060	1.125	1	3	4	2S342-1270-152CMA	★	☆	.500	3.000
	1/2	1.125	.090	1.125	1	3	4	2S342-1270-229CMA	★	☆	.500	3.000
	1/2	1.125	.120	1.125	1	3	4	2S342-1270-305CMA	★	☆	.500	3.000
.625	5/8	1.313	.030	1.313	1	3	4	2S342-1588-076CMA	★	☆	.625	3.500
	5/8	1.313	.060	1.313	1	3	4	2S342-1588-152CMA	★	☆	.625	3.500
	5/8	1.313	.090	1.313	1	3	4	2S342-1588-229CMA	★	☆	.625	3.500
	5/8	1.313	.120	1.313	1	3	4	2S342-1588-305CMA	★	☆	.625	3.500
.750	3/4	1.625	.030	1.625	1	3	4	2S342-1905-076CMA	★	☆	.750	4.000
	3/4	1.625	.060	1.625	1	3	4	2S342-1905-152CMA	★	☆	.750	4.000
	3/4	1.625	.090	1.625	1	3	4	2S342-1905-229CMA	★	☆	.750	4.000
	3/4	1.625	.120	1.625	1	3	4	2S342-1905-305CMA	★	☆	.750	4.000
	3/4	1.625	.190	1.625	1	3	4	2S342-1905-483CMA	★	☆	.750	4.000

A179 A194 E9 E22 E28 E14

CoroMill® Plura solid carbide end mill for high feed side milling

When to use

Excellent in roughing when good surface quality is needed

First choice for CAM-supported, high feed side milling strategies

ISO material	P	K	M	S	
Grade	1630	1640	1740	1745	1710
Shank	Cylindrical		Weldon		

Product range

For stainless steel and steel

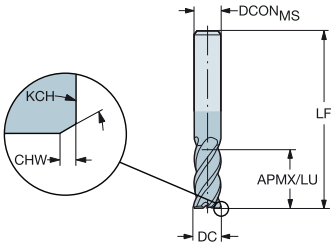
For titanium alloys

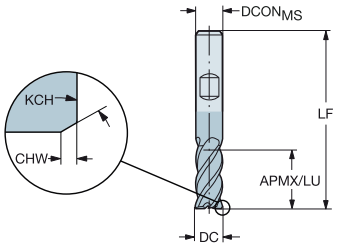
For nickel-based alloys

CoroMill® Plura solid carbide end mill for high feed side milling

For steel with hardness ≤ 48 HRc

	2P340-PA	2P340-PB
FHA	37°	37°
BSG	DIN 6527 L	DIN 6527 L
TCDC	h10	h10
TCDCON	h6	h6





Metric version

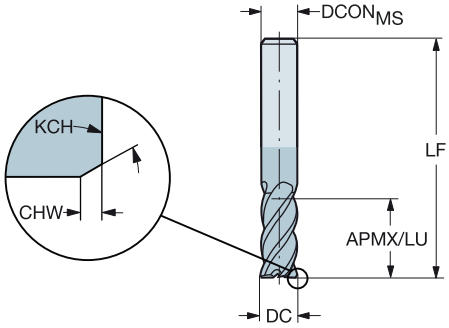
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	K 1630	$DCON_{MS}$	LF
2.0	6	7.0	0.15	45°	7.0	4	2P340-0200-PB	★	☆	6.0	57.0
	6	7.0	0.15	45°	7.0	4	2P340-0200-PA	★	☆	6.0	57.0
2.5	6	8.0	0.15	45°	8.0	4	2P340-0250-PB	★	☆	6.0	57.0
	6	8.0	0.15	45°	8.0	4	2P340-0250-PA	★	☆	6.0	57.0
3.0	6	8.0	0.15	45°	8.0	4	2P340-0300-PB	★	☆	6.0	57.0
	6	8.0	0.15	45°	8.0	4	2P340-0300-PA	★	☆	6.0	57.0
3.5	6	10.0	0.13	45°	10.0	4	2P340-0350-PB	★	☆	6.0	57.0
	6	10.0	0.13	45°	10.0	4	2P340-0350-PA	★	☆	6.0	57.0
4.0	6	11.0	0.13	45°	11.0	4	2P340-0400-PB	★	☆	6.0	57.0
	6	11.0	0.13	45°	11.0	4	2P340-0400-PA	★	☆	6.0	57.0
5.0	6	13.0	0.13	45°	13.0	4	2P340-0500-PB	★	☆	6.0	57.0
	6	13.0	0.13	45°	13.0	4	2P340-0500-PA	★	☆	6.0	57.0
6.0	6	13.0	0.15	45°	13.0	4	2P340-0600-PB	★	☆	6.0	57.0
	6	13.0	0.15	45°	13.0	4	2P340-0600-PA	★	☆	6.0	57.0
7.0	8	16.0	0.15	45°	16.0	4	2P340-0700-PB	★	☆	8.0	63.0
	8	16.0	0.15	45°	16.0	4	2P340-0700-PA	★	☆	8.0	63.0
8.0	8	19.0	0.15	45°	19.0	4	2P340-0800-PB	★	☆	8.0	63.0
	8	19.0	0.15	45°	19.0	4	2P340-0800-PA	★	☆	8.0	63.0
9.0	10	19.0	0.15	45°	19.0	4	2P340-0900-PA	★	☆	10.0	72.0
10.0	10	22.0	0.15	45°	22.0	4	2P340-1000-PB	★	☆	10.0	72.0
	10	22.0	0.15	45°	22.0	4	2P340-1000-PA	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	4	2P340-1200-PB	★	☆	12.0	83.0
	12	26.0	0.15	45°	26.0	4	2P340-1200-PA	★	☆	12.0	83.0
14.0	14	26.0	0.20	45°	26.0	4	2P340-1400-PB	★	☆	14.0	83.0
	14	26.0	0.20	45°	26.0	4	2P340-1400-PA	★	☆	14.0	83.0
16.0	16	32.0	0.20	45°	32.0	4	2P340-1600-PB	★	☆	16.0	92.0
	16	32.0	0.20	45°	32.0	4	2P340-1600-PA	★	☆	16.0	92.0
18.0	18	32.0	0.20	45°	32.0	4	2P340-1800-PB	★	☆	18.0	92.0
	18	32.0	0.20	45°	32.0	4	2P340-1800-PA	★	☆	18.0	92.0
20.0	20	38.0	0.20	45°	38.0	4	2P340-2000-PB	★	☆	20.0	104.0
	20	38.0	0.20	45°	38.0	4	2P340-2000-PA	★	☆	20.0	104.0
25.0	25	45.0	0.20	45°	45.0	4	2P340-2500-PB	★	☆	25.0	121.0
	25	45.0	0.20	45°	45.0	4	2P340-2500-PA	★	☆	25.0	121.0

A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	37°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

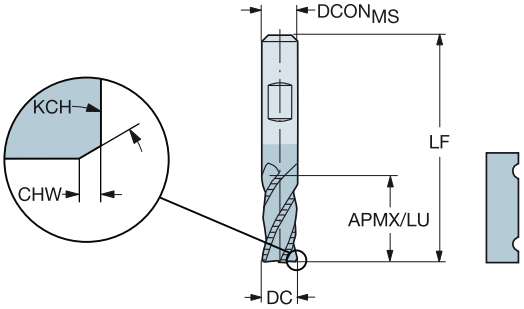
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1630	M 1630	K 1630	S 1630	Dimensions, mm $DCON_{MS}$	LF
6.0	6	22.0	0.15	45°	22.0	4	2P360-0600-PA	★	★	☆	☆	6.0	65.0
8.0	8	28.0	0.15	45°	28.0	4	2P360-0800-PA	★	★	☆	☆	8.0	80.0
10.0	10	32.0	0.15	45°	32.0	4	2P360-1000-PA	★	★	☆	☆	10.0	100.0
12.0	12	40.0	0.15	45°	40.0	4	2P360-1200-PA	★	★	☆	☆	12.0	100.0
14.0	14	50.0	0.20	45°	50.0	4	2P360-1400-PA	★	★	☆	☆	14.0	104.0
16.0	16	60.0	0.15	45°	60.0	4	2P360-1600-PA	★	★	☆	☆	16.0	124.0
20.0	20	70.0	0.20	45°	70.0	4	2P360-2000-PA	★	★	☆	☆	20.0	155.0

A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For stainless steel and steel with hardness ≤ 30 HRc

FHA	37°
TCDC	h10
TCDCON	h6



Metric version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1740	M 1740	K 1740	S 1740	Dimensions, mm DCONMS	LF
6.0	6	24.0	0.10	45°	24.0	4	2P370-0600-PB	★	★	☆	☆	6.0	66.0
8.0	8	32.0	0.10	45°	32.0	4	2P370-0800-PB	★	★	☆	☆	8.0	74.0
10.0	10	40.0	0.15	45°	40.0	4	2P370-1000-PB	★	★	☆	☆	10.0	87.0
12.0	12	48.0	0.15	45°	48.0	4	2P370-1200-PB	★	★	☆	☆	12.0	103.0
16.0	16	64.0	0.20	45°	64.0	4	2P370-1600-PB	★	★	☆	☆	16.0	124.0
20.0	20	80.0	0.25	45°	80.0	4	2P370-2000-PB	★	★	☆	☆	20.0	145.0
25.0	25	100.0	0.25	45°	100.0	4	2P370-2500-PB	★	★	☆	☆	25.0	178.0

Inch version

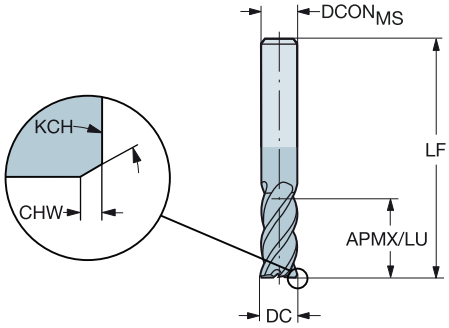
DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1740	M 1740	K 1740	S 1740	Dimensions, inch DCONMS	LF
.250	1/4	1.000	.004	45°	1.000	4	2P370-0635-PB	★	★	☆	☆	.250	2.688
.313	5/16	1.250	.004	45°	1.250	4	2P370-0794-PB	★	★	☆	☆	.313	2.938
.375	3/8	1.500	.006	45°	1.500	4	2P370-0953-PB	★	★	☆	☆	.375	3.375
.500	1/2	2.000	.006	45°	2.000	4	2P370-1270-PB	★	★	☆	☆	.500	4.188
.625	5/8	2.500	.008	45°	2.500	4	2P370-1588-PB	★	★	☆	☆	.625	4.875
.750	3/4	3.000	.010	45°	3.000	4	2P370-1905-PB	★	★	☆	☆	.750	5.625
1.000	1	4.000	.010	45°	4.000	4	2P370-2540-PB	★	★	☆	☆	1.000	7.125

A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For stainless steel

FHA	41°
BSG	DIN 6527 L
TCDC	h10
TCDCON	h6



Metric version

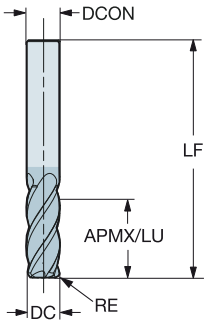
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	M 1640	S 1640	$DCON_{MS}$	LF
										Dimensions, mm	
2.0	6	7.0	0.15	45°	7.0	4	2P341-0200-MA	★	☆	6.0	57.0
3.0	6	8.0	0.15	45°	8.0	4	2P341-0300-MA	★	☆	6.0	57.0
4.0	6	11.0	0.15	45°	11.0	4	2P341-0400-MA	★	☆	6.0	57.0
5.0	6	13.0	0.15	45°	13.0	4	2P341-0500-MA	★	☆	6.0	57.0
6.0	6	13.0	0.15	45°	13.0	4	2P341-0600-MA	★	☆	6.0	57.0
8.0	8	19.0	0.15	45°	19.0	4	2P341-0800-MA	★	☆	8.0	63.0
10.0	10	22.0	0.15	45°	22.0	4	2P341-1000-MA	★	☆	10.0	72.0
12.0	12	26.0	0.15	45°	26.0	4	2P341-1200-MA	★	☆	12.0	83.0
14.0	14	26.0	0.20	45°	26.0	4	2P341-1400-MA	★	☆	14.0	83.0
16.0	16	32.0	0.20	45°	32.0	4	2P341-1600-MA	★	☆	16.0	92.0
20.0	20	38.0	0.20	45°	38.0	4	2P341-2000-MA	★	☆	20.0	104.0
25.0	25	45.0	0.20	45°	45.0	4	2P341-2500-MA	★	☆	25.0	121.0

A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For stainless steel

FHA	41°
BSG	DIN 6527 L
TCDC	h10
TCDCON	h6



Metric version

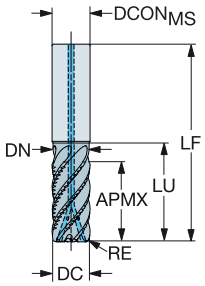
DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	M 1640	S 1640	$DCON_{MS}$	LF
4.0	6	11.0	0.50	11.0	4	2S340-0400-050-MA	★	☆	6.0	57.0
	6	11.0	1.00	11.0	4	2S340-0400-100-MA	★	☆	6.0	57.0
5.0	6	13.0	0.50	13.0	4	2S340-0500-050-MA	★	☆	6.0	57.0
	6	13.0	1.00	13.0	4	2S340-0500-100-MA	★	☆	6.0	57.0
6.0	6	13.0	0.50	13.0	4	2S340-0600-050-MA	★	☆	6.0	57.0
	6	13.0	1.00	13.0	4	2S340-0600-100-MA	★	☆	6.0	57.0
8.0	8	19.0	0.50	19.0	4	2S340-0800-050-MA	★	☆	8.0	63.0
	8	19.0	1.00	19.0	4	2S340-0800-100-MA	★	☆	8.0	63.0
	8	19.0	1.50	19.0	4	2S340-0800-150-MA	★	☆	8.0	63.0
	8	19.0	2.00	19.0	4	2S340-0800-200-MA	★	☆	8.0	63.0
10.0	10	22.0	0.50	22.0	4	2S340-1000-050-MA	★	☆	10.0	72.0
	10	22.0	1.00	22.0	4	2S340-1000-100-MA	★	☆	10.0	72.0
	10	22.0	1.50	22.0	4	2S340-1000-150-MA	★	☆	10.0	72.0
	10	22.0	2.00	22.0	4	2S340-1000-200-MA	★	☆	10.0	72.0
12.0	12	26.0	1.00	26.0	4	2S340-1200-100-MA	★	☆	12.0	83.0
	12	26.0	1.50	26.0	4	2S340-1200-150-MA	★	☆	12.0	83.0
	12	26.0	2.00	26.0	4	2S340-1200-200-MA	★	☆	12.0	83.0
	12	26.0	3.00	26.0	4	2S340-1200-300-MA	★	☆	12.0	83.0
16.0	16	32.0	1.50	32.0	4	2S340-1600-150-MA	★	☆	16.0	92.0
	16	32.0	2.00	32.0	4	2S340-1600-200-MA	★	☆	16.0	92.0
	16	32.0	3.00	32.0	4	2S340-1600-300-MA	★	☆	16.0	92.0
	16	32.0	4.00	32.0	4	2S340-1600-400-MA	★	☆	16.0	92.0
20.0	20	38.0	1.50	38.0	4	2S340-2000-150-MA	★	☆	20.0	104.0
	20	38.0	2.00	38.0	4	2S340-2000-200-MA	★	☆	20.0	104.0
	20	38.0	3.00	38.0	4	2S340-2000-300-MA	★	☆	20.0	104.0
	20	38.0	4.00	38.0	4	2S340-2000-400-MA	★	☆	20.0	104.0

A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For titanium alloys

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	S 1745	Dimensions, mm $DCON_{MS}$	LF	DN
10.0	10	22.0	1.00	30.0	1	3	6	2F340-1000-100CSC	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	1	3	6	2F340-1000-200CSC	★	10.0	72.0	9.5
12.0	12	26.0	1.00	36.0	1	3	6	2F340-1200-100CSC	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	1	3	6	2F340-1200-200CSC	★	12.0	83.0	11.4
16.0	16	34.0	2.00	42.0	1	3	6	2F340-1600-200CSC	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	1	3	6	2F340-1600-300CSC	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	1	3	6	2F340-2000-300CSC	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	1	3	6	2F340-2500-400CSC	★	25.0	121.0	23.8
32.0	32	66.0	4.00	82.0	1	3	6	2F340-3200-400CSC	★	32.0	150.0	30.4

Inch version

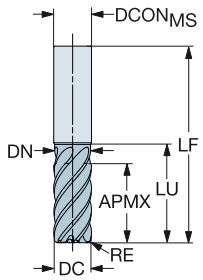
DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	S 1745	Dimensions, inch $DCON_{MS}$	LF	DN
.375	3/8	.781	.030	1.156	1	3	6	2F340-0953-076CSC	★	.375	2.750	.356
	3/8	.781	.060	1.156	1	3	6	2F340-0953-152CSC	★	.375	2.750	.356
.500	1/2	1.125	.060	1.438	1	3	6	2F340-1270-152CSC	★	.500	3.500	.475
	1/2	1.125	.090	1.438	1	3	6	2F340-1270-228CSC	★	.500	3.500	.475
.625	5/8	1.125	.060	1.563	1	3	6	2F340-1588-152CSC	★	.625	3.500	.594
	5/8	1.313	.090	1.563	1	3	6	2F340-1588-228CSC	★	.625	3.500	.594
.750	3/4	1.625	.090	1.563	1	3	6	2F340-1905-228CSC	★	.750	4.000	.713
	3/4	1.625	.120	1.937	1	3	6	2F340-1905-304CSC	★	.750	4.000	.713
1.000	1	2.125	.120	2.656	1	3	6	2F340-2540-304CSC	★	1.000	5.000	.951
1.250	1 1/4	2.625	.120	3.250	1	3	6	2F340-3175-304CSC	★	1.250	6.000	1.187

A181 A194 E9 E22 E28 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For titanium alloys

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	S 1745	$DCON_{MS}$	LF	DN
4.0	6	9.0	0.50	14.5	4	2F340-0400-050-SC	★	6.0	57.0	3.8
5.0	6	11.0	0.50	16.5	4	2F340-0500-050-SC	★	6.0	57.0	4.8
6.0	6	13.0	0.50	20.0	5	2F340-0600-050-SC	★	6.0	57.0	5.7
	6	13.0	1.00	20.0	5	2F340-0600-100-SC	★	6.0	57.0	5.7
8.0	8	18.0	0.50	25.0	5	2F340-0800-050-SC	★	8.0	63.0	7.6
	8	18.0	1.00	25.0	5	2F340-0800-100-SC	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	6	2F340-1000-050-SC	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	6	2F340-1000-100-SC	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	6	2F340-1000-200-SC	★	10.0	72.0	9.5
12.0	12	26.0	1.00	36.0	6	2F340-1200-100-SC	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	6	2F340-1200-200-SC	★	12.0	83.0	11.4
	12	26.0	2.50	36.0	6	2F340-1200-250-SC	★	12.0	83.0	11.4
	12	26.0	3.00	36.0	6	2F340-1200-300-SC	★	12.0	83.0	11.4
16.0	16	34.0	2.00	42.0	6	2F340-1600-200-SC	★	16.0	92.0	15.2
	16	34.0	2.50	42.0	6	2F340-1600-250-SC	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	6	2F340-1600-300-SC	★	16.0	92.0	15.2
	16	34.0	4.00	42.0	6	2F340-1600-400-SC	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	6	2F340-2000-300-SC	★	20.0	104.0	19.0
	20	42.0	4.00	52.0	6	2F340-2000-400-SC	★	20.0	104.0	19.0
	20	42.0	6.35	52.0	6	2F340-2000-635-SC	★	20.0	104.0	19.0
25.0	25	52.0	3.00	63.0	6	2F340-2500-300-SC	★	25.0	121.0	23.8
	25	52.0	4.00	63.0	6	2F340-2500-400-SC	★	25.0	121.0	23.8
	25	52.0	6.35	63.0	6	2F340-2500-635-SC	★	25.0	121.0	23.8
32.0	32	66.0	4.00	82.0	6	2F340-3200-400-SC	★	32.0	150.0	30.4

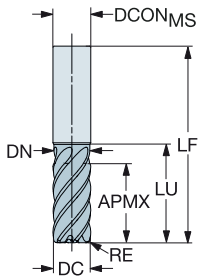
A181 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for high feed side milling

For titanium alloys

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Inch version

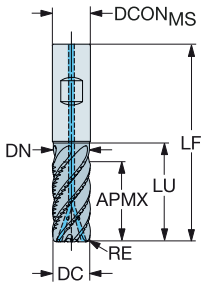
DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	S 1745	DCON$_{MS}$	LF	DN
.188	3/16	.438	.030	.625	4	2F340-0476-076-SC	★	.188	2.000	.178
.250	1/4	.625	.030	.875	5	2F340-0635-076-SC	★	.250	2.500	.237
	1/4	.625	.060	.875	5	2F340-0635-152-SC	★	.250	2.500	.237
.375	3/8	.781	.030	1.156	6	2F340-0953-076-SC	★	.375	2.750	.356
	3/8	.781	.060	1.156	6	2F340-0953-152-SC	★	.375	2.750	.356
	3/8	.781	.090	1.156	6	2F340-0953-228-SC	★	.375	2.750	.356
.500	1/2	1.125	.030	1.438	6	2F340-1270-076-SC	★	.500	3.500	.475
	1/2	1.125	.060	1.438	6	2F340-1270-152-SC	★	.500	3.500	.475
	1/2	1.125	.090	1.438	6	2F340-1270-228-SC	★	.500	3.500	.475
	1/2	1.125	.120	1.438	6	2F340-1270-304-SC	★	.500	3.500	.475
.625	5/8	1.313	.030	1.563	6	2F340-1588-076-SC	★	.625	3.500	.594
	5/8	1.313	.060	1.563	6	2F340-1588-152-SC	★	.625	3.500	.594
	5/8	1.313	.090	1.563	6	2F340-1588-228-SC	★	.625	3.500	.594
	5/8	1.313	.120	1.563	6	2F340-1588-304-SC	★	.625	3.500	.594
.750	3/4	1.625	.030	1.937	6	2F340-1905-076-SC	★	.750	4.000	.713
	3/4	1.625	.060	1.937	6	2F340-1905-152-SC	★	.750	4.000	.713
	3/4	1.625	.090	1.937	6	2F340-1905-228-SC	★	.750	4.000	.713
	3/4	1.625	.120	1.937	6	2F340-1905-304-SC	★	.750	4.000	.713
1.000	1	2.125	.030	2.656	6	2F340-2540-076-SC	★	1.000	5.000	.951
	1	2.125	.060	2.656	6	2F340-2540-152-SC	★	1.000	5.000	.951
	1	2.125	.090	2.656	6	2F340-2540-228-SC	★	1.000	5.000	.951
	1	2.125	.120	2.656	6	2F340-2540-304-SC	★	1.000	5.000	.951
1.250	1 1/4	2.625	.030	3.250	6	2F340-3175-076-SC	★	1.250	6.000	1.187
	1 1/4	2.625	.060	3.250	6	2F340-3175-152-SC	★	1.250	6.000	1.187
	1 1/4	2.625	.090	3.250	6	2F340-3175-228-SC	★	1.250	6.000	1.187
	1 1/4	2.625	.120	3.250	6	2F340-3175-304-SC	★	1.250	6.000	1.187

A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For titanium alloys

FHA 42°
BSG COROMANT
TCDC h10
TCDCON h6

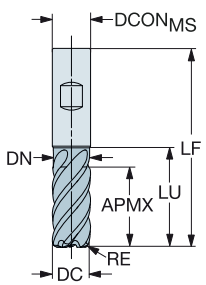


Metric version

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	S 1745	$DCON_{MS}$	LF	DN
16.0	16	34.0	2.00	42.0	1	3	6	2F340-1600-200CSD	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	1	3	6	2F340-1600-300CSD	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	1	3	6	2F340-2000-300CSD	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	1	3	6	2F340-2500-400CSD	★	25.0	121.0	23.8

Dimensions, mm

FHA 42°
BSG COROMANT
TCDC h10
TCDCON h6



Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	S 1745	$DCON_{MS}$	LF	DN
16.0	16	34.0	2.00	42.0	6	2F340-1600-200-SD	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	6	2F340-1600-300-SD	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	6	2F340-2000-300-SD	★	20.0	104.0	19.0
	20	42.0	4.00	52.0	6	2F340-2000-400-SD	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	6	2F340-2500-400-SD	★	25.0	121.0	23.8

Dimensions, mm

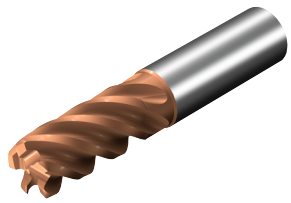
A181 A194 E9 E22 E28 E14

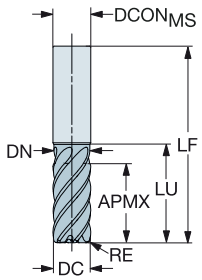
SANDVIK Coromant

CoroMill® Plura solid carbide end mill for high feed side milling

For nickel-based alloys

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

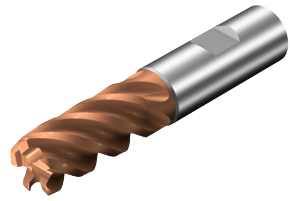
DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	S 1710	$DCON_{MS}$	LF	DN
4.0	6	9.0	0.50	14.5	4	2F341-0400-050-SC	★	6.0	57.0	3.8
5.0	6	11.0	0.50	16.5	4	2F341-0500-050-SC	★	6.0	57.0	4.8
6.0	6	13.0	0.50	20.0	5	2F341-0600-050-SC	★	6.0	57.0	5.7
	6	13.0	1.00	20.0	5	2F341-0600-100-SC	★	6.0	57.0	5.7
8.0	8	18.0	0.50	25.0	5	2F341-0800-050-SC	★	8.0	63.0	7.6
	8	18.0	1.00	25.0	5	2F341-0800-100-SC	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	5	2F341-1000-050-SC	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	5	2F341-1000-100-SC	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	5	2F341-1000-200-SC	★	10.0	72.0	9.5
12.0	12	26.0	1.00	36.0	5	2F341-1200-100-SC	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	5	2F341-1200-200-SC	★	12.0	83.0	11.4
	12	26.0	2.50	36.0	5	2F341-1200-250-SC	★	12.0	83.0	11.4
	12	26.0	3.00	36.0	5	2F341-1200-300-SC	★	12.0	83.0	11.4
16.0	16	34.0	2.00	42.0	5	2F341-1600-200-SC	★	16.0	92.0	15.2
	16	34.0	2.50	42.0	5	2F341-1600-250-SC	★	16.0	92.0	15.2
	16	34.0	3.00	42.0	5	2F341-1600-300-SC	★	16.0	92.0	15.2
	16	34.0	4.00	42.0	5	2F341-1600-400-SC	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	5	2F341-2000-300-SC	★	20.0	104.0	19.0
	20	42.0	4.00	52.0	5	2F341-2000-400-SC	★	20.0	104.0	19.0
	20	42.0	6.35	52.0	5	2F341-2000-635-SC	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	5	2F341-2500-400-SC	★	25.0	121.0	23.8
	25	52.0	6.35	63.0	5	2F341-2500-635-SC	★	25.0	121.0	23.8

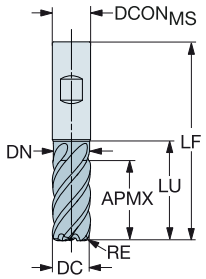
A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed side milling

For nickel-based alloys

FHA	42°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	S 1710	$DCON_{MS}$	LF	DN
16.0	16	34.0	3.00	42.0	5	2F341-1600-300-SD	★	16.0	92.0	15.2
	16	34.0	4.00	42.0	5	2F341-1600-400-SD	★	16.0	92.0	15.2
20.0	20	42.0	3.00	52.0	5	2F341-2000-300-SD	★	20.0	104.0	19.0
	20	42.0	4.00	52.0	5	2F341-2000-400-SD	★	20.0	104.0	19.0
25.0	25	52.0	4.00	63.0	5	2F341-2500-400-SD	★	25.0	121.0	23.8

A181 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed face milling

When to use

Face milling roughing

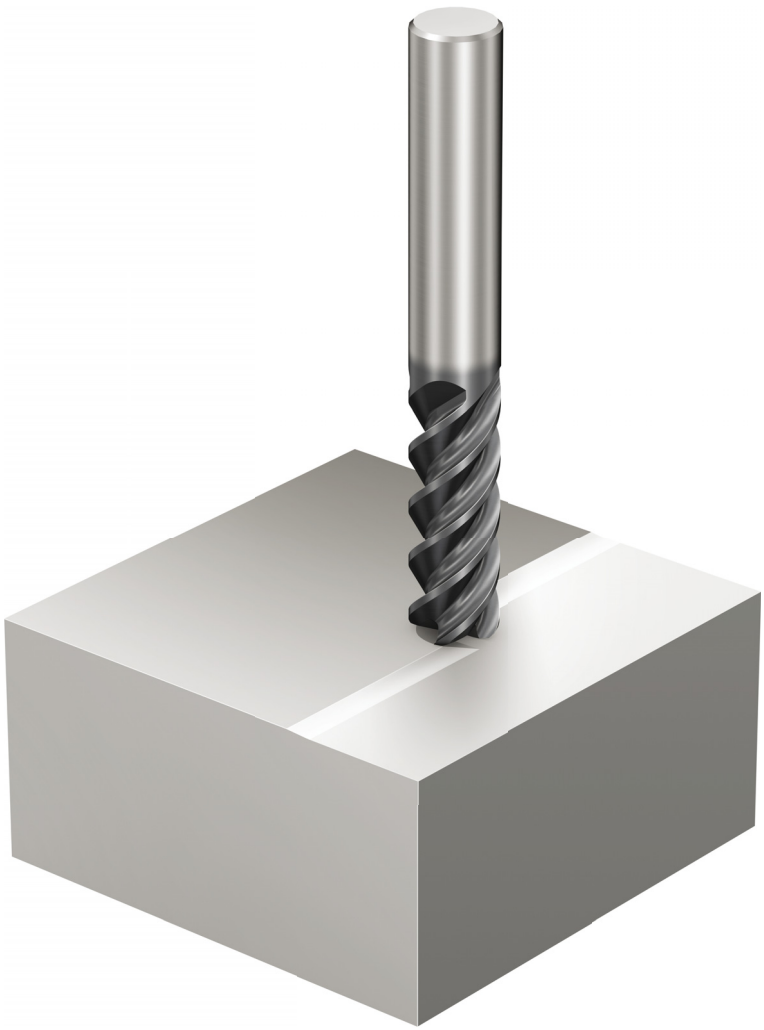
High feed roughing of 3D shapes

ISO material	P	M	K	S	H
Grade	1610		1620		
Shank	Cylindrical				

Product range

For hardened steel with hardness 43 ≤ HRc ≤ 63

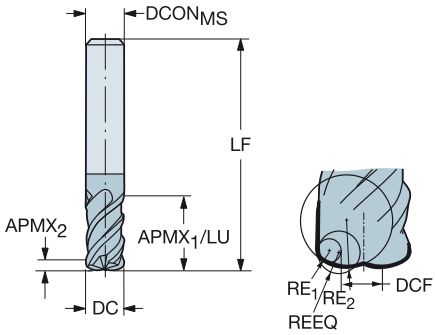
For stainless steel and steel with hardness ≤ 48 HRc



CoroMill® Plura solid carbide end mill for high feed face milling

For steel and hardened steel with hardness ≤ 63 HRc

FHA	50°
BSG	COROMANT
TCDC	h9
TCDCON	h8



Metric version

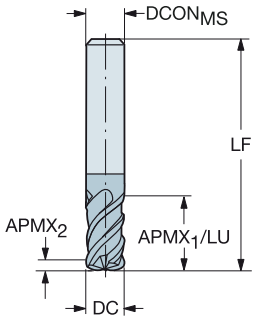
DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	LU	ZEFP	Ordering code	P 1610	H 1610	$DCON_{MS}$	DCF	LF	REEQ
											Dimensions, mm			
4.0	6	11.0	0.1	0.5	4.0	15.0	4	R215.H4-04050BAC01H	☆	★	6.0	1.2	57.0	0.62
6.0	6	15.0	0.2	0.5	9.0	15.0	4	R215.H4-06050BAC02H	☆	★	6.0	1.4	57.0	0.69
8.0	8	20.0	0.2	1.0	12.0	20.0	4	R215.H4-08050CAC02H	☆	★	8.0	6.4	63.0	1.23
10.0	10	26.0	0.3	1.5	15.0	26.0	4	R215.H4-10050DAC03H	☆	★	10.0	1.6	72.0	1.77
12.0	12	30.0	0.4	1.5	18.0	30.0	4	R215.H4-12050DAC04H	☆	★	12.0	2.0	83.0	1.88
16.0	16	36.0	0.5	2.0	24.0	36.0	4	R215.H4-16050EAC05H	☆	★	16.0	3.0	92.0	2.46
20.0	20	45.0	0.6	2.0	30.0	45.0	4	R215.H4-20050EAC06H	☆	★	20.0	4.4	104.0	2.61

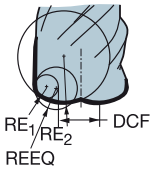
A183 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed face milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9
TCDCON	h6





Metric version

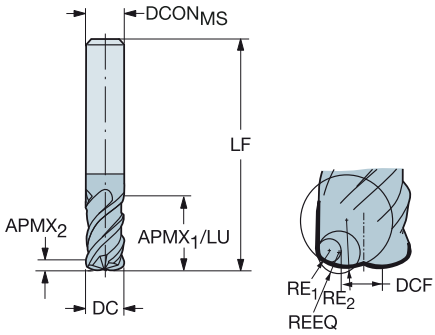
DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm $DCON_{MS}$	DCF	LF	REEQ
6.0	6	15.0	0.2	0.5	3.0	15.0	4	R215.H4-06050BAK02P	★	★	☆	☆	6.0	2.8	100.0	0.75
8.0	8	20.0	0.3	1.0	4.0	20.0	4	R215.H4-08050CAK02P	★	★	☆	☆	8.0	3.1	120.0	1.38
10.0	10	26.0	0.7	1.5	5.0	26.0	4	R215.H4-10050DAK03P	★	★	☆	☆	10.0	3.4	150.0	1.99
12.0	12	12.0	0.7	1.5	6.0	12.0	4	R215.H4-12050DAK08P	★	★	☆	☆	12.0	4.5	93.0	2.10
16.0	16	16.0	1.0	2.0	8.0	16.0	4	R215.H4-16050EAK10P	★	★	☆	☆	16.0	6.2	112.0	2.75
20.0	20	20.0	1.3	2.0	10.0	20.0	4	R215.H4-20050EAK13P	★	★	☆	☆	20.0	8.0	130.0	3.07

A183 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for high feed face milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h6



Metric version

DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	$DCON_{MS}$	DCF	LF	REEQ
4.0	6	11.0	0.2	0.5	2.0	11.0	4	R215.H4-04050BAC02P	★	★	☆	☆	6.0	1.6	57.0	0.67
6.0	6	15.0	0.3	0.5	3.0	15.0	4	R215.H4-06050BAC03P	★	★	☆	☆	6.0	2.8	57.0	0.75
8.0	8	20.0	0.5	1.0	4.0	20.0	4	R215.H4-08050CAC05P	★	★	☆	☆	8.0	3.1	63.0	1.38
10.0	10	26.0	0.7	1.5	5.0	26.0	4	R215.H4-10050DAC07P	★	★	☆	☆	10.0	3.4	72.0	1.99
12.0	12	30.0	0.8	1.5	6.0	30.0	4	R215.H4-12050DAC08P	★	★	☆	☆	12.0	4.5	83.0	2.10
16.0	16	36.0	1.0	2.0	8.0	36.0	4	R215.H4-16050EAC10P	★	★	☆	☆	16.0	6.2	92.0	2.75
20.0	20	45.0	1.3	2.0	10.0	45.0	4	R215.H4-20050EAC13P	★	★	☆	☆	20.0	8.0	104.0	3.07

A183 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for stable multi-operations milling

When to use

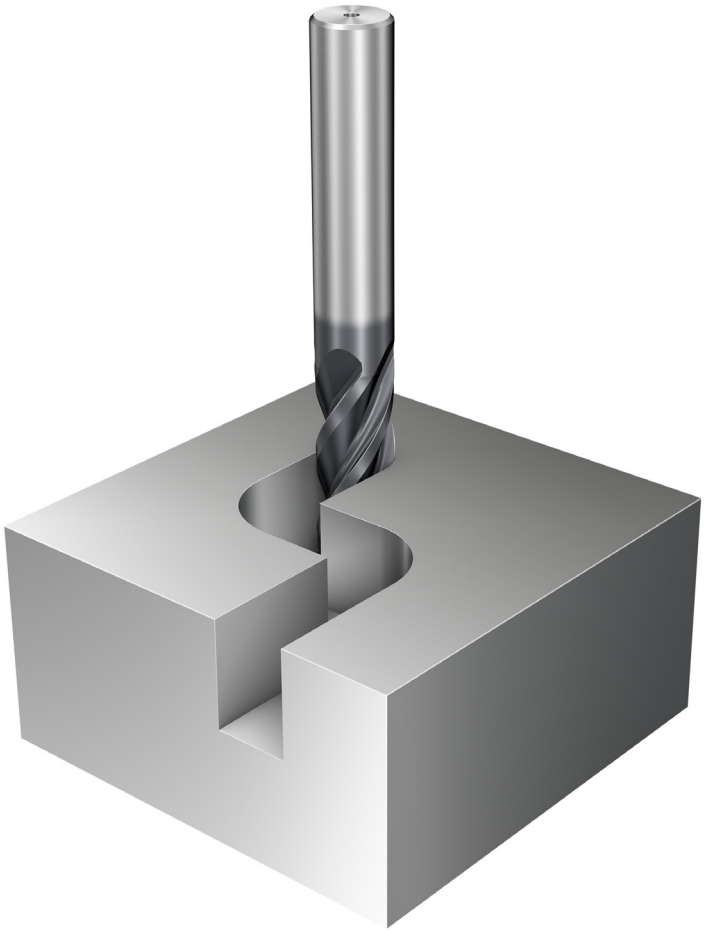
Multi-purpose concept with good performance in most operations and applications
Excellent choice for helical interpolation

ISO material	P	M	K	S	H
Grade	1620	1630	1640		
Shank	Cylindrical	Weldon			

Product range

For stainless steel and steel with hardness ≤ 48 HRc

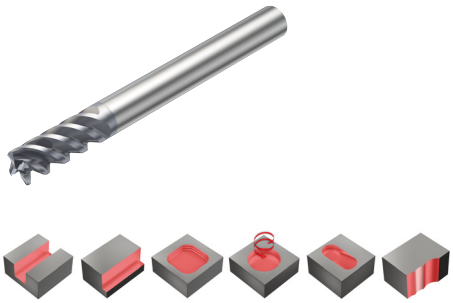
For stainless steel and steel with hardness ≤ 63 HRc

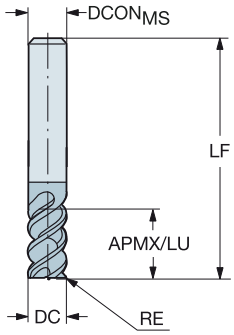


CoroMill® Plura solid carbide end mill for stable multi-operations milling

For steel and hardened steel with hardness ≤ 63 HRc

FHA	50°
BSG	COROMANT
TCDC	h9
TCDCON	h6





Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1620	H 1620	Dimensions, mm DCON$_{MS}$	LF
2.0	6	7.0	0.50	7.0	3	R216.23-02050BAK70H	☆	★	6.0	57.0
3.0	6	8.0	0.50	8.0	3	R216.23-03050BAK08H	☆	★	6.0	57.0
4.0	6	11.0	1.00	11.0	3	R216.23-04050CAK11H	☆	★	6.0	57.0
5.0	6	13.0	1.00	13.0	3	R216.23-05050CAK13H	☆	★	6.0	57.0
6.0	6	13.0	1.00	13.0	4	R216.24-06050CAK13H	☆	★	6.0	65.0
8.0	8	19.0	2.00	19.0	4	R216.24-08050EAK19H	☆	★	8.0	80.0
10.0	10	22.0	2.00	22.0	4	R216.24-10050EAK22H	☆	★	10.0	100.0
12.0	12	26.0	3.00	26.0	4	R216.24-12050GAK26H	☆	★	12.0	100.0
14.0	14	26.0	3.00	26.0	4	R216.24-14050GAK26H	☆	★	14.0	104.0
16.0	16	32.0	4.00	32.0	4	R216.24-16050IAK32H	☆	★	16.0	115.0
20.0	20	38.0	4.00	38.0	4	R216.24-20050IAK38H	☆	★	20.0	125.0

Inch version

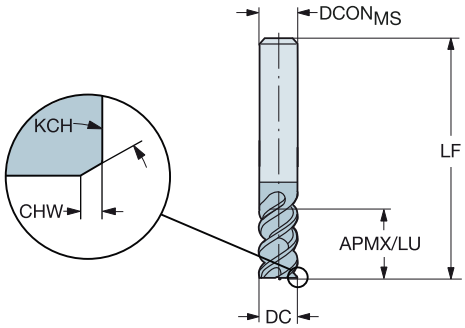
DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1620	H 1620	Dimensions, inch DCON$_{MS}$	LF
.187	1/4	.375	.016	.375	3	RA216.23-1250AAK06H	☆	★	.250	3.000
	1/4	.375	.031	.375	3	RA216.23-1250BAK06H	☆	★	.250	3.000
.250	1/4	.500	.016	.500	4	RA216.24-1650AAK08H	☆	★	.250	3.000
	1/4	.500	.031	.500	4	RA216.24-1650BAK08H	☆	★	.250	3.000
.313	3/8	.625	.016	.625	4	RA216.24-2050AAK10H	☆	★	.375	3.500
	3/8	.625	.031	.625	4	RA216.24-2050BAK10H	☆	★	.375	3.500
.375	3/8	.750	.016	.750	4	RA216.24-2450AAK12H	☆	★	.375	3.500
	3/8	.750	.031	.750	4	RA216.24-2450BAK12H	☆	★	.375	3.500
.500	1/2	1.000	.031	1.000	4	RA216.24-3250BAK16H	☆	★	.500	4.000
	1/2	1.000	.063	1.000	4	RA216.24-3250DAK16H	☆	★	.500	4.000
.625	5/8	1.250	.063	1.250	4	RA216.24-4050DAK20H	☆	★	.625	4.500
.750	3/4	1.500	.063	1.500	4	RA216.24-4850DAK24H	☆	★	.750	5.000

A184 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For steel and hardened steel with hardness ≤ 63 HRc

FHA	50°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

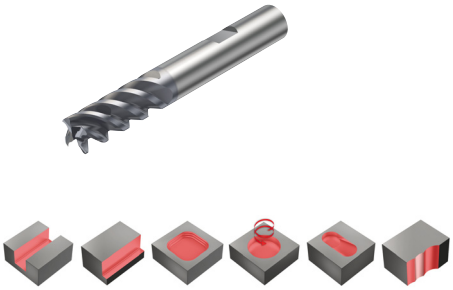
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	H 1620	$DCON_{MS}$	LF
										Dimensions, mm	
2.0	6	7.0	0.10	45°	7.0	3	R216.33-02050-AK70H	☆	★	6.0	57.0
3.0	6	8.0	0.10	45°	8.0	3	R216.33-03050-AK08H	☆	★	6.0	57.0
4.0	6	11.0	0.10	45°	11.0	3	R216.33-04050-AK11H	☆	★	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	3	R216.33-05050-AK13H	☆	★	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	4	R216.34-06050-AK13H	☆	★	6.0	65.0
8.0	8	19.0	0.10	45°	19.0	4	R216.34-08050-AK19H	☆	★	8.0	80.0
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10050-AK22H	☆	★	10.0	100.0
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12050-AK26H	☆	★	12.0	100.0
14.0	14	26.0	0.15	45°	26.0	4	R216.34-14050-AK26H	☆	★	14.0	104.0
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16050-AK32H	☆	★	16.0	115.0
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20050-AK38H	☆	★	20.0	125.0

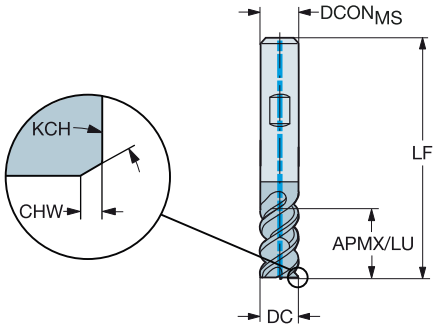
A184 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

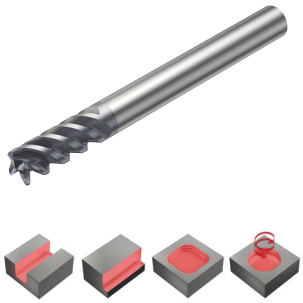
DC	CZC_{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Ordering code	P 1640	M 1640	K 1640	S 1640	Dimensions, mm $DCON_{MS}$	LF
6.0	6	13.0	0.10	45°	13.0	1	1	4	R215.34C06050-BC13P	☆	★	☆	★	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	1	1	4	R215.34C08050-BC19P	☆	★	☆	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	1	1	4	R215.34C10050-BC22P	☆	★	☆	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	1	1	4	R215.34C12050-BC26P	☆	★	☆	★	12.0	83.0
16.0	16	32.0	0.15	45°	32.0	1	1	4	R215.34C16050-BC32P	☆	★	☆	★	16.0	92.0
20.0	20	38.0	0.15	45°	38.0	1	1	4	R215.34C20050-BC38P	☆	★	☆	★	20.0	104.0

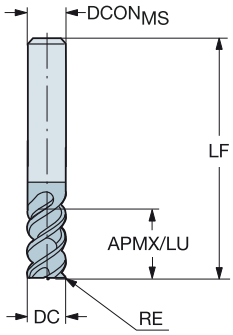
A184 A194 E9 E22 E28 E14

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9
TCDCON	h6





Metric version

DC	CZCMS	APMX	RE	LU	ZEFP	Ordering code	P 1620	P 1630	M 1620	M 1630	K 1620	K 1630	S 1620	S 1630	Dimensions, mm DCONMS	LF
4.0	6	11.0	1.00	11.0	3	R216.23-04050CAK11P	☆	★	★	☆	☆	★	★	☆	6.0	57.0
5.0	6	13.0	1.00	13.0	3	R216.23-05050CAK13P	☆	★	★	☆	☆	★	★	☆	6.0	57.0
6.0	6	13.0	1.00	13.0	4	R216.24-06050CAK13P	☆	★	★	☆	☆	★	★	☆	6.0	65.0
8.0	8	19.0	2.00	19.0	4	R216.24-08050EAK19P	☆	★	★	☆	☆	★	★	☆	8.0	80.0
10.0	10	22.0	2.00	22.0	4	R216.24-10050EAK22P	☆	★	★	☆	☆	★	★	☆	10.0	100.0
12.0	12	26.0	3.00	26.0	4	R216.24-12050GAK26P	☆	★	★	☆	☆	★	★	☆	12.0	100.0
14.0	14	26.0	3.00	26.0	4	R216.24-14050GAK26P	☆	★	★	☆	☆	★	★	☆	14.0	104.0
16.0	16	32.0	4.00	32.0	4	R216.24-16050IAK32P	☆	★	★	☆	☆	★	★	☆	16.0	115.0
20.0	20	38.0	4.00	38.0	4	R216.24-20050IAK38P	☆	★	★	☆	☆	★	★	☆	20.0	125.0

Inch version

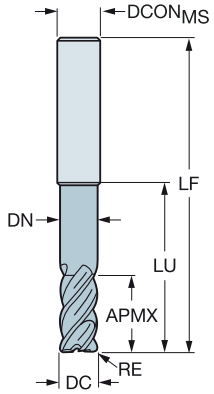
DC	CZCMS	APMX	RE	LU	ZEFP	Ordering code	P 1620	P 1630	M 1620	M 1630	K 1620	K 1630	S 1620	S 1630	Dimensions, inch DCONMS	LF
.187	1/4	.375	.016	.375	3	RA216.23-1250AAK06P		★		★		☆		☆	.250	3.000
	1/4	.562	.016	.562	3	RA216.23-1250AAK09P	★		★		☆		☆		.250	3.000
	1/4	.562	.031	.562	3	RA216.23-1250BAK09P	★		★		☆		☆		.250	3.000
.250	1/4	.750	.016	.750	4	RA216.24-1650AAK12P	★		★		☆		☆		.250	3.000
	1/4	.500	.016	.500	4	RA216.24-1650AAK08P		★		★		☆		☆	.250	3.000
	1/4	.750	.031	.750	4	RA216.24-1650BAK12P	★		★		☆		☆		.250	3.000
.313	3/8	1.000	.016	1.000	4	RA216.24-2050AAK15P	★		★		☆		☆		.375	3.500
	3/8	.625	.016	.625	4	RA216.24-2050AAK10P		★		★		☆		☆	.375	3.500
	3/8	1.000	.031	1.000	4	RA216.24-2050BAK15P	★		★		☆		☆		.375	3.500
.375	3/8	.750	.016	.750	4	RA216.24-2450AAK12P		★		★		☆		☆	.375	3.500
	3/8	1.125	.016	1.125	4	RA216.24-2450AAK18P	★		★		☆		☆		.375	3.500
	3/8	1.125	.031	1.125	4	RA216.24-2450BAK18P	★		★		☆		☆		.375	3.500
.500	1/2	1.000	.031	1.000	4	RA216.24-3250BAK16P		★		★		☆		☆	.500	4.000
	1/2	1.500	.031	1.500	4	RA216.24-3250BAK24P	★		★		☆		☆		.500	4.000
	1/2	1.500	.063	1.500	4	RA216.24-3250DAK24P	★		★		☆		☆		.500	4.000
.625	5/8	1.250	.031	1.250	4	RA216.24-4050BAK20P		★		★		☆		☆	.625	4.500
	5/8	1.875	.063	1.875	4	RA216.24-4050DAK30P	★		★		☆		☆		.625	4.500
.750	3/4	1.500	.031	1.500	4	RA216.24-4850BAK24P		★		★		☆		☆	.750	5.000
	3/4	2.250	.063	2.250	4	RA216.24-4850DAK36P	★		★		☆		☆		.750	5.000

A184 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9
TCDCON	h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	10	22.0	1.00	42.0	4	R216.24-10050CCK22P	★	★	☆	☆	10.0	100.0	9.5
	10	22.0	1.50	42.0	4	R216.24-10050DCK22P	★	★	☆	☆	10.0	100.0	9.5
	10	22.0	2.00	42.0	4	R216.24-10050ECK22P	★	★	☆	☆	10.0	100.0	9.5
	10	22.0	2.50	42.0	4	R216.24-10050FCK22P	★	★	☆	☆	10.0	100.0	9.5
	10	22.0	3.00	42.0	4	R216.24-10050GCK22P	★	★	☆	☆	10.0	100.0	9.5
12.0	12	26.0	1.00	53.0	4	R216.24-12050CCK26P	★	★	☆	☆	12.0	100.0	11.4
	12	26.0	1.50	53.0	4	R216.24-12050DCK26P	★	★	☆	☆	12.0	100.0	11.4
	12	26.0	2.00	53.0	4	R216.24-12050ECK26P	★	★	☆	☆	12.0	100.0	11.4
	12	26.0	2.50	53.0	4	R216.24-12050FCK26P	★	★	☆	☆	12.0	100.0	11.4
	12	26.0	3.00	53.0	4	R216.24-12050GCK26P	★	★	☆	☆	12.0	100.0	11.4
	12	26.0	3.00	60.0	4	R216.24-12050GCL26P	★	★	☆	☆	12.0	105.0	11.4
	12	26.0	4.00	53.0	4	R216.24-12050ICK26P	★	★	☆	☆	12.0	100.0	11.4
16.0	16	36.0	1.00	65.0	4	R216.24-16050CCK36P	★	★	☆	☆	16.0	115.0	15.2
	16	36.0	1.50	65.0	4	R216.24-16050DCK36P	★	★	☆	☆	16.0	115.0	15.2
	16	36.0	2.00	65.0	4	R216.24-16050ECK36P	★	★	☆	☆	16.0	115.0	15.2
	16	36.0	2.50	65.0	4	R216.24-16050FCK36P	★	★	☆	☆	16.0	115.0	15.2
	16	36.0	3.00	65.0	4	R216.24-16050GCK36P	★	★	☆	☆	16.0	115.0	15.2
	16	36.0	3.00	80.0	4	R216.24-16050GCL36P	★	★	☆	☆	16.0	128.0	15.2
	16	36.0	4.00	65.0	4	R216.24-16050ICK36P	★	★	☆	☆	16.0	115.0	15.2
	16	36.0	6.35	67.0	4	R216.24-16050OCK36P	★	★	☆	☆	16.0	115.0	15.2
	16	36.0	6.35	80.0	4	R216.24-16050OCL36P	★	★	☆	☆	16.0	128.0	15.2
20.0	20	44.0	2.50	80.0	4	R216.24-20050FCK44P	★	★	☆	☆	20.0	145.0	19.0
	20	44.0	3.00	80.0	4	R216.24-20050GCK44P	★	★	☆	☆	20.0	145.0	19.0
	20	44.0	3.00	100.0	4	R216.24-20050GCL44P	★	★	☆	☆	20.0	150.0	19.0
	20	44.0	4.00	80.0	4	R216.24-20050ICK44P	★	★	☆	☆	20.0	145.0	19.0
	20	44.0	6.35	80.0	4	R216.24-20050OCK44P	★	★	☆	☆	20.0	145.0	19.0
25.0	25	54.0	3.00	98.0	5	R216.25-25050GCK54P	★	★	☆	☆	25.0	155.0	24.0
	25	54.0	3.00	125.0	5	R216.25-25050GCL54P	★	★	☆	☆	25.0	181.0	23.8
	25	54.0	4.00	99.0	5	R216.25-25050ICK54P	★	★	☆	☆	25.0	156.0	24.0
	25	54.0	6.35	99.0	5	R216.25-25050OCK54P	★	★	☆	☆	25.0	156.0	24.0
	25	54.0	6.35	125.0	5	R216.25-25050OCL54P	★	★	☆	☆	25.0	181.0	24.0

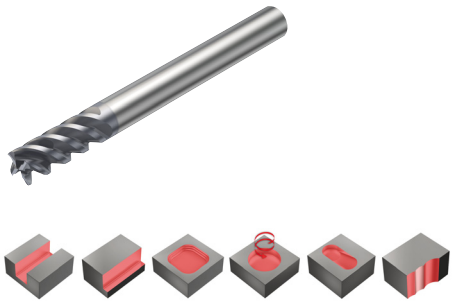
A184 A194 E9 E22 E14

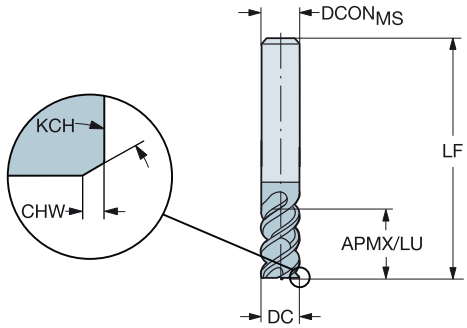
SANDVIK Coromant

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h10
TCDCON	h6





Metric version

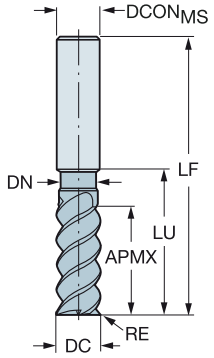
DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	P 1630	M 1620	M 1630	K 1620	K 1630	S 1620	S 1630	Dimensions, mm DCON$_{MS}$	LF
4.0	6	11.0	0.10	45°	11.0	3	R216.33-04050-AK11P	★	★	★	★	☆	☆	☆	☆	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	3	R216.33-05050-AK13P	★	★	★	★	☆	☆	☆	☆	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	4	R216.34-06050-AK13P	★	★	★	★	☆	☆	☆	☆	6.0	65.0
8.0	8	19.0	0.10	45°	19.0	4	R216.34-08050-AK19P	★	★	★	★	☆	☆	☆	☆	8.0	80.0
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10050-AK22P	★	★	★	★	☆	☆	☆	☆	10.0	100.0
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12050-AK26P	★	★	★	★	☆	☆	☆	☆	12.0	100.0
14.0	14	26.0	0.15	45°	26.0	4	R216.34-14050-AK26P	★	★	★	★	☆	☆	☆	☆	14.0	104.0
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16050-AK32P	★	★	★	★	☆	☆	☆	☆	16.0	115.0
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20050-AK38P	★	★	★	★	☆	☆	☆	☆	20.0	125.0

A184 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9
TCDCON	h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm DCON$_{MS}$	LF	DN
2.0	6	7.0	0.20	9.5	3	R216.23-02050ACC07P	★	★	☆	☆	6.0	57.0	1.9
3.0	6	8.0	0.30	10.0	3	R216.23-03050ACC08P	★	★	☆	☆	6.0	57.0	2.9
4.0	6	11.0	0.50	15.0	3	R216.23-04050BCC11P	★	★	☆	☆	6.0	57.0	3.8
5.0	6	13.0	0.50	16.0	3	R216.23-05050BCC13P	★	★	☆	☆	6.0	57.0	4.8
6.0	6	13.0	0.50	19.0	4	R216.24-06050BCC13P	★	★	☆	☆	6.0	57.0	5.7
	6	13.0	1.00	19.0	4	R216.24-06050CCC13P	★	★	☆	☆	6.0	57.0	5.7
8.0	8	19.0	0.50	25.0	4	R216.24-08050BCC19P	★	★	☆	☆	8.0	63.0	7.6
	8	19.0	1.00	25.0	4	R216.24-08050CCC19P	★	★	☆	☆	8.0	63.0	7.6
	8	19.0	1.50	25.0	4	R216.24-08050DCC19P	★	★	☆	☆	8.0	63.0	7.6
	8	19.0	2.00	25.0	4	R216.24-08050ECC19P	★	★	☆	☆	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	4	R216.24-10050BCC22P	★	★	☆	☆	10.0	72.0	9.5
	10	22.0	1.00	30.0	4	R216.24-10050CCC22P	★	★	☆	☆	10.0	72.0	9.5
	10	22.0	1.50	30.0	4	R216.24-10050DCC22P	★	★	☆	☆	10.0	72.0	9.5
	10	22.0	2.00	30.0	4	R216.24-10050ECC22P	★	★	☆	☆	10.0	72.0	9.5
12.0	12	26.0	0.50	36.0	4	R216.24-12050BCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	1.00	36.0	4	R216.24-12050CCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	1.50	36.0	4	R216.24-12050DCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	2.00	36.0	4	R216.24-12050ECC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	2.50	36.0	4	R216.24-12050FCC26P	★	★	☆	☆	12.0	83.0	11.4
	12	26.0	3.00	36.0	4	R216.24-12050GCC26P	★	★	☆	☆	12.0	83.0	11.4
16.0	16	32.0	0.50	42.0	4	R216.24-16050BCC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	1.00	42.0	4	R216.24-16050CCC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	2.00	42.0	4	R216.24-16050ECC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	2.50	42.0	4	R216.24-16050FCC32P	★	★	☆	☆	16.0	92.0	15.2
	16	32.0	4.00	42.0	4	R216.24-16050ICC32P	★	★	☆	☆	16.0	92.0	15.2
20.0	20	38.0	1.00	52.0	4	R216.24-20050CCC38P	★	★	☆	☆	20.0	104.0	19.0
	20	38.0	2.00	52.0	4	R216.24-20050ECC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	2.50	80.0	4	R216.24-20050FCC44P	★	★	☆	☆	20.0	130.0	19.0
	20	38.0	2.50	52.0	4	R216.24-20050FCC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	3.00	80.0	4	R216.24-20050GCC44P	★	★	☆	☆	20.0	130.0	19.0
	20	38.0	3.00	52.0	4	R216.24-20050GCC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	4.00	80.0	4	R216.24-20050ICC44P	★	★	☆	☆	20.0	130.0	19.0
	20	38.0	4.00	52.0	4	R216.24-20050ICC38P	★	★	☆	☆	20.0	104.0	19.0
	20	44.0	6.35	80.0	4	R216.24-20050OCC44P	★	★	☆	☆	20.0	104.0	19.0

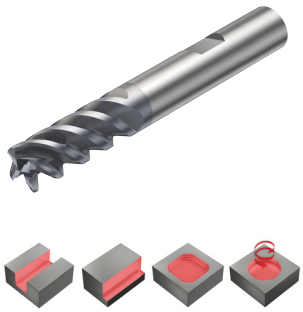
A184 A194 E9 E22 E14

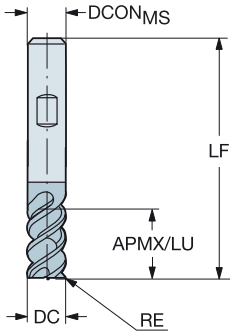
SANDVIK Coromant

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA 50°
BSG DIN 6527 L
TCDC h9
TCDCON h6

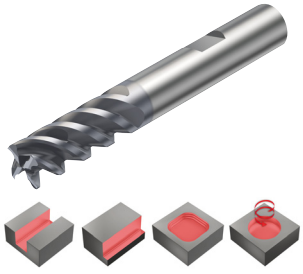


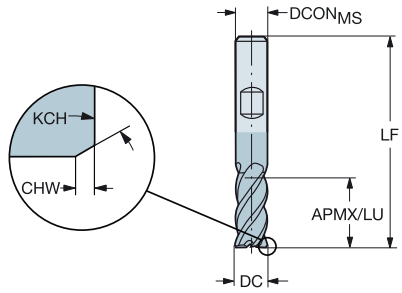


Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1620	P 1630	M 1620	M 1630	K 1620	K 1630	S 1620	S 1630	Dimensions, mm DCON$_{MS}$	LF
6.0	6	13.0	1.00	13.0	4	R216.24-06050CBC13P	☆	★	★	☆	☆	★	★	☆	6.0	57.0
8.0	8	19.0	2.00	19.0	4	R216.24-08050EBC19P	☆	★	★	☆	☆	★	★	☆	8.0	63.0
10.0	10	22.0	2.00	22.0	4	R216.24-10050EBC22P	☆	★	★	☆	☆	★	★	☆	10.0	72.0
12.0	12	26.0	3.00	26.0	4	R216.24-12050GBC26P	☆	★	★	☆	☆	★	★	☆	12.0	83.0
14.0	14	26.0	3.00	26.0	4	R216.24-14050GBC26P		★		☆		★		☆	14.0	83.0
16.0	16	32.0	4.00	32.0	4	R216.24-16050IBC32P	☆	★	★	☆	☆	★	★	☆	16.0	92.0
20.0	20	38.0	4.00	38.0	4	R216.24-20050IBC38P	☆	★	★	☆	☆	★	★	☆	20.0	104.0

FHA 50°
BSG DIN 6527 L
TCDC h10
TCDCON h6





Metric version

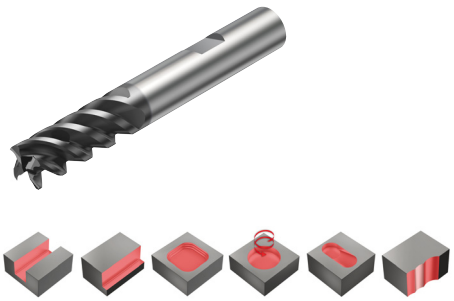
DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	P 1630	P 1640	M 1620	M 1630	M 1640	K 1620	K 1630	K 1640	S 1620	S 1630	S 1640	Dimensions, mm DCON$_{MS}$	LF
6.0	6	13.0	0.10	45°	13.0	4	R216.34-06050-BC13P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	4	R216.34-08050-BC19P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10050-BC22P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12050-BC26P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	12.0	83.0
14.0	14	26.0	0.15	45°	26.0	4	R216.34-14050-BC26P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	14.0	83.0
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16050-BC32P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	16.0	92.0
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20050-BC38P	★	★	☆	★	★	★	☆	☆	☆	☆	☆	★	20.0	104.0

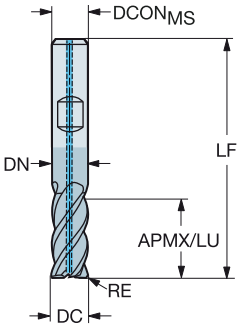
A184 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For nickel-based alloys

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h6





Metric version

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	S 1725	Dimensions, mm $DCON_{MS}$	LF	DN
6.0	6	13.0	0.50	19.0	1	1	4	2F440-0600-050ASD	★	6.0	57.0	5.7
	6	13.0	1.00	19.0	1	1	4	2F440-0600-100ASD	★	6.0	57.0	5.7
8.0	8	19.0	0.50	25.0	1	1	4	2F440-0800-050ASD	★	8.0	63.0	7.6
	8	19.0	1.00	25.0	1	1	4	2F440-0800-100ASD	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	1	1	4	2F440-1000-050ASD	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	1	1	4	2F440-1000-100ASD	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	1	1	4	2F440-1000-200ASD	★	10.0	72.0	9.5
12.0	12	26.0	0.50	36.0	1	1	4	2F440-1200-050ASD	★	12.0	83.0	11.4
	12	26.0	1.00	36.0	1	1	4	2F440-1200-100ASD	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	1	1	4	2F440-1200-200ASD	★	12.0	83.0	11.4
16.0	16	32.0	2.00	42.0	1	1	4	2F440-1600-200ASD	★	16.0	92.0	15.2
	16	32.0	3.00	42.0	1	1	4	2F440-1600-300ASD	★	16.0	92.0	15.2
	16	32.0	4.00	42.0	1	1	4	2F440-1600-400ASD	★	16.0	92.0	15.2
20.0	20	38.0	3.00	52.0	1	1	4	2F440-2000-300ASD	★	20.0	104.0	19.0
	20	38.0	4.00	52.0	1	1	4	2F440-2000-400ASD	★	20.0	104.0	19.0
	20	38.0	6.35	52.0	1	1	4	2F440-2000-635ASD	★	20.0	104.0	19.0

Inch version

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	S 1725	Dimensions, inch $DCON_{MS}$	LF	DN
.250	1/4	.625	.030	.875	1	1	4	2F440-0635-076ASD	★	.250	2.500	.237
	1/4	.625	.060	.875	1	1	4	2F440-0635-152ASD	★	.250	2.500	.237
.375	3/8	.781	.030	1.156	1	1	4	2F440-0953-076ASD	★	.375	3.000	.356
	3/8	.781	.060	1.156	1	1	4	2F440-0953-152ASD	★	.375	3.000	.356
	3/8	.781	.090	1.156	1	1	4	2F440-0953-228ASD	★	.375	3.000	.356
.500	1/2	1.125	.030	1.438	1	1	4	2F440-1270-076ASD	★	.500	3.500	.475
	1/2	1.125	.060	1.438	1	1	4	2F440-1270-152ASD	★	.500	3.500	.475
	1/2	1.125	.090	1.438	1	1	4	2F440-1270-228ASD	★	.500	3.500	.475
	1/2	1.125	.120	1.438	1	1	4	2F440-1270-304ASD	★	.500	3.500	.475
.625	5/8	1.313	.030	1.563	1	1	4	2F440-1588-076ASD	★	.625	3.750	.594
	5/8	1.313	.060	1.563	1	1	4	2F440-1588-152ASD	★	.625	3.750	.594
	5/8	1.313	.090	1.563	1	1	4	2F440-1588-228ASD	★	.625	3.750	.594
	5/8	1.313	.120	1.563	1	1	4	2F440-1588-304ASD	★	.625	3.750	.594
.750	3/4	1.625	.030	1.937	1	1	4	2F440-1905-076ASD	★	.750	4.250	.713
	3/4	1.625	.060	1.937	1	1	4	2F440-1905-152ASD	★	.750	4.250	.713
	3/4	1.625	.090	1.937	1	1	4	2F440-1905-228ASD	★	.750	4.250	.713
	3/4	1.625	.120	1.937	1	1	4	2F440-1905-304ASD	★	.750	4.250	.713

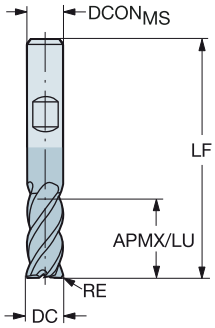
A184 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for stable multi-operations milling

For nickel-based alloys

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h6



Metric version

DC	CZCMS	APMX	RE	LU	ZEFP	Ordering code	S 1725	DCONMS	LF
2.0	6	7.0	0.20	9.5	3	2S440-0200-020-SD	★	6.0	57.0
3.0	6	8.0	0.30	10.0	3	2S440-0300-030-SD	★	6.0	57.0
4.0	6	11.0	0.50	15.0	3	2S440-0400-050-SD	★	6.0	57.0
5.0	6	13.0	0.50	16.0	3	2S440-0500-050-SD	★	6.0	57.0
6.0	6	13.0	0.50	19.0	4	2S440-0600-050-SD	★	6.0	57.0
	6	13.0	1.00	19.0	4	2S440-0600-100-SD	★	6.0	57.0
8.0	8	19.0	0.50	25.0	4	2S440-0800-050-SD	★	8.0	63.0
	8	19.0	1.00	25.0	4	2S440-0800-100-SD	★	8.0	63.0
10.0	10	22.0	0.50	30.0	4	2S440-1000-050-SD	★	10.0	72.0
	10	22.0	1.00	30.0	4	2S440-1000-100-SD	★	10.0	72.0
	10	22.0	2.00	30.0	4	2S440-1000-200-SD	★	10.0	72.0
12.0	12	26.0	0.50	36.0	4	2S440-1200-050-SD	★	12.0	83.0
	12	26.0	1.00	36.0	4	2S440-1200-100-SD	★	12.0	83.0
	12	26.0	2.00	36.0	4	2S440-1200-200-SD	★	12.0	83.0
16.0	16	32.0	2.00	42.0	4	2S440-1600-200-SD	★	16.0	92.0
	16	32.0	3.00	42.0	4	2S440-1600-300-SD	★	16.0	92.0
	16	32.0	4.00	42.0	4	2S440-1600-400-SD	★	16.0	92.0
20.0	20	38.0	3.00	52.0	4	2S440-2000-300-SD	★	20.0	104.0
	20	38.0	4.00	52.0	4	2S440-2000-400-SD	★	20.0	104.0
	20	38.0	6.35	52.0	4	2S440-2000-635-SD	★	20.0	104.0

Inch version

DC	CZCMS	APMX	RE	LU	ZEFP	Ordering code	S 1725	DCONMS	LF
.250	1/4	.625	.030	.875	4	2S440-0635-076-SD	★	.250	2.500
	1/4	.625	.060	.875	4	2S440-0635-152-SD	★	.250	2.500
.375	3/8	.781	.030	1.156	4	2S440-0953-076-SD	★	.375	3.000
	3/8	.781	.060	1.156	4	2S440-0953-152-SD	★	.375	3.000
	3/8	.781	.090	1.156	4	2S440-0953-228-SD	★	.375	3.000
.500	1/2	1.125	.030	1.438	4	2S440-1270-076-SD	★	.500	3.500
	1/2	1.125	.060	1.438	4	2S440-1270-152-SD	★	.500	3.500
	1/2	1.125	.090	1.438	4	2S440-1270-228-SD	★	.500	3.500
	1/2	1.125	.120	1.438	4	2S440-1270-304-SD	★	.500	3.500
.625	5/8	1.313	.030	1.563	4	2S440-1588-076-SD	★	.625	3.750
	5/8	1.313	.060	1.563	4	2S440-1588-152-SD	★	.625	3.750
	5/8	1.313	.090	1.563	4	2S440-1588-228-SD	★	.625	3.750
	5/8	1.313	.120	1.563	4	2S440-1588-304-SD	★	.625	3.750
.750	3/4	1.625	.030	1.937	4	2S440-1905-076-SD	★	.750	4.250
	3/4	1.625	.060	1.937	4	2S440-1905-152-SD	★	.750	4.250
	3/4	1.625	.090	1.937	4	2S440-1905-228-SD	★	.750	4.250
	3/4	1.625	.120	1.937	4	2S440-1905-304-SD	★	.750	4.250

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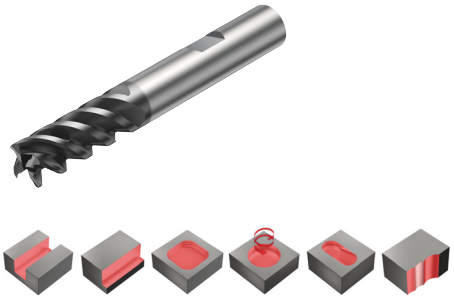
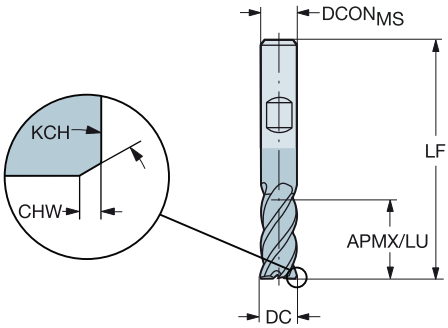
CoroMill® Plura solid carbide end mill for stable multi-operations milling

For nickel-based alloys

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h6





Metric version

DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	S 1725	$DCON_{MS}$	LF
									Dimensions, mm	
6.0	6	13.0	0.10	45°	19.0	4	2P440-0600-SD	★	6.0	57.0
8.0	8	19.0	0.10	45°	25.0	4	2P440-0800-SD	★	8.0	63.0
10.0	10	22.0	0.10	45°	30.0	4	2P440-1000-SD	★	10.0	72.0
12.0	12	26.0	0.10	45°	36.0	4	2P440-1200-SD	★	12.0	83.0
16.0	16	32.0	0.15	45°	42.0	4	2P440-1600-SD	★	16.0	92.0
20.0	20	38.0	0.15	45°	52.0	4	2P440-2000-SD	★	20.0	104.0

A184 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for hard part milling

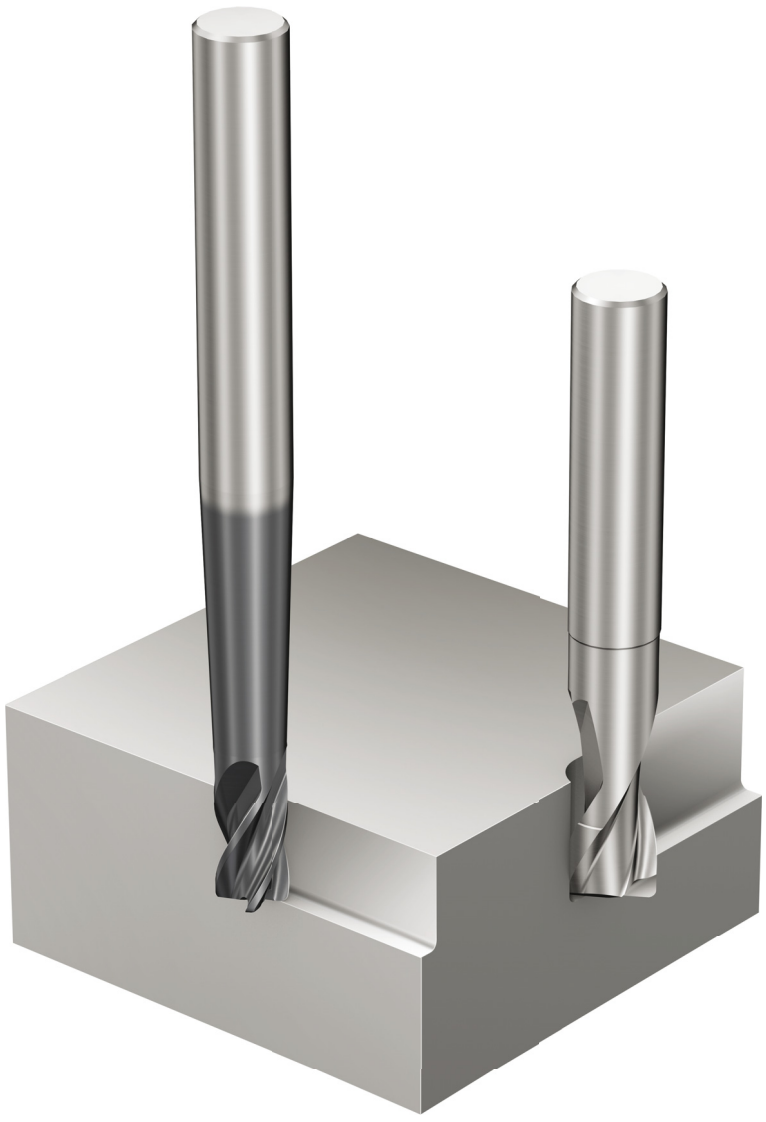
When to use

First choice for roughing to semi-finishing in hardened steel in stable conditions
Use in dry conditions

ISO material	P H
Grade	1610
Shank	Cylindrical

Product range

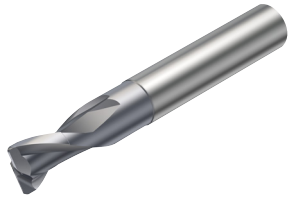
For hardened steel with hardness 43 ≤ HRc ≤ 63

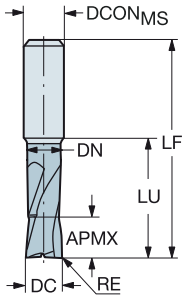


CoroMill® Plura solid carbide end mill for hard part milling

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6





Metric version

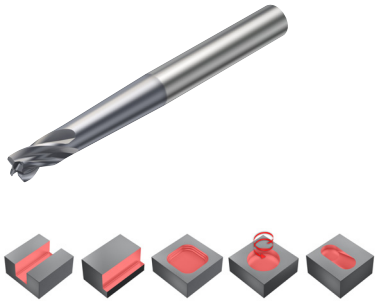
DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1610	H 1610	$DCON_{MS}$	LF	DN
									Dimensions, mm		
2.0	6	2.0	0.20	2.0	2	R216.22-02030AAI20G	☆	★	6.0	57.0	
	6	2.0	0.20	20.0	2	R216.22-02030AAJ20G	☆	★	6.0	75.0	1.9
3.0	6	3.0	0.30	20.0	2	R216.22-03030AAJ03G	☆	★	6.0	72.0	2.9
	6	3.0	0.50	3.0	2	R216.22-03030BAI03G	☆	★	6.0	57.0	
4.0	6	4.0	0.40	20.0	4	R216.24-04030AAJ04G	☆	★	6.0	72.0	3.8
	6	4.0	0.50	4.0	2	R216.22-04030BAI04G	☆	★	6.0	57.0	
5.0	6	5.0	0.50	20.0	2	R216.22-05030BAI05G	☆	★	6.0	57.0	4.9
	6	5.0	0.50	20.0	4	R216.24-05030BAJ05G	☆	★	6.0	72.0	4.8
6.0	6	6.0	0.50	24.0	4	R216.24-06030BAJ06G	☆	★	6.0	72.0	5.7
	6	6.0	1.00	21.0	2	R216.22-06030CAI06G	☆	★	6.0	63.0	5.7
	6	6.0	1.00	21.0	4	R216.24-06030CAI06G	☆	★	6.0	57.0	5.7
8.0	8	8.0	0.50	29.0	4	R216.24-08030BAJ08G	☆	★	8.0	80.0	7.9
	8	8.0	1.00	27.0	2	R216.22-08030CAI08G	☆	★	8.0	72.0	7.7
	8	8.0	1.00	27.0	4	R216.24-08030CAI08G	☆	★	8.0	63.0	7.7
	8	8.0	1.00	29.0	4	R216.24-08030CAJ08G	☆	★	8.0	80.0	7.9
	8	8.0	1.50	29.0	4	R216.24-08030DAJ08G	☆	★	8.0	80.0	7.9
10.0	10	10.0	0.50	35.0	4	R216.24-10030BAJ10G	☆	★	10.0	100.0	9.9
	10	10.0	1.00	35.0	4	R216.24-10030CAJ10G	☆	★	10.0	100.0	9.9
	10	10.0	1.50	32.0	2	R216.22-10030DAI10G	☆	★	10.0	72.0	9.7
	10	10.0	1.50	32.0	4	R216.24-10030DAI10G	☆	★	10.0	72.0	9.7
12.0	12	12.0	0.50	36.0	4	R216.24-12030BAJ12G	☆	★	12.0	100.0	11.8
	12	12.0	1.00	36.0	4	R216.24-12030CAJ12G	☆	★	12.0	100.0	11.8
	12	12.0	1.50	36.0	2	R216.22-12030DAI12G	☆	★	12.0	83.0	11.8
	12	12.0	1.50	36.0	4	R216.24-12030DAI12G	☆	★	12.0	83.0	11.8
	12	12.0	2.00	36.0	4	R216.24-12030EAJ12G	☆	★	12.0	100.0	11.8
16.0	16	16.0	2.00	42.0	4	R216.24-16030EAI16G	☆	★	16.0	92.0	15.8

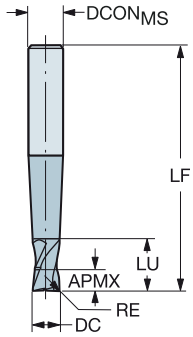
A185 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for hard part milling

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6





Metric version

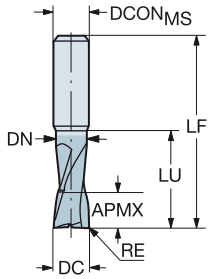
DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1610	H 1610	$DCON_{MS}$	LF
3.0	6	3.0	0.50	4.0	2	R216.22-03030BAP03G	☆	★	6.0	80.0
4.0	6	4.0	0.50	5.0	2	R216.22-04030BAP04G	☆	★	6.0	90.0
6.0	8	6.0	0.50	7.0	2	R216.22-06030BAP06G	☆	★	8.0	100.0
	8	6.0	1.00	7.0	4	R216.24-06030CAP06G	☆	★	8.0	100.0
8.0	10	8.0	1.00	10.0	4	R216.24-08030CAP08G	☆	★	10.0	100.0
10.0	12	10.0	1.00	15.0	4	R216.24-10030CAP10G	☆	★	12.0	125.0
	12	10.0	3.00	12.0	4	R216.24-10030GAP10G	☆	★	12.0	125.0
12.0	14	12.0	1.00	14.0	4	R216.24-12030CAP12G	☆	★	14.0	140.0
16.0	16	16.0	1.00	16.0	4	R216.24-16030CAP16G	☆	★	16.0	150.0
	16	16.0	3.00	16.0	4	R216.24-16030GAP16G	☆	★	16.0	150.0

A185 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for hard part milling

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6



Inch version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1610	H 1610	$DCON_{MS}$	LF	DN
.125	1/4	.125	.031	.750	4	RA216.24-0830BAK02G	☆	★	.250	3.000	.121
.156	1/4	.156	.031	.750	4	RA216.24-1030BAK02G	☆	★	.250	3.000	.137
.188	1/4	.188	.063	.750	4	RA216.24-1230DAK03G	☆	★	.250	3.000	.183
.250	1/4	.250	.063	1.000	4	RA216.24-1630DAK04G	☆	★	.250	3.000	.246
.375	3/8	.375	.063	1.250	4	RA216.24-2430DAK06G	☆	★	.375	3.500	.369

Dimensions, inch

A185 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for large chip removal

When to use

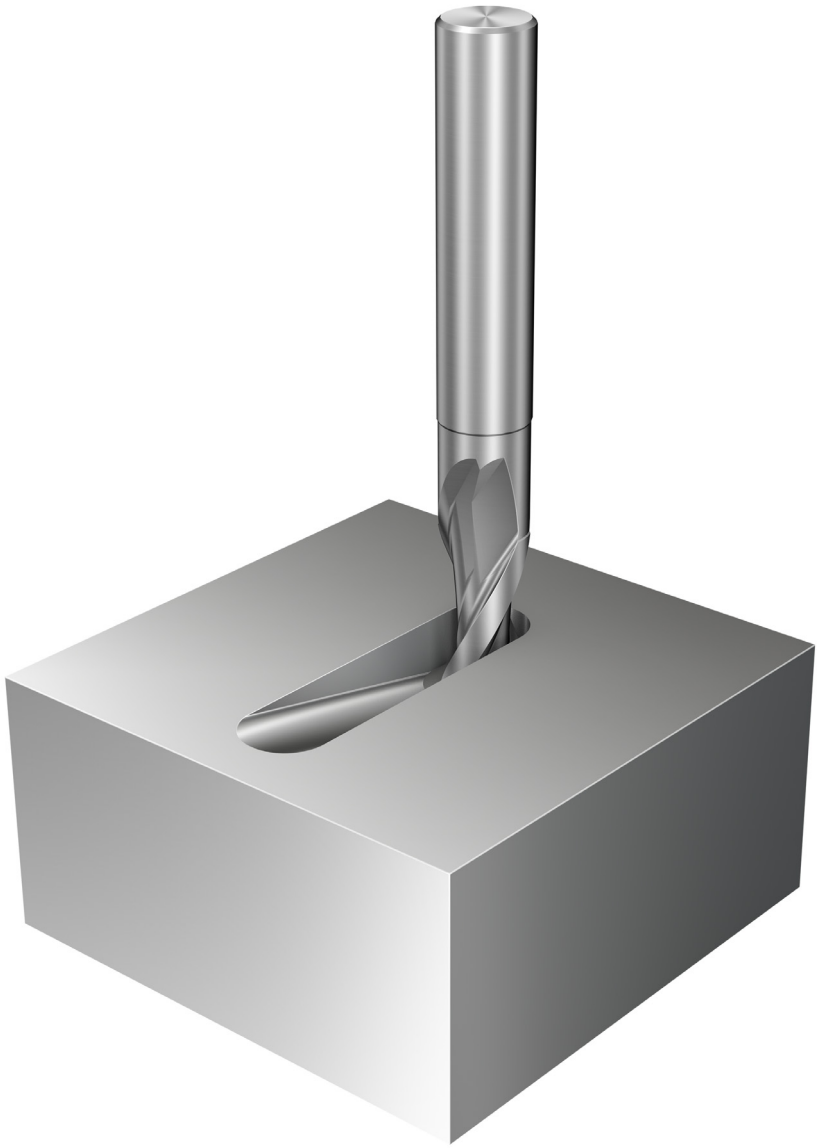
First choice for roughing in aluminum, graphite and thermoplastic machining

ISO material	N O	
Grade	H10F	N20C
Shank	Cylindrical	Undersized

Product range

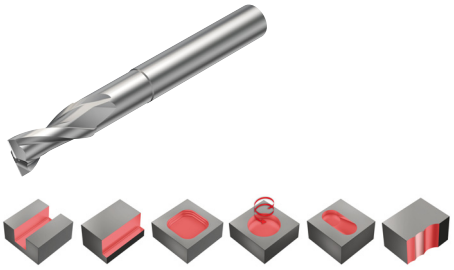
For non-ferrous material

For non-ferrous material with silicon content > 9%

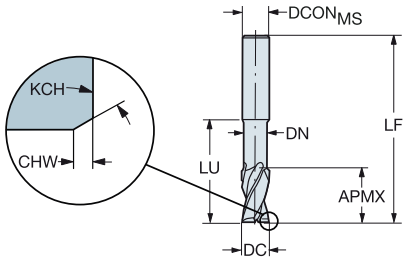


CoroMill® Plura solid carbide end mill for large chip removal

For non-ferrous material

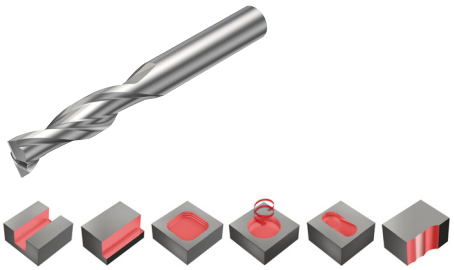


FHA 25°
BSG COROMANT
TCDC h10
TCDCON h6

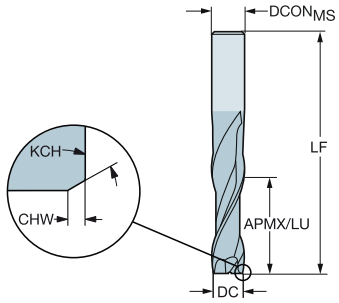


Metric version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	N H10F	DCONMS	LF	DN
									Dimensions, mm		
2.0	3	3.0			9.0	2	2P120-0200-NC	★	3.0	38.0	1.9
3.0	3	4.0			12.0	2	2P120-0300-NC	★	3.0	38.0	2.9
4.0	4	6.0			14.0	2	2P120-0400-NC	★	4.0	50.0	3.8
5.0	6	8.0			16.0	2	2P120-0500-NC	★	6.0	57.0	4.8
6.0	6	10.0			28.0	2	2P120-0600-NC	★	6.0	65.0	5.7
8.0	8	12.0			35.0	2	2P120-0800-NC	★	8.0	80.0	7.6
10.0	10	14.0	0.10	45°	45.0	2	2P120-1000-NC	★	10.0	90.0	9.5
12.0	12	16.0	0.10	45°	50.0	2	2P120-1200-NC	★	12.0	100.0	11.4
16.0	16	20.0	0.15	45°	63.0	2	2P120-1600-NC	★	16.0	115.0	15.2
20.0	20	20.0	0.15	45°	70.0	2	2P120-2000-NC	★	20.0	125.0	19.0



FHA 25°
BSG COROMANT
TCDC h10
TCDCON h6



Metric version

DC	CZCMS	APMX	CHW	KCH	LU	ZEFP	Ordering code	N H10F	DCONMS	LF
									Dimensions, mm	
2.0	3	8.0			8.0	2	2P160-0200-NA	★	3.0	38.0
3.0	3	12.0			12.0	2	2P160-0300-NA	★	3.0	38.0
4.0	4	14.0			14.0	2	2P160-0400-NA	★	4.0	50.0
5.0	6	16.0			16.0	2	2P160-0500-NA	★	6.0	57.0
6.0	6	22.0			22.0	2	2P160-0600-NA	★	6.0	65.0
8.0	8	28.0			28.0	2	2P160-0800-NA	★	8.0	80.0
10.0	10	32.0	0.10	45°	32.0	2	2P160-1000-NA	★	10.0	90.0
12.0	12	38.0	0.10	45°	38.0	2	2P160-1200-NA	★	12.0	100.0

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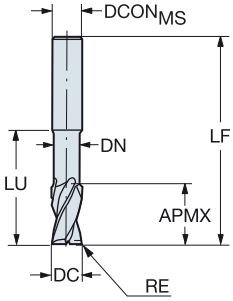
CoroMill® Plura solid carbide end mill for large chip removal

For non-ferrous material

FHA	25°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	N H10F	Dimensions, mm $DCON_{MS}$	LF	DN
2.0	3	3.0	0.15	5.0	2	2P121-0200-NC	★	3.0	38.0	1.8
	3	3.0	0.15	8.0	2	2P122-0200-NC	★	3.0	50.0	1.8
3.0	3	4.5	0.15	9.0	2	2P121-0300-NC	★	3.0	38.0	2.7
	3	4.5	0.15	12.0	2	2P122-0300-NC	★	3.0	50.0	2.7
4.0	4	6.0	0.15	12.0	2	2P121-0400-NC	★	4.0	50.0	3.7
	4	6.0	0.15	16.0	2	2P122-0400-NC	★	4.0	60.0	3.7
5.0	5	7.5	0.15	15.0	2	2P121-0500-NC	★	5.0	50.0	4.7
	5	7.5	0.15	20.0	2	2P122-0500-NC	★	5.0	60.0	4.6
6.0	6	9.0	0.15	18.0	2	2P121-0600-NC	★	6.0	57.0	5.7
	6	9.0	0.15	24.0	2	2P122-0600-NC	★	6.0	65.0	5.5
8.0	8	12.0	0.15	24.0	2	2P121-0800-NC	★	8.0	63.0	7.7
	8	12.0	0.15	32.0	2	2P122-0800-NC	★	8.0	80.0	7.4
10.0	10	15.0	0.15	30.0	2	2P121-1000-NC	★	10.0	72.0	9.7
	10	15.0	0.15	40.0	2	2P122-1000-NC	★	10.0	89.0	9.2
12.0	12	18.0	0.15	36.0	2	2P121-1200-NC	★	12.0	83.0	11.7
	12	18.0	0.15	48.0	2	2P122-1200-NC	★	12.0	100.0	11.0
14.0	14	21.0	0.15	42.0	2	2P121-1400-NC	★	14.0	83.0	13.7
16.0	16	24.0	0.15	48.0	2	2P121-1600-NC	★	16.0	92.0	15.7
	16	24.0	0.15	64.0	2	2P122-1600-NC	★	16.0	120.0	15.0
20.0	20	30.0	0.15	60.0	2	2P121-2000-NC	★	20.0	104.0	19.7
	20	30.0	0.15	80.0	2	2P122-2000-NC	★	20.0	150.0	19.0

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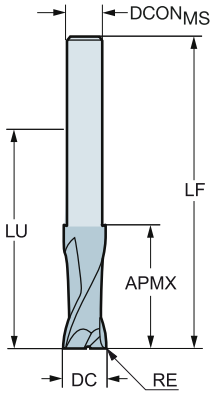
CoroMill® Plura solid carbide end mill for large chip removal

For non-ferrous material

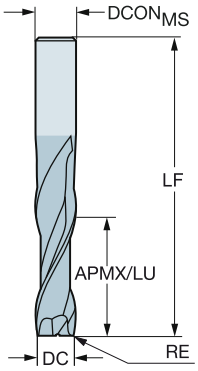
FHA 25°
BSG COROMANT
TCDC h10
TCDCON h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	N	H10F	Dimensions, mm DCON$_{MS}$	LF
3.0	2	4.0	0.15	32.0	2	2P123-0300-NG		★	2.9	60.0
4.0	3	5.0	0.15	32.0	2	2P123-0400-NG		★	3.8	60.0
5.0	4	8.0	0.15	42.0	2	2P123-0500-NG		★	4.8	70.0
6.0	5	9.0	0.15	64.0	2	2P123-0600-NG		★	5.8	100.0
8.0	7	11.0	0.15	64.0	2	2P123-0800-NG		★	7.8	100.0
10.0	9	15.0	0.15	60.0	2	2P123-1000-NG		★	9.7	100.0
12.0	11	17.0	0.15	80.0	2	2P123-1200-NG		★	11.7	125.0
16.0	15	23.0	0.15	77.0	2	2P123-1600-NG		★	15.7	125.0
20.0	19	26.0	0.15	100.0	2	2P123-2000-NG		★	19.7	150.0

FHA 25°
BSG COROMANT
TCDC h10
TCDCON h6



Metric version

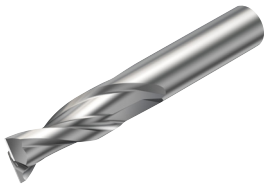
DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	N	H10F	Dimensions, mm DCON$_{MS}$	LF
2.0	3	8.0	0.15	8.0	2	2P170-0200-NA		★	3.0	50.0
3.0	3	12.0	0.15	12.0	2	2P170-0300-NA		★	3.0	50.0
4.0	4	16.0	0.15	16.0	2	2P170-0400-NA		★	4.0	60.0
5.0	5	20.0	0.15	20.0	2	2P170-0500-NA		★	5.0	60.0
6.0	6	24.0	0.15	24.0	2	2P170-0600-NA		★	6.0	65.0
7.0	7	28.0	0.15	28.0	2	2P170-0700-NA		★	7.0	79.0
8.0	8	32.0	0.15	32.0	2	2P170-0800-NA		★	8.0	79.0
9.0	9	36.0	0.15	36.0	2	2P170-0900-NA		★	9.0	88.0
10.0	10	40.0	0.15	40.0	2	2P170-1000-NA		★	10.0	88.0
12.0	12	48.0	0.15	48.0	2	2P170-1200-NA		★	12.0	99.0
14.0	14	56.0	0.15	56.0	2	2P170-1400-NA		★	14.0	105.0
16.0	16	64.0	0.15	64.0	2	2P170-1600-NA		★	16.0	120.0
20.0	20	80.0	0.15	80.0	2	2P170-2000-NA		★	20.0	150.0

A187 A194 E9 E22 E14

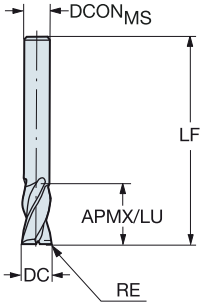
SANDVIK Coromant

CoroMill® Plura solid carbide end mill for large chip removal

For non-ferrous material



FHA	30°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

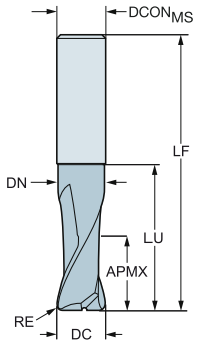
DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	N H10F	Dimensions, mm DCON$_{MS}$	LF
2.0	3	4.0	0.15	4.0	2	2P232-0200-NA	★	3.0	38.0
3.0	3	5.0	0.15	5.0	2	2P232-0300-NA	★	3.0	38.0
4.0	4	7.0	0.15	7.0	2	2P232-0400-NA	★	4.0	50.0
5.0	5	9.0	0.15	9.0	2	2P232-0500-NA	★	5.0	50.0
6.0	6	18.0	0.15	18.0	2	2P232-0600-NA	★	6.0	57.0
7.0	7	18.0	0.15	18.0	2	2P232-0700-NA	★	7.0	60.0
8.0	8	18.0	0.15	18.0	2	2P232-0800-NA	★	8.0	63.0
9.0	9	20.0	0.15	20.0	2	2P232-0900-NA	★	9.0	67.0
10.0	10	22.0	0.15	22.0	2	2P232-1000-NA	★	10.0	72.0
12.0	12	22.0	0.15	22.0	2	2P232-1200-NA	★	12.0	83.0
14.0	14	25.0	0.15	25.0	2	2P232-1400-NA	★	14.0	83.0
16.0	16	29.0	0.15	29.0	2	2P232-1600-NA	★	16.0	92.0
18.0	18	33.0	0.15	33.0	2	2P232-1800-NA	★	18.0	92.0
20.0	20	36.0	0.15	36.0	2	2P232-2000-NA	★	20.0	104.0

A187 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for large chip removal

For non-ferrous material

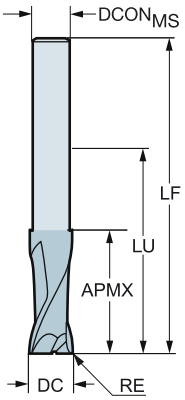
FHA 30°
BSG COROMANT
TCDC h10
TCDCON h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	N / H10F	Dimensions, mm DCON$_{MS}$	LF	DN
3.0	3	4.5	0.20	8.0	2	2S220-0300-020-NC	★	3.0	38.0	2.7
4.0	4	6.0	0.30	11.0	2	2S220-0400-030-NC	★	4.0	50.0	3.7
5.0	5	7.5	0.50	14.0	2	2S220-0500-050-NC	★	5.0	50.0	4.7
6.0	6	9.0	1.00	17.0	2	2S220-0600-100-NC	★	6.0	57.0	5.7
8.0	8	12.0	1.00	23.0	2	2S220-0800-100-NC	★	8.0	63.0	7.7
10.0	10	15.0	1.50	29.0	2	2S220-1000-150-NC	★	10.0	72.0	9.7
12.0	12	18.0	1.50	35.0	2	2S220-1200-150-NC	★	12.0	83.0	11.7
16.0	16	24.0	2.00	47.0	2	2S220-1600-200-NC	★	16.0	92.0	15.7

FHA 30°
BSG COROMANT
TCDC h10
TCDCON h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	N / H10F	Dimensions, mm DCON$_{MS}$	LF
3.0	2	4.0	0.20	32.0	2	2S221-0300-020-NG	★	2.9	60.0
4.0	3	5.0	0.30	32.0	2	2S221-0400-030-NG	★	3.8	60.0
5.0	4	8.0	0.50	42.0	2	2S221-0500-050-NG	★	4.8	70.0
6.0	5	9.0	1.00	64.0	2	2S221-0600-100-NG	★	5.8	100.0
8.0	7	13.0	1.00	64.0	2	2S221-0800-100-NG	★	7.8	100.0
10.0	9	15.0	1.50	60.0	2	2S221-1000-150-NG	★	9.7	100.0
12.0	11	17.0	1.50	80.0	2	2S221-1200-150-NG	★	11.7	125.0
16.0	15	23.0	2.00	77.0	2	2S221-1600-200-NG	★	15.7	125.0
20.0	19	26.0	2.50	100.0	2	2S221-2000-250-NG	★	19.7	150.0

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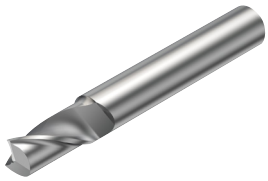
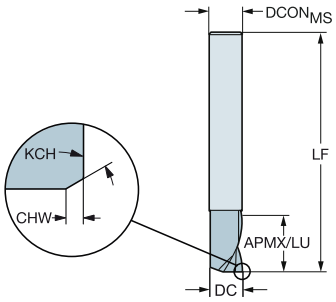
CoroMill® Plura solid carbide end mill for large chip removal

For non-ferrous material

FHA	30°
BSG	DIN 6527 L
TCDC	h10
TCDCON	h6





Metric version

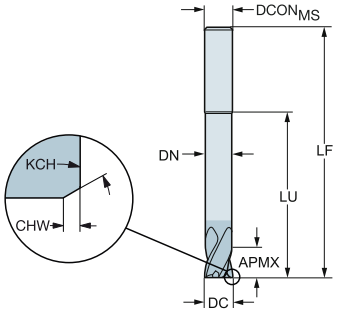
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	N 1630	N H10F	$DCON_{MS}$	LF
										Dimensions, mm	
3.0	6	7.0			7.0	1	2P230-0300-NA		★	6.0	57.0
	6	7.0			7.0	1	2P231-0300-NA	★		6.0	57.0
4.0	6	8.0			8.0	1	2P230-0400-NA		★	6.0	57.0
	6	8.0			8.0	1	2P231-0400-NA	★		6.0	57.0
5.0	6	10.0			10.0	1	2P230-0500-NA		★	6.0	57.0
	6	10.0			10.0	1	2P231-0500-NA	★		6.0	57.0
6.0	6	10.0			10.0	1	2P230-0600-NA		★	6.0	57.0
	6	10.0			10.0	1	2P231-0600-NA	★		6.0	57.0
8.0	8	16.0			16.0	1	2P230-0800-NA		★	8.0	63.0
	8	16.0			16.0	1	2P231-0800-NA	★		8.0	63.0
10.0	10	19.0	0.10	45°	19.0	1	2P230-1000-NA		★	10.0	72.0
	10	19.0	0.10	45°	19.0	1	2P231-1000-NA	★		10.0	72.0

A187 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for large chip removal

For non-ferrous material with silicon content > 9%

FHA	30°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	N 20C	O 20C	Dimensions, mm DCON$_{MS}$	LF	DN
1.0	3	1.0			2.0	2	2P210-0100-NC	★	☆	3.0	50.0	
1.5	3	1.5			1.5	2	2P210-0150-NC	★	☆	3.0	50.0	
2.0	3	2.0			2.0	2	2P210-0200-NC	★	☆	3.0	50.0	
3.0	6	3.0			3.0	2	2P210-0300-NC	★	☆	6.0	80.0	
4.0	6	4.0			40.0	2	2P210-0400-NC	★	☆	6.0	100.0	3.8
5.0	6	5.0			50.0	2	2P210-0500-NC	★	☆	6.0	100.0	4.8
6.0	6	6.0			60.0	4	2P210-0600-NC	★	☆	6.0	100.0	5.7
8.0	8	8.0			80.0	4	2P210-0800-NC	★	☆	8.0	120.0	7.6
10.0	10	10.0	0.10	45°	100.0	4	2P210-1000-NC	★	☆	10.0	150.0	9.5
12.0	12	12.0	0.10	45°	100.0	4	2P210-1200-NC	★	☆	12.0	150.0	11.4
16.0	16	16.0	0.15	45°	100.0	4	2P210-1600-NC	★	☆	16.0	150.0	15.2

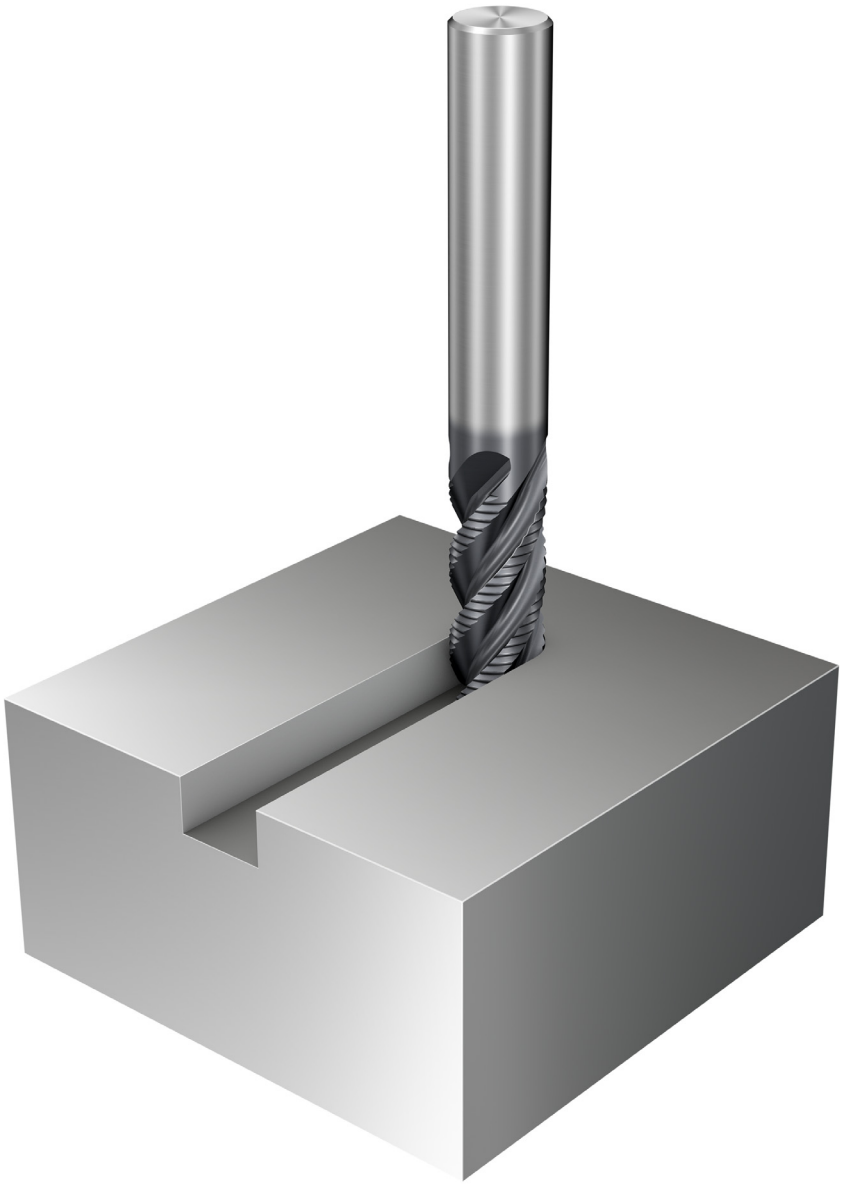
A187 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for roughing with chip breaker

When to use

First choice for roughing in aluminum, graphite and thermoplastic machining

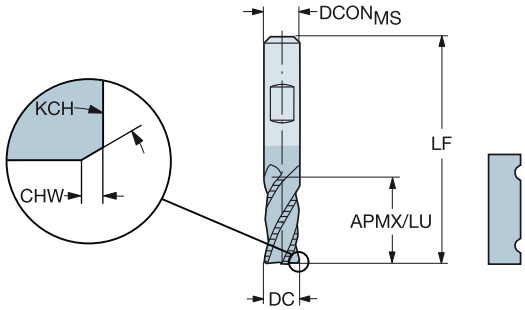
ISO material	P	M	K	S	N
Grade	H10F	1620	1640		
Shank	Cylindrical	Weldon			



CoroMill® Plura solid carbide end mill for roughing with chip breaker

For ISO S materials

FHA	30°
BSG	DIN 6527 L
TCDC	h10
TCDCON	h6



Metric version

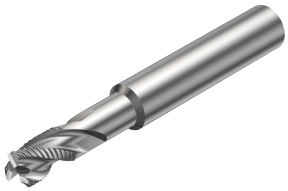
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	M 1620	S 1620	$DCON_{MS}$	LF
										Dimensions, mm	
6.0	6	13.0			13.0	4	R216.34-06030-BC13B	☆	★	6.0	57.0
8.0	8	19.0			19.0	4	R216.34-08030-BC19B	☆	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	4	R216.34-10030-BC22B	☆	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	4	R216.34-12030-BC26B	☆	★	12.0	83.0
16.0	16	32.0	0.15	45°	32.0	4	R216.34-16030-BC32B	☆	★	16.0	92.0
18.0	18	32.0	0.15	45°	32.0	4	R216.34-18030-BC32B	☆	★	18.0	92.0
20.0	20	38.0	0.15	45°	38.0	4	R216.34-20030-BC38B	☆	★	20.0	104.0
25.0	25	45.0	0.15	45°	45.0	5	R216.35-25030-BC45B	☆	★	25.0	121.0

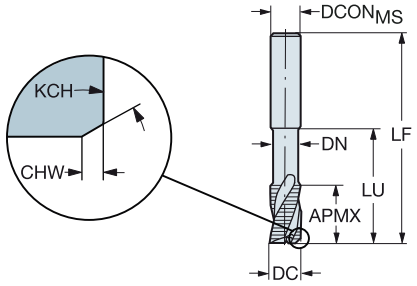
A188 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for roughing with chip breaker

For non-ferrous material

FHA 40°
BSG COROMANT
TCDC h12
TCDCON h5

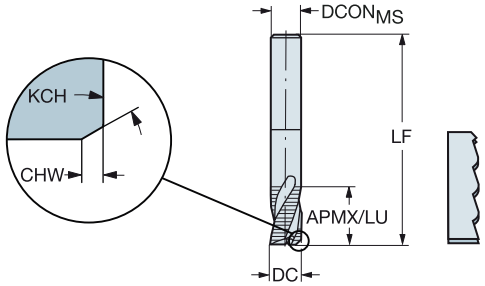




Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	N H10F	Dimensions, mm DCON$_{MS}$	LF	DN
6.0	8	10.0	0.64	55°	24.0	3	R216.33-06040-AJ10U	★	8.0	63.0	5.5
8.0	10	12.0	0.64	55°	29.0	3	R216.33-08040-AJ12U	★	10.0	72.0	7.5
10.0	12	14.0	0.83	55°	35.0	3	R216.33-10040-AJ14U	★	12.0	83.0	9.5
12.0	12	16.0	0.83	55°	50.0	3	R216.33-12040-AJ16U	★	12.0	100.0	11.4
16.0	16	20.0	1.00	55°	63.0	3	R216.33-16040-AJ20U	★	16.0	115.0	15.2
20.0	20	20.0	1.00	55°	70.0	3	R216.33-20040-AJ20U	★	20.0	125.0	19.0
25.0	25	25.0	1.29	55°	75.0	3	R216.33-25040-AJ25U	★	25.0	135.0	23.8

FHA 40°
BSG DIN 6527 L
TCDC h12
TCDCON h5



Metric version

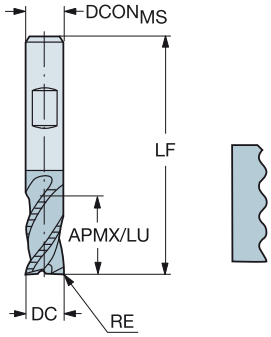
DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	N H10F	Dimensions, mm DCON$_{MS}$	LF
6.0	6	13.0	0.64	55°	13.0	3	R216.33-06040-AC13U	★	6.0	57.0
8.0	8	19.0	0.64	55°	19.0	3	R216.33-08040-AC19U	★	8.0	63.0
10.0	10	22.0	0.83	55°	22.0	3	R216.33-10040-AC22U	★	10.0	72.0
12.0	12	26.0	0.83	55°	26.0	3	R216.33-12040-AC26U	★	12.0	83.0
14.0	14	26.0	1.00	55°	26.0	3	R216.33-14040-AC26U	★	14.0	83.0
16.0	16	32.0	1.00	55°	32.0	3	R216.33-16040-AC32U	★	16.0	92.0
20.0	20	38.0	1.00	55°	38.0	3	R216.33-20040-AC38U	★	20.0	104.0

A188 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for roughing with chip breaker

For steel with hardness ≤ 48 HRc

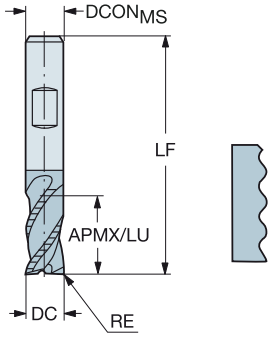
FHA 30°
BSG DIN 6527 K
TCDC h12
TCDCON h6



Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1640	M 1640	K 1640	$DCON_{MS}$	LF
										Dimensions, mm	
6.0	6	7.0	0.35	7.0	3	R216.33-06030-BS07K	★	☆	★	6.0	54.0
8.0	8	9.0	0.40	9.0	3	R216.33-08030-BS09K	★	☆	★	8.0	58.0
10.0	10	11.0	0.40	11.0	3	R216.33-10030-BS11K	★	☆	★	10.0	66.0
12.0	12	12.0	0.40	12.0	3	R216.33-12030-BS12K	★	☆	★	12.0	73.0
14.0	14	14.0	0.40	14.0	3	R216.33-14030-BS14K	★	☆	★	14.0	75.0
16.0	16	16.0	0.40	16.0	3	R216.33-16030-BS16K	★	☆	★	16.0	82.0
20.0	20	20.0	0.40	20.0	3	R216.33-20030-BS20K	★	☆	★	20.0	92.0

FHA 40°
BSG DIN 6527 L
TCDC h12
TCDCON h6



Metric version

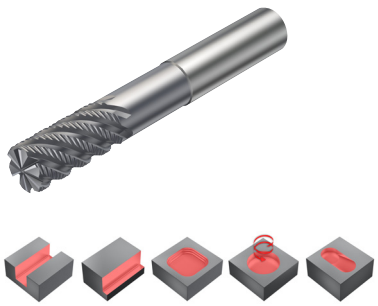
DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1640	M 1640	K 1640	$DCON_{MS}$	LF
										Dimensions, mm	
6.0	6	13.0	0.35	13.0	4	R216.34-06040-BC13K	★	☆	★	6.0	57.0
8.0	8	19.0	0.35	19.0	4	R216.34-08040-BC19K	★	☆	★	8.0	63.0
10.0	10	22.0	0.40	22.0	4	R216.34-10040-BC22K	★	☆	★	10.0	72.0
12.0	12	26.0	0.40	26.0	4	R216.34-12040-BC26K	★	☆	★	12.0	83.0
14.0	14	26.0	0.40	26.0	4	R216.34-14040-BC26K	★	☆	★	14.0	83.0
16.0	16	32.0	0.40	32.0	4	R216.34-16040-BC32K	★	☆	★	16.0	92.0
18.0	18	32.0	0.40	32.0	4	R216.34-18040-BC32K	★	☆	★	18.0	92.0
20.0	20	38.0	0.40	38.0	4	R216.34-20040-BC38K	★	☆	★	20.0	104.0

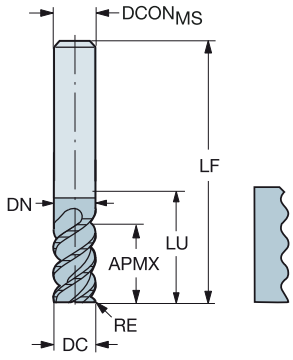
A188 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for roughing with chip breaker

For steel with hardness ≤ 48 HRc

FHA	45°
BSG	DIN 6527 L
TCDC	h12
TCDCON	h6





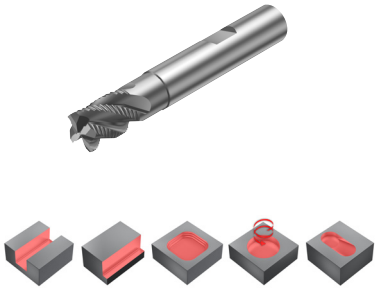
Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1640	M 1640	K 1640	S 1640	$DCON_{MS}$	LF	DN
							Dimensions, mm						
16.0	16	32.0	4.00	44.0	6	R216.36-16045ICC32K	★	☆	☆	☆	16.0	92.0	15.2
	16	32.0	4.00	64.0	6	R216.36-16045ICK32K	★	☆	☆	☆	16.0	112.0	15.2
20.0	20	38.0	4.00	54.0	6	R216.36-20045ICC38K	★	☆	☆	☆	20.0	104.0	19.0
	20	38.0	4.00	80.0	6	R216.36-20045ICK38K	★	☆	☆	☆	20.0	130.0	19.0
25.0	25	45.0	4.00	65.0	8	R216.38-25045ICC45K	★	☆	☆	☆	25.0	121.0	23.8
	25	45.0	4.00	100.0	8	R216.38-25045ICK45K	★	☆	☆	☆	25.0	156.0	23.8

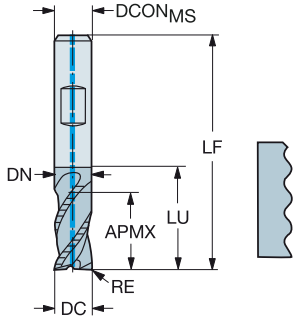
A188 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for roughing with chip breaker

For steel and stainless steel



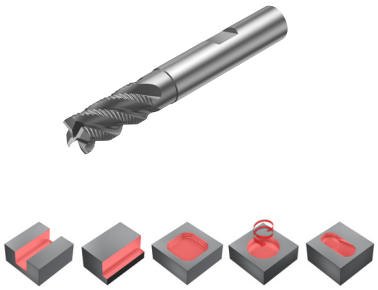
FHA 40°
BSG DIN 6527 K
TCDC h12
TCDCON h6

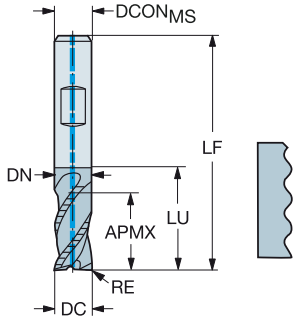


Metric version

DC	CZCMS	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	P 1640	M 1640	K 1640	S 1640	Dimensions, mm DCONMS	LF	DN
6.0	6	7.0	0.35	16.0	1	1	4	R215.34C06040-DS07K	★	★	☆	☆	6.0	54.0	5.5
8.0	8	9.0	0.40	20.0	1	1	4	R215.34C08040-DS09K	★	★	☆	☆	8.0	58.0	7.5
10.0	10	11.0	0.40	24.0	1	1	4	R215.34C10040-DS11K	★	★	☆	☆	10.0	66.0	9.5
12.0	12	12.0	0.40	26.0	1	1	4	R215.34C12040-DS12K	★	★	☆	☆	12.0	73.0	11.4
16.0	16	16.0	0.40	32.0	1	1	4	R215.34C16040-DS16K	★	★	☆	☆	16.0	82.0	15.2
20.0	20	20.0	0.40	40.0	1	1	4	R215.34C20040-DS20K	★	★	☆	☆	20.0	92.0	19.0

FHA 40°
BSG DIN 6527 L
TCDC h12
TCDCON h6





Metric version

DC	CZCMS	APMX	RE	LU	CNSC	CXSC	ZEFP	Ordering code	P 1640	M 1640	K 1640	S 1640	Dimensions, mm DCONMS	LF	DN
6.0	6	13.0	0.35	19.0	1	1	4	R215.34C06040-DC13K	★	★	☆	☆	6.0	57.0	5.5
8.0	8	19.0	0.40	25.0	1	1	4	R215.34C08040-DC19K	★	★	☆	☆	8.0	63.0	7.5
10.0	10	22.0	0.40	30.0	1	1	4	R215.34C10040-DC22K	★	★	☆	☆	10.0	72.0	9.5
12.0	12	26.0	0.40	36.0	1	1	4	R215.34C12040-DC26K	★	★	☆	☆	12.0	83.0	11.4
16.0	16	32.0	0.40	42.0	1	1	4	R215.34C16040-DC32K	★	★	☆	☆	16.0	92.0	15.2
20.0	20	38.0	0.40	52.0	1	1	4	R215.34C20040-DC38K	★	★	☆	☆	20.0	104.0	19.0

A188 A194 E9 E22 E28 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for finishing

When to use

First choice for finishing in shoulder milling operations

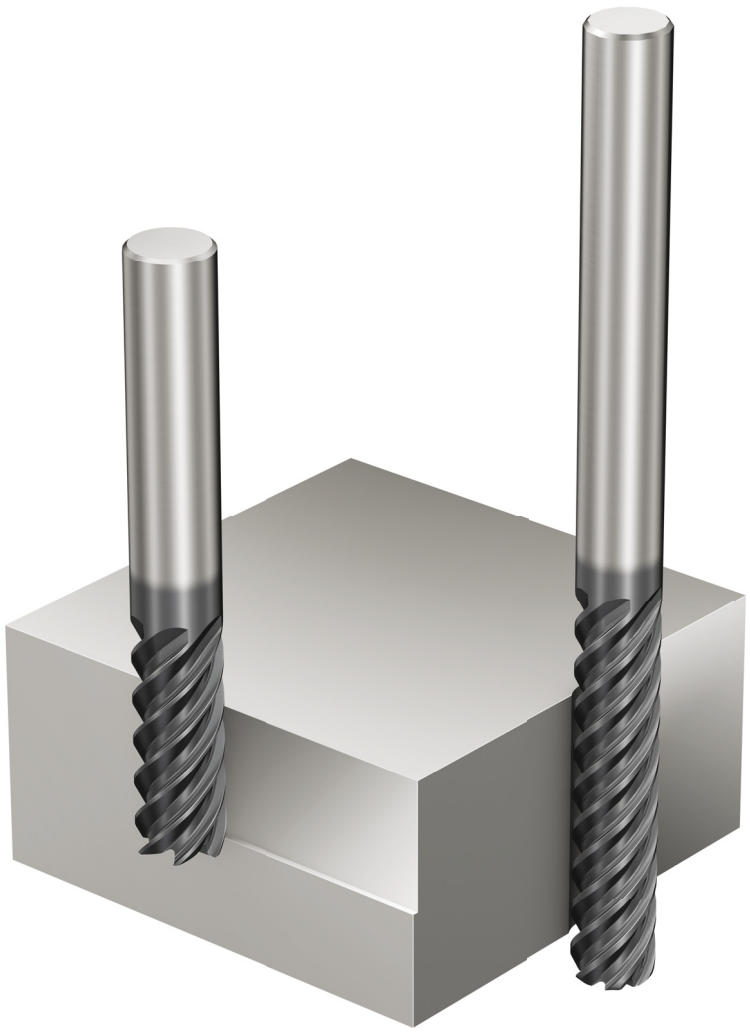
Can be used in roughing operations with low radial engagement a if high feed rate is desired (trochoidal strategy)

ISO material	P	M	K	S	H
Grade	1610		1620		
Shank	Cylindrical				

Product range

For hardened steel with hardness 43 ≤ HRc ≤ 63

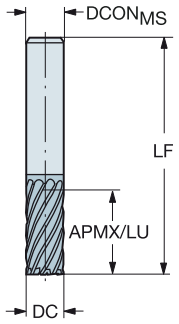
For steel and stainless steel with hardness ≤ 48 HRc



CoroMill® Plura solid carbide end mill for finishing

For hardened steel with hardness 43 ≤ HRc ≤ 63

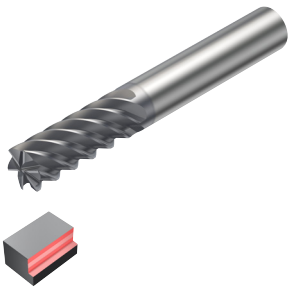
FHA 30°
BSG DIN 6527 L
TCDC h10
TCDCON h6

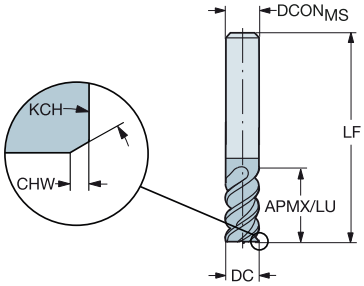


Metric version

DC	CZC$_{MS}$	APMX	LU	ZEFP	Ordering code	P 1610	H 1610	DCON$_{MS}$	LF
5.0	6	13.0	13.0	6	R215.36-05030-AC13H	☆	★	6.0	57.0
6.0	6	13.0	13.0	6	R215.36-06030-AC13H	☆	★	6.0	57.0
8.0	8	19.0	19.0	8	R215.38-08030-AC19H	☆	★	8.0	63.0
10.0	10	22.0	22.0	10	R215.3A-10030-AC22H	☆	★	10.0	72.0
12.0	12	26.0	26.0	12	R215.3C-12030-AC26H	☆	★	12.0	83.0
14.0	14	26.0	26.0	14	R215.3E-14030-AC26H	☆	★	14.0	83.0
16.0	16	32.0	32.0	16	R215.3G-16030-AC32H	☆	★	16.0	92.0
20.0	20	38.0	38.0	16	R215.3G-20030-AC38H	☆	★	20.0	104.0

FHA 50°
BSG DIN 6527 L
TCDC h10
TCDCON h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1610	H 1610	DCON$_{MS}$	LF
3.0	6	8.0	0.10	45°	8.0	4	R215.34-03050-AC08H	☆	★	6.0	57.0
4.0	6	11.0	0.10	45°	11.0	4	R215.34-04050-AC11H	☆	★	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	6	R215.36-06050-AC13H	☆	★	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	6	R215.36-08050-AC19H	☆	★	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	6	R215.36-10050-AC22H	☆	★	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	6	R215.36-12050-AC26H	☆	★	12.0	83.0
16.0	16	32.0	0.15	45°	32.0	6	R215.36-16050-AC32H	☆	★	16.0	92.0
20.0	20	38.0	0.15	45°	38.0	8	R215.38-20050-AC38H	☆	★	20.0	104.0

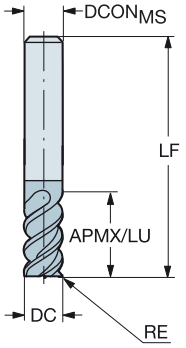
A189 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for finishing

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h5



Metric version

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Ordering code	P 1610	H 1610	$DCON_{MS}$	LF
									Dimensions, mm	
3.0	6	8.0	0.50	8.0	4	R215.24-03050BAC08H	☆	★	6.0	57.0
4.0	6	11.0	0.50	11.0	4	R215.24-04050BAC11H	☆	★	6.0	57.0
6.0	6	13.0	0.50	13.0	6	R215.26-06050BAC13H	☆	★	6.0	57.0
8.0	8	19.0	0.50	19.0	6	R215.26-08050BAC19H	☆	★	8.0	63.0
10.0	10	22.0	1.00	22.0	6	R215.26-10050CAC22H	☆	★	10.0	72.0
	10	22.0	1.50	22.0	6	R215.26-10050DAC22H	☆	★	10.0	72.0
	10	22.0	2.00	22.0	6	R215.26-10050EAC22H	☆	★	10.0	72.0
12.0	12	26.0	1.00	26.0	6	R215.26-12050CAC26H	☆	★	12.0	83.0
16.0	16	32.0	1.50	32.0	6	R215.26-16050DAC32H	☆	★	16.0	92.0
20.0	20	38.0	1.50	38.0	8	R215.28-20050DAC38H	☆	★	20.0	104.0

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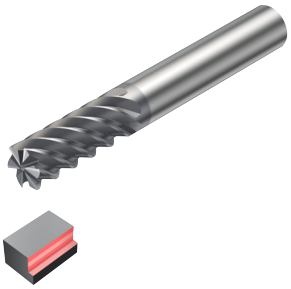
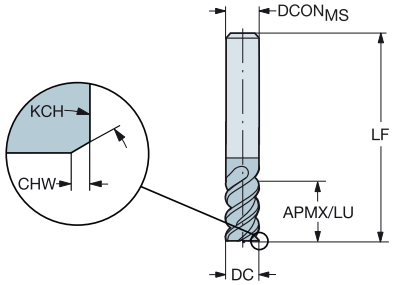
CoroMill® Plura solid carbide end mill for finishing

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	DIN 6527 L
TCDC	h10
TCDCON	h6





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm DCON$_{MS}$	LF
3.0	6	8.0	0.10	45°	8.0	4	R215.34-03050-AC08L	★	★	☆	☆	6.0	57.0
4.0	6	11.0	0.10	45°	11.0	4	R215.34-04050-AC11L	★	★	☆	☆	6.0	57.0
5.0	6	13.0	0.10	45°	13.0	5	R215.35-05050-AC13L	★	★	☆	☆	6.0	57.0
6.0	6	13.0	0.10	45°	13.0	6	R215.36-06050-AC13L	★	★	☆	☆	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	6	R215.36-08050-AC19L	★	★	☆	☆	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	6	R215.36-10050-AC22L	★	★	☆	☆	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	6	R215.36-12050-AC26L	★	★	☆	☆	12.0	83.0
16.0	16	32.0	0.15	45°	32.0	6	R215.36-16050-AC32L	★	★	☆	☆	16.0	92.0
20.0	20	38.0	0.15	45°	38.0	8	R215.38-20050-AC38L	★	★	☆	☆	20.0	104.0

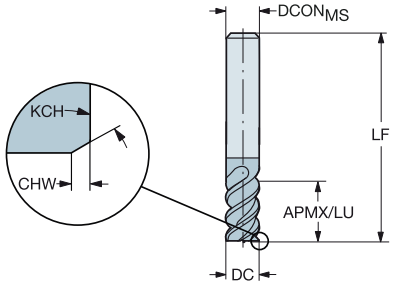
A189 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for finishing

For stainless steel and steel with hardness ≤ 48 HRc

FHA	60°
BSG	DIN 6527 L
TCDC	h10
TCDCON	h6



Metric version

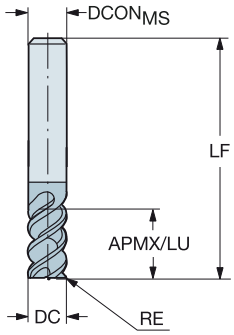
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, mm $DCON_{MS}$	LF
6.0	6	13.0	0.10	45°	13.0	6	R215.36-06060-AC13L	★	★	☆	☆	6.0	57.0
8.0	8	19.0	0.10	45°	19.0	6	R215.36-08060-AC19L	★	★	☆	☆	8.0	63.0
10.0	10	22.0	0.10	45°	22.0	6	R215.36-10060-AC22L	★	★	☆	☆	10.0	72.0
12.0	12	26.0	0.10	45°	26.0	6	R215.36-12060-AC26L	★	★	☆	☆	12.0	83.0
14.0	14	26.0	0.15	45°	26.0	6	R215.36-14060-AC26L	★	★	☆	☆	14.0	83.0
16.0	16	32.0	0.15	45°	32.0	6	R215.36-16060-AC32L	★	★	☆	☆	16.0	92.0
18.0	18	32.0	0.15	45°	32.0	6	R215.36-18060-AC32L	★	★	☆	☆	18.0	92.0
20.0	20	38.0	0.15	45°	38.0	6	R215.36-20060-AC38L	★	★	☆	☆	20.0	104.0

A189 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for finishing

For stainless steel and steel with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9
TCDCON	h6



Inch version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	S 1620	Dimensions, inch DCON$_{MS}$	LF
.063	1/4	.188	.016	.188	4	RA215.24-0450AAK13L	★	★	☆	☆	.250	3.000
.094	1/4	.281	.016	.281	4	RA215.24-0650AAK18L	★	★	☆	☆	.250	3.000
	1/4	.281	.031	.281	4	RA215.24-0650BAK18L	★	★	☆	☆	.250	3.000
.125	1/4	.375	.016	.375	4	RA215.24-0850AAK06L	★	★	☆	☆	.250	3.000
	1/4	.375	.031	.375	4	RA215.24-0850BAK06L	★	★	☆	☆	.250	3.000
.156	1/4	.500	.016	.500	4	RA215.24-1050AAK08L	★	★	☆	☆	.250	3.000
	1/4	.500	.031	.500	4	RA215.24-1050BAK08L	★	★	☆	☆	.250	3.000
.188	1/4	.571	.016	.563	6	RA215.26-1250AAK09L	★	★	☆	☆	.250	3.000
	1/4	.571	.031	.563	6	RA215.26-1250BAK09L	★	★	☆	☆	.250	3.000
.250	1/4	.750	.016	.750	6	RA215.26-1650AAK12L	★	★	☆	☆	.250	3.000
	1/4	.750	.031	.750	6	RA215.26-1650BAK12L	★	★	☆	☆	.250	3.000
	1/4	1.125	.031	1.125	6	RA215.26-1650BAL18L	★	★	☆	☆	.250	4.000
.313	3/8	1.000	.016	1.000	6	RA215.26-2050AAK15L	★	★	☆	☆	.375	3.500
	3/8	1.400	.031	1.406	6	RA215.26-2050BAL23L	★	★	☆	☆	.375	4.500
	3/8	1.000	.031	1.000	6	RA215.26-2050BAK15L	★	★	☆	☆	.375	3.500
.375	3/8	1.125	.031	1.125	6	RA215.26-2450BAK18L	★	★	☆	☆	.375	3.500
	3/8	1.666	.063	1.688	6	RA215.26-2450DAL27L	★	★	☆	☆	.375	4.500
	3/8	1.125	.063	1.125	6	RA215.26-2450DAK18L	★	★	☆	☆	.375	3.500
.500	1/2	1.500	.031	1.500	6	RA215.26-3250BAK24L	★	★	☆	☆	.500	4.000
	1/2	1.500	.063	1.500	6	RA215.26-3250DAK24L	★	★	☆	☆	.500	4.000
	1/2	2.250	.063	2.250	6	RA215.26-3250DAL36L	★	★	☆	☆	.500	5.000
.625	5/8	1.875	.063	1.875	6	RA215.26-4050DAK30L	★	★	☆	☆	.625	4.500
	5/8	2.813	.125	2.813	6	RA215.26-4050HAL45L	★	★	☆	☆	.625	5.500
.750	3/4	2.250	.063	2.250	8	RA215.28-4850DAK36L	★	★	☆	☆	.750	5.000
	3/4	3.375	.125	3.375	8	RA215.28-4850HAL54L	★	★	☆	☆	.750	6.000

A189 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for micromilling

When to use

An excellent tool dedicated for roughing in small part machining

ISO material	P M K N S H
Grade	1620
Shank	Cylindrical

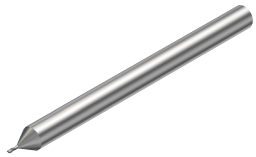
Product range

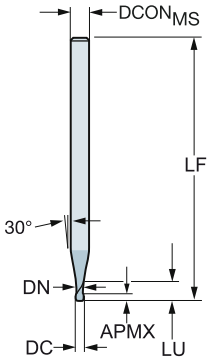
For multi-material with hardness ≤ 63 HRc

CoroMill® Plura solid carbide end mill for micromilling

For multi-material with hardness ≤ 63 HRc

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6

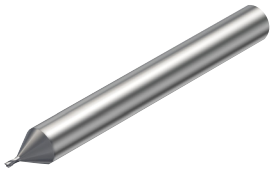


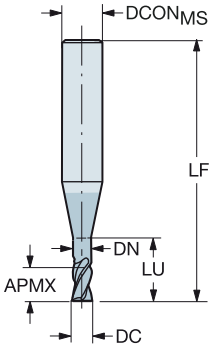


Metric version

DC	CZCMS	APMX	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	N 1620	S 1620	H 1620	Dimensions, mm DCONMS	LF	DN
0.4	3	0.4	1.3	2	2P211-0040-PC	★	★	★	★	★	★	3.0	38.0	0.4
0.5	3	0.5	1.5	2	2P211-0050-PC	★	★	★	★	★	★	3.0	38.0	0.5
	3	0.5	2.5	2	2P212-0050-PC	★	★	★	★	★	★	3.0	60.0	0.5
0.6	3	0.6	1.8	2	2P211-0060-PC	★	★	★	★	★	★	3.0	38.0	0.6
	3	0.6	3.0	2	2P212-0060-PC	★	★	★	★	★	★	3.0	60.0	0.6
0.8	3	0.8	2.0	2	2P211-0080-PC	★	★	★	★	★	★	3.0	38.0	0.8
	3	0.8	4.0	2	2P212-0080-PC	★	★	★	★	★	★	3.0	60.0	0.8
1.0	3	1.0	2.5	2	2P211-0100-PC	★	★	★	★	★	★	3.0	38.0	1.0
	3	1.0	5.0	2	2P212-0100-PC	★	★	★	★	★	★	3.0	60.0	1.0

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6





DC	CZCMS	APMX	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	N 1620	S 1620	H 1620	Dimensions, mm DCONMS	LF	DN
0.4	6	0.4	1.0	2	R216.32-00430-AE04G	★	★	★	★	★	★	6.0	54.0	0.4
0.5	6	0.5	1.2	2	R216.32-00530-AE05G	★	★	★	★	★	★	6.0	54.0	0.5
	6	0.5	2.5	2	R216.32-00530-AI05G	★	★	★	★	★	★	6.0	57.0	0.5
	6	0.5	5.0	2	R216.32-00530-AJ05G	★	★	★	★	★	★	6.0	57.0	0.5
0.6	6	0.6	1.5	2	R216.32-00630-AE06G	★	★	★	★	★	★	6.0	54.0	0.6
	6	0.6	3.0	2	R216.32-00630-AI06G	★	★	★	★	★	★	6.0	57.0	0.6
	6	0.6	6.0	2	R216.32-00630-AJ06G	★	★	★	★	★	★	6.0	57.0	0.6
0.8	6	0.8	2.0	2	R216.32-00830-AE08G	★	★	★	★	★	★	6.0	54.0	0.8
	6	0.8	4.0	2	R216.32-00830-AI08G	★	★	★	★	★	★	6.0	57.0	0.8
	6	0.8	8.0	2	R216.32-00830-AJ08G	★	★	★	★	★	★	6.0	57.0	0.8
1.0	6	1.0	2.5	2	R216.32-01030-AE10G	★	★	★	★	★	★	6.0	54.0	1.0
	6	1.0	5.0	2	R216.32-01030-AI10G	★	★	★	★	★	★	6.0	57.0	1.0
	6	1.0	10.0	2	R216.32-01030-AJ10G	★	★	★	★	★	★	6.0	57.0	1.0

A190 A194 E9 E22 E14

CoroMill® Plura solid carbide ball nose end mill for micromilling

When to use

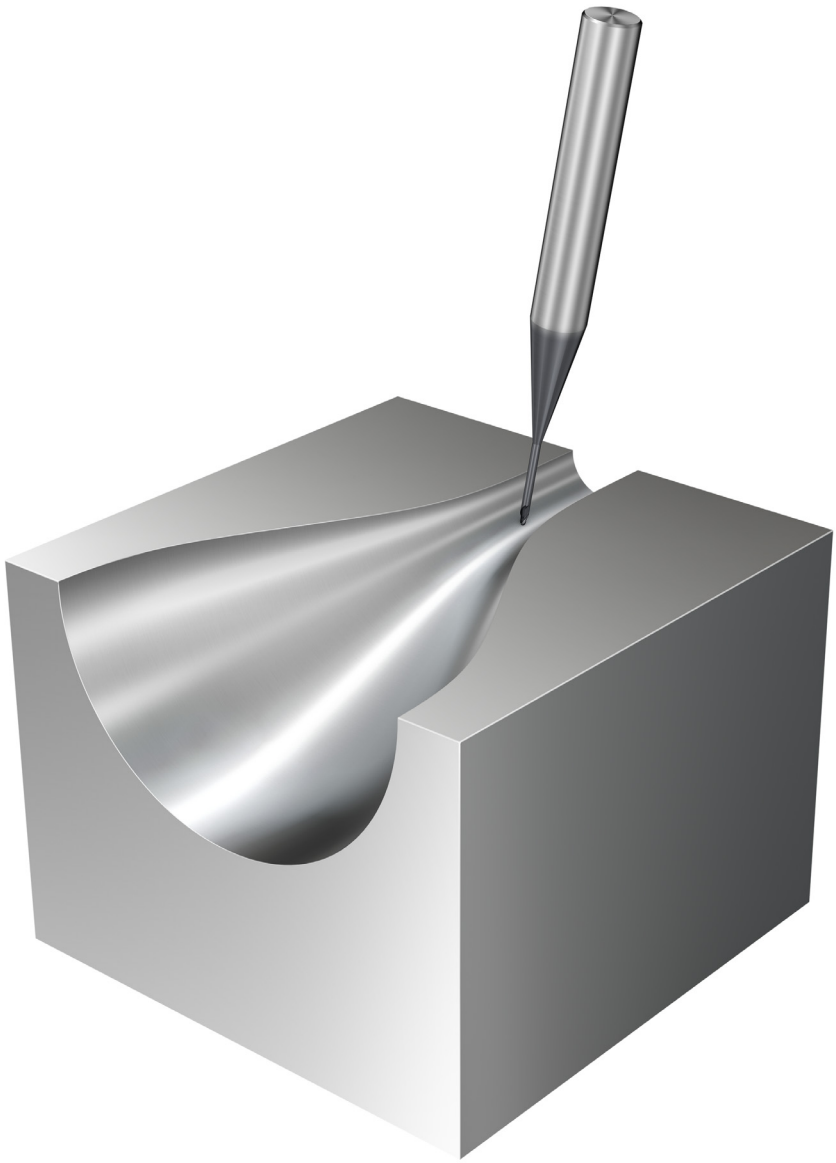
Dedicated for profiling in small part machining

ISO material	P M K N S H
Grade	1620 1700
Shank	Cylindrical

Product range

For multi-material with hardness ≤ 63 HRc

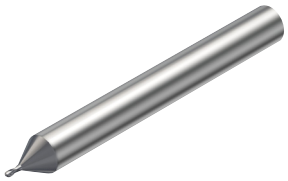
For hardened steel with hardness 43 ≤ HRc ≤ 63

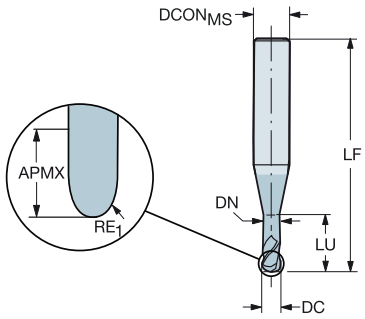


CoroMill® Plura solid carbide ball nose end mill for micromilling

For multi-material with hardness ≤ 63 HRc

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°

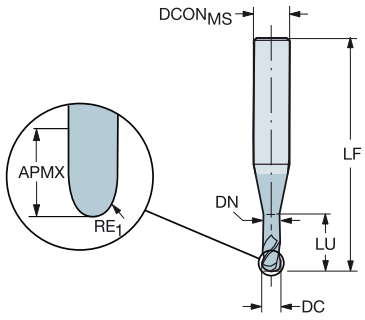




Metric version

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	N 1620	S 1620	H 1620	Dimensions, mm $DCON_{MS}$	LF	DN
0.4	6	0.4	0.20	1.0	2	R216.42-00430-AE04G	★	★	★	★	★	★	6.0	54.0	0.4
0.5	6	0.5	0.25	1.2	2	R216.42-00530-AE05G	★	★	★	★	★	★	6.0	54.0	0.5
0.6	6	0.6	0.30	1.5	2	R216.42-00630-AE06G	★	★	★	★	★	★	6.0	54.0	0.6
0.8	6	0.8	0.40	2.0	2	R216.42-00830-AE08G	★	★	★	★	★	★	6.0	54.0	0.8
1.0	6	1.0	0.50	2.5	2	R216.42-01030-AE10G	★	★	★	★	★	★	6.0	54.0	1.0

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°



Metric version

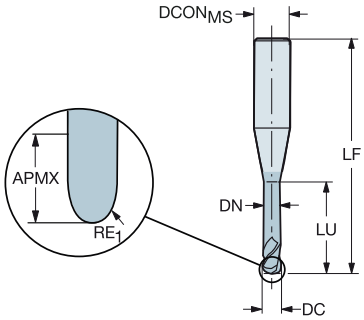
DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	N 1620	S 1620	H 1620	Dimensions, mm $DCON_{MS}$	LF	DN
0.5	6	0.5	0.25	2.5	2	R216.42-00530-AO05G	★	★	★	★	★	★	6.0	57.0	0.5
0.6	6	0.6	0.30	3.0	2	R216.42-00630-AO06G	★	★	★	★	★	★	6.0	57.0	0.6
0.8	6	0.8	0.40	4.0	2	R216.42-00830-AO08G	★	★	★	★	★	★	6.0	57.0	0.8
1.0	6	1.0	0.50	5.0	2	R216.42-01030-AO10G	★	★	★	★	★	★	6.0	57.0	1.0

A190 A194 E9 E22 E14

CoroMill® Plura solid carbide ball nose end mill for micromilling

For multi-material with hardness ≤ 63 HRc

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°



Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	N 1620	S 1620	H 1620	Dimensions, mm DCON$_{MS}$	LF	DN
0.5	6	0.5	0.25	5.0	2	R216.42-00530-AJ05G	★	★	★	★	★	★	6.0	57.0	0.5
0.6	6	0.6	0.30	6.0	2	R216.42-00630-AJ06G	★	★	★	★	★	★	6.0	57.0	0.6
0.8	6	0.8	0.40	8.0	2	R216.42-00830-AJ08G	★	★	★	★	★	★	6.0	57.0	0.8
1.0	6	1.0	0.50	10.0	2	R216.42-01030-AJ10G	★	★	★	★	★	★	6.0	57.0	1.0

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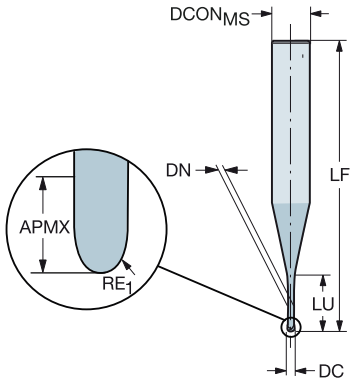
CoroMill® Plura solid carbide ball nose end mill for micromilling

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA	30°
BSG	COROMANT
TCDC	h8
TCDCON	h5
PSIR	0°



Metric version

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	H 1700	Dimensions, mm $DCON_{MS}$	LF	DN
0.2	4	0.2	0.10	0.3	2	R216.42-00230-EC02G	★	4.0	45.0	0.2
	4	0.2	0.10	2.0	2	R216.42-00230-IC02G	★	4.0	45.0	0.2
0.3	4	0.3	0.15	0.5	2	R216.42-00330-EC03G	★	4.0	45.0	0.3
	4	0.3	0.15	0.9	2	R216.42-00330-FC03G	★	4.0	45.0	0.3
	4	0.3	0.15	1.5	2	R216.42-00330-GC03G	★	4.0	45.0	0.3
	4	0.3	0.15	2.0	2	R216.42-00330-HC03G	★	4.0	45.0	0.3
	4	0.3	0.15	3.0	2	R216.42-00330-JC03G	★	4.0	45.0	0.3
0.4	4	0.3	0.20	0.6	2	R216.42-00430-EC04G	★	4.0	45.0	0.4
	4	0.3	0.20	1.2	2	R216.42-00430-FC04G	★	4.0	45.0	0.4
	4	0.3	0.20	2.0	2	R216.42-00430-GC04G	★	4.0	45.0	0.4
	4	0.3	0.20	4.0	2	R216.42-00430-JC04G	★	4.0	45.0	0.4
0.5	4	0.4	0.25	0.8	2	R216.42-00530-EC05G	★	4.0	45.0	0.5
	4	0.4	0.25	1.5	2	R216.42-00530-FC05G	★	4.0	45.0	0.5
	4	0.4	0.25	3.0	2	R216.42-00530-HC05G	★	4.0	45.0	0.5
	4	0.4	0.25	5.0	2	R216.42-00530-JC05G	★	4.0	45.0	0.5
0.8	4	0.5	0.40	1.2	2	R216.42-00830-EC08G	★	4.0	45.0	0.8
	4	0.5	0.40	2.4	2	R216.42-00830-FC08G	★	4.0	45.0	0.8
1.0	6	0.8	0.50	1.5	2	R216.42-01030-EC10G	★	6.0	45.0	1.0
	6	0.8	0.50	3.0	2	R216.42-01030-FC10G	★	6.0	45.0	1.0
	6	0.8	0.50	6.0	2	R216.42-01030-HC10G	★	6.0	45.0	1.0
	6	0.8	0.50	10.0	2	R216.42-01030-JC10G	★	6.0	50.0	1.0
1.2	6	1.1	0.60	3.6	2	R216.42-01230-FC12G	★	6.0	45.0	1.2
1.5	6	1.4	0.75	2.3	2	R216.42-01530-EC15G	★	6.0	45.0	1.4
	6	1.4	0.75	4.5	2	R216.42-01530-FC15G	★	6.0	45.0	1.4
	6	1.4	0.75	8.0	2	R216.42-01530-GC15G	★	6.0	45.0	1.4
	6	1.4	0.75	12.0	2	R216.42-01530-IC15G	★	6.0	50.0	1.4
2.0	6	1.7	1.00	3.0	2	R216.42-02030-EC20G	★	6.0	45.0	1.9
	6	1.7	1.00	6.0	2	R216.42-02030-FC20G	★	6.0	45.0	1.9
	6	1.7	1.00	8.0	2	R216.42-02030-GC20G	★	6.0	45.0	1.9
	6	1.7	1.00	12.0	2	R216.42-02030-HC20G	★	6.0	50.0	1.9
	6	1.7	1.00	16.0	2	R216.42-02030-IC20G	★	6.0	50.0	1.9
	6	1.7	1.00	20.0	2	R216.42-02030-JC20G	★	6.0	55.0	1.9
2.5	6	2.0	1.25	15.0	2	R216.42-02530-HC25G	★	6.0	50.0	2.4
	6	2.0	1.25	20.0	2	R216.42-02530-IC25G	★	6.0	55.0	2.4

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SANDVIK Coromant

CoroMill® Plura solid carbide ball nose end mill for profiling

When to use

Profiling in different materials

ISO material	P	M	K	N	S	O
Grade	1620	1630				
Shank	Cylindrical					

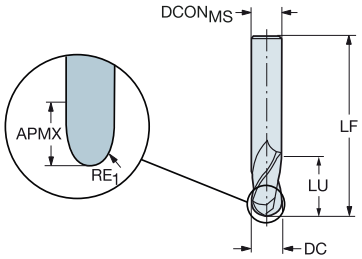
Product range

For multi-material with hardness ≤ 48 HRc

CoroMill® Plura solid carbide ball nose end mill for profiling

For non-ferrous material

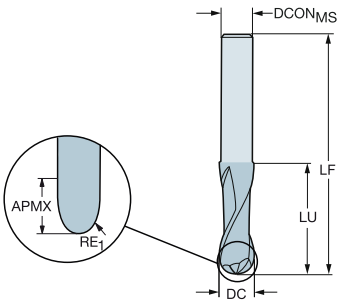
FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°



Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	N H10F	Dimensions, mm DCON$_{MS}$	LF
2.0	6	6.0	1.00	6.0	2	R216.42-02030-AK60A	★	6.0	57.0
3.0	6	7.0	1.50	7.0	2	R216.42-03030-AK07A	★	6.0	80.0
4.0	6	8.0	2.00	8.0	2	R216.42-04030-AK08A	★	6.0	80.0
5.0	6	10.0	2.50	10.0	2	R216.42-05030-AK10A	★	6.0	80.0
6.0	6	10.0	3.00	10.0	2	R216.42-06030-AK10A	★	6.0	80.0
8.0	8	16.0	4.00	16.0	2	R216.42-08030-AK16A	★	8.0	100.0
10.0	10	19.0	5.00	19.0	2	R216.42-10030-AK19A	★	10.0	100.0
12.0	12	22.0	6.00	22.0	2	R216.42-12030-AK22A	★	12.0	100.0
16.0	16	26.0	8.00	26.0	2	R216.42-16030-AK26A	★	16.0	100.0

FHA	40°
BSG	COROMANT
TCDC	h10
TCDCON	h6
PSIR	0°



Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	N H10F	Dimensions, mm DCON$_{MS}$	LF
3.0	2	4.0	1.50	32.0	2	2B320-0300-NG	★	2.9	60.0
4.0	3	5.0	2.00	32.0	2	2B320-0400-NG	★	3.8	60.0
5.0	4	8.0	2.50	42.0	2	2B320-0500-NG	★	4.8	70.0
6.0	5	9.0	3.00	64.0	2	2B320-0600-NG	★	5.8	100.0
8.0	7	13.0	4.00	64.0	2	2B320-0800-NG	★	7.8	100.0
10.0	9	15.0	5.00	60.0	2	2B320-1000-NG	★	9.7	100.0
12.0	11	17.0	6.00	80.0	2	2B320-1200-NG	★	11.7	125.0
16.0	15	23.0	8.00	77.0	2	2B320-1600-NG	★	15.7	125.0

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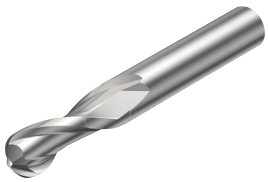
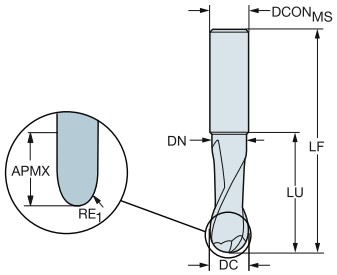
SANDVIK Coromant

CoroMill® Plura solid carbide ball nose end mill for profiling

For non-ferrous material

FHA	40°
BSG	COROMANT
TCDC	h10
TCDCON	h8
PSIR	0°





Metric version

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	N H10F	Dimensions, mm $DCON_{MS}$	LF	DN
3.0	3	5.0	1.50	8.8	2	2B330-0300-NC	★	3.0	38.0	2.7
4.0	4	7.0	2.00	11.8	2	2B330-0400-NC	★	4.0	50.0	3.7
5.0	5	10.0	2.50	14.8	2	2B330-0500-NC	★	5.0	50.0	4.7
6.0	6	11.0	3.00	17.8	2	2B330-0600-NC	★	6.0	57.0	5.7
8.0	8	14.0	4.00	23.8	2	2B330-0800-NC	★	8.0	63.0	7.7
10.0	10	18.0	5.00	29.8	2	2B330-1000-NC	★	10.0	73.0	9.7
12.0	12	22.0	6.00	35.8	2	2B330-1200-NC	★	12.0	83.0	11.7
16.0	16	29.0	8.00	47.8	2	2B330-1600-NC	★	16.0	92.0	15.7

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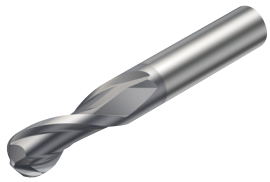
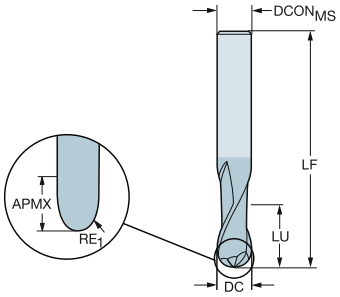
CoroMill® Plura solid carbide ball nose end mill for profiling

For non-ferrous material with silicon content > 9%

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h8
PSIR	0°





Metric version

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	N N20C	O N20C	Dimensions, mm $DCON_{MS}$	LF
1.0	3	3.0	0.50	3.0	2	2B230-0100-NA	★	☆	3.0	38.0
1.5	3	3.0	0.75	3.0	2	2B230-0150-NA	★	☆	3.0	38.0
2.0	3	6.0	1.00	6.0	2	2B230-0200-NA	★	☆	3.0	38.0
3.0	3	7.0	1.50	7.0	2	2B230-0300-NA	★	☆	3.0	38.0
4.0	6	8.0	2.00	8.0	2	2B230-0400-NA	★	☆	6.0	57.0
6.0	6	10.0	3.00	10.0	2	2B230-0600-NA	★	☆	6.0	57.0
8.0	8	16.0	4.00	16.0	2	2B230-0800-NA	★	☆	8.0	63.0
10.0	10	19.0	5.00	19.0	2	2B230-1000-NA	★	☆	10.0	72.0
12.0	12	22.0	6.00	22.0	2	2B230-1200-NA	★	☆	12.0	83.0

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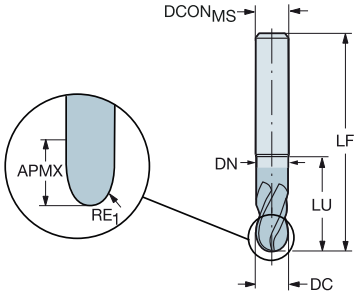
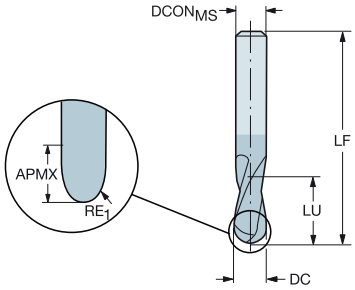
CoroMill® Plura solid carbide ball nose end mill for profiling

For steel and hardened steel with hardness ≤ 63 HRc

	R216.42..30-AI..G	R216.4x..30-AK..G
FHA	30°	30°
BSG	COROMANT	COROMANT
TCDC	h9	h9
TCDCON	h6	h6
PSIR	0°	0°





Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1610	P 1620	M 1620	K 1620	S 1620	H 1610	Dimensions, mm DCON$_{MS}$	LF	DN
1.0	6	1.0	0.50	1.0	2	R216.42-01030-AI10G	☆	★	★	☆	☆	★	6.0	57.0	
	6	1.5	0.50	1.5	2	R216.42-01030-AK15G	★	★	★	☆	☆	★	6.0	57.0	
1.5	6	1.5	0.75	2.0	2	R216.42-01530-AI15G	☆					★	6.0	57.0	
	6	2.0	0.75	2.0	2	R216.42-01530-AK20G	★	★	★	☆	☆	★	6.0	57.0	
2.0	6	2.0	1.00	2.0	2	R216.42-02030-AI20G	☆	★	★	☆	☆	★	6.0	57.0	
	6	3.0	1.00	3.0	2	R216.42-02030-AK30G	★	★	★	☆	☆	★	6.0	57.0	
2.5	6	2.5	1.25	2.0	2	R216.42-02530-AI25G	☆					★	6.0	57.0	
	6	3.0	1.25	3.0	2	R216.42-02530-AK30G	★	★	★	☆	☆	★	6.0	57.0	
3.0	6	3.0	1.50	3.0	2	R216.42-03030-AI03G	☆	★	★	☆	☆	★	6.0	57.0	
	6	4.0	1.50	4.0	2	R216.42-03030-AK04G	★	★	★	☆	☆	★	6.0	57.0	
4.0	6	4.0	2.00	4.0	2	R216.42-04030-AI04G	☆	★	★	☆	☆	★	6.0	57.0	
	6	5.0	2.00	5.0	2	R216.42-04030-AK05G	★	★	★	☆	☆	★	6.0	80.0	
5.0	6	5.0	2.50	20.0	2	R216.42-05030-AI05G	☆	★	★	☆	☆	★	6.0	57.0	4.9
	6	6.0	2.50	6.0	2	R216.42-05030-AK06G	★	★	★	☆	☆	★	6.0	80.0	
6.0	6	6.0	3.00	21.0	2	R216.42-06030-AI06G	☆	★	★	☆	☆	★	6.0	63.0	5.7
	6	10.0	3.00	10.0	2	R216.42-06030-AK10G	★	★	★	☆	☆	★	6.0	80.0	
8.0	8	8.0	4.00	27.0	2	R216.42-08030-AI08G	☆	★	★	☆	☆	★	8.0	63.0	7.7
	8	16.0	4.00	16.0	2	R216.42-08030-AK16G	★	★	★	☆	☆	★	8.0	100.0	
10.0	10	10.0	5.00	32.0	2	R216.42-10030-AI10G	☆	★	★	☆	☆	★	10.0	72.0	9.7
	10	19.0	5.00	19.0	2	R216.42-10030-AK19G	★	★	★	☆	☆	★	10.0	100.0	
12.0	12	12.0	6.00	36.0	2	R216.42-12030-AI12G	☆	★	★	☆	☆	★	12.0	83.0	11.4
	12	22.0	6.00	22.0	2	R216.42-12030-AK22G	★	★	★	☆	☆	★	12.0	100.0	
16.0	16	32.0	8.00	32.0	2	R216.42-16030-AK32G	★	★	★	☆	☆	★	16.0	125.0	

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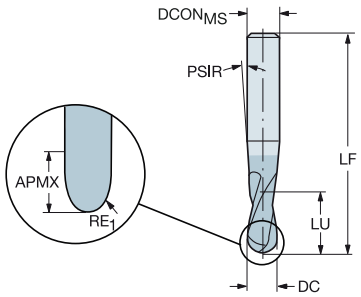
CoroMill® Plura solid carbide ball nose end mill for profiling

For steel and hardened steel with hardness ≤ 63 HRc

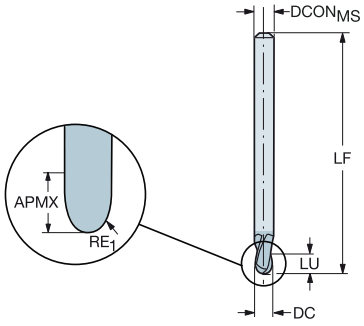
FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°



Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1610	P 1620	M 1620	K 1620	S 1620	H 1610	Dimensions, mm DCON$_{MS}$	LF	PSIR
1.0	6	1.0	0.50	1.0	2	R216.42-01030-AP10G	★	★	★	☆	☆	★	6.0	80.0	0°
2.0	6	2.0	1.00	2.0	2	R216.42-02030-AP20G	★	★	★	☆	☆	★	6.0	80.0	0°
3.0	6	3.0	1.50	3.0	2	R216.42-03030-AP03G	★	★	★	☆	☆	★	6.0	80.0	0°
4.0	8	4.0	2.00	4.0	2	R216.42-04030-AP04G	★	★	★	☆	☆	★	8.0	90.0	0°
5.0	8	5.0	2.50	5.0	2	R216.42-05030-AP05G	★	★	★	☆	☆	★	8.0	100.0	0°
6.0	10	6.0	3.00	6.0	2	R216.42-06030-AP06G	★	★	★	☆	☆	★	10.0	100.0	0°
8.0	12	8.0	4.00	8.0	2	R216.42-08030-AP08G	★	★	★	☆	☆	★	12.0	100.0	0°
10.0	14	10.0	5.00	10.0	2	R216.42-10030-AP10G	★	★	★	☆	☆	★	14.0	125.0	0°
12.0	16	12.0	6.00	12.0	2	R216.42-12030-AP12G	★	★	★	☆	☆	★	16.0	140.0	0°

FHA	30°
BSG	COROMANT
TCDC	h7
TCDCON	h6
PSIR	0°



Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P P10	M P10	K P10	S P10	H P10	Dimensions, mm DCON$_{MS}$	LF
3.0	3	5.0	1.50	5.0	2	R216.42-03030-AQ05G	★	☆	☆	☆	★	3.0	100.0
4.0	4	6.0	2.00	6.0	2	R216.42-04030-AQ06G	★	☆	☆	☆	★	4.0	100.0
6.0	6	9.0	3.00	9.0	2	R216.42-06030-AQ09G	★	☆	☆	☆	★	6.0	125.0
8.0	8	12.0	4.00	12.0	2	R216.42-08030-AQ12G	★	☆	☆	☆	★	8.0	150.0
10.0	10	15.0	5.00	15.0	2	R216.42-10030-AQ15G	★	☆	☆	☆	★	10.0	150.0
12.0	12	18.0	6.00	18.0	2	R216.42-12030-AQ18G	★	☆	☆	☆	★	12.0	150.0

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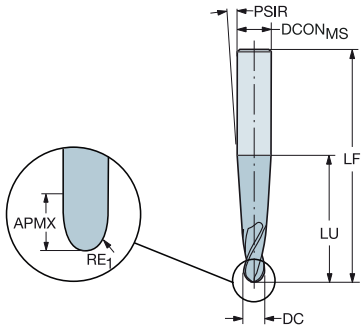
CoroMill® Plura solid carbide ball nose end mill for profiling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	40°
BSG	COROMANT
TCDCON	h6
PSIR	3°



Metric version

DC	CZC_{MS}	APMX	RE_1	LU	ZEFP	Ordering code	P 1620	P 1630	M 1620	M 1630	K 1620	K 1630	N 1620	N 1630	S 1620	S 1630	H 1620	H 1630	Dimensions, mm $DCON_{MS}$	LF	PSIR
4.0	8	40.0	2.00	40.0	3	R216.53-04040RAL40G	☆		★		☆		☆		★		☆		8.0	80.0	3°
	8	10.0	2.00	10.0	2	R216.52-04040RAL10G		★		☆		★		☆		☆		☆	8.0	80.0	3°
6.0	10	12.0	3.00	12.0	2	R216.52-06040RAL12G		★		☆		★		☆		☆		☆	10.0	100.0	3°
	10	40.0	3.00	40.0	4	R216.54-06040RAL40G	☆		★		☆		☆		★		☆		10.0	100.0	3°
8.0	12	15.0	4.00	15.0	3	R216.53-08040RAL15G		★		☆		★		☆		☆		☆	12.0	100.0	3°
	12	40.0	4.00	40.0	4	R216.54-08040RAL40G	☆		★		☆		☆		★		☆		12.0	100.0	3°
10.0	14	40.0	5.00	40.0	4	R216.54-10040RAL40G	☆		★		☆		☆		★		☆		14.0	115.0	3°
12.0	16	42.0	6.00	42.0	4	R216.54-12040RAL42G	☆		★		☆		☆		★		☆		16.0	115.0	3°
16.0	20	45.0	8.00	45.0	4	R216.54-16040RAL45G	☆		★		☆		☆		★		☆		20.0	125.0	3°

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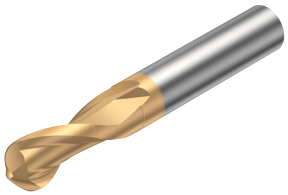
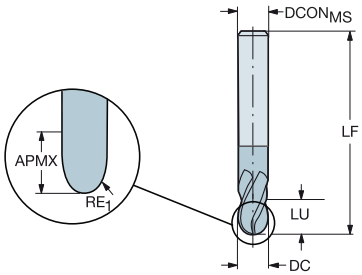
CoroMill® Plura solid carbide ball nose end mill for profiling

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA 30°
BSG COROMANT
TCDCON h6
PSIR 0°

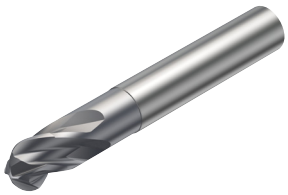


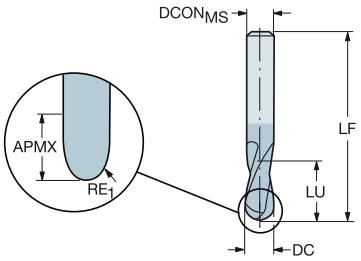


Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	H 1700	DCON$_{MS}$	LF
3.0	6	4.5	1.50	10.0	2	R216.42-03030-AL04G	★	6.0	70.0
	6	4.5	1.50	5.0	2	R216.42-03030-AS04G	★	6.0	57.0
4.0	6	6.0	2.00	6.0	2	R216.42-04030-AC06G	★	6.0	70.0
	6	6.0	2.00	6.0	2	R216.42-04030-AS06G	★	6.0	57.0
5.0	6	7.5	2.50	8.0	2	R216.42-05030-AC07G	★	6.0	80.0
	6	7.5	2.50	8.0	2	R216.42-05030-AS07G	★	6.0	57.0
6.0	6	9.0	3.00	9.0	2	R216.42-06030-AC09G	★	6.0	90.0
	6	9.0	3.00	9.0	2	R216.42-06030-AS09G	★	6.0	57.0
8.0	8	12.0	4.00	12.0	2	R216.42-08030-AC12G	★	8.0	100.0
	8	12.0	4.00	12.0	2	R216.42-08030-AS12G	★	8.0	63.0
10.0	10	15.0	5.00	15.0	2	R216.42-10030-AC15G	★	10.0	100.0
	10	15.0	5.00	15.0	2	R216.42-10030-AS15G	★	10.0	72.0
12.0	12	18.0	6.00	18.0	2	R216.42-12030-AS18G	★	12.0	83.0

FHA 30°
BSG COROMANT
TCDC h9
TCDCON h6
PSIR 0°





Metric version

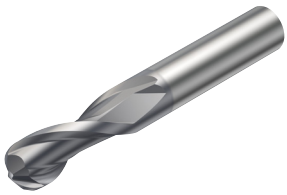
DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1610	H 1610	DCON$_{MS}$	LF
6.0	6	6.0	3.00	21.0	4	R216.44-06030-AI06G	☆	★	6.0	57.0
8.0	8	8.0	4.00	27.0	4	R216.44-08030-AI08G	☆	★	8.0	63.0
10.0	10	10.0	5.00	32.0	4	R216.44-10030-AI10G	☆	★	10.0	72.0
12.0	12	12.0	6.00	36.0	4	R216.44-12030-AI12G	☆	★	12.0	83.0
16.0	16	16.0	8.00	42.0	4	R216.44-16030-AI16G	☆	★	16.0	92.0

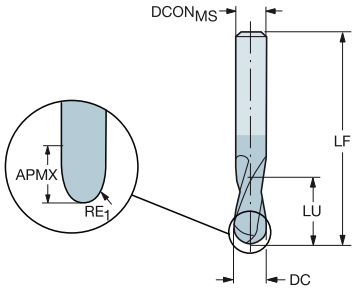
A192 A194 E9 E22 E14

CoroMill® Plura solid carbide ball nose end mill for profiling

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA	30°
BSG	COROMANT
TCDC	h9
TCDCON	h6
PSIR	0°





Metric version

DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1610	H 1610	Dimensions, mm DCON$_{MS}$	LF
1.0	6	1.5	0.50	1.5	2	R216.42-01030-AC15G	☆	★	6.0	57.0
2.0	6	3.0	1.00	3.0	2	R216.42-02030-AC30G	☆	★	6.0	57.0
3.0	6	4.0	1.50	4.0	2	R216.42-03030-AC04G	☆	★	6.0	21.0
4.0	6	5.0	2.00	5.0	2	R216.42-04030-AC05G	☆	★	6.0	57.0
5.0	6	6.0	2.50	6.0	2	R216.42-05030-AC06G	☆	★	6.0	57.0
6.0	6	10.0	3.00	10.0	2	R216.42-06030-AC10G	☆	★	6.0	57.0
8.0	8	16.0	4.00	16.0	2	R216.42-08030-AC16G	☆	★	8.0	63.0
10.0	10	19.0	5.00	19.0	2	R216.42-10030-AC19G	☆	★	10.0	72.0
12.0	12	22.0	6.00	22.0	2	R216.42-12030-AC22G	☆	★	12.0	83.0

Inch version

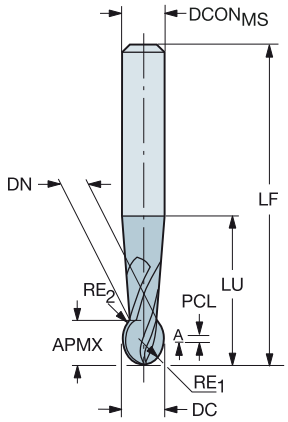
DC	CZC$_{MS}$	APMX	RE$_1$	LU	ZEFP	Ordering code	P 1610	H 1610	Dimensions, inch DCON$_{MS}$	LF
.063	1/4	.125	.031	.125	2	RA216.42-0430-AK08G	☆	★	.250	3.000
.094	1/4	.188	.047	.188	2	RA216.42-0630-AK12G	☆	★	.250	3.000
.125	1/4	.250	.063	.250	2	RA216.42-0830-AK04G	☆	★	.250	3.000
.187	1/4	.375	.094	.375	2	RA216.42-1230-AK06G	☆	★	.250	3.000
.250	1/4	.500	.125	.500	2	RA216.42-1630-AK08G	☆	★	.250	3.000
.313	3/8	.625	.156	.625	2	RA216.42-2030-AK10G	☆	★	.375	3.500
.375	3/8	.750	.188	.750	2	RA216.42-2430-AK12G	☆	★	.375	3.500
.500	1/2	1.000	.250	1.000	2	RA216.42-3230-AK16G	☆	★	.500	4.000

A192 A194 E9 E22 E14

CoroMill® Plura solid carbide ball nose end mill for profiling

For hardened steel with hardness 43 ≤ HRc ≤ 63

FHA	30°
BSG	COROMANT
TCDC	h7
TCDCON	h5
PSIR	0°



Metric version

DC	CZC_{MS}	APMX	RE_1	RE_2	LU	ZEFP	Ordering code	P 1610	H 1610	$DCON_{MS}$	LF	PCL	DN
1.0	6	2.0	0.50		4.0	2	R216.62-01030-AO20G	☆	★	6.0	75.0	1.5	1.0
2.0	6	3.0	1.00	1.00	11.0	2	R216.62-02030-AO30G	☆	★	6.0	75.0	1.5	1.7
3.0	6	4.0	1.50	1.50	16.1	2	R216.62-03030-AO04G	☆	★	6.0	80.0	1.7	2.5
4.0	6	5.0	2.00	2.00	21.2	2	R216.62-04030-AO05G	☆	★	6.0	80.0	1.9	3.3
5.0	6	7.0	2.50	2.50	43.0	2	R216.62-05030-AO07G	☆	★	6.0	80.0	3.1	4.1
	6	7.0	2.50	2.50	43.0	4	R216.64-05030-AO07G	☆	★	6.0	80.0	3.1	4.1
6.0	6	7.0	3.00	3.00	30.0	2	R216.62-06030-AO07G	☆	★	6.0	100.0	2.1	4.7
	6	7.0	3.00	3.00	30.0	4	R216.64-06030-AO07G	☆	★	6.0	100.0	2.1	4.7
8.0	8	9.0	4.00	4.00	36.0	2	R216.62-08030-AO09G	☆	★	8.0	100.0	2.7	6.5
	8	9.0	4.00	4.00	36.0	4	R216.64-08030-AO09G	☆	★	8.0	100.0	2.7	6.5
10.0	10	11.0	5.00	5.00	43.0	2	R216.62-10030-AO11G	☆	★	10.0	100.0	3.1	8.2
	10	11.0	5.00	5.00	43.0	4	R216.64-10030-AO11G	☆	★	10.0	100.0	3.1	8.2
12.0	12	13.0	6.00	6.00	52.0	2	R216.62-12030-AO13G	☆	★	12.0	100.0	3.5	9.8
	12	13.0	6.00	6.00	52.0	4	R216.64-12030-AO13G	☆	★	12.0	100.0	3.5	9.8
16.0	16	15.0	8.00	8.00	61.0	2	R216.62-16030-AO15G	☆	★	16.0	150.0	2.6	13.4
	16	15.0	8.00	8.00	61.0	4	R216.64-16030-AO15G	☆	★	16.0	150.0	2.6	13.4

A192 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for edging applications

When to use

When shaping resin-infused material, including CFRP, GRFP, aramid and other composite materials

ISO material	O
Grade	1630 O10A 012M 010M
Shank	Cylindrical

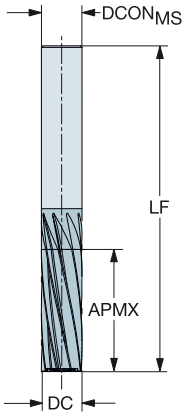
Product range

For composite materials

CoroMill® Plura solid carbide end mill for edging applications

For CFRP materials

FHA -4°
TCDCON h6



Metric version

DC	CZC_{MS}	APMX	ZEFP	Ordering code	O10A	$DCON_{MS}$	LF
					O	Dimensions, mm	
4.0	4	12.0	5	2P051-0400-OA	★	4.0	40.0
6.0	6	18.0	7	2P051-0600-OA	★	6.0	60.0
8.0	8	20.0	9	2P051-0800-OA	★	8.0	70.0
10.0	10	30.0	9	2P051-1000-OA	★	10.0	80.0
12.0	12	31.8	11	2P051-1200-OA	★	12.0	82.5

Inch version

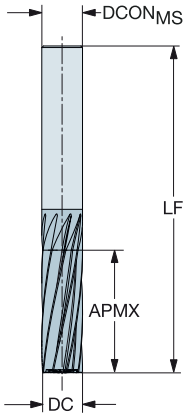
DC	CZC_{MS}	APMX	ZEFP	Ordering code	O10A	$DCON_{MS}$	LF
					O	Dimensions, inch	
.250	1/4	.752	7	2P051-0635-OA	★	.250	2.500
.313	5/16	.752	7	2P051-0794-OA	★	.313	2.500
.375	3/8	1.122	9	2P051-0953-OA	★	.375	3.000
.500	1/2	1.252	11	2P051-1270-OA	★	.500	3.248

A192 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for edging applications

For CFRP materials

FHA 4°
TCDCON h6



Metric version

DC	CZC_{MS}	APMX	ZEFP	Ordering code	O10A	$DCON_{MS}$	LF
					0	Dimensions, mm	
4.0	4	12.0	5	2P050-0400-OA	★	4.0	40.0
6.0	6	18.0	7	2P050-0600-OA	★	6.0	60.0
8.0	8	20.0	9	2P050-0800-OA	★	8.0	70.0
10.0	10	30.0	9	2P050-1000-OA	★	10.0	80.0
12.0	12	31.8	11	2P050-1200-OA	★	12.0	82.5

Inch version

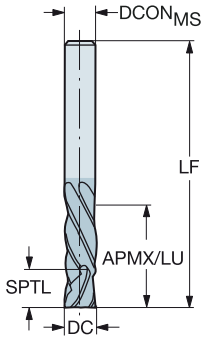
DC	CZC_{MS}	APMX	ZEFP	Ordering code	O10A	$DCON_{MS}$	LF
					0	Dimensions, inch	
.250	1/4	.752	7	2P050-0635-OA	★	.250	2.500
.313	5/16	.752	7	2P050-0794-OA	★	.313	2.500
.375	3/8	1.122	9	2P050-0953-OA	★	.375	3.000
.500	1/2	1.252	11	2P050-1270-OA	★	.500	3.248

A192 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for edging applications

For CFRP materials

FHA	30°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Metric version

DC	CZC$_{MS}$	APMX	LU	ZEFP	Ordering code	0 / 1630	DCON$_{MS}$	LF	SPTL
6.0	6	26.0	26.0	6	2P460-0600-NA	★	6.0	76.0	6.0
8.0	8	26.0	26.0	6	2P460-0800-NA	★	8.0	76.0	8.0
10.0	10	30.0	30.0	6	2P460-1000-NA	★	10.0	76.0	10.0
12.0	12	38.0	38.0	6	2P460-1200-NA	★	12.0	100.0	12.0
16.0	16	38.0	38.0	6	2P460-1600-NA	★	16.0	100.0	16.0

Inch version

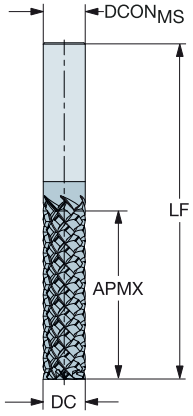
DC	CZC$_{MS}$	APMX	LU	ZEFP	Ordering code	0 / 1630	DCON$_{MS}$	LF	SPTL
.250	1/4	1.000	1.000	6	2P460-0635-NA	★	.250	3.000	.250
.313	5/16	1.000	1.000	6	2P460-0794-NA	★	.313	3.000	.313
.375	3/8	1.250	1.250	6	2P460-0952-NA	★	.375	3.000	.375
.500	1/2	1.500	1.500	6	2P460-1270-NA	★	.500	4.000	.500
.625	5/8	1.500	1.500	6	2P460-1588-NA	★	.625	4.000	.625

A192 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for edging applications

For CFRP materials

FHA 40°
TCDCON h6



Metric version

DC	CZC$_{MS}$	APMX	ZEFP	Ordering code	O12M	DCON$_{MS}$	LF
6.0	6	18.0	5	2P350-0600-OA	★	6.0	60.0
8.0	8	20.0	6	2P350-0800-OA	★	8.0	70.0
10.0	10	30.0	6	2P350-1000-OA	★	10.0	80.0
12.0	12	31.8	6	2P350-1200-OA	★	12.0	82.5

Inch version

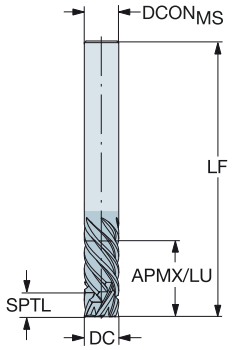
DC	CZC$_{MS}$	APMX	ZEFP	Ordering code	O12M	DCON$_{MS}$	LF
.250	1/4	.750	5	2P350-0635-OA	★	.250	2.500
.313	5/16	.750	6	2P350-0794-OA	★	.313	2.500
.375	3/8	1.122	6	2P350-0953-OA	★	.375	3.000
.500	1/2	1.252	6	2P350-1270-OA	★	.500	3.248

A192 A194 E9 E22 E14

CoroMill® Plura solid carbide end mill for edging applications

For CFRP materials

FHA 40°
TCDCON h6



Metric version

DC	CZC_{MS}	APMX	ZEFP	Ordering code	O 010M	$DCON_{MS}$	LF	SPTL
						Dimensions, mm		
6.0	6	18.0	6	2P460-0600-OA	★	6.0	60.0	5.0
8.0	8	20.0	6	2P460-0800-OA	★	8.0	70.0	5.0
10.0	10	30.0	6	2P460-1000-OA	★	10.0	80.0	5.0
12.0	12	31.8	6	2P460-1200-OA	★	12.0	82.5	10.0
16.0	16	38.1	6	2P460-1600-OA	★	16.0	100.0	10.0

Inch version

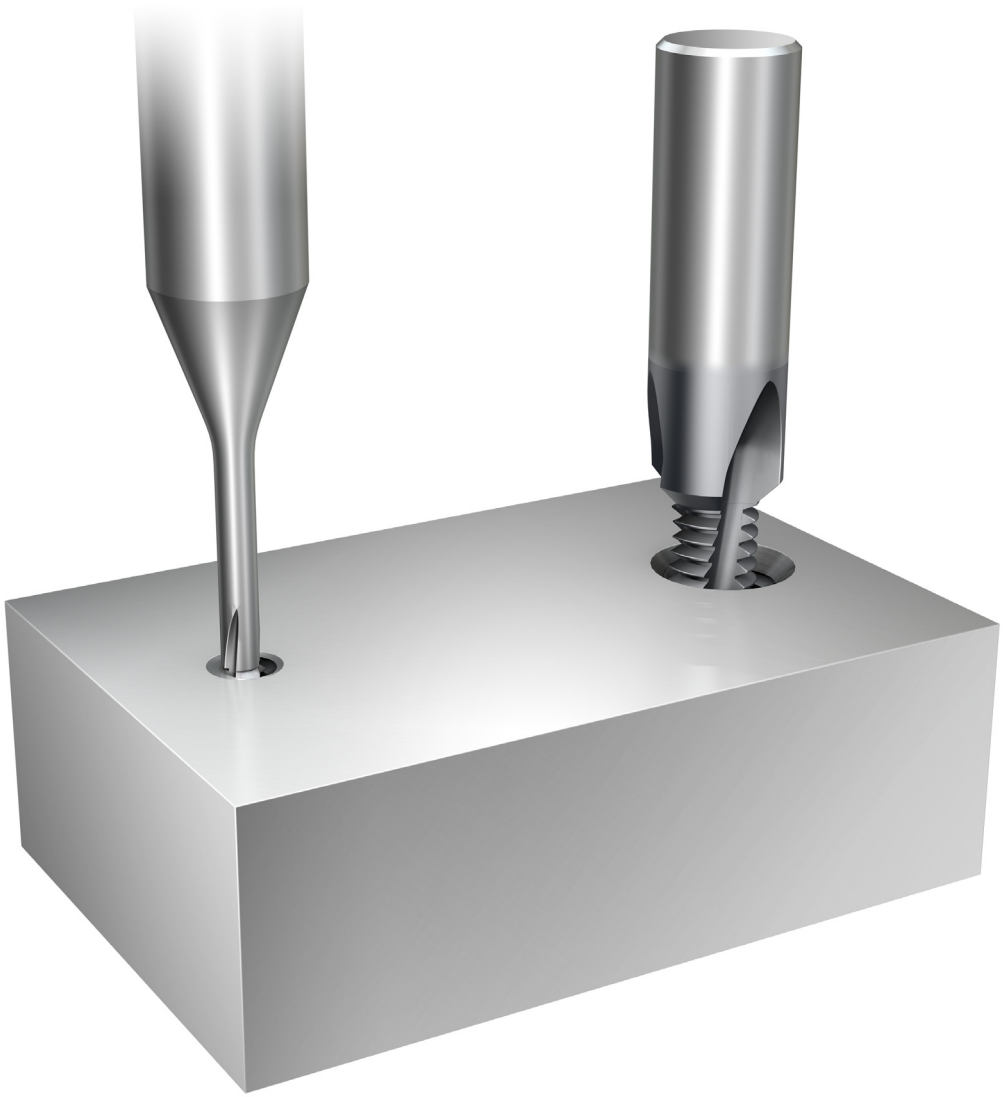
DC	CZC_{MS}	APMX	ZEFP	Ordering code	O 010M	$DCON_{MS}$	LF	SPTL
						Dimensions, inch		
.250	1/4	.752	6	2P460-0635-OA	★	.250	2.500	.197
.313	5/16	.752	6	2P460-0794-OA	★	.313	2.500	.197
.375	3/8	1.122	6	2P460-0953-OA	★	.375	3.000	.197
.500	1/2	1.252	6	2P460-1270-OA	★	.500	3.248	.394
.625	5/8	1.500	6	2P460-1588-OA	★	.625	4.000	.394

A192 A194 E9 E22 E14

SANDVIK Coromant

CoroMill® Plura solid carbide end mill for thread milling

ISO material	P	M	K	N	S	H	O
Grade	1610	1620	H07F				
Shank	Cylindrical		Weldon				

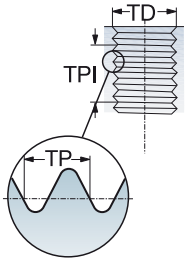


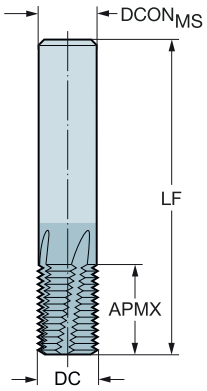
CoroMill® Plura solid carbide end mill for thread milling

For multi-materials

Internal threads

FHA 10°
BSG COROMANT
TCDCON h6





Metric/Metric Fine, 60°

FTDZ	TP	DC	CZC_{MS}	APMX	CNSC	CXSC	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, mm $DCON_{MS}$	LF
M4X0.7	0.70	3.20	6.0	8.40	0	0	3	R217.13-032070AC08N	★	★	★	★	★	★	6.00	57.00
M5X0.8	0.80	4.10	6.0	11.20	0	0	3	R217.13-041080AC11N	★	★	★	★	★	★	6.00	57.00
M6X0,5	0.50	4.80	6.0	10.00	1	1	3	R217.13C048050AC10N	★	★	★	★	★	★	6.00	57.00
M8X0,75	0.75	6.00	6.0	12.00	1	1	3	R217.13C060075AC12N	★	★	★	★	★	★	6.00	57.00
M6X1.0	1.00	4.50	6.0	13.00	1	1	4	R217.14C045100AC13N	★	★	★	★	★	★	6.00	57.00
M8X1.25	1.25	6.00	6.0	17.50	1	1	4	R217.14C060125AK17N	★	★	★	★	★	★	6.00	65.00
M10X1.5	1.50	7.50	8.0	21.00	1	1	4	R217.14C075150AK21N	★	★	★	★	★	★	8.00	72.00
M10X1,0	1.00	8.00	8.0	16.00	1	1	4	R217.14C080100AC16N	★	★	★	★	★	★	8.00	63.00
M12X1.75	1.75	9.50	10.0	26.25	1	1	4	R217.14C095175AK26N	★	★	★	★	★	★	10.00	80.00
M14X2.0	2.00	10.00	10.0	30.00	1	1	5	R217.15C100200AK30N	★	★	★	★	★	★	10.00	83.00
M14X1,5	1.50	12.00	12.0	22.50	1	1	4	R217.14C120150AC22N	★	★	★	★	★	★	12.00	83.00
M16X2.0	2.00	12.00	12.0	34.00	1	1	5	R217.15C120200AK34N	★	★	★	★	★	★	12.00	92.00
M18X1,5	1.50	16.00	16.0	30.00	1	1	5	R217.15C160150AC30N	★	★	★	★	★	★	16.00	92.00
M20X2,5	2.50	16.00	16.0	42.50	1	1	5	R217.15C160250AK42N	★	★	★	★	★	★	16.00	105.00
M24X3,0	3.00	19.00	20.0	50.00	1	1	5	R217.15C190300AK50N	★	★	★	★	★	★	20.00	125.00

A193 A194 E9 E26 E28 E14

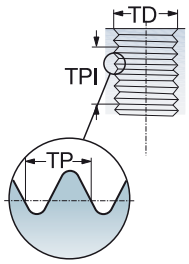
SANDVIK Coromant

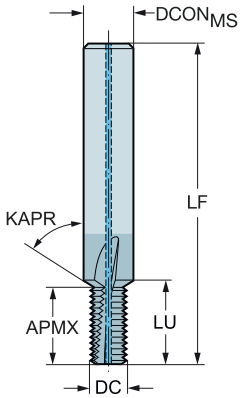
CoroMill® Plura solid carbide end mill for thread milling

For multi-materials

Internal threads

FHA 10°
BSG COROMANT
TCDCON h6





Metric/Metric Fine, 60°

FTDZ	TP	DC	CZC_{MS}	APMX	LU	CNSC	CXSC	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, mm $DCON_{MS}$	LF
M3X0.5	0.50	2.30	6.0	5.00	6.00	0	0	3	R217.13-023050CC06K	★	★	★	★	★	★	6.00	57.0
M4X0.70	0.70	3.20	6.0	8.80	9.50	1	1	3	R217.13C032070CC08K	★	★	★	★	★	★	6.00	57.0
M5X0.80	0.80	4.10	6.0	10.72	11.67	1	1	3	R217.13C041080CC11K	★	★	★	★	★	★	6.00	57.0
M6X1.0	1.00	4.80	8.0	12.78	13.58	1	1	3	R217.13C048100CC13K	★	★	★	★	★	★	8.00	63.0
M8X1.25	1.25	6.50	10.0	17.35	18.24	1	1	3	R217.13C065125CC17K	★	★	★	★	★	★	10.00	72.0
M10X1.5	1.50	8.20	12.0	22.41	23.41	1	1	3	R217.13C082150CC21K	★	★	★	★	★	★	12.00	83.0
M12X1.75	1.75	9.90	14.0	26.00	27.00	1	1	4	R217.14C099175CC26K	★	★	★	★	★	★	14.00	83.0
M14X2.0	2.00	11.60	16.0	31.30	32.40	1	1	4	R217.14C116200CC30K	★	★	★	★	★	★	16.00	92.0
M16X2.0	2.00	13.60	18.0	33.30	34.40	1	1	4	R217.14C136200CC34K	★	★	★	★	★	★	18.00	92.0

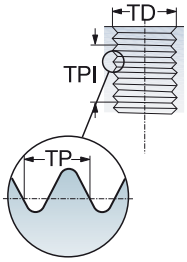
A193 A194 E9 E26 E28 E14

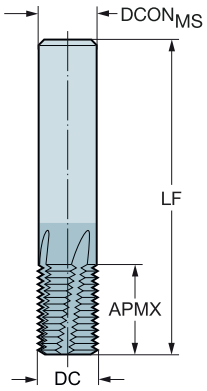
CoroMill® Plura solid carbide end mill for thread milling

For multi-materials

Internal threads

FHA 10°
BSG COROMANT
TCDCON h6





Metric/Metric Fine, 60°

FTDZ	TP	DC	CZC_{MS}	APMX	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, mm $DCON_{MS}$	LF
MF6X0.5	0.50	4.80	6.0	10.00	3	R217.13-048050AC10N	★	★	★	★	★	★	6.00	57.00
MF8X0.75	0.75	6.00	6.0	12.00	3	R217.13-060075AC12N	★	★	★	★	★	★	6.00	57.00
MF8X1.0	1.00	6.00	6.0	12.00	3	R217.13-060100AC12N	★	★	★	★	★	★	6.00	57.00
MF10X1	1.00	8.00	8.0	16.00	4	R217.14-080100AC16N	★	★	★	★	★	★	8.00	63.00
MF12X1	1.00	10.00	10.0	20.00	4	R217.14-100100AC20N	★	★	★	★	★	★	10.00	72.00
MF12X1.5	1.50	10.00	10.0	21.00	4	R217.14-100150AC20N	★	★	★	★	★	★	10.00	72.00
MF14X1	1.00	12.00	12.0	22.00	4	R217.14-120100AC22N	★	★	★	★	★	★	12.00	83.00
MF14X1.5	1.50	12.00	12.0	22.50	4	R217.14-120150AC22N	★	★	★	★	★	★	12.00	83.00
MF16X1	1.00	14.00	14.0	26.00	5	R217.15-140100AC26N	★	★	★	★	★	★	14.00	83.00
MF16X1.5	1.50	14.00	14.0	27.00	5	R217.15-140150AC26N	★	★	★	★	★	★	14.00	83.00
MF20X2	2.00	16.00	16.0	30.00	5	R217.15-160200AC30N	★	★	★	★	★	★	16.00	92.00
M20X2,5	2.50	16.00	16.0	42.50	5	R217.15-160250AC42N	★	★	★	★	★	★	16.00	105.00
M24X3	3.00	19.00	20.0	50.00	5	R217.15-190300AC50N	★	★	★	★	★	★	20.00	125.00
MF24X2	2.00	20.00	20.0	36.00	5	R217.15-200200AC35N	★	★	★	★	★	★	20.00	104.00
MF28X2	2.00	25.00	25.0	46.00	6	R217.16-250200AC46N	★	★	★	★	★	★	25.00	121.00

A193 A194 E9 E26 E14

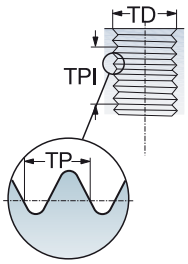
SANDVIK Coromant

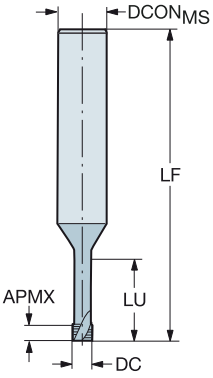
CoroMill® Plura solid carbide end mill for thread milling

For multi-materials

Internal threads

FHA 15°
BSG COROMANT
TCDCON h6





Metric/Metric Fine, 60°

								P		M		K		N		S		H		O		Dimensions, mm	
FTDZ	TP	DC	CZC_{MS}	APMX	LU	ZEFP	Ordering code	1620	H07F	1620	H07F	1620	H07F	1620	H07F	1620	H07F	1620	H07F	1620	H07F	$DCON_{MS}$	LF
M 1.6	0.35	1.20	3.0	0.53	5.33	3	R217.13-012035AC05P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.00	37.8
M 1.6	0.35	1.20	6.0	0.53	3.73	3	R217.13-012035AC03P	★		★		★		★		★		★		★		6.00	37.8
M 2	0.40	1.55	6.0	1.00	4.60	3	R217.13-015040AC04P	★		★		★		★		★		★		★		6.00	56.8
M 2	0.40	1.55	6.0	1.00	6.60	3	R217.13-015040AC06P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.00	56.8
M 2.5	0.45	1.95	6.0	1.13	5.68	3	R217.13-019045AC05P	★		★		★		★		★		★		★		6.00	56.8
M 2.5	0.45	1.95	6.0	1.13	8.18	3	R217.13-019045AC07P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.00	56.8
M 3	0.50	2.30	6.0	1.25	6.75	3	R217.13-023050AC06P	★		★		★		★		★		★		★		6.00	56.8
M 3	0.50	2.30	6.0	1.25	9.75	3	R217.13-023050AC09P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.00	56.8
M 4	0.70	3.10	6.0	1.75	9.05	3	R217.13-031070AC08P	★		★		★		★		★		★		★		6.00	56.7
M 4	0.70	3.10	6.0	1.75	13.05	3	R217.13-031070AC12P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.00	56.7
M 5	0.80	4.00	6.0	2.00	11.20	3	R217.13-040080AC10P	★		★		★		★		★		★		★		6.00	56.6
M 5	0.80	4.00	6.0	2.00	16.20	3	R217.13-040080AC15P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.00	56.6
M 6	1.00	4.80	6.0	2.50	13.50	3	R217.13-048100AC12P	★		★		★		★		★		★		★		6.00	56.5
M 6	1.00	4.80	6.0	2.50	19.50	3	R217.13-048100AC18P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.00	59.5
M 8	1.25	6.40	8.0	3.13	17.90	3	R217.13-064125AC16P	★		★		★		★		★		★		★		8.00	63.0
M 8	1.25	6.40	8.0	3.13	25.88	3	R217.13-064125AC24P	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.00	67.4
M 10	1.50	8.20	10.0	3.75	22.30	4	R217.14-082150AC20P	★		★		★		★		★		★		★		10.00	71.3
M 12	1.75	9.50	10.0	4.38	26.70	5	R217.15-095175AC24P	★		★		★		★		★		★		★		10.00	71.1

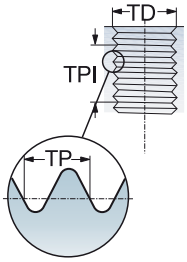
A193 A194 E9 E26 E14

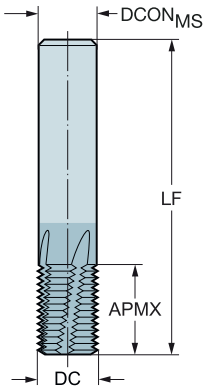
CoroMill® Plura solid carbide end mill for thread milling

For nickel-based alloys and hardened steel

Internal threads

FHA 10°
BSG COROMANT
TCDCON h6





Metric/Metric Fine, 60°

FTDZ	TP	DC	CZC_{MS}	APMX	ZEFP	Ordering code	S 1620	H 1620	$DCON_{MS}$	LF
									Dimensions, mm	
M6X1.0	1.00	4.50	6.0	10.00	4	R217.14-045100AC10M	★	★	6.00	57.00
M8X1.25	1.25	6.00	6.0	12.50	5	R217.15-060125AC12M	★	★	6.00	57.00
M10X1.5	1.50	8.00	8.0	16.50	5	R217.15-080150AC16M	★	★	8.00	63.00
M12X1.75	1.75	9.00	10.0	19.25	5	R217.15-090175AC19M	★	★	10.00	72.00
MF12X1	1.00	10.00	10.0	20.00	5	R217.15-100100AC20M	★	★	10.00	72.00
M14X2.0	2.00	12.00	12.0	26.00	5	R217.15-120200AC26M	★	★	12.00	83.00
MF14X1.5	1.50	12.00	12.0	27.00	6	R217.16-120150AC27M	★	★	12.00	83.00

A193 A194 E9 E26 E14

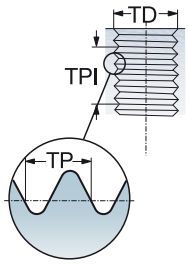
SANDVIK Coromant

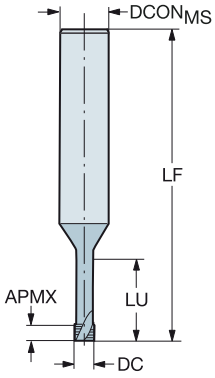
CoroMill® Plura solid carbide end mill for thread milling

For nickel-based alloys and hardened steel

Internal threads

FHA 15°
BSG COROMANT
TCDCON h6





Metric/Metric Fine, 60°

FTDZ	TP	DC	CZC_{MS}	APMX	LU	ZEFP	Ordering code	S 1610	H 1610	$DCON_{MS}$	LF
										Dimensions, mm	
M 2	0.40	1.50	6.0	0.60	4.60	3	R217.13-015040AC04S	★	★	6.00	56.8
M 2.5	0.45	1.95	6.0	0.68	5.68	3	R217.13-019045AC05S	★	★	6.00	56.8
M 3	0.50	2.30	6.0	0.75	6.75	3	R217.13-023050AC06S	★	★	6.00	56.8
M 4	0.70	3.10	6.0	1.05	9.05	3	R217.13-031070AC08S	★	★	6.00	56.7
M 5	0.80	4.00	6.0	1.20	11.20	4	R217.14-040080AC10S	★	★	6.00	56.6
M 6	1.00	4.80	6.0	1.50	13.50	4	R217.14-048100AC12S	★	★	6.00	56.5

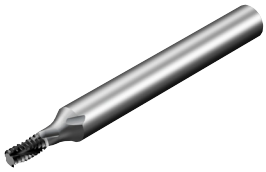
A193 A194 E9 E26 E14

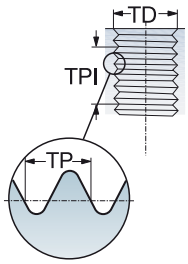
CoroMill® Plura solid carbide end mill for thread milling

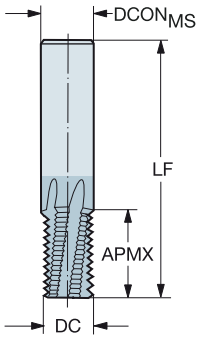
For multi-materials

Internal threads

FHA 27°
BSG COROMANT
TCDCON h6







MJ 60°

FTDZ	TP	DC	CZC_{MS}	APMX	CNSC	CXSC	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, mm $DCON_{MS}$	LF
MJ4X0.7	0.70	3.00	6.0	6.30	0	0	3	R217.13-030070AC6H	★	★	★	★	★	★	6.00	54.00
MJ5X0.8	0.80	3.90	6.0	8.00	0	0	3	R217.13-039080AC8H	★	★	★	★	★	★	6.00	54.00
MJ6X1	1.00	4.80	6.0	9.00	0	0	3	R217.13-048100AC9H	★	★	★	★	★	★	6.00	54.00
MJ8X1.25	1.25	6.30	8.0	12.50	1	1	4	R217.14C063125AC12H	★	★	★	★	★	★	8.00	58.00
MJ10X1.5	1.50	7.50	8.0	15.00	1	1	4	R217.14C075150AC15H	★	★	★	★	★	★	8.00	58.00
MJ12X1.75	1.75	9.50	10.0	19.25	1	1	4	R217.14C095175AC19H	★	★	★	★	★	★	10.00	72.00

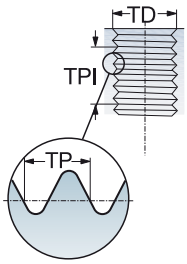
A193 A194 E9 E26 E28 E14

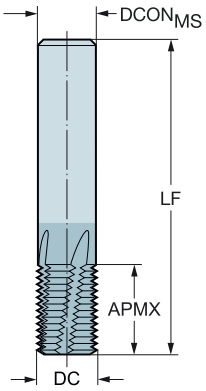
CoroMill® Plura solid carbide end mill for thread milling

For multi-materials

Internal threads

FHA 10°
BSG COROMANT
TCDCON h6





UN 60°

FTDZ	TPI	DC	CZC_{MS}	APMX	CNSC	CXSC	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, inch $DCON_{MS}$	LF
1/4-20 UNC	20.0	.189	6.0	.551	1	1	3	R217.33C048200AC13N	★	★	★	★	★	★	.236	2.244
5/16-18 UNC	18.0	.217	6.0	.556	1	1	3	R217.33C055180AC14N	★	★	★	★	★	★	.236	2.244
3/8-16 UNC	16.0	.295	8.0	.750	1	1	4	R217.34C075160AC19N	★	★	★	★	★	★	.315	2.480
7/16-14 UNC	14.0	.315	8.0	.785	1	1	4	R217.34C080140AC19N	★	★	★	★	★	★	.315	2.480
1/2-13 UNC	13.0	.394	10.0	.846	1	1	4	R217.34C100130AC21N	★	★	★	★	★	★	.394	2.835
9/16-12 UNC	12.0	.394	10.0	.833	1	1	4	R217.34C100120AC21N	★	★	★	★	★	★	.394	2.835
5/8-11 UNC	11.0	.472	12.0	1.000	1	1	4	R217.34C120110AC25N	★	★	★	★	★	★	.472	3.268
3/4-10 UNC	10.0	.551	14.0	1.300	1	1	5	R217.35C140100AC33N	★	★	★	★	★	★	.551	3.268

UNC/UNF, 60°

FTDZ	TPI	DC	CZC_{MS}	APMX	CNSC	CXSC	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, inch $DCON_{MS}$	LF
1/4-28 UNF	28.0	.189	6.0	.536	1	1	3	R217.33C048280AC13N	★	★	★	★	★	★	.236	2.244
5/16-24 UNF	24.0	.236	6.0	.541	1	1	3	R217.33C060240AC13N	★	★	★	★	★	★	.236	2.244
7/16-20 UNF	20.0	.315	8.0	.750	1	1	4	R217.34C080200AC19N	★	★	★	★	★	★	.315	2.480
9/16-18 UNF	18.0	.394	10.0	.889	1	1	4	R217.34C100180AC22N	★	★	★	★	★	★	.394	2.835
3/4-16 UNF	16.0	.551	14.0	1.250	1	1	5	R217.35C140160AC31N	★	★	★	★	★	★	.551	3.268

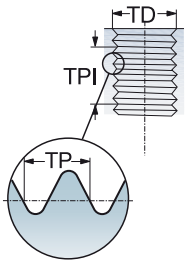
A193 A194 E9 E26 E28 E14

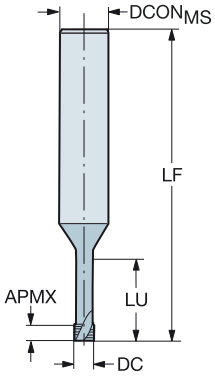
CoroMill® Plura solid carbide end mill for thread milling

For multi-materials

Internal threads

FHA 15°
BSG COROMANT
TCDCON h6





UNC/UNF, 60°

FTDZ	TPI	DC_1	DC_2	CZC_{MS}	APMX	LU	ZEFP	Ordering code	P 1620	M 1620	K 1620	N 1620	S 1620	H 1620	O 1620	Dimensions, inch $DCON_{MS}$	LF_1	LF_2
UNC # 1-64	64.0	.053	.027	6.0	.023	.244	3	R217.33-013640AC05P	★	★	★	★	★	★	★	.236	2.236	2.244
UNF #2-64	64.0	.067	.033	6.0	.016	.281	3	R217.33-017640AC06P	★	★	★	★	★	★	★	.236	2.236	2.244
UNC #2-56	56.0	.063	.027	6.0	.027	.285	3	R217.33-016560AC06P	★	★	★	★	★	★	★	.236	2.235	2.244
UNF #3-56	56.0	.077	.041	6.0	.009	.325	3	R217.33-019560AC07P	★	★	★	★	★	★	★	.236	2.235	2.244
UNC #3-48	48.0	.077	.038	6.0	.052	.329	3	R217.33-019480AC07P	★	★	★	★	★	★	★	.236	2.223	2.244
UNF #4-48	48.0	.083	.046	6.0	.031	.368	3	R217.33-021480AC08P	★	★	★	★	★	★	★	.236	2.223	2.244
UNC #4-40	40.0	.083	.041	6.0	.062	.374	3	R217.33-021400AC08P	★	★	★	★	★	★	★	.236	2.219	2.244
UNF #6-40	40.0	.108	.059	6.0	.037	.453	3	R217.33-027400AC10P	★	★	★	★	★	★	★	.236	2.230	2.244
UNC #6-32	32.0	.102	.051	6.0	.078	.463	3	R217.33-026320AC10P	★	★	★	★	★	★	★	.236	2.228	2.244
UNC #8-32	32.0	.128	.064	6.0	.078	.539	3	R217.33-032320AC12P	★	★	★	★	★	★	★	.236	2.228	2.244
UNF #10-32	32.0	.152	.076	6.0	.047	.618	3	R217.33-038320AC14P	★	★	★	★	★	★	★	.236	2.228	2.244
UNF 1/4	28.0	.207	.112	6.0	.054	.805	3	R217.33-052280AC19P	★	★	★	★	★	★	★	.236	2.226	2.244
UNC #10-24	24.0	.140	.070	6.0	.104	.634	3	R217.33-035240AC14P	★	★	★	★	★	★	★	.236	2.223	2.244
UNF 5/16	24.0	.258	.140	8.0	.062	1.000	3	R217.33-065240AC24P	★	★	★	★	★	★	★	.315	2.459	2.480
UNC 1/4	20.0	.191	.095	6.0	.125	.827	3	R217.33-048200AC19P	★	★	★	★	★	★	★	.236	2.219	2.244
UNC 5/16	18.0	.244	.122	8.0	.139	1.022	3	R217.33-062180AC24P	★	★	★	★	★	★	★	.315	2.453	2.480

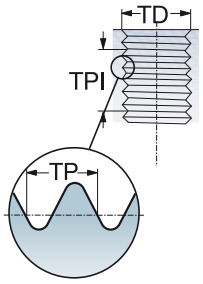
A193 A194 E9 E26 E14

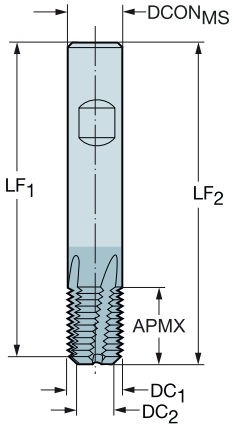
CoroMill® Plura solid carbide end mill for thread milling

For multi-materials

Internal threads

FHA 10°
TCDCON h6





NPT 60°

TPI	DC1	DC2	CZCMS	APMX	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, inch DCONMS	LF1	LF2
27.0	.311	.150	8.0	.453	3	R217.53-079270AC11N	★	★	★	★	★	★	.315	2.243	2.283
18.0	.390	.189	10.0	.627	3	R217.53-099180AC15N	★	★	★	★	★	★	.394	2.548	2.598
14.0	.626	.313	16.0	.806	4	R217.54-159140AC20N	★	★	★	★	★	★	.630	3.150	3.228
11.5	.783	.386	20.0	1.068	5	R217.55-199115AC27N	★	★	★	★	★	★	.787	3.523	3.622

NPTF 60°

TPI	DC1	DC2	CZCMS	APMX	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, inch DCONMS	LF1	LF2
27.0	.311	.150	8.0	.453	3	R217.73-079270AC11N	★	★	★	★	★	★	.315	2.243	2.283
18.0	.390	.189	10.0	.627	3	R217.73-099180AC15N	★	★	★	★	★	★	.394	2.548	2.598
14.0	.626	.313	16.0	.806	4	R217.74-159140AC20N	★	★	★	★	★	★	.630	3.150	3.228
11.5	.783	.386	20.0	1.068	5	R217.75-199115AC27N	★	★	★	★	★	★	.787	3.523	3.622

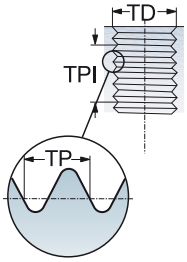
A193 A194 E9 E26 E14

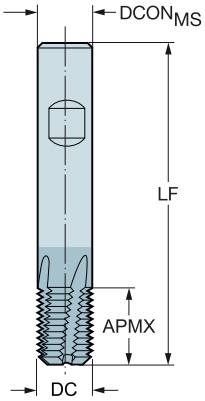
CoroMill® Plura solid carbide end mill for thread milling

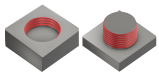
For multi-materials

Internal and external

FHA 10°
BSG COROMANT
TCDCON h6







G-thread

FTDZ	TPI	DC	CZC_{MS}	APMX	ZEFP	Ordering code	P 1630	M 1630	K 1630	N 1630	S 1630	H 1630	Dimensions, inch $DCON_{MS}$	LF
G1/8	28.0	.236	6.0	.606	3	R217.93-060280BC15N	★	★	★	★	★	★	.236	2.244
G1/4	19.0	.394	10.0	.787	4	R217.94-100190BC20N	★	★	★	★	★	★	.394	2.835
G3/8	19.0	.551	14.0	1.051	5	R217.95-140190BC26N	★	★	★	★	★	★	.551	3.268
G1/2 5/8	14.0	.630	16.0	1.213	5	R217.95-160140BC30N	★	★	★	★	★	★	.630	3.622
G5/8 3/4 7/8	14.0	.787	20.0	1.425	4	R217.95-200140BC35N	★	★	★	★	★	★	.787	4.094
G1"-3"	11.0	.984	25.0	1.817	5	R217.95-250110BC45N	★	★	★	★	★	★	.984	4.764

A193 A194 E9 E26 E14

CoroMill® Plura solid ceramic end mill for high-speed roughing

When to use

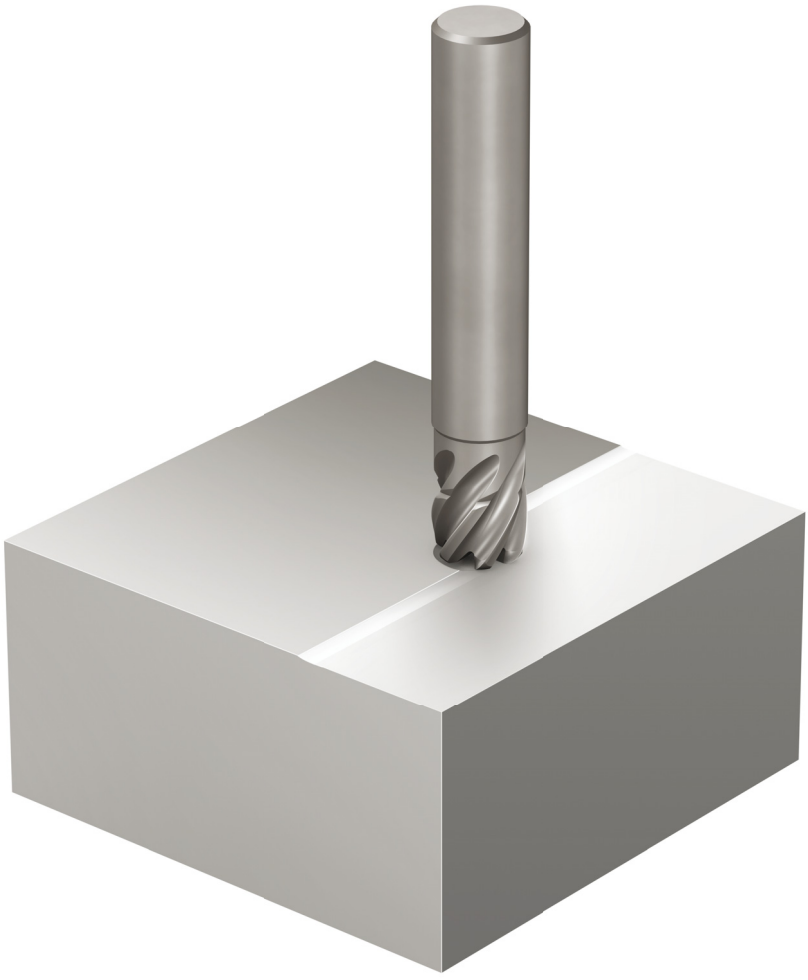
Optimized for shoulder and face milling in nickel-based alloys

A productive and stable solution for aerospace engine applications

ISO material	S
Grade	CG6060
Shank	Cylindrical

Product range

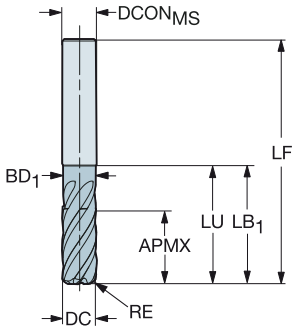
Optimized for side milling and face milling in nickel-based alloys



CoroMill® Plura solid ceramic end mill for high-speed roughing

For nickel-based alloys

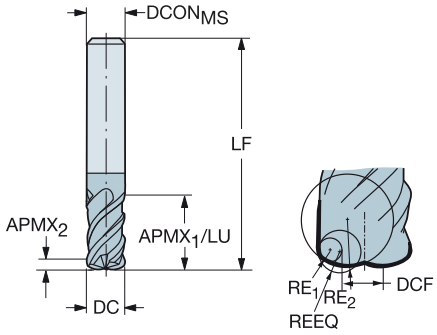
FHA 35°
BSG COROMANT
TCDC h9
TCDCON h6



Metric version

DC	CZC$_{MS}$	APMX	RE	LU	ZEFP	Ordering code	S 6060	DCON$_{MS}$	LF	BD$_1$	LB$_1$
								Dimensions, mm			
10.0	10	7.5	2.00	15.0	6	2F210-1000-200-SC	★	10.0	60.0	9.5	15.0
12.0	12	9.0	2.00	18.0	6	2F210-1200-200-SC	★	12.0	65.0	11.4	18.0

FHA 38°
BSG COROMANT
TCDC h9
TCDCON h6



Metric version

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

A186 E9

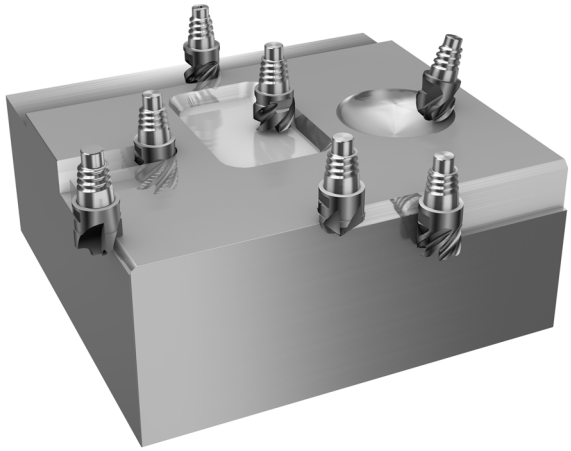
CoroMill® 316

Roughing to finishing

Application

- Slot milling
- Helical interpolation
- Shoulder milling
- Profile milling
- High feed face milling
- Chamfer milling

O C



ISO application area

P M K N S

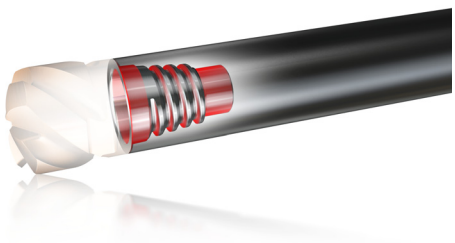
www.sandvik.coromant.com/coromill316

Product range

- Tools with high-feed capability
- Chip-breaker geometry
- Tools with internal coolant
- Geometries for roughing to super-finishing
- Wide assortment of shanks and integrated machine adapters

Coromant EH coupling

The Coromant EH coupling provides reliability and accuracy between the head and shank. It is easy to handle, and the head can be changed in a few seconds.



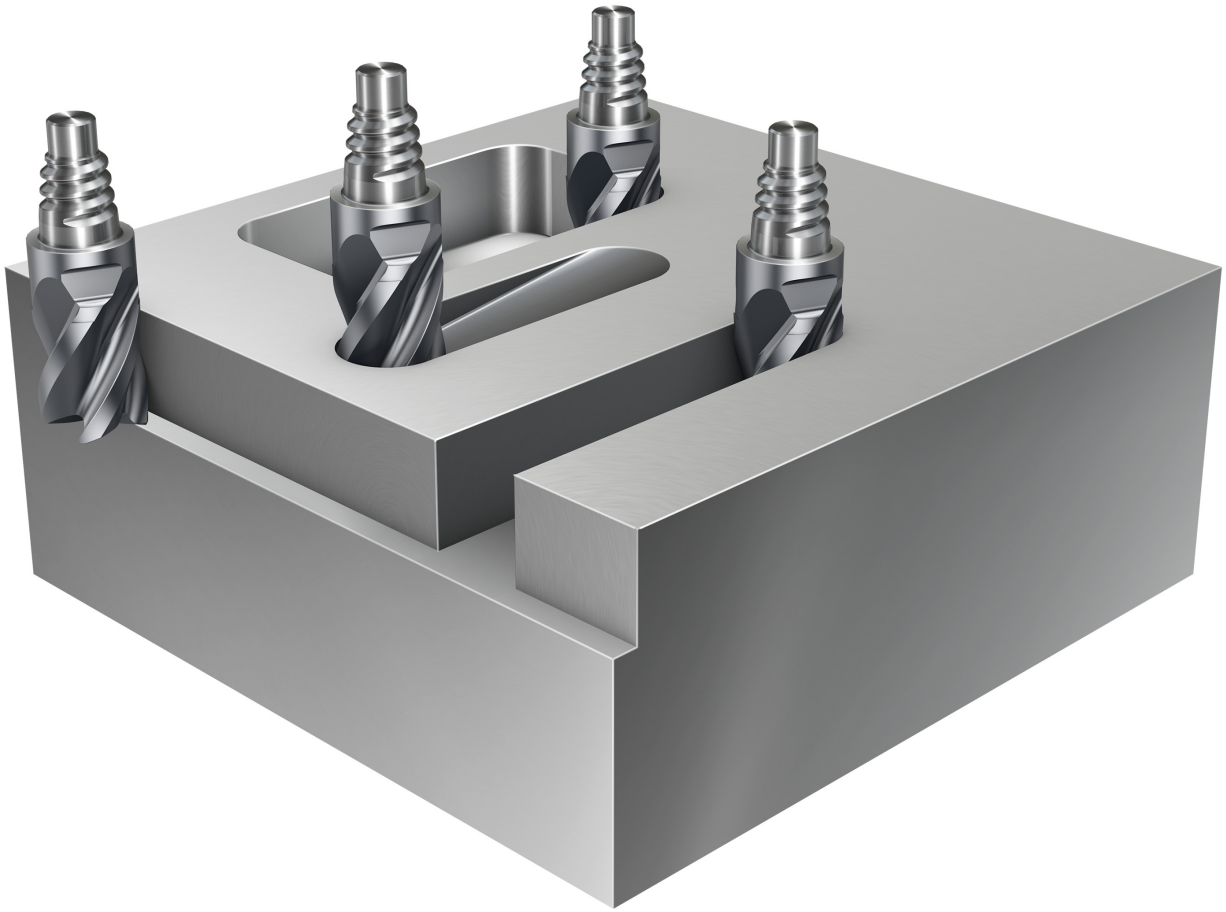
For ordering, see Rotating tools catalog.

CoroMill® 316 solid carbide head for heavy duty milling

When to use

First choice for roughing in ISO P and ISO M

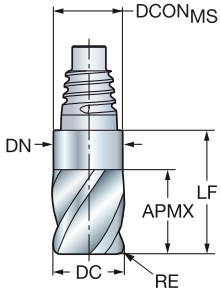
ISO material	P K M S
Grade	1730
Shank	Coromant EH



CoroMill® 316 solid carbide head for heavy duty milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	42°
BSG	COROMANT
TCDC	h10



Metric version

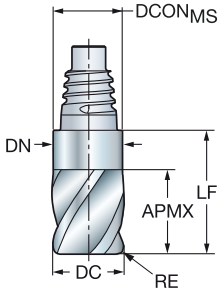
DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	$DCON_{MS}$	LF	DN
						Dimensions, mm						
10.0	E10	12.0	0.50	4	316-10SL442-10005P	★	★	☆	☆	9.7	18.5	9.7
	E10	12.0	1.00	4	316-10SL442-10010P	★	★	☆	☆	9.7	18.5	9.7
	E10	12.0	1.50	4	316-10SL442-10015P	★	★	☆	☆	9.7	18.5	9.7
	E10	12.0	2.00	4	316-10SL442-10020P	★	★	☆	☆	9.7	18.5	9.7
	E10	12.0	3.00	4	316-10SL442-10030P	★	★	☆	☆	9.7	18.5	9.7
12.0	E12	14.4	0.50	4	316-12SL442-12005P	★	★	☆	☆	11.7	22.0	11.7
	E12	14.4	1.00	4	316-12SL442-12010P	★	★	☆	☆	11.7	22.0	11.7
	E12	14.4	1.50	4	316-12SL442-12015P	★	★	☆	☆	11.7	22.0	11.7
	E12	14.4	2.00	4	316-12SL442-12020P	★	★	☆	☆	11.7	22.0	11.7
	E12	14.4	3.00	4	316-12SL442-12030P	★	★	☆	☆	11.7	22.0	11.7
	E12	14.4	4.00	4	316-12SL442-12040P	★	★	☆	☆	11.7	22.0	11.7
16.0	E16	19.2	0.50	4	316-16SL442-16005P	★	★	☆	☆	15.5	29.1	15.5
	E16	19.2	1.00	4	316-16SL442-16010P	★	★	☆	☆	15.5	29.1	15.5
	E16	19.2	1.50	4	316-16SL442-16015P	★	★	☆	☆	15.5	29.1	15.5
	E16	19.2	2.00	4	316-16SL442-16020P	★	★	☆	☆	15.5	29.1	15.5
	E16	19.2	3.00	4	316-16SL442-16030P	★	★	☆	☆	15.5	29.1	15.5
	E16	19.2	4.00	4	316-16SL442-16040P	★	★	☆	☆	15.5	29.1	15.5
20.0	E20	24.0	0.50	4	316-20SL442-20005P	★	★	☆	☆	19.3	34.2	19.3
	E20	24.0	1.00	4	316-20SL442-20010P	★	★	☆	☆	19.3	34.2	19.3
	E20	24.0	2.00	4	316-20SL442-20020P	★	★	☆	☆	19.3	34.2	19.3
	E20	24.0	3.00	4	316-20SL442-20030P	★	★	☆	☆	19.3	34.2	19.3
	E20	24.0	4.00	4	316-20SL442-20040P	★	★	☆	☆	19.3	34.2	19.3
25.0	E25	30.0	0.50	4	316-25SL442-25005P	★	★	☆	☆	24.2	41.9	24.2
	E25	30.0	1.00	4	316-25SL442-25010P	★	★	☆	☆	24.2	41.9	24.2
	E25	30.0	1.50	4	316-25SL442-25015P	★	★	☆	☆	24.2	41.9	24.2
	E25	30.0	2.00	4	316-25SL442-25020P	★	★	☆	☆	24.2	41.9	24.2
	E25	30.0	3.00	4	316-25SL442-25030P	★	★	☆	☆	24.2	41.9	24.2
	E25	30.0	4.00	4	316-25SL442-25040P	★	★	☆	☆	24.2	41.9	24.2

A179 A194 E9 E25

CoroMill® 316 solid carbide head for heavy duty milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	42°
BSG	COROMANT
TCDC	h10



Inch version

DC	CZC$_{MS}$	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	LF	DN
						Dimensions, inch						
.375	E10	.453	.015	4	A316-10SL442-03704P	★	★	☆	☆	.364	.713	.364
	E10	.453	.030	4	A316-10SL442-03708P	★	★	☆	☆	.364	.713	.364
	E10	.453	.060	4	A316-10SL442-03715P	★	★	☆	☆	.364	.713	.364
.500	E12	.602	.015	4	A316-12SL442-05004P	★	★	☆	☆	.484	.898	.484
	E12	.602	.030	4	A316-12SL442-05008P	★	★	☆	☆	.484	.898	.484
	E12	.602	.060	4	A316-12SL442-05015P	★	★	☆	☆	.484	.898	.484
	E12	.602	.090	4	A316-12SL442-05023P	★	★	☆	☆	.484	.898	.484
	E12	.602	.120	4	A316-12SL442-05031P	★	★	☆	☆	.484	.898	.484
.625	E16	.752	.015	4	A316-16SL442-06204P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.030	4	A316-16SL442-06208P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.060	4	A316-16SL442-06215P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.090	4	A316-16SL442-06223P	★	★	☆	☆	.610	1.146	.610
	E16	.752	.120	4	A316-16SL442-06231P	★	★	☆	☆	.610	1.146	.610
.750	E20	.902	.015	4	A316-20SL442-07504P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.030	4	A316-20SL442-07508P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.060	4	A316-20SL442-07515P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.090	4	A316-20SL442-07523P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.120	4	A316-20SL442-07531P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.190	4	A316-20SL442-07548P	★	★	☆	☆	.728	1.291	.728
	E20	.902	.250	4	A316-20SL442-07563P	★	★	☆	☆	.728	1.291	.728
1.000	E25	1.201	.060	4	A316-25SL442-10015P	★	★	☆	☆	.965	1.665	.965
	E25	1.201	.120	4	A316-25SL442-10031P	★	★	☆	☆	.965	1.665	.965
	E25	1.201	.190	4	A316-25SL442-10048P	★	★	☆	☆	.965	1.665	.965
	E25	1.201	.250	4	A316-25SL442-10063P	★	★	☆	☆	.965	1.665	.965

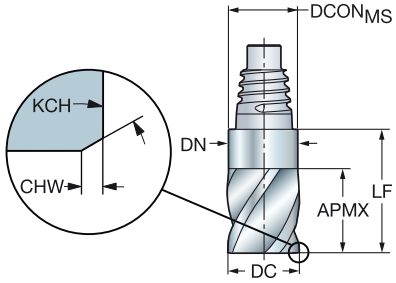
A179 A194 E9 E25

SANDVIK Coromant

CoroMill® 316 solid carbide head for heavy duty milling

For stainless steel and steel with hardness ≤ 48 HRc

FHA	42°
BSG	COROMANT
TCDC	h10



Metric version

DC	CZC_{MS}	APMX	CHW	KCH	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	$DCON_{MS}$	LF	DN
							Dimensions, mm						
10.0	E10	12.0	0.15	45°	4	316-10SL442-10000P	★	★	☆	☆	9.7	18.5	9.7
12.0	E12	14.4	0.15	45°	4	316-12SL442-12000P	★	★	☆	☆	11.7	22.0	11.7
16.0	E16	19.2	0.25	45°	4	316-16SL442-16000P	★	★	☆	☆	15.5	29.1	15.5
20.0	E20	24.0	0.25	45°	4	316-20SL442-20000P	★	★	☆	☆	19.3	34.2	19.3
25.0	E25	30.0	0.25	45°	4	316-25SL442-25000P	★	★	☆	☆	24.2	41.9	24.2

A179 A194 E9 E25

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

When to use

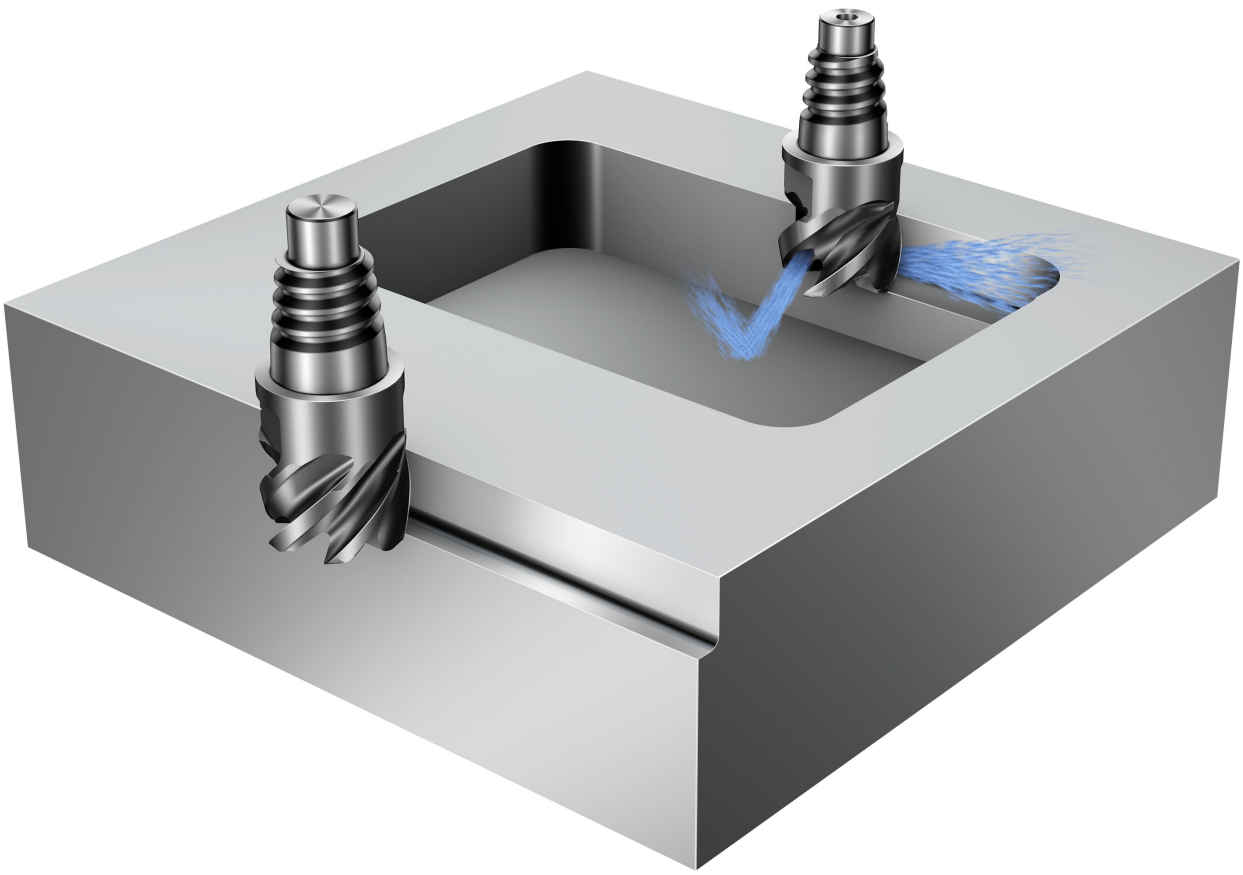
When you need good roughing performance in many different applications and materials

First choice in general milling applications

ISO material	P K M S
Grade	1730
Shank	Coromant EH

Product range

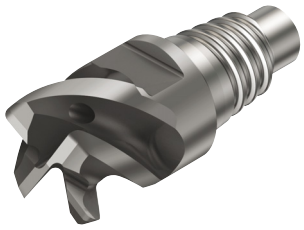
Differential pitch reduces vibration

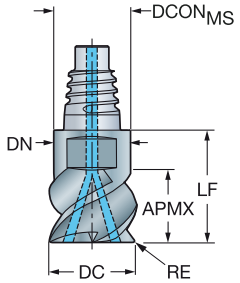


CoroMill® 316 solid carbide head for stable multi-operations milling

For multi-material with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9





Metric version

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

Inch version

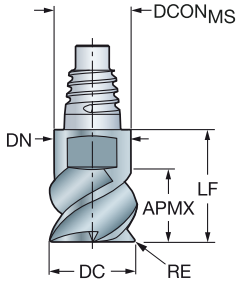
DC	CZCMS	APMX	RE	CNSC	CXSC	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCONMS	LF	DN
												Dimensions, inch		
.375	E10	.236	.015	1	3	4	A316-10SM450C03704P	★	★	☆	☆	.364	.488	.364
	E10	.236	.031	1	3	4	A316-10SM450C03708P	★	★	☆	☆	.364	.488	.364
.500	E12	.315	.015	1	3	4	A316-12SM450C05004P	★	★	☆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

A184 A194 E9 E25 E28

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

For multi-material with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9



Metric version

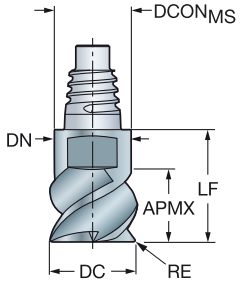
DC	CZC$_{MS}$	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	E10	5.5	0.50	3	316-10SM350-10005P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	0.50	4	316-10SM450-10005P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.00	3	316-10SM350-10010P	★	★	☆	☆	9.7	12.4	9.7
	E10	5.5	1.00	4	316-10SM450-10010P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

A184 A194 E9 E25

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

For multi-material with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9



Inch version

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

A184 A194 E9 E25

CoroMill® 316 solid carbide head for high-feed side milling

When to use

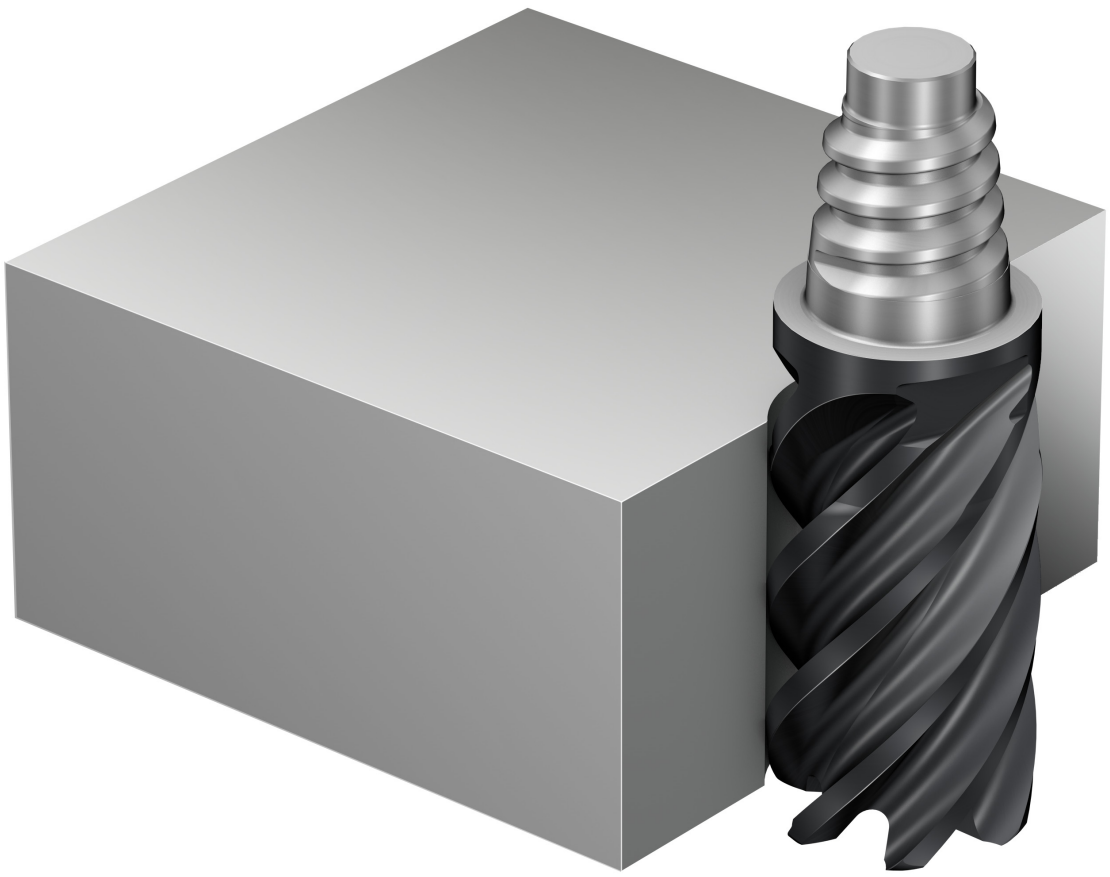
First choice for high feed side milling in titanium alloys

Excellent in intermediate conditions (ae up 10% DC) when good surface quality is needed

ISO material	S
Grade	1745
Shank	Coromant EH

Product range

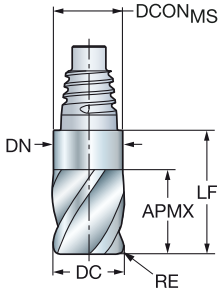
Dedicated grade for titanium alloys



CoroMill® 316 solid carbide head for high-feed side milling

For titanium alloys

FHA	42°
BSG	COROMANT
TCDC	h10



Metric version

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

Inch version

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

A181 E9

CoroMill® 316 solid carbide head for high feed face milling

When to use

High feed facemilling
High feed roughing of 3D shapes

ISO material	P M K S
Grade	1730
Shank	Coromant EH

Product range

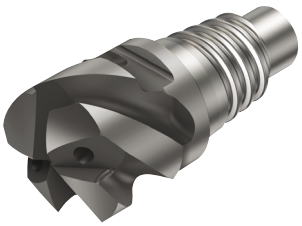
For multi-material with hardness ≤ 48 HRc

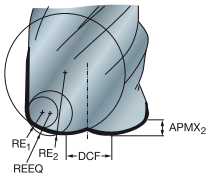
CoroMill® 316 solid carbide head for high feed face milling

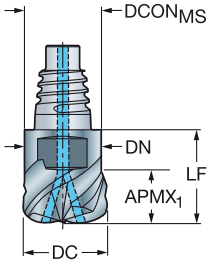
For multi-material with hardness ≤ 48 HRc

BSG
TCDC

COROMANT
h9







Metric version

DC	CZC$_{MS}$	APMX$_1$	APMX$_2$	RE$_1$	RE$_2$	CNSC	CXSC	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCON$_{MS}$	DCF	LF	DN	REEQ
10.0	E10	6.0	0.7	1.5	5.0	1	2	4	50°	316-10HM450C10015P	★	★	☆	☆	9.7	3.4	12.4	9.7	1.99
12.0	E12	7.5	0.8	1.5	6.0	1	2	4	50°	316-12HM450C12015P	★	★	☆	☆	11.7	4.5	14.5	11.7	2.10
16.0	E16	10.0	1.0	2.0	8.0	1	2	4	50°	316-16HM450C16020P	★	★	☆	☆	15.5	6.2	18.7	15.5	2.75
20.0	E20	12.0	1.3	2.0	10.0	1	2	4	50°	316-20HM450C20020P	★	★	☆	☆	19.3	8.0	21.3	19.3	3.07
25.0	E25	13.0	1.6	3.0	12.0	1	3	5	50°	316-25HM550C25030P	★	★	☆	☆	24.2	10.0	25.6	24.2	4.21

Inch version

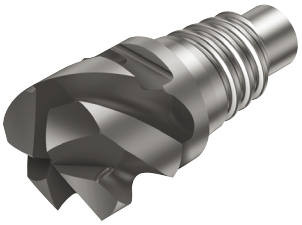
DC	CZC$_{MS}$	APMX$_1$	APMX$_2$	RE$_1$	RE$_2$	CNSC	CXSC	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCON$_{MS}$	DCF	LF	DN	REEQ
.375	E10	.236	.024	.060	.181	1	3	4	50°	A316-10HM450C03715P	★	★	☆	☆	.364	.134	.488	.364	.076
.500	E12	.315	.033	.060	.236	1	3	4	50°	A316-12HM450C05015P	★	★	☆	☆	.484	.197	.571	.484	.086
.625	E16	.394	.039	.080	.315	1	3	4	50°	A316-16HM450C06220P	★	★	☆	☆	.610	.236	.736	.610	.110
.750	E20	.453	.047	.080	.354	1	3	4	50°	A316-20HM450C07520P	★	★	☆	☆	.728	.315	.839	.728	.117

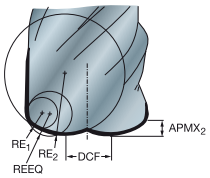
A183 A194 E9 E25 E28

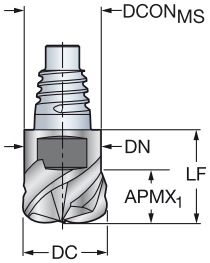
CoroMill® 316 solid carbide head for high feed face milling

For multi-material with hardness ≤ 48 HRc

TCDC h9







Metric version

DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm $DCON_{MS}$	DCF	LF	DN	REEQ
10.0	E10	5.5	0.7	1.5	5.0	3	50°	316-10HM350-10015P	★	★	☆	☆	9.7	3.4	12.4	9.7	1.99
	E10	5.5	0.7	1.5	5.0	4	50°	316-10HM450-10015P	★	★	☆	☆	9.7	3.4	12.4	9.7	1.99
12.0	E12	6.5	0.8	1.5	6.0	3	50°	316-12HM350-12015P	★	★	☆	☆	11.7	4.5	14.5	11.7	2.10
	E12	6.5	0.8	1.5	6.0	4	50°	316-12HM450-12015P	★	★	☆	☆	11.7	4.5	14.5	11.7	2.10
16.0	E16	8.5	1.0	2.0	8.0	3	50°	316-16HM350-16020P	★	★	☆	☆	15.5	6.2	18.7	15.5	2.75
	E16	8.5	1.0	2.0	8.0	4	50°	316-16HM450-16020P	★	★	☆	☆	15.5	6.2	18.7	15.5	2.75
20.0	E20	11.0	1.3	2.0	10.0	4	50°	316-20HM450-20020P	★	★	☆	☆	19.3	8.0	21.3	19.3	3.07
25.0	E25	13.5	1.6	3.0	12.0	4	50°	316-25HM450-25030P	★	★	☆	☆	24.2	10.0	25.6	24.2	4.21

Inch version

DC	CZC_{MS}	$APMX_1$	$APMX_2$	RE_1	RE_2	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch $DCON_{MS}$	DCF	LF	DN	REEQ
.375	E10	.209	.024	.060	.181	4	50°	A316-10HM450-03715P	★	★	☆	☆	.364	.134	.488	.364	.076
.500	E12	.276	.033	.060	.236	4	50°	A316-12HM450-05015P	★	★	☆	☆	.484	.197	.575	.484	.086
.625	E16	.335	.039	.080	.315	4	50°	A316-16HM450-06220P	★	★	☆	☆	.610	.236	.736	.610	.110
.750	E20	.413	.047	.080	.354	4	50°	A316-20HM450-07520P	★	★	☆	☆	.728	.315	.839	.728	.117

A183 A194 E9 E25 E28

CoroMill® 316 solid carbide head for high chip load milling

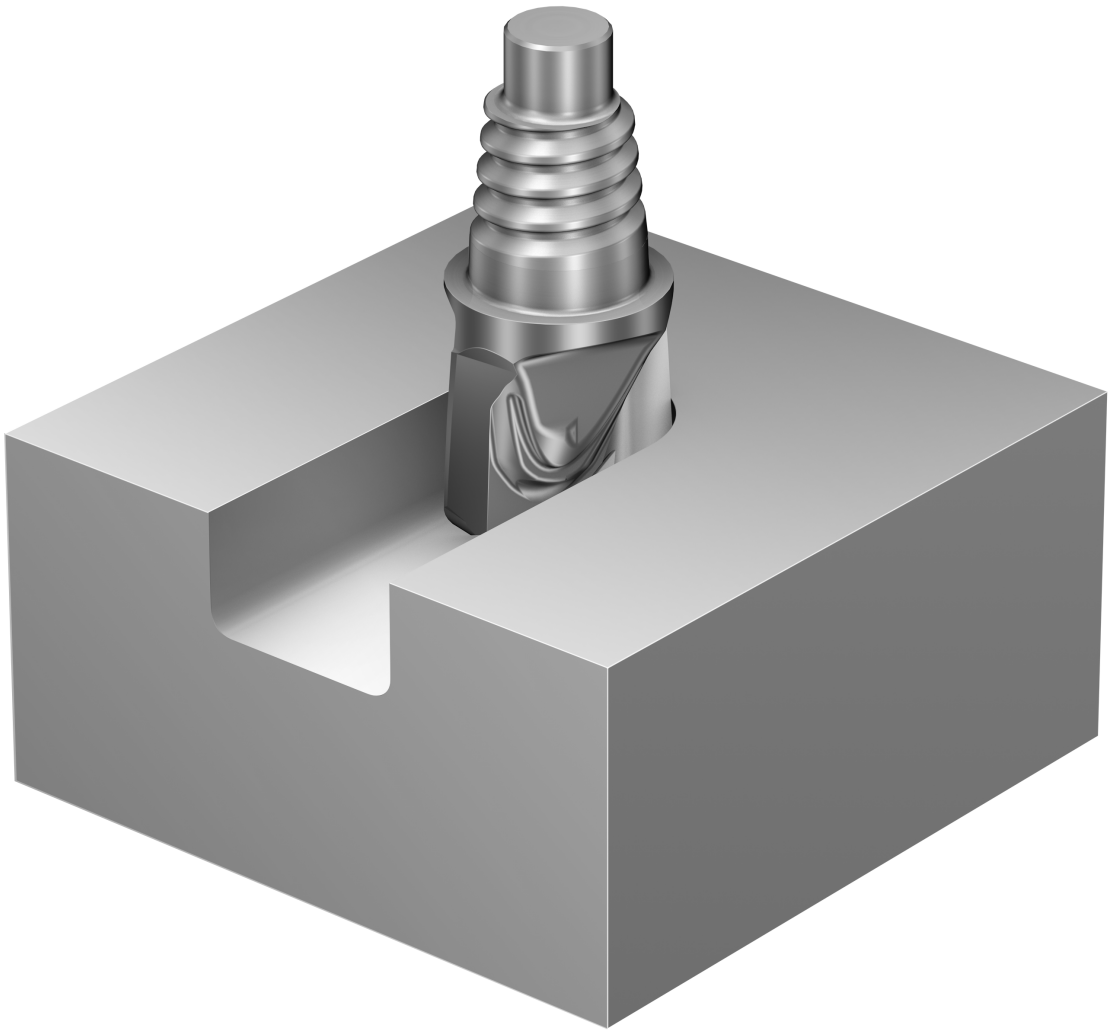
When to use

Use when large chip space is needed (for example, full slot)
Good ramping and plunging capabilities

ISO material	P M K S
Grade	1730
Shank	Coromant EH

Product range

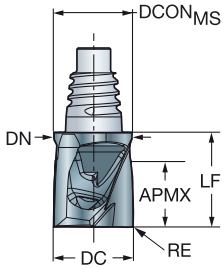
For multi-material with hardness ≤ 48 HRc



CoroMill® 316 solid carbide head for high chip load milling

For multi-material with hardness ≤ 48 HRc

FHA	10°
BSG	COROMANT
TCDC	h10



Metric version

DC	CZC_{MS}	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	$DCON_{MS}$	LF	DN
10.0	E10	8.0	0.50	2	316-10SM210-10005P	★	★	☆	☆	9.7	11.8	9.7
	E10	8.0	0.80	2	316-10SM210-10008P	★	★	☆	☆	9.7	11.8	9.7
	E10	8.0	1.00	2	316-10SM210-10010P	★	★	☆	☆	9.7	11.8	9.7
12.0	E12	10.0	0.50	2	316-12SM210-12005P	★	★	☆	☆	11.7	14.0	11.7
	E12	10.0	0.80	2	316-12SM210-12008P	★	★	☆	☆	11.7	14.0	11.7
16.0	E16	13.0	0.50	2	316-16SM210-16005P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	0.80	2	316-16SM210-16008P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	1.00	2	316-16SM210-16010P	★	★	☆	☆	15.5	18.1	15.5
	E16	13.0	3.00	2	316-16SM210-16030P	★	★	☆	☆	15.5	18.1	15.5

A191 A194 E9 E25

CoroMill® 316 solid carbide head for large chip removal

When to use

First choice for aluminum and thermoplastic machining

ISO material	N
Grade	H10F
Shank	Coromant EH

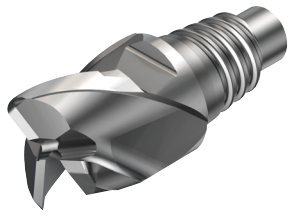
Product range

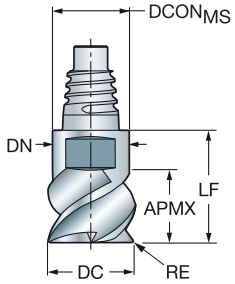
For non-ferrous material

CoroMill® 316 solid carbide head for large chip removal

For non-ferrous material

FHA 45°
BSG COROMANT
TCDC h9

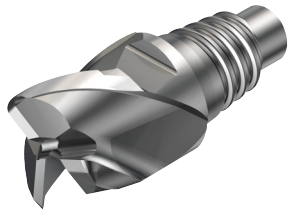


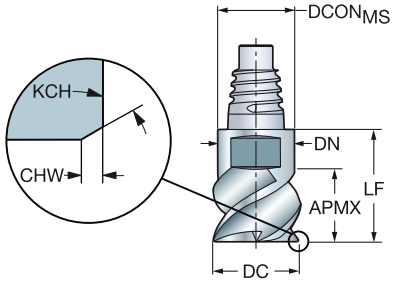


Metric version

DC	CZC$_{MS}$	APMX	RE	ZEFP	Ordering code	N H10F	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	E10	5.5	1.00	3	316-10SM345-10010A	★	9.7	12.4	9.7
	E10	5.5	2.50	3	316-10SM345-10025A	★	9.7	12.4	9.7
12.0	E12	6.5	1.00	3	316-12SM345-12010A	★	11.7	14.5	11.7
	E12	6.5	2.50	3	316-12SM345-12025A	★	11.7	14.5	11.7
	E12	6.5	4.00	3	316-12SM345-12040A	★	11.7	14.5	11.7
16.0	E16	8.5	1.50	3	316-16SM345-16015A	★	15.5	18.7	15.5
	E16	8.5	2.50	3	316-16SM345-16025A	★	15.5	18.7	15.5
	E16	8.5	4.00	3	316-16SM345-16040A	★	15.5	18.7	15.5
20.0	E20	11.0	2.50	3	316-20SM345-20025A	★	19.3	21.3	19.3
	E20	11.0	4.00	3	316-20SM345-20040A	★	19.3	21.3	19.3
25.0	E25	13.5	4.00	3	316-25SM345-25040A	★	24.2	25.6	24.2

FHA 45°
BSG COROMANT
TCDC h9





Metric version

DC	CZC$_{MS}$	APMX	CHW	KCH	ZEFP	Ordering code	N H10F	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	E10	5.5	0.10	45°	3	316-10SM345-10000A	★	9.7	12.4	9.7
12.0	E12	6.5	0.10	45°	3	316-12SM345-12000A	★	11.7	14.5	11.7
16.0	E16	8.5	0.15	45°	3	316-16SM345-16000A	★	15.5	18.7	15.5
20.0	E20	11.0	0.15	45°	3	316-20SM345-20000A	★	19.3	21.3	19.3
25.0	E25	13.5	0.15	45°	3	316-25SM345-25000A	★	24.2	25.6	24.2

A187 A194 E9 E25

CoroMill® 316 solid carbide head for roughing with chip breaker

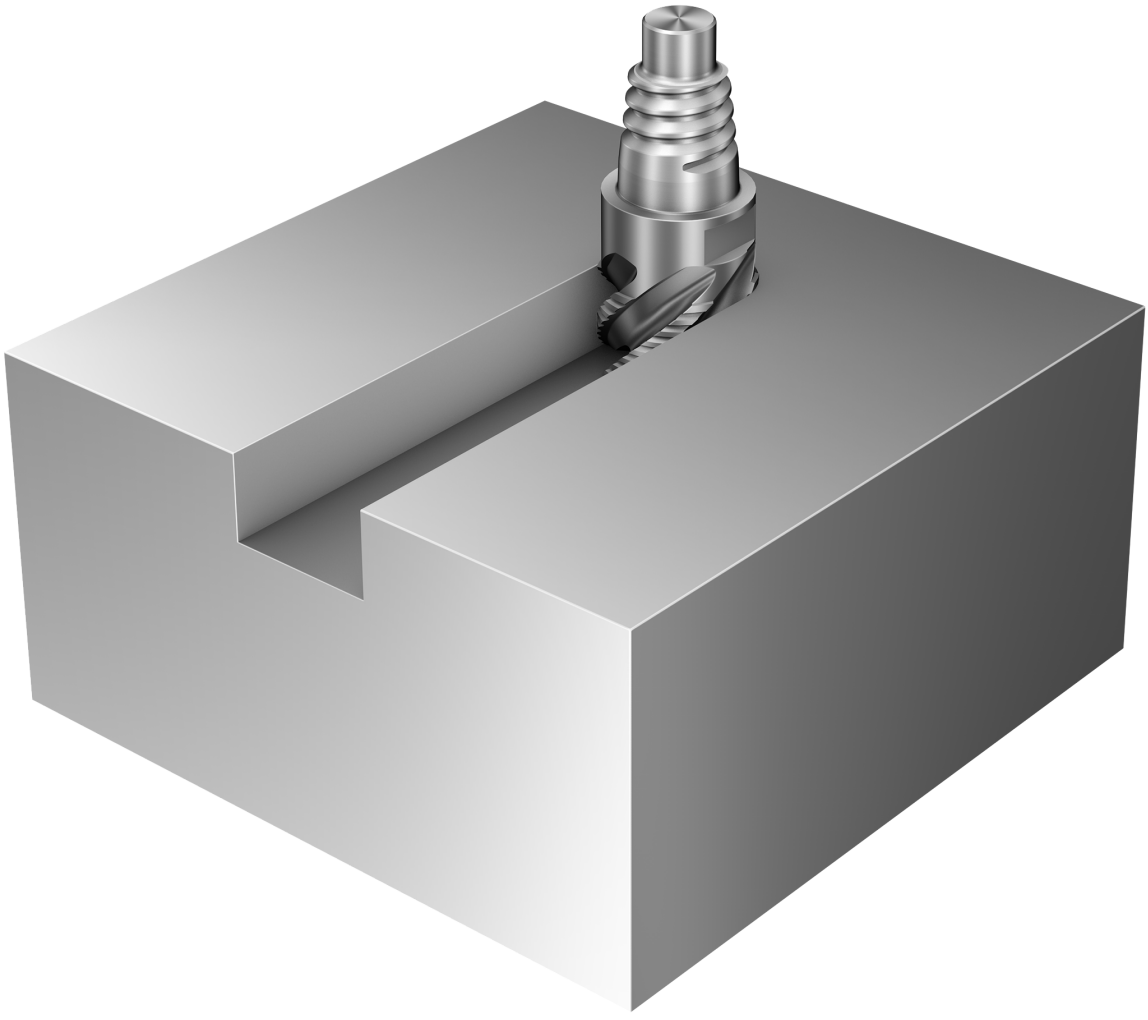
When to use

When it is necessary to break chips into smaller pieces
Problem solver in unstable conditions

ISO material	P M K S
Grade	1730
Shank	Coromant EH

Product range

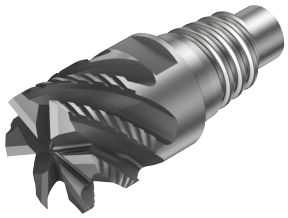
For multi-material with hardness ≤ 48 HRc

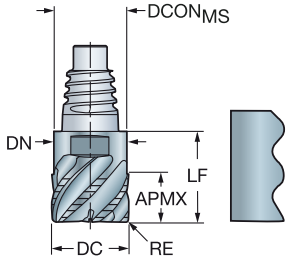


CoroMill® 316 solid carbide head for roughing with chip breaker

For multi-material with hardness ≤ 48 HRc

FHA	45°
BSG	COROMANT
TCDC	h12





Metric version

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

Dimensions, mm

Inch version

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

Dimensions, inch

A188 A194 E9 E25

SANDVIK Coromant

CoroMill® 316 solid carbide head for profiling

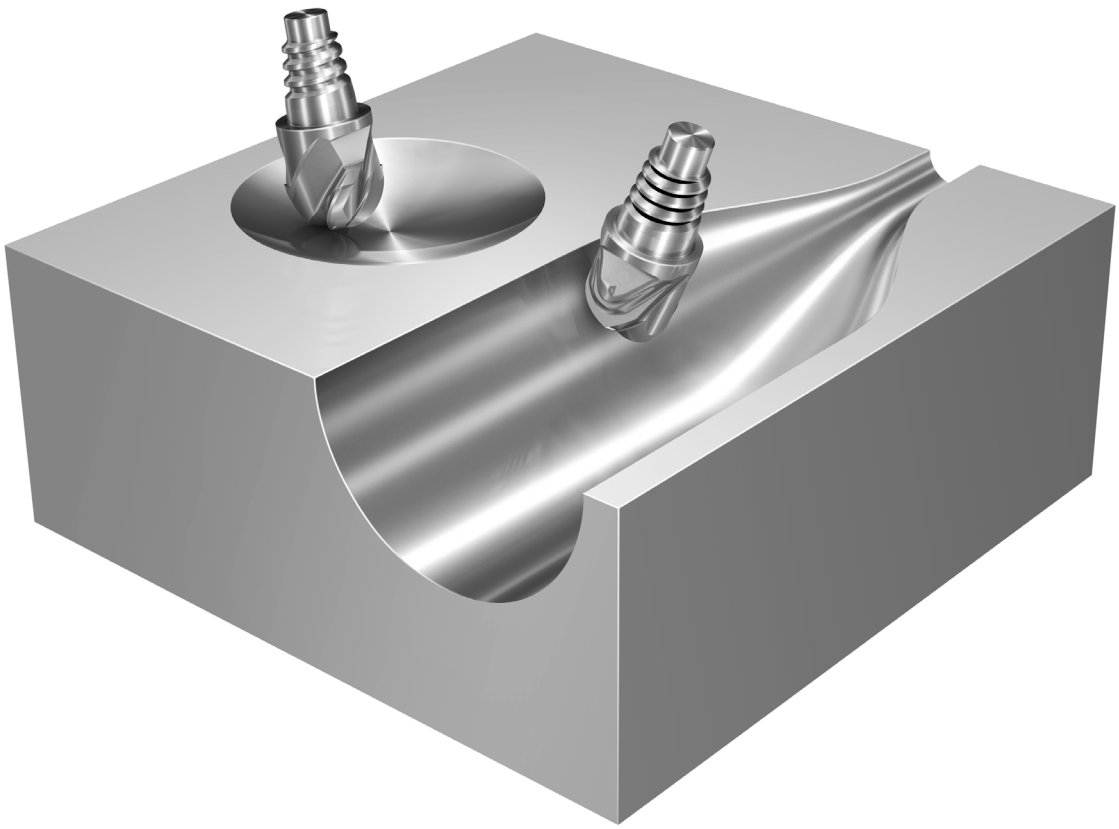
When to use

Profiling with the same tool in multiple materials

ISO material	P M K N S
Grade	1730
Shank	Coromant EH

Product range

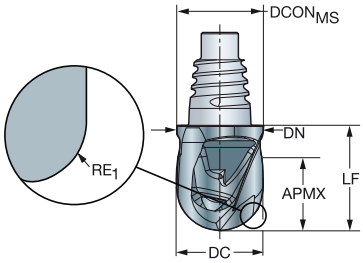
For multi-material with hardness ≤ 48 HRc



CoroMill® 316 solid carbide head for profiling

For multi-material with hardness ≤ 48 HRc

BSG	COROMANT
TCDC	h9
PSIR	0°



Metric version

DC	CZCMS	APMX	RE1	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCONMS	LF	DN
10.0	E10	8.0	5.00	2	10°	316-10BM210-10050G	★	★	☆	☆	9.7	11.8	9.7
12.0	E12	10.0	6.00	2	10°	316-12BM210-12060G	★	★	☆	☆	11.7	14.0	11.7
16.0	E16	13.0	8.00	2	10°	316-16BM210-16080G	★	★	☆	☆	15.5	18.1	15.5

Inch version

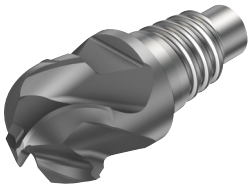
DC	CZCMS	APMX	RE1	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCONMS	LF	DN
.375	E10	.315	.188	2	10°	A316-10BM210-03750G	★	★	☆	☆	.364	.465	.382
.500	E12	.413	.250	2	10°	A316-12BM210-05060G	★	★	☆	☆	.484	.551	.461
.625	E16	.512	.313	2	10°	A316-16BM210-06280G	★	★	☆	☆	.610	.713	.610

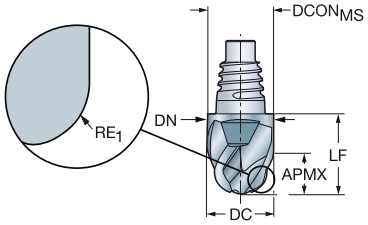
A192 A194 E9 E25

CoroMill® 316 solid carbide head for profiling

For multi-material with hardness ≤ 48 HRc

BSG	COROMANT
TCDC	h9
PSIR	0°





Metric version

DC	CZCMS	APMX	RE1	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm DCONMS	LF	DN
10.0	E10	5.5	5.00	4	40°	316-10BM440-10050G	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	6.00	4	40°	316-12BM440-12060G	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	8.00	4	40°	316-16BM440-16080G	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	10.00	2	40°	316-20BM240-200AG	★	★	☆	☆	19.3	21.3	19.3
	E20	11.0	10.00	4	40°	316-20BM440-200AG	★	★	☆	☆	19.3	21.3	19.3
25.0	E25	13.5	12.50	4	40°	316-25BM440-250DG	★	★	☆	☆	24.2	25.6	24.2

Inch version

DC	CZCMS	APMX	RE1	ZEFP	FHA	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCONMS	LF	DN
.375	E10	.209	.188	4	40°	A316-10BM440-03750G	★	★	☆	☆	.364	.488	.364
.500	E12	.276	.250	4	40°	A316-12BM440-05060G	★	★	☆	☆	.484	.575	.484
.625	E16	.335	.313	4	40°	A316-16BM440-06280G	★	★	☆	☆	.610	.736	.610
.750	E20	.413	.375	4	40°	A316-20BM440-075AG	★	★	☆	☆	.728	.839	.728
1.000	E25	.551	.500	4	40°	A316-25BM440-100CG	★	★	☆	☆	.965	1.008	.965

A192 A194 E9 E25

CoroMill® 316 solid carbide head for finishing

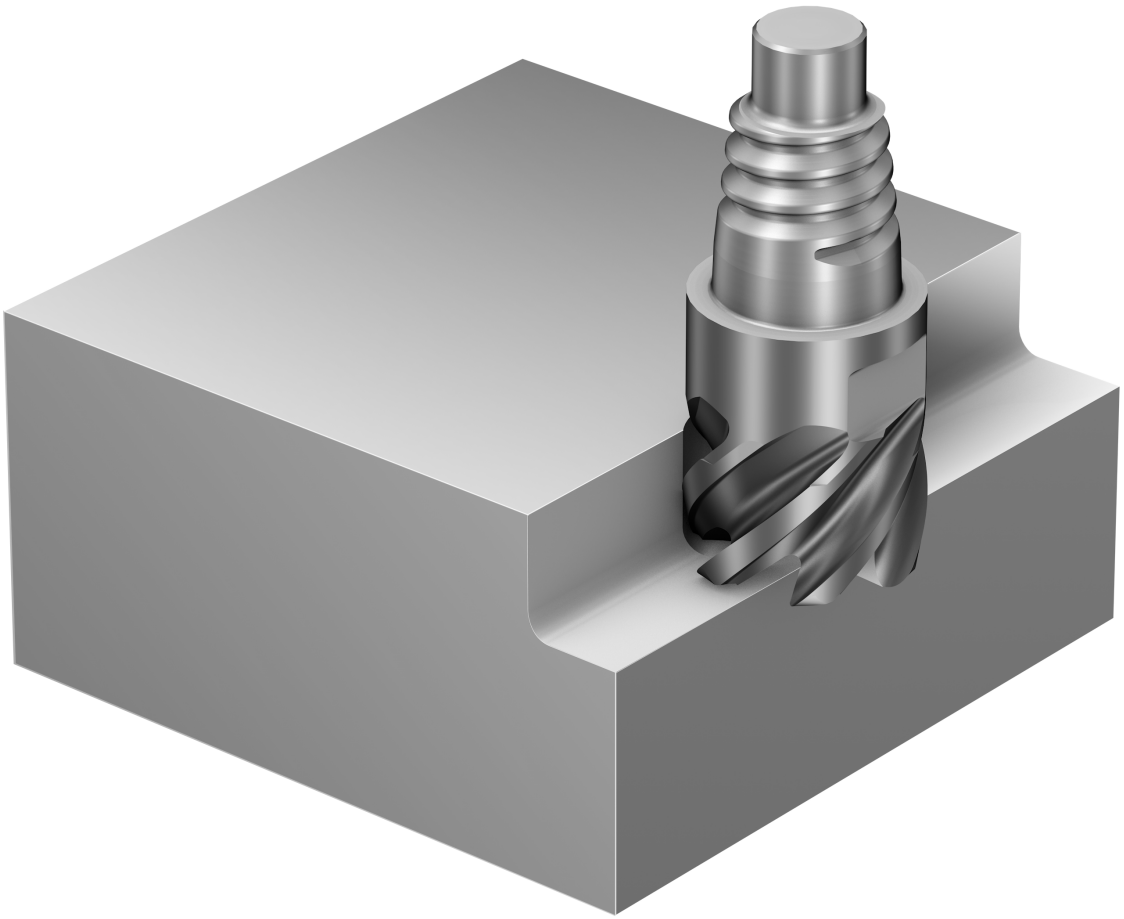
When to use

First choice for finishing in shoulder milling operations
Can be used in roughing operations with low radial engagement if high feed rate is required (trochoidal strategy)

ISO material	P M K S
Grade	1730
Shank	Coromant EH

Product range

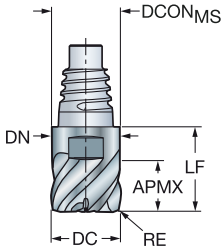
For multi-material with hardness ≤ 48 HRc



CoroMill® 316 solid carbide head for finishing

For multi-material with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h9



Metric version

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

Inch version

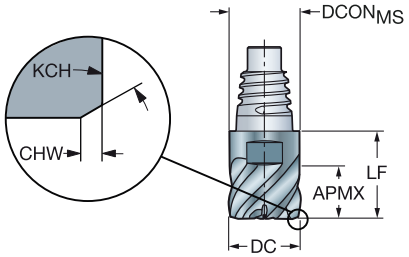
DC	CZC$_{MS}$	APMX	RE	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	LF	DN
						Dimensions, inch						
.375	E10	.209	.015	6	A316-10FM650-03704L	★	★	☆	☆	.364	.488	.364
	E10	.209	.031	6	A316-10FM650-03708L	★	★	☆	☆	.364	.488	.364
	E10	.209	.062	6	A316-10FM650-03715L	★	★	☆	☆	.364	.488	.364
.500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

A189 A194 E9 E25

CoroMill® 316 solid carbide head for finishing

For multi-material with hardness ≤ 48 HRc

FHA	50°
BSG	COROMANT
TCDC	h10



Metric version

DC	CZC_{MS}	APMX	CHW	KCH	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, mm $DCON_{MS}$	LF	DN
10.0	E10	5.5	0.10	45°	6	316-10FM650-10000L	★	★	☆	☆	9.7	12.4	9.7
12.0	E12	6.5	0.10	45°	6	316-12FM650-12000L	★	★	☆	☆	11.7	14.5	11.7
16.0	E16	8.5	0.15	45°	6	316-16FM650-16000L	★	★	☆	☆	15.5	18.7	15.5
20.0	E20	11.0	0.15	45°	8	316-20FM850-20000L	★	★	☆	☆	19.3	21.3	19.3

A189 A194 E9 E25

CoroMill® 316 solid-carbide head for chamfer milling

When to use

Chamfering with the same tool in multiple materials

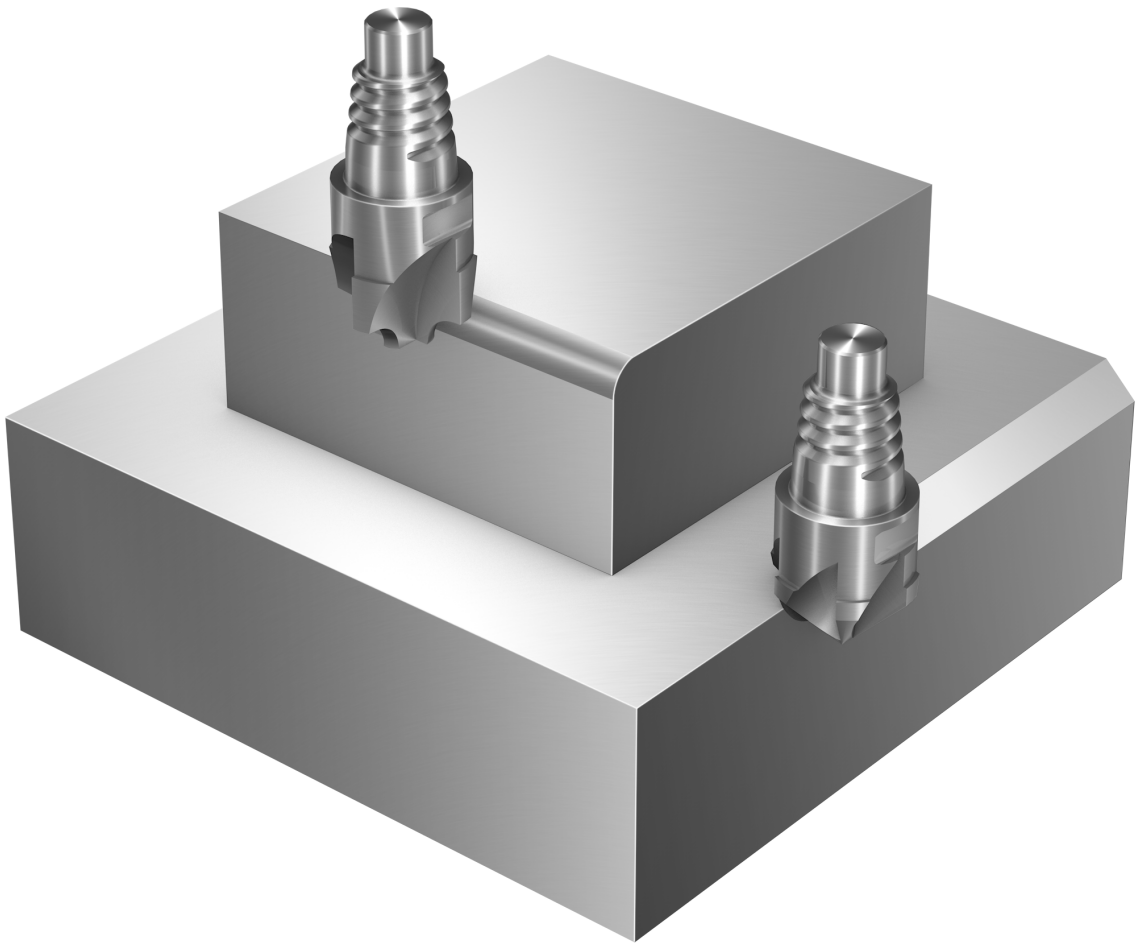
When creating convex radii

Using a chamfer head with two flutes suitable for spot drilling

ISO material	P M K S
Grade	1730
Shank	Coromant EH

Product range

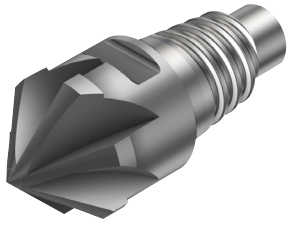
For multi-material with hardness ≤ 48 HRc

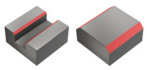


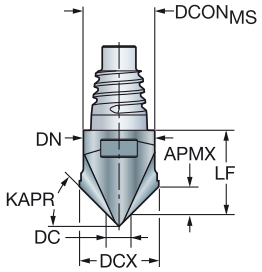
CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc

BSG COROMANT







Metric version

KAPR	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	DC	DCX	LF	DN
					Dimensions, mm								
15°	E12	1.20	6	316-12CM600-12015G	★	★	☆	☆	11.70	3.00	12.0	14.50	11.7
30°		2.60	6	316-12CM600-12030G	★	★	☆	☆	11.70	3.00	12.0	13.60	11.7
45°	E10	4.25	4	316-10CM400-10045G	★	★	☆	☆	9.70	1.50	10.0	11.66	9.7
45°	E12	4.50	6	316-12CM600-12045G	★	★	☆	☆	11.70	3.00	12.0	13.00	11.7
45°	E16	6.00	8	316-16CM800-16045G	★	★	☆	☆	15.50	4.00	16.0	16.70	15.5
60°	E10	5.60	4	316-10CM400-10060G	★	★	☆	☆	9.70	3.50	10.0	12.40	9.7
60°	E12	6.50	6	316-12CM600-12060G	★	★	☆	☆	11.70	4.50	12.0	14.50	11.7

Inch version

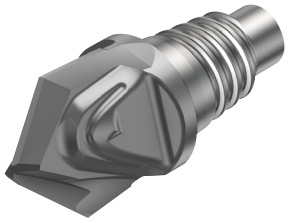
KAPR	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	DC	DCX	LF	DN
					Dimensions, inch								
30°	E10	.073	4	A316-10CM400-03730G	★	★	☆	☆	.364	.118	.375	.454	.364
30°	E12	.110	6	A316-12CM600-05030G	★	★	☆	☆	.484	.118	.500	.541	.484
30°	E16	.146	8	A316-16CM800-06230G	★	★	☆	☆	.610	.118	.625	.702	.610
45°	E10	.128	4	A316-10CM400-03745G	★	★	☆	☆	.364	.118	.375	.429	.364
45°	E12	.191	6	A316-12CM600-05045G	★	★	☆	☆	.484	.118	.500	.516	.484
45°	E16	.256	8	A316-16CM800-06245G	★	★	☆	☆	.610	.256	.625	.736	.610
49°	E12	.220	6	A316-12CM600-05049G	★	★	☆	☆	.484	.118	.500	.575	.484
49°	E16	.291	8	A316-16CM800-06249G	★	★	☆	☆	.610	.118	.625	.736	.610
60°	E10	.222	4	A316-10CM400-03760G	★	★	☆	☆	.364	.118	.375	.488	.364
60°	E12	.280	6	A316-12CM600-05060G	★	★	☆	☆	.484	.177	.500	.575	.484
60°	E16	.303	8	A316-16CM800-06260G	★	★	☆	☆	.610	.276	.625	.736	.610

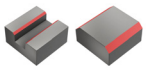
A178 A194 E9 E25

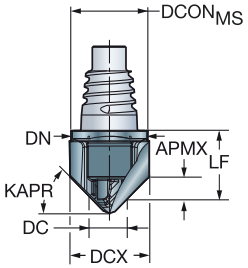
CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc

BSG COROMANT







Metric version

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

Inch version

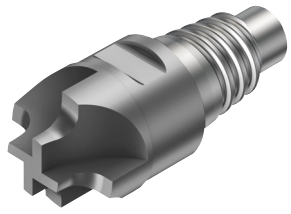
KAPR	CZCMS	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	Dimensions, inch DCONMS	DC	DCX	LF	DN
45°	E10	4.29	2	A316-10CM210-03745G	★	★	☆	☆	9.25	1.50	9.5	11.53	9.3
45°	E12	5.85	2	A316-12CM210-05045G	★	★	☆	☆	12.30	1.50	12.7	13.80	12.3
45°	E16	7.45	2	A316-16CM210-06245G	★	★	☆	☆	15.50	1.50	15.9	17.83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

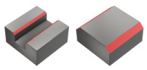
A178 A194 E9 E25

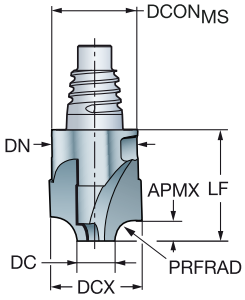
CoroMill® 316 solid carbide head for chamfer milling

For multi-material with hardness ≤ 48 HRc

BSG COROMANT







Metric version

PRFRAD	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	DC	DCX	LF	DN
					Dimensions, mm								
1.5	E10	1.50	4	316-10UM400-10015G	★	★	☆	☆	9.70	5.00	10.0	12.40	9.7
3.0		3.00	4	316-10UM400-10030G	★	★	☆	☆	9.70	4.00	10.0	12.40	9.7
3.0	E12	3.00	4	316-12UM400-12030G	★	★	☆	☆	11.70	5.00	12.0	14.50	11.7
4.0		4.00	4	316-12UM400-12040G	★	★	☆	☆	11.70	4.00	12.0	14.50	11.7
4.0	E16	4.00	4	316-16UM400-16040G	★	★	☆	☆	15.50	6.00	16.0	18.70	15.5
5.0		5.00	4	316-16UM400-16050G	★	★	☆	☆	15.50	6.00	16.0	18.70	15.5
6.0	E20	6.00	4	316-20UM400-20060G	★	★	☆	☆	19.30	8.00	20.0	21.30	19.3
8.0	E25	8.00	4	316-25UM400-25080G	★	★	☆	☆	24.20	8.00	25.0	25.60	24.2

Inch version

PRFRAD	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1730	M 1730	K 1730	S 1730	DCON$_{MS}$	DC	DCX	LF	DN
					Dimensions, inch								
.062	E10	.062	4	A316-10UM400-03715G	★	★	☆	☆	.364	.236	.375	.488	.364
.125		.125	4	A316-10UM400-03732G	★	★	☆	☆	.364	.118	.375	.488	.364
.188	E16	.188	4	A316-16UM400-06247G	★	★	☆	☆	.610	.236	.625	.736	.610
.250	E20	.250	4	A316-20UM400-07563G	★	★	☆	☆	.728	.236	.750	.839	.728

A178 A194 E9 E25

CoroMill® 316 brazed ceramic head for high-speed roughing

When to use

When superior productivity in nickel-based alloys milling is needed

ISO material	S
Grade	6060
Shank	Coromant EH

Product range

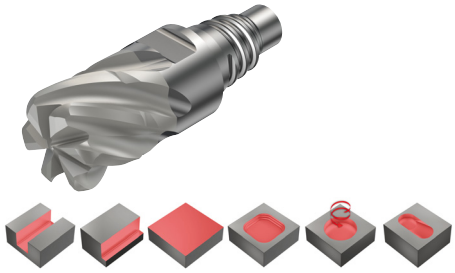
For nickel-based alloys

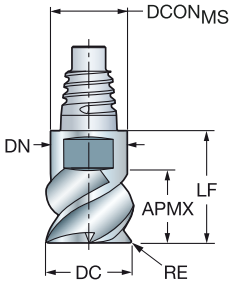
CoroMill® 316 brazed ceramic head for high-speed roughing

For nickel-based alloys

Optimized

FHA 35°
BSG COROMANT
TCDC h9

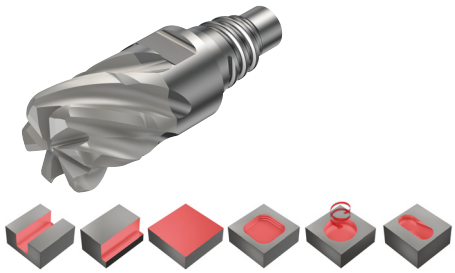


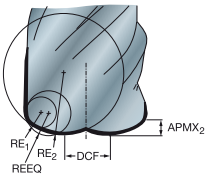


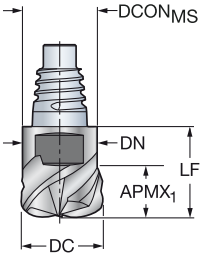
Metric version

DC	CZC$_{MS}$	APMX	RE	ZEFP	Ordering code	S 6060	Dimensions, mm DCON$_{MS}$	LF	DN
10.0	E10	7.0	2.00	6	316-10FM635-10020D	★	9.7	15.9	9.7
12.0	E12	7.0	2.00	6	316-12FM635-12020D	★	11.7	18.5	11.7

FHA 38°
BSG COROMANT
TCDC h9







Metric version

DC	CZC$_{MS}$	APMX$_2$	RE$_1$	RE$_2$	ZEFP	Ordering code	S 6060	Dimensions, mm DCON	DCF	LF	DN	REEQ
10.0	E10	0.7	1.5	5.0	4	316-10HM438-10015D	★	9.7	3.4	15.9	9.7	1.99
12.0	E12	0.8	1.5	6.0	4	316-12HM438-12015D	★	11.7	4.5	18.5	11.7	2.10

A140 E9

CoroMill® 326

Internal threading and chamfering in small holes

Application

- Internal thread milling
- Chamfer milling

O

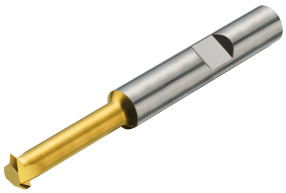
ISO application area:

P M K N S H O

Features and benefits

- Three cutting edges for productivity
- Chamfering and back-chamfering of holes with one tool
- Very high-precision and low cutting forces
- Same tool for different pitches
- One grade for all materials
- Partial thread profiles for flexibility

Chamfering



Threading

www.sandvik.coromant.com/coromill326

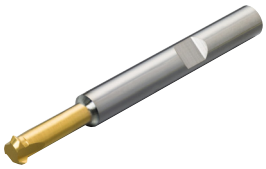
Recommendations

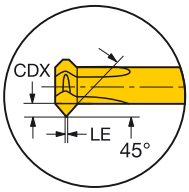
Use with CoroChuck® 930 for best stability and precision. Always use with cylindrical collets for CoroChuck® 930.

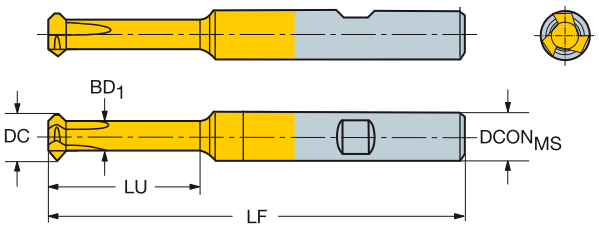
CoroMill® 326 solid-carbide chamfering end mill

For multi-materials

TCDCON h6







Metric version

CZC$_{MS}$	APMX	LU	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	O 1025	DCON$_{MS}$	DC	BD$_1$	LF	RPMX
				Dimensions, mm												
6.0	0.60	15.00	3	326R06-B1502006-CH	★	★	★	★	★	★	★	6.00	4.6	4.2	58.00	80000
	0.60	25.00	3	326R06-B2502006-CH	★	★	★	★	★	★	★	6.00	4.6	4.2	68.00	80000
8.0	1.20	25.00	3	326R08-B2502012-CH	★	★	★	★	★	★	★	8.00	5.5	5.0	68.00	80000
	1.20	35.00	3	326R08-B3502012-CH	★	★	★	★	★	★	★	8.00	5.5	5.0	78.00	80000

Inch version

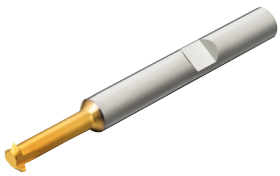
CZC$_{MS}$	APMX	LU	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	O 1025	DCON$_{MS}$	DC	BD$_1$	LF	RPMX
				Dimensions, inch												
1/4	.024	.591	3	A326R06-M1502006-CH	★	★	★	★	★	★	★	.250	.181	.165	2.283	80000
	.024	.984	3	A326R06-M2502006-CH	★	★	★	★	★	★	★	.250	.181	.165	2.677	80000
5/16	.047	.984	3	A326R08-M2502012-CH	★	★	★	★	★	★	★	.313	.217	.197	2.677	80000
	.047	1.378	3	A326R08-M3502012-CH	★	★	★	★	★	★	★	.313	.217	.197	3.071	80000

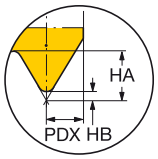
A193 A194 E9

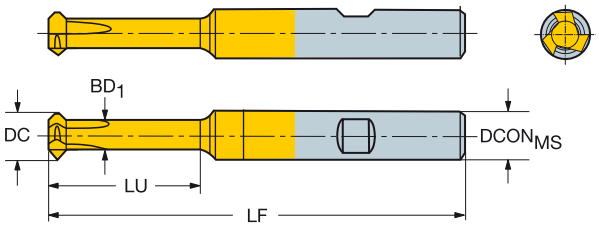
CoroMill® 326 solid carbide end mill for thread milling

For multi-materials

FHA 0°
BSG COROMANT
TCDCON h6







Metric version

TPN	TPX	TPIN	TPIX	DC	CZC_{MS}	APMX	LU	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, mm $DCON_{MS}$	BD_1	CF	HA	HB	LF
0.5	1.5	16.0	50.0	5.80	6.0	1.94	15.00	3	326R06-B15050VM-TH	★	★	★	★	★	★	6.00	3.5	0.1	0.97	0.06	58.00
0.5	1.5	16.0	50.0	7.80	8.0	1.94	25.00	3	326R08-B25050VM-TH	★	★	★	★	★	★	8.00	5.5	0.1	0.97	0.06	68.00
1.0	2.0	12.0	24.0	7.80	8.0	2.62	25.00	3	326R08-B25100VM-TH	★	★	★	★	★	★	8.00	5.0	0.1	1.31	0.12	68.00

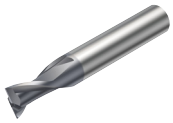
Inch version

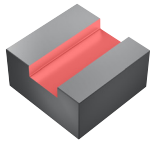
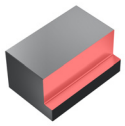
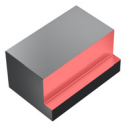
TPN	TPX	TPIN	TPIX	DC	CZC_{MS}	APMX	LU	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, inch $DCON_{MS}$	BD_1	CF	HA	HB	LF
.020	.059	16.0	50.0	.228	1/4	.076	.591	3	A326R06-M15050VM-TH	★	★	★	★	★	★	.250	.138	.002	.038	.002	2.283
.020	.059	16.0	50.0	.307	5/16	.076	.984	3	A326R08-M25050VM-TH	★	★	★	★	★	★	.313	.217	.002	.038	.002	2.677
.039	.079	12.0	24.0	.307	5/16	.103	.984	3	A326R08-M25100VM-TH	★	★	★	★	★	★	.313	.197	.005	.052	.005	2.677

A193 A194 E9

Cutting speed recommendations

Versatile – CoroMill® Plura solid carbide end mill for heavy roughing
Versatile – CoroMill® Plura solid carbide end mill for medium roughing
Versatile – CoroMill® Plura solid carbide end mill for roughing with chip breaker



					a_e = 1.0 x DC a_p = 0.5 x DC			a_e = 0.5 x DC a_p = 1.0 x DC			a_e = 0.1 x DC a_p = 1.5 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	A04	145	476	A02	175	574	A06	290	951
	P2.2.Z.AN	02.2	Low-alloyed steel	240	A04	110	361	A02	135	443	A06	200	656
	P3.0.Z.HT	03.21	High alloyed steel	380	A04	80	262	A02	100	328	A06	170	558
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	A04	65	213	A02	80	262	A06	150	492
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	A03	65	213	A01	80	262	A05	120	394
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	A03	55	180	A01	70	230	A05	90	295
K	K1.1.C.NS	07.2	Malleable cast iron	200	A04	140	459	A02	165	541	A06	150	492
	K2.1.C.UT	08.2	Gray cast iron	180	A04	130	427	A02	150	492	A06	200	656
	K3.2.C.UT	09.2	Nodular cast iron	215	A04	125	410	A02	145	476	A06	155	509
S	S1.0.U.AG	20.12	Iron-based superalloys	280	A03	30	98	A01	40	131	A05	50	164
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	A03	30	98	A01	40	131	A05	60	197
	S4.2.Z.AN	23.22	Titanium-based alloys	320	A03	40	131	A01	50	164	A05	100	328

For optimized cutting data see CoroPlus® ToolGuide.

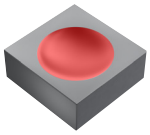
Feed recommendations

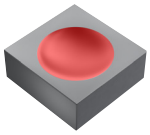
mm/tooth
inch/tooth

D_c	1.000	2.000	3.000	4.000	6.000	6.350	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	*0.039*	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.750*	*0.787*	*0.984*	*1.000*
A01	0.001	0.003	0.005	0.008	0.013	0.013	0.020	0.027	0.027	0.035	0.035	0.040	0.050	0.050	0.055	0.060	0.060	0.080	0.080
	.0001	*.0001*	*.0002*	*.0003*	*.0005*	*.0005*	*.0008*	*.0011*	*.0011*	*.0014*	*.0014*	*.0016*	*.0020*	*.0020*	*.0022*	*.0024*	*.0024*	*.0031*	*.0031*
A02	0.002	0.004	0.008	0.012	0.020	0.020	0.030	0.040	0.040	0.050	0.050	0.060	0.070	0.070	0.080	0.090	0.090	0.115	0.115
	.0002	*.0002*	*.0003*	*.0005*	*.0008*	*.0008*	*.0012*	*.0016*	*.0016*	*.0020*	*.0020*	*.0024*	*.0028*	*.0028*	*.0031*	*.0035*	*.0035*	*.0045*	*.0045*
A03	0.002	0.005	0.009	0.013	0.020	0.020	0.023	0.035	0.035	0.040	0.040	0.050	0.055	0.055	0.060	0.070	0.070	0.080	0.080
	.0002	*.0002*	*.0004*	*.0005*	*.0008*	*.0008*	*.0009*	*.0014*	*.0014*	*.0016*	*.0016*	*.0020*	*.0022*	*.0022*	*.0024*	*.0028*	*.0028*	*.0031*	*.0031*
A04	0.003	0.007	0.013	0.020	0.030	0.030	0.040	0.050	0.050	0.060	0.060	0.070	0.080	0.080	0.090	0.100	0.100	0.110	0.110
	.0001	*.0003*	*.0005*	*.0008*	*.0012*	*.0012*	*.0016*	*.0020*	*.0020*	*.0024*	*.0024*	*.0028*	*.0031*	*.0031*	*.0035*	*.0039*	*.0039*	*.0043*	*.0043*
A05	0.002	0.006	0.010	0.016	0.027	0.027	0.041	0.055	0.055	0.072	0.072	0.082	0.103	0.103	0.113	0.123	0.123	0.164	0.164
	.0002	*.0002*	*.0004*	*.0006*	*.0010*	*.0010*	*.0016*	*.0022*	*.0022*	*.0028*	*.0028*	*.0032*	*.0040*	*.0040*	*.0044*	*.0048*	*.0048*	*.0065*	*.0065*
A06	0.004	0.008	0.016	0.025	0.041	0.041	0.062	0.082	0.082	0.103	0.103	0.123	0.144	0.144	0.164	0.185	0.185	0.236	0.236
	.0002	*.0003*	*.0006*	*.0010*	*.0016*	*.0016*	*.0024*	*.0032*	*.0032*	*.0040*	*.0040*	*.0048*	*.0056*	*.0056*	*.0065*	*.0073*	*.0073*	*.0093*	*.0093*

Cutting speed recommendations

Versatile – CoroMill® Plura solid carbide ball nose mill for profiling





ISO	MC No.	CMC	Material	HB	a_p = 0.05 x DC			a_p = 0.01 x DC		
					f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	B01	245	804	B03	295	968
	P2.2.Z.AN	02.2	Low-alloyed steel	240	B01	180	591	B03	215	705
	P3.0.Z.HT	03.21	High alloyed steel	380	B01	120	394	B03	140	459
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	B01	100	328	B03	110	361
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	B02	90	295	B04	110	361
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	B02	80	262	B04	90	295
K	K1.1.C.NS	07.2	Malleable cast iron	200	B01	180	591	B03	215	705
	K2.1.C.UT	08.2	Gray cast iron	180	B01	205	673	B03	245	804
	K3.2.C.UT	09.2	Nodular cast iron	215	B01	165	541	B03	200	656
S	S1.0.U.AG	20.12	Iron-based superalloys	280	B02	50	164	B04	70	230
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	B02	40	131	B04	55	180
	S4.2.Z.AN	23.22	Titanium-based alloys	320	B02	80	262	B04	105	344

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

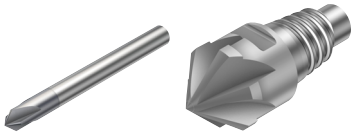
mm/tooth
inch/tooth

D_c	1.000	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000
f_z	*0.039*	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.750*	*0.787*
B01	0.020	0.030	0.050	0.060	0.080	0.080	0.120	0.120	0.150	0.150	0.150	0.150	0.150	0.160	0.160	0.180	0.200	0.200
	0.0008	*0.0012*	*0.0020*	*0.0024*	*0.0031*	*0.0031*	*0.0047*	*0.0047*	*0.0059*	*0.0059*	*0.0059*	*0.0059*	*0.0059*	*0.0063*	*0.0063*	*0.0071*	*0.0079*	*0.0079*
B02	0.020	0.030	0.040	0.050	0.060	0.060	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.140	0.140	0.150	0.160	0.160
	0.0008	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0024*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0055*	*0.0055*	*0.0059*	*0.0063*	*0.0063*
B03	0.030	0.050	0.080	0.100	0.120	0.120	0.150	0.150	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.200	0.250	0.250
	0.0012	*0.0020*	*0.0031*	*0.0039*	*0.0047*	*0.0047*	*0.0059*	*0.0059*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0098*	*0.0098*
B04	0.020	0.040	0.065	0.080	0.100	0.100	0.120	0.120	0.160	0.160	0.160	0.160	0.160	0.160	0.160	0.160	0.200	0.200
	0.0008	*0.0016*	*0.0026*	*0.0031*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0079*	*0.0079*

Cutting speed recommendations

Versatile – CoroMill® Plura solid carbide end mill for chamfer milling

Optimized – CoroMill® 316 solid carbide head for chamfer milling



a_e = 0.1 x DC

a_p = 0.1 x DC

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

For optimized cutting data see CoroPlus® ToolGuide.

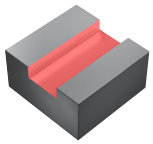
Feed recommendations

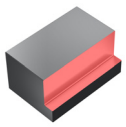
mm/tooth
inch/tooth

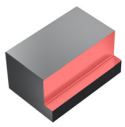
D_c	1	2	3	4	6	6.35	8	9.525	10	12	12.7	14	15.875	16	20
f_z	*0.039*	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.787*
C01	0.020	0.030	0.040	0.050	0.070	0.070	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.200
	0.0008	*0.0012*	*0.0016*	*0.0020*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

Cutting speed recommendations

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







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

For optimized cutting data see CoroPlus® ToolGuide.

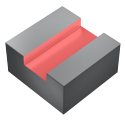
Feed recommendations

mm/tooth
inch/tooth

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

Cutting speed recommendations

Optimized – CoroMill® 316 solid carbide head for heavy duty milling



				a_e = 1.0 x DC			a_e = 0.5 x DC			a_e = 0.1 x DC		
				a_p = 0.5 x DC			a_p = 0.5 x DC			a_p = 1.0 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	E01	150	476	E02	180	640	E03	250	951
	P2.2.Z.AN	02.2	Low-alloyed steel	240	E04	120	361	E02	145	492	E03	200	738
	P3.0.Z.HT	03.21	High alloyed steel	380	E04	80	180	E02	75	246	E03	135	377
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	E04	80	246	E02	100	328	E03	150	492
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	E04	70	197	E05	85	279	E06	125	410
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	E07	65	246	E08	80	328	E09	120	492
K	K1.1.C.NS	07.2	Malleable cast iron	200	E01	150	459	E02	160	607	E03	220	919
	K2.1.C.UT	08.2	Gray cast iron	180	E01	150	246	E02	160	344	E03	220	509
	K3.2.C.UT	09.2	Nodular cast iron	215	E01	130	361	E02	140	492	E03	200	722
S	S2.0.Z.AG	20.22	Nickel-based superalloys	350	E07	20	49	E08	25	82	E09	35	115
	S4.2.Z.AN	23.22	Titanium-based alloys	320	E07	40	82	E08	35	115	E09	50	164

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

D_c	9.525	10.000	12.000	12.700	15.875	16.000	19.050	20.000	25.000	25.400
f_z	*0.375*	*0.394*	*0.472*	*0.500*	*0.625*	*0.630*	*0.750*	*0.787*	*0.984*	*1.000*
E01	0.048	0.050	0.057	0.059	0.070	0.070	0.080	0.083	0.100	0.100
	0.0019	*0.0020*	*0.0022*	*0.0023*	*0.0027*	*0.0028*	*0.0032*	*0.0033*	*0.0039*	*0.0039*
E02	0.067	0.070	0.080	0.084	0.099	0.100	0.115	0.120	0.145	0.145
	0.0026	*0.0028*	*0.0031*	*0.0033*	*0.0039*	*0.0039*	*0.0045*	*0.0047*	*0.0057*	*0.0057*
E03	0.077	0.080	0.093	0.098	0.119	0.120	0.140	0.147	0.180	0.180
	0.0030	*0.0031*	*0.0037*	*0.0039*	*0.0047*	*0.0047*	*0.0055*	*0.0058*	*0.0071*	*0.0071*
E04	0.039	0.040	0.047	0.049	0.060	0.060	0.070	0.073	0.090	0.090
	0.0015	*0.0016*	*0.0018*	*0.0019*	*0.0023*	*0.0024*	*0.0028*	*0.0029*	*0.0035*	*0.0035*
E05	0.063	0.067	0.076	0.079	0.093	0.093	0.107	0.111	0.133	0.133
	0.0025	*0.0026*	*0.0030*	*0.0031*	*0.0037*	*0.0037*	*0.0042*	*0.0044*	*0.0052*	*0.0052*
E06	0.076	0.080	0.090	0.094	0.109	0.110	0.125	0.130	0.200	0.200
	0.0030	*0.0031*	*0.0035*	*0.0037*	*0.0043*	*0.0043*	*0.0049*	*0.0051*	*0.0079*	*0.0079*
E07	0.033	0.035	0.038	0.040	0.045	0.045	0.050	0.052	0.060	0.060
	0.0013	*0.0014*	*0.0015*	*0.0016*	*0.0018*	*0.0018*	*0.0020*	*0.0020*	*0.0024*	*0.0024*
E08	0.041	0.042	0.048	0.050	0.060	0.060	0.069	0.072	0.087	0.087
	0.0016	*0.0017*	*0.0019*	*0.0020*	*0.0023*	*0.0024*	*0.0027*	*0.0028*	*0.0034*	*0.0034*
E09	0.049	0.050	0.070	0.077	0.110	0.111	0.142	0.152	0.203	0.203
	0.0019	*0.0020*	*0.0028*	*0.0030*	*0.0043*	*0.0044*	*0.0056*	*0.0060*	*0.0080*	*0.0080*

Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for high feed side milling

					a_e = according to material				a_e = according to material				a_e = according to material						
					a_p = 2.0 x DC				a_p = 3.0 x DC				a_p = 4.0 x DC						
ISO	MC No.	CMC	Material	HB	a_e	f_z	v_c m/min	V_c feet/min	a_e	f_z	v_c m/min	V_c feet/min	a_e	f_z	v_c m/min	V_c feet/min			
P	P1.2.Z.AN	01.2	Unalloyed steel	190	0.12 x DC	F01	250	820	0.10 x DC	F04	250	820	0.10 x DC	F07	230	755			
	P2.2.Z.AN	02.2	Low-alloyed steel	240	0.10 x DC	F01	240	787	0.10 x DC	F04	240	787	0.10 x DC	F07	220	722			
	P3.0.Z.HT	03.21	High alloyed steel	320	0.08 x DC	F01	140	459	0.08 x DC	F04	140	459	0.05 x DC	F07	120	394			
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	0.08 x DC	F01	120	394	0.08 x DC	F04	120	394	0.05 x DC	F07	110	361			
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	0.10 x DC	F02	150	492	0.10 x DC	F05	140	459	0.10 x DC	F08	125	410			
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	0.08 x DC	F02	130	427	0.08 x DC	F05	130	427	0.08 x DC	F08	110	361			
K	K1.1.C.NS	07.2	Malleable cast iron	200	0.12 x DC	F01	235	771	0.10 x DC	F04	235	771	0.10 x DC	F07	215	705			
	K2.1.C.UT	08.2	Gray cast iron	180	0.12 x DC	F01	240	787	0.10 x DC	F04	240	787	0.10 x DC	F07	220	722			
	K3.2.C.UT	09.2	Nodular cast iron	215	0.12 x DC	F01	245	804	0.10 x DC	F04	245	804	0.10 x DC	F07	225	738			
S	S1.0.U.AG	20.12	Iron-based superalloys	280	0.05 x DC	F03	65	213	0.05 x DC	F06	65	213	0.05 x DC	F09	60	197			
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	0.05 x DC	F03	55	180	0.05 x DC	F06	55	180	0.05 x DC	F09	50	164			
	S4.2.Z.AN	23.22	Titanium-based alloys	320	0.05 x DC	F03	120	394	0.05 x DC	F06	115	377	0.05 x DC	F09	105	344			

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

D_c	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.750*	*0.787*	*0.984*	*1.000*
F01	0.016	0.024	0.032	0.072	0.076	0.095	0.096	0.143	0.150	0.180	0.191	0.210	0.238	0.240	0.270	0.286	0.300	0.375	0.375
	0.0006	*0.0009*	*0.0013*	*0.0028*	*0.0030*	*0.0038*	*0.0038*	*0.0056*	*0.0059*	*0.0071*	*0.0075*	*0.0083*	*0.0094*	*0.0094*	*0.0106*	*0.0113*	*0.0118*	*0.0148*	*0.0148*
F02	0.012	0.018	0.024	0.060	0.064	0.079	0.080	0.124	0.130	0.156	0.165	0.182	0.206	0.208	0.234	0.248	0.260	0.325	0.325
	0.0005	*0.0007*	*0.0009*	*0.0024*	*0.0025*	*0.0031*	*0.0031*	*0.0049*	*0.0051*	*0.0061*	*0.0065*	*0.0072*	*0.0081*	*0.0082*	*0.0092*	*0.0098*	*0.0102*	*0.0128*	*0.0128*
F03	0.008	0.012	0.016	0.036	0.038	0.048	0.048	0.071	0.075	0.090	0.095	0.105	0.119	0.120	0.135	0.143	0.150	0.188	0.188
	0.0003	*0.0005*	*0.0006*	*0.0014*	*0.0015*	*0.0019*	*0.0019*	*0.0028*	*0.0030*	*0.0035*	*0.0038*	*0.0041*	*0.0047*	*0.0047*	*0.0053*	*0.0056*	*0.0059*	*0.0074*	*0.0074*
F04	-	-	-	0.072	0.076	0.086	0.086	0.114	0.120	0.144	0.152	0.168	0.191	0.192	0.216	0.229	0.240	-	-
	-	-	-	*0.0028*	*0.0030*	*0.0034*	*0.0034*	*0.0045*	*0.0047*	*0.0057*	*0.0060*	*0.0066*	*0.0075*	*0.0076*	*0.0085*	*0.0090*	*0.0094*	-	-
F05	-	-	-	0.060	0.064	0.071	0.072	0.099	0.104	0.125	0.132	0.146	0.165	0.166	0.187	0.198	0.208	-	-
	-	-	-	*0.0024*	*0.0025*	*0.0028*	*0.0028*	*0.0039*	*0.0041*	*0.0049*	*0.0052*	*0.0057*	*0.0065*	*0.0066*	*0.0074*	*0.0078*	*0.0082*	-	-
F06	-	-	-	0.036	0.038	0.048	0.048	0.057	0.060	0.072	0.076	0.084	0.095	0.096	0.108	0.114	0.120	-	-
	-	-	-	*0.0014*	*0.0015*	*0.0019*	*0.0019*	*0.0023*	*0.0024*	*0.0028*	*0.0030*	*0.0033*	*0.0038*	*0.0038*	*0.0043*	*0.0045*	*0.0047*	-	-
F07	-	-	-	0.070	0.070	0.080	0.080	0.080	0.080	0.090	0.090	0.100	0.100	0.100	0.150	0.150	0.160	0.190	0.190
	-	-	-	*0.0028*	*0.0028*	*0.0031*	*0.0031*	*0.0031*	*0.0031*	*0.0035*	*0.0035*	*0.0039*	*0.0039*	*0.0039*	*0.0059*	*0.0059*	*0.0063*	*0.0075*	*0.0075*
F08	-	-	-	0.060	0.060	0.060	0.060	0.070	0.070	0.070	0.070	0.080	0.080	0.080	0.130	0.130	0.140	0.160	0.160
	-	-	-	*0.0024*	*0.0024*	*0.0024*	*0.0024*	*0.0028*	*0.0028*	*0.0028*	*0.0028*	*0.0031*	*0.0031*	*0.0031*	*0.0051*	*0.0051*	*0.0055*	*0.0063*	*0.0063*
F09	-	-	-	0.040	0.040	0.050	0.050	0.050	0.050	0.060	0.060	0.070	0.070	0.070	0.120	0.120	0.130	0.150	0.150
	-	-	-	*0.0016*	*0.0016*	*0.0020*	*0.0020*	*0.0020*	*0.0020*	*0.0024*	*0.0024*	*0.0028*	*0.0028*	*0.0028*	*0.0047*	*0.0047*	*0.0051*	*0.0059*	*0.0059*

Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for high feed side milling

						a_e = 0.5 x DC a_p = 1.0 x DC			a_e = 0.25 x DC a_p = 1.5 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	F11	220	804	F13	235	902
	P2.2.Z.AN	02.2	Low-alloyed steel	240	F11	175	574	F13	200	656
	P3.0.Z.HT	03.21	High alloyed steel	380	F11	150	574	F13	175	656
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	F11	115	574	F13	130	656
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	F10	120	410	F12	135	463
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	F10	110	377	F12	125	427
K	K1.1.C.NS	07.2	Malleable cast iron	200	F11	165	541	F13	185	607
	K2.1.C.UT	08.2	Gray cast iron	180	F11	275	902	F13	310	1017
	K3.2.C.UT	09.2	Nodular cast iron	215	F11	165	541	F13	185	607
S	S1.0.U.AG	20.12	Iron-based superalloys	280	F10	35	115	F12	45	148
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	F10	35	115	F12	45	148
	S4.2.Z.AN	23.22	Titanium-based alloys	320	F10	80	272	F12	95	305

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

D_c	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.750*	*0.787*	*0.984*	*1.000*
F10	0.003	0.005	0.008	0.013	0.013	0.020	0.020	0.027	0.027	0.035	0.035	0.040	0.050	0.050	0.055	0.060	0.060	0.080	0.080
	0.0001	*0.0002*	*0.0003*	*0.0005*	*0.0005*	*0.0008*	*0.0008*	*0.0011*	*0.0011*	*0.0014*	*0.0014*	*0.0016*	*0.0020*	*0.0020*	*0.0022*	*0.0024*	*0.0024*	*0.0031*	*0.0031*
F11	0.004	0.008	0.012	0.020	0.020	0.030	0.030	0.040	0.040	0.050	0.050	0.060	0.070	0.070	0.080	0.090	0.090	0.115	0.115
	0.0002	*0.0003*	*0.0005*	*0.0008*	*0.0008*	*0.0012*	*0.0012*	*0.0016*	*0.0016*	*0.0020*	*0.0020*	*0.0024*	*0.0028*	*0.0028*	*0.0031*	*0.0035*	*0.0035*	*0.0045*	*0.0045*
F12	0.004	0.007	0.011	0.017	0.017	0.027	0.027	0.036	0.036	0.047	0.047	0.053	0.067	0.067	0.073	0.080	0.080	0.106	0.106
	0.0002	*0.0003*	*0.0004*	*0.0007*	*0.0007*	*0.0011*	*0.0011*	*0.0014*	*0.0014*	*0.0019*	*0.0019*	*0.0021*	*0.0026*	*0.0026*	*0.0029*	*0.0031*	*0.0031*	*0.0042*	*0.0042*
F13	0.005	0.011	0.016	0.027	0.027	0.040	0.040	0.053	0.053	0.067	0.067	0.080	0.093	0.093	0.011	0.120	0.120	0.153	0.153
	0.0002	*0.0004*	*0.0006*	*0.0010*	*0.0010*	*0.0016*	*0.0016*	*0.0021*	*0.0021*	*0.0026*	*0.0026*	*0.0031*	*0.0037*	*0.0037*	*0.0004*	*0.0047*	*0.0047*	*0.0060*	*0.0060*

				a_e = 0.1 x DC a_p = 2.0 x DC			a_e = 0.4 x DC a_p = 1.0 x DC		
ISO	MC No.	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
S	S2.0.Z.AG	Nickel based alloys	350	F14	35	115	F15	20	66
	S2.0.Z.AN		250	F16	50	164	F17	30	98
	S4.3.Z.AN	Titanium-based alloys	330	F18	110	361	F19	44	144
	S4.4.Z.AN		410	F18	50	164	F19	30	98

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

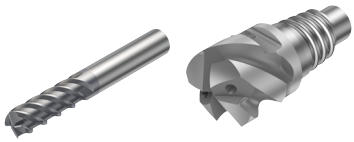
mm/tooth
inch/tooth

D_c	4.000	4.765	5.000	6.000	6.350	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400	31.750	32.000
f_z	*0.157*	*0.188*	*0.197*	*0.236*	*0.250*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.750*	*0.787*	*0.984*	*1.000*	*1.250*	*1.260*
F14	0.020	0.024	0.025	0.030	0.032	0.040	0.048	0.050	0.060	0.064	0.070	0.079	0.080	0.090	0.095	0.100	0.013			
	0.0008	*0.0009*	*0.001*	*0.0012*	*0.0013*	*0.0016*	*0.0019*	*0.0020*	*0.0024*	*0.0025*	*0.0028*	*0.0031*	*0.0031*	*0.0035*	*0.0038*	*0.0039*	*0.0049*			
F15	0.013	0.015	0.016	0.019	0.020	0.025	0.030	0.031	0.038	0.040	0.044	0.050	0.050	0.056	0.060	0.063	0.078			
	0.0005	*0.0006*	*0.0006*	*0.0007*	*0.0008*	*0.0010*	*0.0012*	*0.0012*	*0.0015*	*0.0016*	*0.0017*	*0.0020*	*0.0020*	*0.0022*	*0.0023*	*0.0025*	*0.0031*			
F16	0.026	0.031	0.033	0.039	0.041	0.052	0.062	0.065	0.078	0.083	0.091	0.103	0.104	0.117	0.124	0.130	0.163			
	0.0010	*0.0012*	*0.0013*	*0.0015*	*0.0016*	*0.0020*	*0.0024*	*0.0026*	*0.0031*	*0.0033*	*0.0036*	*0.0041*	*0.0041*	*0.0046*	*0.0049*	*0.0051*	*0.0064*			
F17	0.016	0.019	0.02	0.024	0.026	0.033	0.039	0.041	0.049	0.052	0.057	0.064	0.065	0.073	0.077	0.081	0.102			
	0.0006	*0.0008*	*0.0008*	*0.0010*	*0.0010*	*0.0013*	*0.0015*	*0.0016*	*0.0019*	*0.0020*	*0.0022*	*0.0025*	*0.0026*	*0.0029*	*0.0030*	*0.0032*	*0.0040*			
F18	0.028	0.033	0.034	0.041	0.044	0.055	0.065	0.069	0.083	0.087	0.096	0.109	0.111	0.124	0.131	0.138	0.172	0.175	0.218	0.22
	0.0011	*0.0013*	*0.0014*	*0.0016*	*0.0017*	*0.0022*	*0.0026*	*0.0027*	*0.0032*	*0.0034*	*0.0038*	*0.0043*	*0.0043*	*0.0049*	*0.0052*	*0.0054*	*0.0068*	*0.0069*	*0.0086*	*0.0087*
F19	0.015	0.018	0.019	0.023	0.024	0.030	0.036	0.038	0.045	0.048	0.053	0.060	0.060	0.068	0.071	0.075	0.094	0.095	0.119	0.12
	0.0006	*0.0007*	*0.0007*	*0.0009*	*0.0009*	*0.0012*	*0.0014*	*0.0015*	*0.0018*	*0.0019*	*0.0021*	*0.0023*	*0.0024*	*0.0027*	*0.0028*	*0.0030*	*0.0037*	*0.0038*	*0.0047*	*0.0047*

Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for high feed face milling

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



a_e = 0.5 x DC

a_p = 0.1 x DC

ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	G01	110	361
	P2.2.Z.AN	02.2	Low-alloyed steel	240	G01	100	328
	P3.0.Z.HT	03.21	High alloyed steel	380	G01	60	197
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	G01	50	164
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	G01	60	197
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	G01	50	164
K	K1.1.C.NS	07.2	Malleable cast iron	200	G01	120	394
	K2.1.C.UT	08.2	Gray cast iron	180	G01	120	394
	K3.2.C.UT	09.2	Nodular cast iron	215	G01	110	361
S	S1.0.U.AG	20.12	Iron-based superalloys	280	G01	50	165
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	G01	35	115
	S4.2.Z.AN	23.22	Titanium-based alloys	320	G01	75	246
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	G02	110	361
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC	G02	110	361
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC	G02	60	197

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

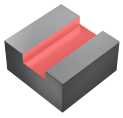
mm/tooth
inch/tooth

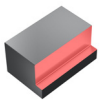
D_c	4.000	6.000	6.000	10.000	12.000	16.000	20.000
f_z	*0.157*	*0.236*	*0.236*	*0.394*	*0.472*	*0.630*	*0.787*
G01	0.100	0.160	0.250	0.300	0.350	0.500	0.700
	0.0039	*0.0063*	*0.0098*	*0.0118*	*0.0138*	*0.0197*	*0.0276*
G02	0.080	0.130	0.200	0.240	0.280	0.400	0.560
	0.0031	*0.0051*	*0.0079*	*0.0094*	*0.0110*	*0.0157*	*0.0220*

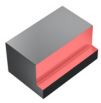
Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for stable multi-operations milling

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







					a_e = 1.0 x DC a_p = 0.5 x DC			a_e = 0.5 x DC a_p = 1.0 x DC			a_e = 0.1 x DC a_p = 1.5 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	K01	165	541	K02	215	705	K03	305	1001
	P2.2.Z.AN	02.2	Low-alloyed steel	240	K01	125	410	K02	160	525	K03	220	722
	P3.0.Z.HT	03.21	High alloyed steel	380	K01	75	246	K02	95	312	K03	130	427
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	K01	45	148	K02	65	213	K03	85	279
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	K05	60	197	K06	75	246	K07	110	361
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	K05	45	148	K06	65	213	K07	85	279
K	K1.1.C.NS	07.2	Malleable cast iron	200	K01	135	443	K02	170	558	K03	240	787
	K2.1.C.UT	08.2	Gray cast iron	180	K01	135	443	K02	165	541	K03	240	787
	K3.2.C.UT	09.2	Nodular cast iron	215	K01	125	410	K02	150	492	K03	215	705
S	S1.0.U.AG	20.12	Iron-based superalloys	280	K05	25	82	K06	35	115	K07	60	197
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	K08	25	82	K08	35	115	K08	60	197
	S4.2.Z.AN	23.22	Titanium-based alloys	320	K05	40	131	K06	55	180	K07	95	312
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	K05	50	164	K06	80	262	K07	90	295
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC	K05	50	164	K06	80	262	K07	90	295
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC	K05	30	98	K06	50	164	K07	50	164

For optimized cutting data see CoroPlus® ToolGuide.

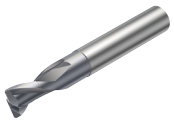
Feed recommendations

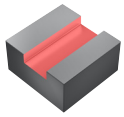
mm/tooth
inch/tooth

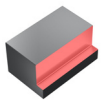
D_c	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	19.050	20.000	25.000	25.400
f_z	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.750*	*0.787*	*0.984*	*1*
K01	0.020	0.020	0.020	0.030	0.030	0.050	0.050	0.060	0.060	0.070	0.070	0.080	0.090	0.090	0.100	0.100	0.100	0.100
	0.0008	*0.0008*	*0.0008*	*0.0012*	*0.0012*	*0.0020*	*0.0020*	*0.0024*	*0.0024*	*0.0028*	*0.0028*	*0.0031*	*0.0035*	*0.0035*	*0.0039*	*0.0039*	*0.0039*	*0.0039*
K02	0.02	0.030	0.030	0.040	0.040	0.070	0.070	0.100	0.100	0.100	0.100	0.100	0.120	0.120	0.120	0.140	0.160	0.160
	0.0008	*0.0012*	*0.0012*	*0.0016*	*0.0016*	*0.0028*	*0.0028*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0055*	*0.0063*	*0.0063*
K03	0.03	0.040	0.050	0.070	0.070	0.100	0.100	0.120	0.120	0.120	0.120	0.120	0.120	0.120	0.180	0.200	0.200	0.200
	0.0012	*0.0016*	*0.0020*	*0.0028*	*0.0028*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0071*	*0.0079*	*0.0079*	*0.0079*
K04	0.02	0.020	0.020	0.020	0.020	0.040	0.040	0.050	0.050	0.060	0.060	0.060	0.070	0.070	0.080	0.080	0.080	0.080
	0.0008	*0.0008*	*0.0008*	*0.0008*	*0.0008*	*0.0016*	*0.0016*	*0.0020*	*0.0020*	*0.0024*	*0.0024*	*0.0024*	*0.0028*	*0.0028*	*0.0031*	*0.0031*	*0.0031*	*0.0031*
K05	0.02	0.020	0.020	0.040	0.040	0.060	0.060	0.080	0.080	0.080	0.080	0.080	0.100	0.100	0.100	0.110	0.130	0.130
	0.0008	*0.0008*	*0.0008*	*0.0016*	*0.0016*	*0.0024*	*0.0024*	*0.0031*	*0.0031*	*0.0031*	*0.0031*	*0.0031*	*0.0039*	*0.0039*	*0.0039*	*0.0043*	*0.0051*	*0.0051*
K06	0.02	0.030	0.040	0.060	0.060	0.080	0.080	0.100	0.100	0.100	0.100	0.100	0.100	0.120	0.140	0.160	0.160	0.160
	0.0008	*0.0012*	*0.0016*	*0.0024*	*0.0024*	*0.0031*	*0.0031*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0039*	*0.0047*	*0.0055*	*0.0063*	*0.0063*	*0.0063*
K07	0.015	0.015	0.02	0.02	0.02	0.025	0.025	0.03	0.031	0.038	0.040	0.045	0.050	0.050	0.060	0.063	0.078	0.078
	0.0006	*0.0006*	*0.0008*	*0.0008*	*0.0008*	*0.0010*	*0.0010*	*0.0012*	*0.0012*	*0.0015*	*0.0016*	*0.0018*	*0.0020*	*0.0020*	*0.0024*	*0.0025*	*0.0031*	*0.0031*

Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for hard part milling







					a_e = 1.0 x DC			a_e = 0.1 x DC			a_e = 0.05 X DC		
					a_p = 0.1 x DC			a_p = 1.0 x DC			a_p = 1.5 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P3.0.Z.HT	03.21	High-alloyed steel	380	H01	140	459	H02	225	738	H03	250	820
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	H04	110	361	H05	185	607	H06	205	673
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC	H04	125	410	H05	215	705	H06	245	804
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC	H04	75	246	H05	130	427	H06	145	476

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

D_c	2.000	3.000	4.000	6.000	6.350	8.000	9.525	10.000	12.000	16.000
f_z	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.315*	*0.375*	*0.394*	*0.472*	*0.630*
H01	0.020	0.020	0.020	0.030	0.030	0.050	0.060	0.060	0.070	0.090
	0.0008	*0.0008*	*0.0008*	*0.0012*	*0.0012*	*0.0020*	*0.0024*	*0.0024*	*0.0028*	*0.0035*
H02	0.030	0.040	0.050	0.070	0.070	0.100	0.120	0.120	0.120	0.120
	0.0012	*0.0016*	*0.0020*	*0.0028*	*0.0028*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*
H03	0.030	0.050	0.060	0.080	0.080	0.120	0.150	0.150	0.150	0.160
	0.0012	*0.0020*	*0.0024*	*0.0031*	*0.0031*	*0.0047*	*0.0059*	*0.0059*	*0.0059*	*0.0063*
H04	0.020	0.020	0.020	0.020	0.020	0.040	0.050	0.050	0.060	0.070
	0.0008	*0.0008*	*0.0008*	*0.0008*	*0.0008*	*0.0016*	*0.0020*	*0.0020*	*0.0024*	*0.0028*
H05	0.020	0.030	0.040	0.060	0.060	0.080	0.100	0.100	0.100	0.120
	0.0008	*0.0012*	*0.0016*	*0.0024*	*0.0024*	*0.0031*	*0.0039*	*0.0039*	*0.0039*	*0.0047*
H06	0.030	0.040	0.050	0.060	0.060	0.100	0.120	0.120	0.120	0.140
	0.0012	*0.0016*	*0.0020*	*0.0024*	*0.0024*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0055*

Cutting speed recommendations

CoroMill® Plura solid ceramic end mill for high-speed roughing

CoroMill® 316 brazed ceramic head for high-speed roughing

						a_e = 0.1 x DC			a_e = 0.075 x DC		
						a_p = 1.5 x DC Overhang 4 x d			a_p = 1.5 x DC Overhang 6 x d		
ISO	MC No.	CMC	Material	HB	ZEFP	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
S	S2.0.Z.AG	20.22	Nickel-based superalloys	350	4	P02	600-1000	1698-3280	P01	600-700	1968-2296
					6	P01	600-1000	1698-3280	P01	600-700	1968-2296

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

mm/tooth
inch/tooth

D_c	10	12
f_z	*0.394*	*0.472*
P01	0.02	0.02
	0.0008	*0.0008*
P02	0.07	0.09
	0.0028	*0.0035*

CoroMill® 316 solid carbide head for high-feed side milling

					a_e = 0.1 x DC			a_e = 0.075 x DC		
					a_p = 1.5 x DC Overhang 4 x d			a_p = 1.5 x DC Overhang 6 x d		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
S	S4.3.Z.AN		Titanium-based alloys	320	Q01	100	328	Q01	90	295
	S4.4.Z.AN		Titanium-based alloys	410	Q01	50	164	Q01	45	145

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

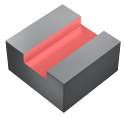
mm/tooth
inch/tooth

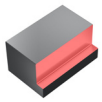
D_c	9.525	10	12	12.7	15.875	16	19.05	20	25	25.4
f_z	*0.375*	*0.394*	*0.472*	*0.50*	*0.625*	*0.630*	*0.75*	*0.787*	*0.984*	*1.00*
Q01	0.057	0.057	0.066	0.066	0.076	0.076	0.095	0.095	0.123	0.123
	0.0022	*0.0022*	*0.0026*	*0.0026*	*0.003*	*0.003*	*0.0037*	*0.0037*	*0.0049*	*0.0049*

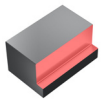
Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for large chip removal

Optimized – CoroMill® 316 solid carbide head for large chip removal







						a_e = 1.0 x DC			a_e = 0.5 x DC			a_e = 0.1 x DC		
						a_p = 0.5 x DC			a_p = 1.0 x DC			a_p = 1.5 x DC		
ISO	MC No.	CMC	Material	HB		f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
N	N1.2.Z.AG	30.12	Aluminum based alloys	100		I01	800	2625	I02	980	3215	I03	1120	3675
	N1.3.C.UT	30.21	Aluminum based alloys	75		I01	270	886	I02	360	1181	I03	480	1575
	N1.4.C.NS	30.42	Aluminum based alloys	130		I01	100	328	I02	130	427	I03	190	623
	N3.2.C.UT	33.2	Copper and copper alloys	90		I01	150	492	I02	200	656	I03	290	951
O	O7.0.S.UT		Graphite			-	-	-	I04	450	1476	I05	500	1640

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

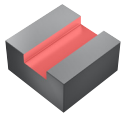
mm/tooth
inch/tooth

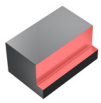
D_c	1.000	2.000	3.000	4.000	6.000	8.000	10.000	12.000	14.000	16.000	18.000	18.000
f_z	*0.039*	*0.079*	*0.118*	*0.157*	*0.236*	*0.315*	*0.394*	*0.472*	*0.551*	*0.630*	*0.709*	*0.709*
I01	0.020	0.040	0.040	0.040	0.072	0.110	0.130	0.150	0.180	0.200	0.220	0.220
	0.0008	*0.0016*	*0.0016*	*0.0016*	*0.0028*	*0.0043*	*0.0051*	*0.0059*	*0.0071*	*0.0079*	*0.0087*	*0.0087*
I02	0.030	0.060	0.070	0.070	0.100	0.170	0.220	0.220	0.220	0.260	0.260	0.310
	0.0012	*0.0024*	*0.0028*	*0.0028*	*0.0039*	*0.0067*	*0.0087*	*0.0087*	*0.0087*	*0.0102*	*0.0102*	*0.0122*
I03	0.040	0.070	0.070	0.110	0.150	0.200	0.260	0.260	0.260	0.260	0.330	0.440
	0.0016	*0.0028*	*0.0028*	*0.0043*	*0.0059*	*0.0079*	*0.0102*	*0.0102*	*0.0102*	*0.0102*	*0.0130*	*0.0173*
I04	0.010	0.010	0.010	0.020	0.020	0.030	0.040	0.050	0.060	0.070	-	-
	0.0004	*0.0004*	*0.0004*	*0.0008*	*0.0008*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0028*	-	-
I05	0.010	0.020	0.020	0.030	0.040	0.060	0.080	0.100	0.120	0.140	-	-
	0.0004	*0.0008*	*0.0008*	*0.0012*	*0.0016*	*0.0024*	*0.0031*	*0.0039*	*0.0047*	*0.0055*	-	-

Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for roughing with chip breaker

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





					a_e = 1.0 x DC			a_e = 0.5 x DC			a_e = 0.1 x DC		
					a_p = 0.5 x DC			a_p = 1.0 x DC			a_p = 1.5 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	L01	170	558	L02	220	722	L03	315	1033
	P2.2.Z.AN	02.2	Low-alloyed steel	240	L01	120	394	L02	160	525	L03	230	755
	P3.0.Z.HT	03.21	High alloyed steel	380	L01	80	262	L02	100	328	L03	140	459
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	L01	50	164	L02	65	213	L03	95	312
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	L04	60	197	L05	75	246	L06	115	377
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	L04	50	164	L05	65	213	L06	95	312
K	K1.1.C.NS	07.2	Malleable cast iron	200	L01	130	427	L02	170	558	L03	245	804
	K2.1.C.UT	08.2	Gray cast iron	180	L01	130	427	L02	170	558	L03	245	804
	K3.2.C.UT	09.2	Nodular cast iron	215	L01	115	377	L02	155	509	L03	220	722
N	N1.2.Z.AG	30.12	Aluminum based alloys	100	L08	1270	4167	L09	1610	5282	L07	2150	7054
	N1.3.C.UT	30.21	Aluminum based alloys	75	L08	310	1017	L09	380	1247	L07	540	1772
	N1.4.C.NS	30.42	Aluminum based alloys	130	L08	110	361	L09	150	492	L07	220	722
	N3.2.C.UT	33.2	Copper and copper alloys	90	L08	170	558	L09	230	755	L07	320	1050
S	S1.0.U.AG	20.12	Iron-based superalloys	280	L04	20	66	L05	30	98	L06	50	164
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	L04	20	66	L05	30	98	L06	50	164
	S4.2.Z.AN	23.22	Titanium-based alloys	320	L04	50	164	L05	80	262	L06	130	427

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

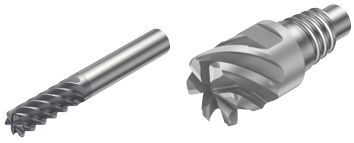
mm/tooth
inch/tooth

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

Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for finishing

Optimized – CoroMill® 316 solid carbide head for finishing



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

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

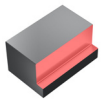
mm/tooth
inch/tooth

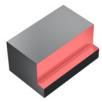
D_c	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400
f_z	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.551*	*0.625*	*0.630*	*0.709*	*0.750*	*0.787*	*0.984*	*1.000*
J01	0.040	0.050	0.070	0.070	0.100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

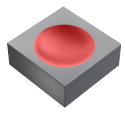
Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide end mill for micromilling

Optimized – CoroMill® Plura solid carbide ball nose end mill for micromilling







					a_e = 1.0 x DC			a_e = 0.5 x DC			a_e = 0.25 x DC			a_e = 0.05 x DC		
					a_p = 0.5 x DC			a_p = 1.0 x DC			a_p = 1.0 x DC			a_p = 0.05 x DC		
ISO	MC No.	CMC	Material	HB	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min	f_z	v_c m/min	V_c feet/min
P	P1.2.Z.AN	01.2	Unalloyed steel	190	M01	140	459	M02	195	640	M08	215	705	M03	330	1083
	P2.2.Z.AN	02.2	Low-alloyed steel	240	M01	115	377	M02	160	525	M08	175	574	M03	240	787
	P3.0.Z.HT	03.21	High alloyed steel	380	M01	80	262	M02	90	295	M08	100	328	M03	140	459
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	M01	70	230	M02	80	262	M08	90	295	M03	100	328
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	M04	90	295	M05	110	361	M11	120	394	M06	120	394
	M3.2.Z.AQ	05.51	Duplex (austenitic/ferritic) stainless steel	260	M04	70	230	M05	75	246	M11	85	279	M06	100	328
K	K1.1.C.NS	07.2	Malleable cast iron	200	M01	155	509	M02	170	558	M08	185	607	M03	270	886
	K2.1.C.UT	08.2	Gray cast iron	180	M01	160	525	M02	175	574	M08	195	640	M03	270	886
	K3.2.C.UT	09.2	Nodular cast iron	215	M01	165	541	M02	180	591	M08	200	656	M03	240	787
N	N1.2.Z.AG	30.12	Aluminum based alloys	100	M09	800	2625	M10	1040	3412	M12	1145	3757	M07	1450	4757
	N1.3.C.UT	30.21	Aluminum based alloys	75	M09	640	2100	M10	830	2723	M12	915	3002	M07	1030	3379
	N1.4.C.NS	30.42	Aluminum based alloys	130	M09	200	656	M10	240	787	M12	265	869	M07	360	1181
	N3.2.C.UT	33.2	Copper and copper alloys	90	M09	320	1050	M10	385	1263	M12	425	1394	M07	740	2428
S	S1.0.U.AG	20.12	Iron-based superalloys	280	M04	30	98	M05	40	131	M11	45	148	M06	60	197
	S2.0.Z.AG	20.22	Nickel-based superalloys	350	M04	30	98	M05	40	131	M11	45	148	M06	60	197
	S4.2.Z.AN	23.22	Titanium-based alloys	320	M04	65	213	M05	85	279	M11	95	312	M06	110	361
H	H1.1.Z.HA	04.1	Steel - Hardness level 50	50HRC	M04	40	131	M05	45	148	M11	50	164	M06	140	459
	H1.2.Z.HA	04.1	Steel - Hardness level 55	55HRC	M04	20	66	M05	25	82	M11	25	82	M06	140	459
	H1.3.Z.HA	04.1	Steel - Hardness level 60	60HRC	M04	10	33	M05	15	49	M11	15	49	M06	80	262

For optimized cutting data see CoroPlus® ToolGuide.

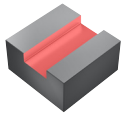
Feed recommendations

mm/tooth
inch/tooth

D_c	0.500	1.000	2.000
f_z	*0.020*	*0.039*	*0.079*
M01	0.010	0.010	0.020
	0.0004	*0.0004*	*0.0008*
M02	0.010	0.010	0.020
	0.0004	*0.0004*	*0.0008*
M03	0.010	0.020	0.030
	0.0004	*0.0008*	*0.0012*
M04	0.010	0.010	0.020
	0.0004	*0.0004*	*0.0008*
M05	0.010	0.010	0.020
	0.0004	*0.0004*	*0.0008*
M06	0.015	0.020	0.030
	0.0006	*0.0008*	*0.0012*
M07	0.035	0.060	0.080
	0.0014	*0.0024*	*0.0031*
M08	0.010	0.010	0.020
	0.0004	*0.0004*	*0.0008*
M09	0.020	0.020	0.040
	0.0008	*0.0008*	*0.0016*
M10	0.020	0.030	0.060
	0.0008	*0.0012*	*0.0024*
M11	0.020	0.010	0.020
	0.0008	*0.0004*	*0.0008*
M12	-	0.030	0.060
	-	*0.0012*	*0.0024*

Cutting speed recommendations

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



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

For optimized cutting data see CoroPlus® ToolGuide.

Feed recommendations

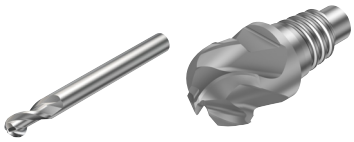
mm/tooth
inch/tooth

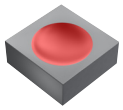
D_c	10.000	12.000	16.000
f_z	*0.394*	*0.472*	*0.630*
O01	0.070	0.080	0.110
	0.0028	*0.0031*	*0.0043*
O02	0.120	0.120	0.140
	0.0047	*0.0047*	*0.0055*
O03	0.140	0.140	0.140
	0.0055	*0.0055*	*0.0055*
O04	0.120	0.120	0.120
	0.0047	*0.0047*	*0.0047*
O05	0.075	0.090	0.120
	0.0030	*0.0035*	*0.0047*
O06	0.050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

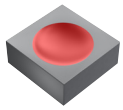
Cutting speed recommendations

Optimized – CoroMill® Plura solid carbide ball nose end mill for profiling

Optimized – CoroMill® 316 solid carbide head for profiling







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

For optimized cutting data see CoroPlus® ToolGuide.

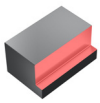
Feed recommendations

mm/tooth
inch/tooth

D_c	1.000	2.000	3.000	4.000	6.000	6.350	7.938	8.000	9.525	10.000	12.000	12.700	16.000	20.000	25.000	25.400
f_z	*0.039*	*0.079*	*0.118*	*0.157*	*0.236*	*0.250*	*0.313*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.630*	*0.787*	*0.984*	*1.000*
N01	0.020	0.030	0.050	0.060	0.080	0.080	0.120	0.120	0.150	0.150	0.150	0.150	0.160	0.020	0.025	0.025
	0.0008	*0.0012*	*0.0020*	*0.0024*	*0.0031*	*0.0031*	*0.0047*	*0.0047*	*0.0059*	*0.0059*	*0.0059*	*0.0059*	*0.0063*	*0.0079*	*0.0098*	*0.0098*
N02	0.020	0.030	0.040	0.050	0.060	0.060	0.100	0.100	0.120	0.120	0.120	0.120	0.140	0.016	0.020	0.020
	0.0008	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0024*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0047*	*0.0047*	*0.0055*	*0.0630*	*0.0079*	*0.0790*
N03	0.060	0.080	0.100	0.130	0.180	0.180	0.260	0.260	0.330	0.330	0.330	0.330	0.380	0.440	0.500	0.500
	0.0024	*0.0031*	*0.0039*	*0.0051*	*0.0071*	*0.0071*	*0.0102*	*0.0102*	*0.0130*	*0.0130*	*0.0130*	*0.0130*	*0.0150*	*0.0173*	*0.0197*	*0.0197*
N04	0.030	0.050	0.080	0.100	0.120	0.120	0.150	0.150	0.200	0.200	0.200	0.200	0.200	0.250	0.250	0.250
	0.0012	*0.0020*	*0.0031*	*0.0039*	*0.0047*	*0.0047*	*0.0059*	*0.0059*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0079*	*0.0098*	*0.0098*	*0.0098*
N05	0.020	0.040	0.065	0.080	0.100	0.100	0.120	0.120	0.160	0.160	0.160	0.160	0.160	0.200	0.200	0.200
	0.0008	*0.0016*	*0.0026*	*0.0031*	*0.0039*	*0.0039*	*0.0047*	*0.0047*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0063*	*0.0079*	*0.0079*	*0.0079*
N06	0.070	0.110	0.175	0.220	0.260	0.260	0.330	0.330	0.440	0.440	0.440	0.440	0.440	0.500	0.500	0.500
	0.0028	*0.0043*	*0.0069*	*0.0087*	*0.0102*	*0.0102*	*0.0130*	*0.0130*	*0.0173*	*0.0173*	*0.0173*	*0.0173*	*0.0173*	*0.0197*	*0.0197*	*0.0197*

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

For composite materials



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

Feed same for all diameters.

CoroMill® Plura thread milling cutting data

Speed and feed recommendations

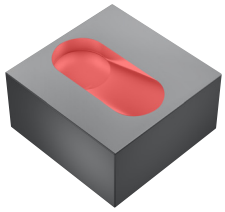
ISO	Material	Hardness HB	Hardness HRC	Thread mill	Dimensions, mm, inch DC	DC"	ZEFP	$l_{Th} = 0.5 \times a_p$ Cutting speed v_c m/min	ft/min	Feed per tooth, f_z mm	inch	$l_{Th} = a_p$ Cutting speed v_c m/min	ft/min	Feed per tooth, f_z mm	inch
P	**Unalloyed steel**			M2	1.55	.061	3	127	417	0.027	.0011	120	396	0.020	.0008
	P1.1.Z.AN	125		M4	3.2	.126	3	152	500	0.030	.0012	141	465	0.018	.0007
				M10	8.2	.323	4	132	435	0.052	.0020	124	410	0.029	.0012
				M20	16	.630	5	141	465	0.130	.0051	131	430	0.069	.0028
	Low alloy steel			M2	1.55	.061	3	84	276	0.018	.0007	80	263	0.016	.0006
	P2.5.Z.HT	300		M4	3.2	.126	3	147	485	0.012	.0005	137	440	0.006	.0003
				M10	8.2	.323	4	164	540	0.086	.0034	153	500	0.050	.0020
				M20	16	.630	5	173	570	0.089	.0036	162	535	0.118	.0046
	High alloy steel			M2	1.55	.061	3	73	240	0.005	.0002	70	231	0.0045	.0002
	P3.0.Z.HT	450		M4	3.2	.126	3	163	540	0.035	.0014	151	500	0.015	.0006
				M10	8.2	.323	4	164	550	0.061	.0024	153	520	0.049	.0020
				M20	16	.630	5	173	570	0.012	.0005	162	540	0.118	.0046
M	**Stainless steel**			M2	1.55	.061	3	37	121	0.01	.0004	35	114	0.009	.00035
	P5.0.Z.AN	200		M4	3.2	.126	3	81	265	0.024	.0010	75	245	0.009	.0004
				M10	8.2	.323	4	82	270	0.052	.0020	76	250	0.036	.0014
				M20	16	.630	5	86	280	0.089	.0036	93	310	0.089	.0036
				M2	1.55	.061	3	52	170	0.009	.00035	50	164	0.0085	.00035
	M1.0.Z.AQ	200		M4	3.2	.126	3	53	175	0.018	.0007	49	160	0.007	.0007
				M10	8.2	.323	4	53	175	0.052	.0020	50	165	0.027	.0012
				M20	16	.630	5	56	185	0.089	.0036	53	175	0.072	.0029
				M2	1.55	.061	3	42	137	0.0045	.0002	40	131	0.0042	.00015
	M3.1.Z.AQ	230		M4	3.2	.126	3	53	175	0.018	.0008	49	160	0.007	.0003
				M10	8.2	.323	4	53	175	0.052	.0020	50	165	0.027	.0012
				M20	16	.630	5	56	185	0.131	.0052	53	175	0.074	.0030
K	**Malleable cast iron**			M2	1.55	.061	3	97	318	0.0289	.0012	92	301	0.025	.001
	K1.1.C.NS			M4	3.2	.126	3	80	265	0.020	.0008	77	260	0.016	.0006
				M10	8.2	.323	4	89	290	0.061	.0022	83	275	0.036	.0014
				M20	16	.630	5	82	270	0.084	.0032	83	275	0.089	.0036
	Gray cast iron			M2	1.55	.061	3	82	269	0.018	.0007	80	262	0.016	.0006
	K2.2.C.UT			M4	3.2	.126	3	76	260	0.018	.0007	73	250	0.014	.0006
				M10	8.2	.323	4	86	310	0.038	.0014	79	285	0.034	.0013
				M20	16	.630	5	79	285	0.075	.0030	80	290	0.080	.0032
	Nodular cast iron			M2	1.55	.061	3	97	318	0.04	.0015	94	308	0.035	.0014
	K3.1.C.UT			M4	3.2	.126	3	101	340	0.027	.0012	97	330	0.020	.0008
				M10	8.2	.323	4	104	345	0.047	.0020	105	340	0.048	.0020
				M20	16	.630	5	104	345	0.089	.0036	97	330	0.067	.0026
N	**Aluminum**			M2	1.55	.061	3	390	1280	0.06	.0023	375	1230	0.055	.0022
	N1.2.Z.UT	60		M4	3.2	.126	3	503	1660	0.040	.0016	503	1660	0.035	.0014
				M10	8.2	.323	4	1120	3700	0.089	.0036	1060	3500	0.061	.0024
				M20	16	.630	5	1130	3750	0.089	.0036	1060	3500	0.089	.0036
				M2	1.55	.061	3	377	1237	0.058	.0022	365	1198	0.054	.0022
	N1.3.C.UT	95		M4	3.2	.126	3	434	1430	0.040	.0016	404	1330	0.018	.0007
				M10	8.2	.323	4	461	1520	0.061	.0025	432	1420	0.061	.0034
				M20	16	.630	5	467	1540	0.089	.0036	436	1445	0.089	.0036
				M2	1.55	.061	3	125	410	0.056	.0022	123	404	0.054	.0022
		150		M4	3.2	.126	3	273	900	0.028	.0011	262	890	0.021	.0009
				M10	8.2	.323	4	278	920	0.053	.0021	260	870	0.026	.0012
				M20	16	.630	5	282	930	0.089	.0036	263	880	0.071	.0028
S	**Heat resistant alloys**			M2	1.55	.061	3	27	89	0.011	.0004	25	82	0.01	.0004
	S1.0.U.AN	200		M4	3.2	.126	3	35	115	0.006	.0002	35	115	0.003	.0001
				M10	8.2	.323	4	37	120	0.023	.0011	35	115	0.013	.0006
				M20	16	.630	5	38	125	0.066	.0026	38	125	0.063	.0025
	Titanium alloys			M2	1.55	.061	3	16	53	0.007	.0003	15	49	0.0065	.00025
	S2.0.Z.AG	300		M4	3.2	.126	3	30	100	0.008	.0004	29	100	0.004	.0002
				M10	8.2	.323	4	32	105	0.013	.0006	30	100	0.007	.0003
				M20	16	.630	5	32	105	0.037	.0015	30	100	0.018	.0007
				M2	1.55	.061	3	25	82	0.01	.0004	23	75	0.009	.00035
	S4.2.Z.AN	300		M4	3.2	.126	3	55	180	0.012	.0005	51	165	0.006	.0011
				M10	8.2	.323	4	58	190	0.037	.0015	54	175	0.020	.0008
				M20	12	.472	6	59	195	0.089	.0036	55	180	0.051	.0022
H				M2	1.55	.061	3	20	66	0.002	.00008	18	59	0.002	.00008
	H1.3.Z.HA		55	M4	4.5	.177	4	43	140	0.010	.0004	40	130	0.005	.0002
				M10	8.2	.323	5	42	135	0.022	.0010	45	150	0.018	.0007
				M20	12	.472	5	45	150	0.042	.0017	42	135	0.021	.0009
				M2	1.55	.061	3	17	56	0.002	.00008	15	49	0.002	.00008
	H1.3.Z.HA		60	M4	4.5	.177	4	30	100	0.005	.0002	30	100	0.003	.0001
				M10	8.2	.323	5	29	100	0.011	.0005	28	100	0.006	.0002
				M20	12	.472	5	30	100	0.022	.0010	28	100	0.010	.0004

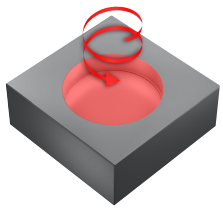
Maximum ramping angle

CoroMill® Plura - Optimized

CoroMill® Plura - Versatile

CoroMill® 316





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

Grades for milling

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

Drilling

V

Versatile

CoroDrill® 460
Drills for multi-materials B3

O

Optimized

CoroDrill® 860
Drills for multi-materials B18
Drills for steel B28
Drills for stainless steel B36
Drills for aluminum B41
Drills for heat-resistant super alloys B45

CoroDrill® 861
Drills for deep holes in multi-materials B50

CoroDrill® 862
Drills for small diameter precision holes B56

CoroDrill® 863
Drills for CNC, ADU, and robotic machines in aerospace assembly materials B58

CoroDrill® 452
Tooling solution for hand-held machines in composite materials B62

CoroDrill® 400
Drills for aluminum B66

CoroDrill® 430
Drills for aluminum B66

C

Customized

E5

	460	860-GM	860-PM	860-MM	860-NM	860-SM
ISO application area	P M K N S H	P M K N S H	P	M	N	S
Diameter, mm	3.00 - 20.00	3.00 - 16.00	3.00 - 20.00	3.00 - 15.80	3.00 - 17.50	3.00 - 15.87
Diameter, inch	.118 - .787	.118 - .630	.118 - .787	.118 - .622	.118 - .689	.118 - .625
Tool tolerance	m7	m7	m7	m7	m7	m7
TCHA	H9	H9	H8	H8	H9	H9
Internal coolant	✓	✓	✓	✓	✓	✓
External coolant	✓	✓	✗	✗	✗	✗
ULDR	2-8xØ	2-8xØ	2-8xØ	3-8xØ	3-8xØ	2-5xØ
	V	O	O	O	O	O
Page	B18	B18	B28	B36	B41	B45

	861	862	863	452	400/430
ISO application area	P M K N	P M K N S	M N S O	M N S O	N
Diameter, mm	3.00 - 16.00	1.85 - 2.95	3.30 - 11.14	2.50 - 7.94	5.00 - 12.50
Diameter, inch	.118 - .630	.073 - .116	.130 - .439	.098 - .313	.197 - .492
Tool tolerance	m7	m7	m7	m7	m7
TCHA	H9	H9	H9	H9	H9
Internal coolant	✓	✓	✓	✗	✓
External coolant	✗	✗	✓	✓	✗
ULDR	12-30xØ	7-12xØ	1.5-12-5xØ	2-15xØ	6-7xØ
	O	O	O	O	O
Page	B50	B56	B58	B62	B66

SANDVIK Coromant

CoroDrill® 460

Versatile high-performance solid carbide drills

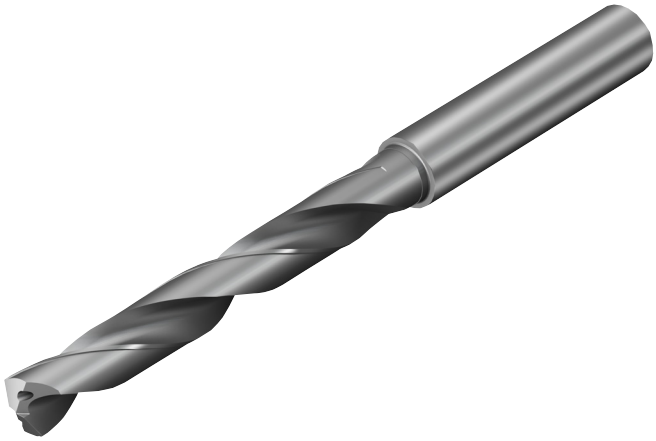
V C

Application

- For a wide range of materials in all industry segments, e.g., general machining, die and mold, automotive, energy and power generation
- Internal and external coolant

ISO application area:

P M K N S H



Features and benefits

- High productivity and consistent tool life
- Exceptional value with no compromise on quality
- Excellent hole quality
- Reduced tooling costs
- Can be reground up to three times, extending tool life even further
- 20 bar coolant pressure

www.sandvik.coromant.com/corodrill460

Recommendations

It is recommended to use hydraulic precision chucks.
It is recommended to use internal coolant, minimum recommended pressure 20 bar

For chucks, see our Rotating Tools catalog.

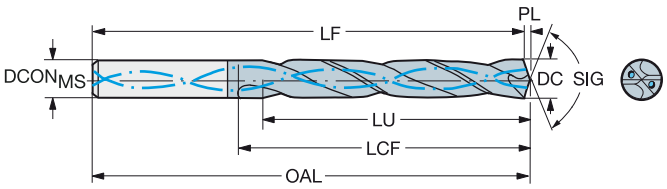
E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch											
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
3.00	.118	9.4	.370	3	6	460.1-0300-009A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.00	.118	15.4	.606	5	6	460.1-0300-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	20	290	DIN 6537 L
3.00	.118	24.4	.961	8	6	460.1-0300-023A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016	20	290	COROMANT
3.05	.120	15.7	.618	5	6	460.1-0305-015A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	20	290	DIN 6537 L
3.10	.122	9.7	.382	3	6	460.1-0310-009A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.10	.122	15.9	.626	5	6	460.1-0310-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	20	290	DIN 6537 L
3.10	.122	25.2	.992	8	6	460.1-0310-023A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016	20	290	COROMANT
3.18	.125	10.0	.394	3	6	460.1-0318-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.18	.125	16.3	.642	5	6	460.1-0318-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.18	.125	25.9	1.020	8	6	460.1-0318-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT
3.20	.126	10.1	.398	3	6	460.1-0320-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.20	.126	16.5	.650	5	6	460.1-0320-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.20	.126	26.1	1.028	8	6	460.1-0320-024A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT
3.26	.128	16.8	.661	5	6	460.1-0326-016A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.30	.130	10.4	.409	3	6	460.1-0330-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.30	.130	17.0	.669	5	6	460.1-0330-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.30	.130	26.9	1.059	8	6	460.1-0330-025A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT
3.35	.132	17.2	.677	5	6	460.1-0335-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.40	.134	10.7	.421	3	6	460.1-0340-010A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.40	.134	17.5	.689	5	6	460.1-0340-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.40	.134	27.7	1.091	8	6	460.1-0340-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT
3.50	.138	11.0	.433	3	6	460.1-0350-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.50	.138	18.0	.709	5	6	460.1-0350-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.50	.138	28.5	1.122	8	6	460.1-0350-026A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT
3.57	.141	11.2	.441	3	6	460.1-0357-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.57	.141	29.1	1.146	8	6	460.1-0357-027A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT
3.60	.142	11.3	.445	3	6	460.1-0360-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.60	.142	18.5	.728	5	6	460.1-0360-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.70	.146	11.6	.457	3	6	460.1-0370-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.70	.146	19.0	.748	5	6	460.1-0370-019A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.70	.146	28.9	1.138	7	6	460.1-0370-028A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020	20	290	COROMANT
3.80	.150	11.9	.469	3	6	460.1-0380-011A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
3.80	.150	19.5	.768	5	6	460.1-0380-019A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.5	2.894	36	1.417	0.5	.020	20	290	DIN 6537 L
3.80	.150	30.9	1.217	8	6	460.1-0380-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.5	3.524	48	1.890	0.5	.020	20	290	COROMANT
3.90	.154	12.3	.484	3	6	460.1-0390-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
3.90	.154	20.1	.791	5	6	460.1-0390-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
3.97	.156	20.4	.803	5	6	460.1-0397-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
3.97	.156	32.3	1.272	8	6	460.1-0397-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT
4.00	.157	12.6	.496	3	6	460.1-0400-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.00	.157	20.6	.811	5	6	460.1-0400-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.00	.157	32.6	1.283	8	6	460.1-0400-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT
4.05	.159	12.7	.500	3	6	460.1-0405-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.05	.159	20.8	.819	5	6	460.1-0405-020A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.10	.161	12.9	.508	3	6	460.1-0410-012A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.10	.161	21.1	.831	5	6	460.1-0410-021A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.10	.161	33.4	1.315	8	6	460.1-0410-031A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT
4.20	.165	13.2	.520	3	6	460.1-0420-013A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.20	.165	21.6	.850	5	6	460.1-0420-021A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.20	.165	34.2	1.346	8	6	460.1-0420-032A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT
4.22	.166	21.7	.854	5	6	460.1-0422-021A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.25	.167	21.9	.862	5	6	460.1-0425-021A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L

Cutting data: www.sandvik.coromant.com

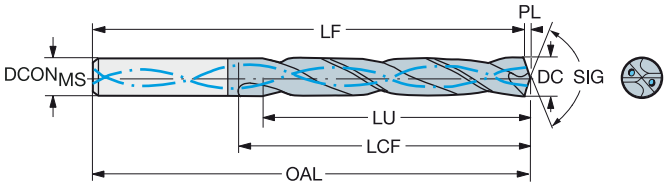
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



								P	M	K	N	S	H	Dimensions, mm, inch								BAR	PSI	
DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code		GC34	GC34	GC34	GC34	GC34	GC34	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"			BSG
4.30	.169	13.5	.531	3	6	460.1-0430-013A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.30	.169	22.1	.870	5	6	460.1-0430-022A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.30	.169	35.0	1.378	8	6	460.1-0430-032A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT
4.37	.172	13.7	.539	3	6	460.1-0437-013A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.37	.172	22.5	.886	5	6	460.1-0437-022A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.37	.172	35.6	1.402	8	6	460.1-0437-033A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024	20	290	COROMANT
4.40	.173	13.8	.543	3	6	460.1-0440-013A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.40	.173	22.6	.890	5	6	460.1-0440-022A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
4.50	.177	14.2	.559	3	6	460.1-0450-014A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.50	.177	23.2	.913	5	6	460.1-0450-023A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.50	.177	36.7	1.445	8	6	460.1-0450-034A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	20	290	COROMANT
4.60	.181	14.5	.571	3	6	460.1-0460-014A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.60	.181	23.7	.933	5	6	460.1-0460-023A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.60	.181	37.5	1.476	8	6	460.1-0460-035A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	20	290	COROMANT
4.70	.185	14.6	.575	3	6	460.1-0470-014A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.70	.185	24.2	.953	5	6	460.1-0470-024A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.70	.185	38.3	1.508	8	6	460.1-0470-035A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028	20	290	COROMANT
4.76	.187	15.0	.591	3	6	460.1-0476-014A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
4.76	.187	24.5	.965	5	6	460.1-0476-024A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L
4.76	.187	38.8	1.528	8	6	460.1-0476-036A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT
4.80	.189	15.1	.594	3	6	460.1-0480-014A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
4.80	.189	24.7	.972	5	6	460.1-0480-024A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L
4.80	.189	39.1	1.539	8	6	460.1-0480-036A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT
4.85	.191	25.0	.984	5	6	460.1-0485-024A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L
4.90	.193	15.4	.606	3	6	460.1-0490-015A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
4.90	.193	25.2	.992	5	6	460.1-0490-025A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L
5.00	.197	15.7	.618	3	6	460.1-0500-015A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.00	.197	25.7	1.012	5	6	460.1-0500-025A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L
5.00	.197	40.7	1.602	8	6	460.1-0500-038A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT
5.05	.199	15.9	.626	3	6	460.1-0505-015A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.05	.199	26.0	1.024	5	6	460.1-0505-025A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L
5.10	.201	16.0	.630	3	6	460.1-0510-015A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.10	.201	26.2	1.032	5	6	460.1-0510-026A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	20	290	DIN 6537 L
5.10	.201	41.5	1.634	8	6	460.1-0510-038A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028	20	290	COROMANT
5.16	.203	16.2	.638	3	6	460.1-0516-016A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.16	.203	26.5	1.043	5	6	460.1-0516-026A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.16	.203	42.0	1.654	8	6	460.1-0516-039A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT
5.20	.205	16.4	.646	3	6	460.1-0520-016A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.20	.205	26.8	1.055	5	6	460.1-0520-026A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.20	.205	42.4	1.669	8	6	460.1-0520-039A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT
5.25	.207	27.0	1.063	5	6	460.1-0525-026A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.31	.209	27.3	1.075	5	6	460.1-0531-027A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.41	.213	27.8	1.094	5	6	460.1-0541-027A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.50	.217	17.3	.681	3	6	460.1-0550-017A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.50	.217	28.3	1.114	5	6	460.1-0550-028A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.50	.217	44.8	1.764	8	6	460.1-0550-041A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT
5.56	.219	17.5	.689	3	6	460.1-0556-017A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.56	.219	28.6	1.126	5	6	460.1-0556-028A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.56	.219	45.3	1.783	8	6	460.1-0556-042A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT
5.60	.220	17.6	.693	3	6	460.1-0560-017A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.60	.220	28.8	1.134	5	6	460.1-0560-028A1-XM		☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L

Cutting data: www.sandvik.coromant.com

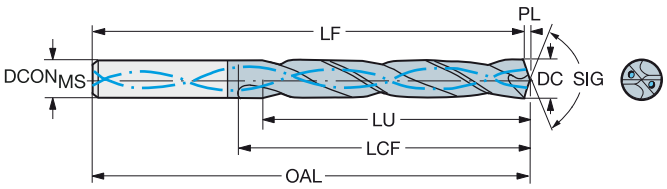
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch										
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
5.70	.224	17.7	.697	3	6	460.1-0570-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.70	.224	29.3	1.154	5	6	460.1-0570-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.70	.224	46.4	1.827	8	6	460.1-0570-043A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031	20	290	COROMANT
5.75	.226	29.6	1.165	5	6	460.1-0575-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.80	.228	17.6	.693	3	6	460.1-0580-017A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K
5.80	.228	29.9	1.177	5	6	460.1-0580-029A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
5.80	.228	47.3	1.862	8	6	460.1-0580-044A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	20	290	COROMANT
5.90	.232	30.4	1.197	5	6	460.1-0590-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
5.95	.234	17.3	.681	2	6	460.1-0595-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K
5.95	.234	30.6	1.205	5	6	460.1-0595-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
5.95	.234	48.5	1.909	8	6	460.1-0595-045A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	20	290	COROMANT
6.00	.236	18.9	.744	3	6	460.1-0600-018A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K
6.00	.236	30.9	1.217	5	6	460.1-0600-030A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
6.00	.236	48.9	1.925	8	6	460.1-0600-045A1-XM	☆	☆	☆	☆	☆	☆	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035	20	290	COROMANT
6.05	.238	19.0	.748	3	8	460.1-0605-018A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.05	.238	31.1	1.224	5	8	460.1-0605-030A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.10	.240	19.2	.756	3	8	460.1-0610-018A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.10	.240	31.4	1.236	5	8	460.1-0610-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.10	.240	49.7	1.957	8	8	460.1-0610-046A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	20	290	COROMANT
6.15	.242	31.7	1.248	5	8	460.1-0615-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.20	.244	19.5	.768	3	8	460.1-0620-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.20	.244	31.9	1.256	5	8	460.1-0620-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.20	.244	50.5	1.988	8	8	460.1-0620-047A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	20	290	COROMANT
6.25	.246	32.2	1.268	5	8	460.1-0625-031A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.30	.248	19.8	.780	3	8	460.1-0630-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.30	.248	32.4	1.276	5	8	460.1-0630-032A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.35	.250	20.0	.787	3	8	460.1-0635-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.35	.250	32.7	1.287	5	8	460.1-0635-032A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.35	.250	51.7	2.035	8	8	460.1-0635-048A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.1	4.925	84	3.307	0.9	.035	20	290	COROMANT
6.40	.252	20.1	.791	3	8	460.1-0640-019A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.40	.252	32.9	1.295	5	8	460.1-0640-032A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	20	290	DIN 6537 L
6.50	.256	20.5	.807	3	8	460.1-0650-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.50	.256	33.5	1.319	5	8	460.1-0650-033A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.50	.256	53.0	2.087	8	8	460.1-0650-049A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT
6.53	.257	33.6	1.323	5	8	460.1-0653-033A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.60	.260	20.8	.819	3	8	460.1-0660-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.60	.260	34.0	1.339	5	8	460.1-0660-033A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.60	.260	53.8	2.118	8	8	460.1-0660-050A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT
6.70	.264	21.1	.831	3	8	460.1-0670-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.70	.264	34.5	1.358	5	8	460.1-0670-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.70	.264	54.6	2.150	8	8	460.1-0670-050A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT
6.75	.266	21.2	.835	3	8	460.1-0675-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.75	.266	34.7	1.366	5	8	460.1-0675-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.75	.266	55.0	2.165	8	8	460.1-0675-051A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT
6.80	.268	21.4	.843	3	8	460.1-0680-020A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.80	.268	35.0	1.378	5	8	460.1-0680-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.80	.268	55.4	2.181	8	8	460.1-0680-051A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT
6.85	.270	35.3	1.390	5	8	460.1-0685-034A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.90	.272	21.7	.854	3	8	460.1-0690-021A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.90	.272	35.5	1.398	5	8	460.1-0690-035A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.90	.272	56.2	2.213	8	8	460.1-0690-052A1-XM	☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT

Cutting data: www.sandvik.coromant.com

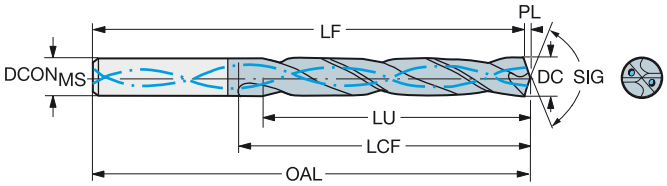
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



								P	M	K	N	S	H	Dimensions, mm, inch											
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code		GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
7.00	.276	22.0	.866	3	8	460.1-0700-021A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
7.00	.276	36.0	1.417	5	8	460.1-0700-035A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
7.00	.276	57.0	2.244	8	8	460.1-0700-053A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039	20	290	COROMANT
7.04	.277	36.2	1.425	5	8	460.1-0704-035A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
7.10	.280	22.3	.878	3	8	460.1-0710-021A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K
7.10	.280	36.5	1.437	5	8	460.1-0710-036A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
7.14	.281	22.5	.886	3	8	460.1-0714-021A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.14	.281	36.8	1.449	5	8	460.1-0714-036A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.14	.281	58.2	2.291	8	8	460.1-0714-054A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT
7.20	.283	37.1	1.461	5	8	460.1-0720-036A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.20	.283	58.7	2.311	8	8	460.1-0720-054A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT
7.30	.287	23.0	.906	3	8	460.1-0730-022A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.30	.287	37.6	1.480	5	8	460.1-0730-037A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.40	.291	23.3	.917	3	8	460.1-0740-022A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.40	.291	38.1	1.500	5	8	460.1-0740-037A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.40	.291	60.3	2.374	8	8	460.1-0740-056A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT
7.45	.293	38.3	1.508	5	8	460.1-0745-037A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.50	.295	23.6	.929	3	8	460.1-0750-023A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.50	.295	38.6	1.520	5	8	460.1-0750-038A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.50	.295	61.1	2.406	8	8	460.1-0750-056A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT
7.54	.297	23.7	.933	3	8	460.1-0754-023A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.54	.297	38.8	1.528	5	8	460.1-0754-038A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.60	.299	23.9	.941	3	8	460.1-0760-023A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.60	.299	39.1	1.539	5	8	460.1-0760-038A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.60	.299	61.9	2.437	8	8	460.1-0760-057A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT
7.70	.303	24.2	.953	3	8	460.1-0770-023A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.70	.303	39.6	1.559	5	8	460.1-0770-039A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.70	.303	62.7	2.469	8	8	460.1-0770-058A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043	20	290	COROMANT
7.80	.307	24.6	.969	3	8	460.1-0780-023A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.80	.307	40.2	1.583	5	8	460.1-0780-039A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.80	.307	63.6	2.504	8	8	460.1-0780-059A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	20	290	COROMANT
7.90	.311	24.9	.980	3	8	460.1-0790-024A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.90	.311	40.7	1.602	5	8	460.1-0790-040A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.94	.313	25.0	.984	3	8	460.1-0794-024A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.94	.313	40.9	1.610	5	8	460.1-0794-040A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.94	.313	64.7	2.547	8	8	460.1-0794-060A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	20	290	COROMANT
8.00	.315	25.2	.992	3	8	460.1-0800-024A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
8.00	.315	41.2	1.622	5	8	460.1-0800-040A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
8.00	.315	65.2	2.567	8	8	460.1-0800-060A1-XM		☆	☆	☆	☆	☆	☆	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047	20	290	COROMANT
8.03	.316	41.3	1.626	5	10	460.1-0803-040A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.05	.317	25.3	.996	3	10	460.1-0805-024A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
8.05	.317	41.4	1.630	5	10	460.1-0805-040A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.10	.319	25.5	1.004	3	10	460.1-0810-024A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
8.10	.319	41.7	1.642	5	10	460.1-0810-041A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.10	.319	66.0	2.598	8	10	460.1-0810-061A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT
8.15	.321	42.0	1.654	5	10	460.1-0815-041A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.20	.323	25.8	1.016	3	10	460.1-0820-025A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
8.20	.323	42.2	1.661	5	10	460.1-0820-041A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.20	.323	66.8	2.630	8	10	460.1-0820-062A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT
8.25	.325	42.5	1.673	5	10	460.1-0825-041A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.30	.327	42.7	1.681	5	10	460.1-0830-042A1-XM		☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L

Cutting data: www.sandvik.coromant.com

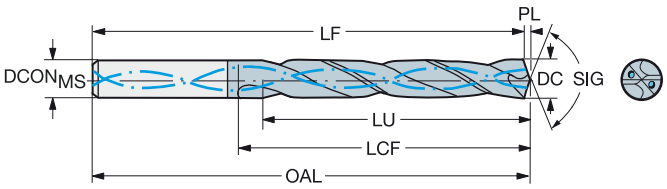
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch											
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
8.33	.328	26.2	1.032	3	10	460.1-0833-025A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
8.33	.328	42.9	1.689	5	10	460.1-0833-042A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.33	.328	67.9	2.673	8	10	460.1-0833-062A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT
8.40	.331	26.4	1.039	3	10	460.1-0840-025A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
8.40	.331	43.2	1.701	5	10	460.1-0840-042A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.40	.331	68.4	2.693	8	10	460.1-0840-063A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.8	5.937	106	4.173	1.2	.047	20	290	COROMANT
8.43	.332	43.4	1.709	5	10	460.1-0843-042A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	20	290	DIN 6537 L
8.50	.335	26.8	1.055	3	10	460.1-0850-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.50	.335	43.8	1.724	5	10	460.1-0850-043A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.50	.335	69.3	2.728	8	10	460.1-0850-064A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT
8.55	.337	44.0	1.732	5	10	460.1-0855-043A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.60	.339	27.1	1.067	3	10	460.1-0860-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.60	.339	44.3	1.744	5	10	460.1-0860-043A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.60	.339	70.1	2.760	8	10	460.1-0860-065A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT
8.70	.343	27.4	1.079	3	10	460.1-0870-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.70	.343	44.8	1.764	5	10	460.1-0870-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.70	.343	70.9	2.791	8	10	460.1-0870-065A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT
8.73	.344	27.5	1.083	3	10	460.1-0873-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.73	.344	44.9	1.768	5	10	460.1-0873-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.73	.344	71.1	2.799	8	10	460.1-0873-065A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT
8.80	.346	27.7	1.091	3	10	460.1-0880-026A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.80	.346	45.3	1.783	5	10	460.1-0880-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.80	.346	71.7	2.823	8	10	460.1-0880-066A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT
8.84	.348	45.5	1.791	5	10	460.1-0884-044A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.90	.350	28.0	1.102	3	10	460.1-0890-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.90	.350	45.8	1.803	5	10	460.1-0890-045A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
9.00	.354	28.3	1.114	3	10	460.1-0900-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
9.00	.354	46.3	1.823	5	10	460.1-0900-045A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
9.00	.354	73.3	2.886	8	10	460.1-0900-068A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.7	5.933	106	4.173	1.3	.051	20	290	COROMANT
9.10	.358	28.6	1.126	3	10	460.1-0910-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
9.10	.358	46.8	1.843	5	10	460.1-0910-046A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
9.13	.359	28.7	1.130	3	10	460.1-0913-027A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
9.13	.359	47.0	1.850	5	10	460.1-0913-046A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.13	.359	74.4	2.929	8	10	460.1-0913-068A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT
9.20	.362	47.4	1.866	5	10	460.1-0920-046A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.30	.366	29.3	1.154	3	10	460.1-0930-028A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
9.30	.366	47.9	1.886	5	10	460.1-0930-047A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.30	.366	75.8	2.984	8	10	460.1-0930-070A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT
9.35	.368	48.1	1.894	5	10	460.1-0935-047A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.40	.370	29.6	1.165	3	10	460.1-0940-028A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
9.40	.370	48.4	1.906	5	10	460.1-0940-047A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.50	.374	29.9	1.177	3	10	460.1-0950-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
9.50	.374	48.7	1.917	5	10	460.1-0950-048A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.50	.374	77.4	3.047	8	10	460.1-0950-071A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT
9.53	.375	30.0	1.181	3	10	460.1-0953-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
9.53	.375	48.6	1.913	5	10	460.1-0953-048A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.53	.375	77.6	3.055	8	10	460.1-0953-071A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055	20	290	COROMANT
9.60	.378	30.2	1.189	3	10	460.1-0960-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
9.60	.378	48.5	1.909	5	10	460.1-0960-048A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.70	.382	30.5	1.201	3	10	460.1-0970-029A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
9.70	.382	48.4	1.906	4	10	460.1-0970-049A1-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L

Cutting data: www.sandvik.coromant.com

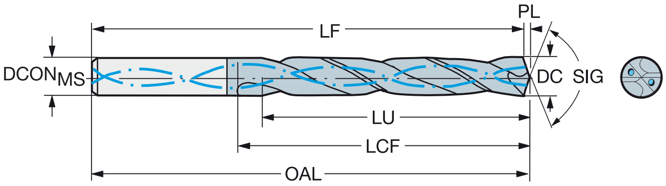
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA	H9
SIG	140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P GC34	M GC34	K GC34	N GC34	S GC34	H GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
9.80	.386	30.9	1.217	3	10	**460.1-0980-029A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.80	.386	48.3	1.902	4	10	**460.1-0980-049A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.80	.386	79.9	3.146	8	10	**460.1-0980-074A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT
9.90	.390	31.2	1.228	3	10	**460.1-0990-030A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.90	.390	48.1	1.894	4	10	**460.1-0990-050A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.90	.390	80.7	3.177	8	10	**460.1-0990-074A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT
9.92	.391	31.2	1.228	3	10	**460.1-0992-030A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.92	.391	48.1	1.894	4	10	**460.1-0992-050A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.92	.391	80.8	3.181	8	10	**460.1-0992-074A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT
10.00	.394	31.5	1.240	3	10	**460.1-1000-030A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
10.00	.394	48.0	1.890	4	10	**460.1-1000-050A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
10.00	.394	81.5	3.209	8	10	**460.1-1000-075A1-XM**	☆	☆	☆	☆	☆	☆	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059	20	290	COROMANT
10.05	.396	31.6	1.244	3	12	**460.1-1005-030A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
10.05	.396	51.7	2.035	5	12	**460.1-1005-050A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L
10.10	.398	31.8	1.252	3	12	**460.1-1010-030A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
10.10	.398	52.0	2.047	5	12	**460.1-1010-051A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L
10.20	.402	32.1	1.264	3	12	**460.1-1020-031A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
10.20	.402	52.5	2.067	5	12	**460.1-1020-051A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L
10.20	.402	83.1	3.272	8	12	**460.1-1020-077A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT
10.26	.404	52.8	2.079	5	12	**460.1-1026-051A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L
10.30	.406	32.4	1.276	3	12	**460.1-1030-031A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
10.30	.406	53.0	2.087	5	12	**460.1-1030-052A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L
10.30	.406	83.9	3.303	8	12	**460.1-1030-077A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT
10.32	.406	32.5	1.280	3	12	**460.1-1032-031A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
10.32	.406	53.1	2.091	5	12	**460.1-1032-052A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L
10.32	.406	84.1	3.311	8	12	**460.1-1032-077A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT
10.40	.409	32.7	1.287	3	12	**460.1-1040-031A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
10.40	.409	53.5	2.106	5	12	**460.1-1040-052A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	20	290	DIN 6537 L
10.40	.409	84.7	3.335	8	12	**460.1-1040-078A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.5	7.028	128	5.039	1.5	.059	20	290	COROMANT
10.50	.413	33.1	1.303	3	12	**460.1-1050-032A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
10.50	.413	54.1	2.130	5	12	**460.1-1050-053A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
10.50	.413	85.6	3.370	8	12	**460.1-1050-079A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	20	290	COROMANT
10.60	.417	33.4	1.315	3	12	**460.1-1060-032A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
10.60	.417	54.6	2.150	5	12	**460.1-1060-053A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
10.70	.421	55.1	2.169	5	12	**460.1-1070-054A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
10.72	.422	33.7	1.327	3	12	**460.1-1072-032A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
10.72	.422	55.2	2.173	5	12	**460.1-1072-054A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
10.72	.422	87.3	3.437	8	12	**460.1-1072-080A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	20	290	COROMANT
10.75	.423	55.3	2.177	5	12	**460.1-1075-054A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
10.90	.429	56.1	2.209	5	12	**460.1-1090-055A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
11.00	.433	34.6	1.362	3	12	**460.1-1100-033A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
11.00	.433	56.6	2.228	5	12	**460.1-1100-055A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
11.00	.433	89.6	3.528	8	12	**460.1-1100-083A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.4	7.024	128	5.039	1.6	.063	20	290	COROMANT
11.11	.437	35.0	1.378	3	12	**460.1-1111-033A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
11.11	.437	57.2	2.252	5	12	**460.1-1111-056A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
11.11	.437	90.5	3.563	8	12	**460.1-1111-083A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	20	290	COROMANT
11.20	.441	35.3	1.390	3	12	**460.1-1120-034A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
11.20	.441	57.6	2.268	5	12	**460.1-1120-056A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
11.20	.441	91.3	3.594	8	12	**460.1-1120-084A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	20	290	COROMANT
11.30	.445	57.4	2.260	5	12	**460.1-1130-057A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
11.40	.449	35.9	1.413	3	12	**460.1-1140-034A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
11.40	.449	57.3	2.256	5	12	**460.1-1140-057A1-XM**	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L

Dimensions, mm, inch

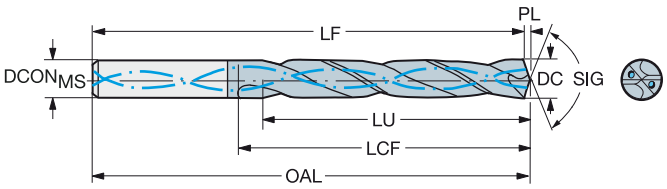
Cutting data: www.sandvik.coromant.com

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch											
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
11.50	.453	36.2	1.425	3	12	460.1-1150-035A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
11.50	.453	57.2	2.252	4	12	460.1-1150-058A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
11.50	.453	93.7	3.689	8	12	460.1-1150-086A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	20	290	COROMANT
11.51	.453	36.2	1.425	3	12	460.1-1151-035A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
11.51	.453	57.2	2.252	4	12	460.1-1151-058A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
11.51	.453	93.8	3.693	8	12	460.1-1151-086A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.3	7.020	128	5.039	1.7	.067	20	290	COROMANT
11.60	.457	36.5	1.437	3	12	460.1-1160-035A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
11.60	.457	57.1	2.248	4	12	460.1-1160-058A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
11.70	.461	57.0	2.244	4	12	460.1-1170-059A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
11.80	.465	37.2	1.465	3	12	460.1-1180-035A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.80	.465	56.8	2.236	4	12	460.1-1180-059A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.80	.465	96.2	3.787	8	12	460.1-1180-089A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	20	290	COROMANT
11.91	.469	37.5	1.476	3	12	460.1-1191-036A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.91	.469	56.7	2.232	4	12	460.1-1191-060A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.91	.469	97.0	3.819	8	12	460.1-1191-089A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	20	290	COROMANT
12.00	.472	37.8	1.488	3	12	460.1-1200-036A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
12.00	.472	56.6	2.228	4	12	460.1-1200-060A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
12.00	.472	97.8	3.850	8	12	460.1-1200-090A1-XM	☆	☆	☆	☆	☆	☆	12.0	.472	180	7.087	178.2	7.016	128	5.039	1.8	.071	20	290	COROMANT
12.05	.474	37.9	1.492	3	14	460.1-1205-036A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
12.05	.474	62.0	2.441	5	14	460.1-1205-060A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L
12.10	.476	38.1	1.500	3	14	460.1-1210-036A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
12.20	.480	38.4	1.512	3	14	460.1-1220-037A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
12.20	.480	62.4	2.457	5	14	460.1-1220-061A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L
12.20	.480	99.4	3.913	8	14	460.1-1220-092A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.2	7.882	151	5.945	1.8	.071	20	290	COROMANT
12.25	.482	62.3	2.453	5	14	460.1-1225-061A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L
12.30	.484	38.7	1.524	3	14	460.1-1230-037A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
12.30	.484	62.2	2.449	5	14	460.1-1230-062A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L
12.30	.484	100.3	3.949	8	14	460.1-1230-092A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.2	7.882	151	5.945	1.8	.071	20	290	COROMANT
12.40	.488	62.1	2.445	5	14	460.1-1240-062A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	20	290	DIN 6537 L
12.50	.492	39.4	1.551	3	14	460.1-1250-038A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
12.50	.492	62.0	2.441	4	14	460.1-1250-063A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L
12.50	.492	101.9	4.012	8	14	460.1-1250-094A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT
12.60	.496	61.9	2.437	4	14	460.1-1260-063A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L
12.70	.500	40.0	1.575	3	14	460.1-1270-038A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
12.70	.500	61.8	2.433	4	14	460.1-1270-064A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L
12.70	.500	103.5	4.075	8	14	460.1-1270-095A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT
12.80	.504	40.3	1.587	3	14	460.1-1280-038A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
12.80	.504	61.6	2.425	4	14	460.1-1280-064A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L
12.80	.504	104.3	4.106	8	14	460.1-1280-096A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT
12.90	.508	61.5	2.421	4	14	460.1-1290-065A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L
13.00	.512	40.9	1.610	3	14	460.1-1300-039A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
13.00	.512	61.4	2.417	4	14	460.1-1300-065A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	20	290	DIN 6537 L
13.00	.512	105.9	4.169	8	14	460.1-1300-098A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.1	7.878	151	5.945	1.9	.075	20	290	COROMANT
13.10	.516	41.2	1.622	3	14	460.1-1310-039A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
13.10	.516	61.3	2.413	4	14	460.1-1310-066A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
13.10	.516	106.7	4.201	8	14	460.1-1310-098A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT
13.25	.522	61.1	2.406	4	14	460.1-1325-066A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
13.40	.528	60.9	2.398	4	14	460.1-1340-067A1-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L

Cutting data: www.sandvik.coromant.com

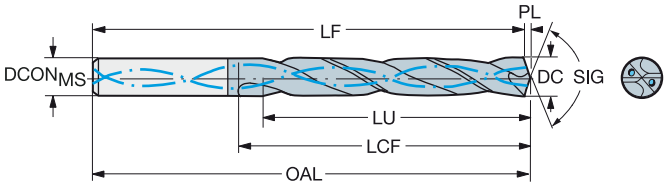
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



								P	M	K	N	S	H	Dimensions, mm, inch											
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code		GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
13.49	.531	42.5	1.673	3	14	460.1-1349-041A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
13.49	.531	60.8	2.394	4	14	460.1-1349-061A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
13.49	.531	110.0	4.331	8	14	460.1-1349-101A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT
13.50	.531	42.5	1.673	3	14	460.1-1350-041A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
13.50	.531	60.8	2.394	4	14	460.1-1350-061A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
13.50	.531	110.0	4.331	8	14	460.1-1350-101A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT
13.65	.537	60.6	2.386	4	14	460.1-1365-061A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
13.70	.539	111.6	4.394	8	14	460.1-1370-103A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	200.0	7.874	151	5.945	2.0	.079	20	290	COROMANT
13.80	.543	43.4	1.709	3	14	460.1-1380-041A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
13.80	.543	60.4	2.378	4	14	460.1-1380-062A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
13.89	.547	43.3	1.705	3	14	460.1-1389-042A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
13.89	.547	60.3	2.374	4	14	460.1-1389-063A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
14.00	.551	44.1	1.736	3	14	460.1-1400-042A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
14.00	.551	63.0	2.480	4	14	460.1-1400-063A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
14.00	.551	114.1	4.492	8	14	460.1-1400-105A1-XM		☆	☆	☆	☆	☆	☆	14.0	.551	202	7.953	199.9	7.870	151	5.945	2.1	.083	20	290	COROMANT
14.10	.555	68.9	2.713	4	16	460.1-1410-063A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L
14.20	.559	115.7	4.555	8	16	460.1-1420-107A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	20	290	COROMANT
14.25	.561	44.9	1.768	3	16	460.1-1425-043A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K
14.25	.561	68.8	2.709	4	16	460.1-1425-071A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L
14.25	.561	116.1	4.571	8	16	460.1-1425-107A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	20	290	COROMANT
14.29	.563	45.0	1.772	3	16	460.1-1429-043A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K
14.29	.563	68.7	2.705	4	16	460.1-1429-072A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L
14.29	.563	116.4	4.583	8	16	460.1-1429-107A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.9	8.854	172	6.772	2.1	.083	20	290	COROMANT
14.30	.563	68.7	2.705	4	16	460.1-1430-072A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	20	290	DIN 6537 L
14.50	.571	45.7	1.799	3	16	460.1-1450-044A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K
14.50	.571	68.5	2.697	4	16	460.1-1450-073A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L
14.50	.571	118.2	4.654	8	16	460.1-1450-109A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT
14.60	.575	68.4	2.693	4	16	460.1-1460-073A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L
14.68	.578	46.2	1.819	3	16	460.1-1468-044A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K
14.68	.578	68.3	2.689	4	16	460.1-1468-073A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L
14.70	.579	119.8	4.717	8	16	460.1-1470-110A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT
14.75	.581	68.3	2.689	4	16	460.1-1475-066A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L
14.80	.583	46.6	1.835	3	16	460.1-1480-044A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K
14.80	.583	68.2	2.685	4	16	460.1-1480-067A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L
15.00	.591	47.2	1.858	3	16	460.1-1500-045A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K
15.00	.591	68.0	2.677	4	16	460.1-1500-068A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L
15.00	.591	122.2	4.811	8	16	460.1-1500-113A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT
15.08	.594	47.5	1.870	3	16	460.1-1508-045A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	20	290	DIN 6537 K
15.08	.594	67.9	2.673	4	16	460.1-1508-068A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	20	290	DIN 6537 L
15.08	.594	122.9	4.839	8	16	460.1-1508-113A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.8	8.850	172	6.772	2.2	.087	20	290	COROMANT
15.10	.594	47.6	1.874	3	16	460.1-1510-045A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K
15.10	.594	67.9	2.673	4	16	460.1-1510-068A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
15.10	.594	123.1	4.846	8	16	460.1-1510-113A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	20	290	COROMANT
15.25	.600	67.8	2.669	4	16	460.1-1525-069A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
15.30	.602	67.7	2.665	4	16	460.1-1530-069A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
15.50	.610	48.8	1.921	3	16	460.1-1550-047A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K
15.50	.610	67.5	2.657	4	16	460.1-1550-070A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
15.50	.610	126.3	4.972	8	16	460.1-1550-116A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	20	290	COROMANT
15.60	.614	67.4	2.654	4	16	460.1-1560-070A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
15.70	.618	127.9	5.035	8	16	460.1-1570-118A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.7	8.846	172	6.772	2.3	.091	20	290	COROMANT
15.80	.622	49.2	1.937	3	16	460.1-1580-047A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	20	290	DIN 6537 K
15.80	.622	67.2	2.646	4	16	460.1-1580-071A1-XM		☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L

Cutting data: www.sandvik.coromant.com

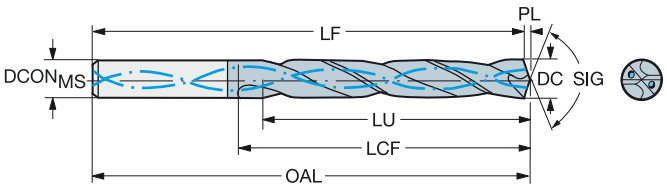
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch											
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
15.88	.625	49.1	1.933	3	16	460.1-1588-048A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	20	290	DIN 6537 K
15.88	.625	67.1	2.642	4	16	460.1-1588-071A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
15.88	.625	129.4	5.094	8	16	460.1-1588-119A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.6	8.843	172	6.772	2.4	.094	20	290	COROMANT
16.00	.630	49.0	1.929	3	16	460.1-1600-048A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	20	290	DIN 6537 K
16.00	.630	67.0	2.638	4	16	460.1-1600-072A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
16.00	.630	130.4	5.134	8	16	460.1-1600-120A1-XM	☆	☆	☆	☆	☆	☆	16.0	.630	227	8.937	224.6	8.843	172	6.772	2.4	.094	20	290	COROMANT
16.10	.634	76.9	3.028	4	18	460.1-1610-072A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	20	290	DIN 6537 L
16.27	.641	51.2	2.016	3	18	460.1-1627-049A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.6	4.748	73	2.874	2.4	.094	20	290	DIN 6537 K
16.27	.641	76.7	3.020	4	18	460.1-1627-081A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.6	5.535	93	3.661	2.4	.094	20	290	DIN 6537 L
16.50	.650	52.0	2.047	3	18	460.1-1650-050A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
16.50	.650	76.5	3.012	4	18	460.1-1650-074A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
16.67	.656	52.5	2.067	3	18	460.1-1667-050A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
16.67	.656	76.3	3.004	4	18	460.1-1667-075A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
16.80	.661	76.2	3.000	4	18	460.1-1680-076A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
17.00	.669	53.5	2.106	3	18	460.1-1700-051A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
17.00	.669	76.0	2.992	4	18	460.1-1700-077A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
17.00	.669	138.5	5.453	8	18	460.1-1700-128A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	246	9.685	243.5	9.587	194	7.638	2.5	.098	20	290	COROMANT
17.07	.672	53.7	2.114	3	18	460.1-1707-051A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	20	290	DIN 6537 K
17.07	.672	75.9	2.988	4	18	460.1-1707-077A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	20	290	DIN 6537 L
17.46	.687	75.5	2.972	4	18	460.1-1746-079A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	20	290	DIN 6537 L
17.50	.689	55.1	2.169	3	18	460.1-1750-053A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	20	290	DIN 6537 K
17.50	.689	75.5	2.972	4	18	460.1-1750-079A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	20	290	DIN 6537 L
17.50	.689	142.6	5.614	8	18	460.1-1750-131A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	246	9.685	243.4	9.583	194	7.638	2.6	.102	20	290	COROMANT
17.80	.701	75.2	2.961	4	18	460.1-1780-080A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L
17.86	.703	55.1	2.169	3	18	460.1-1786-054A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	20	290	DIN 6537 K
18.00	.709	56.7	2.232	3	18	460.1-1800-054A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	20	290	DIN 6537 K
18.00	.709	78.6	3.094	4	18	460.1-1800-081A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L
18.00	.709	146.7	5.776	8	18	460.1-1800-135A1-XM	☆	☆	☆	☆	☆	☆	18.0	.709	246	9.685	243.3	9.579	194	7.638	2.7	.106	20	290	COROMANT
18.26	.719	57.5	2.264	3	20	460.1-1826-055A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.3	5.051	79	3.110	2.7	.106	20	290	DIN 6537 K
18.26	.719	86.4	3.402	4	20	460.1-1826-082A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.3	5.917	101	3.976	2.7	.106	20	290	DIN 6537 L
18.50	.728	58.3	2.295	3	20	460.1-1850-056A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
18.50	.728	86.2	3.394	4	20	460.1-1850-083A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
18.65	.734	58.7	2.311	3	20	460.1-1865-056A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
18.65	.734	86.1	3.390	4	20	460.1-1865-084A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
18.80	.740	59.2	2.331	3	20	460.1-1880-056A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
19.00	.748	59.8	2.354	3	20	460.1-1900-057A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
19.00	.748	85.8	3.378	4	20	460.1-1900-086A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
19.00	.748	154.8	6.094	8	20	460.1-1900-143A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	269	10.591	266.2	10.480	215	8.465	2.8	.110	20	290	COROMANT
19.05	.750	60.0	2.362	3	20	460.1-1905-057A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	20	290	DIN 6537 K
19.05	.750	85.8	3.378	4	20	460.1-1905-086A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	20	290	DIN 6537 L
19.25	.758	85.6	3.370	4	20	460.1-1925-087A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	20	290	DIN 6537 L
19.50	.768	61.4	2.417	3	20	460.1-1950-059A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K
19.50	.768	85.4	3.362	4	20	460.1-1950-088A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	20	290	DIN 6537 L
19.50	.768	158.9	6.256	8	20	460.1-1950-146A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	269	10.591	266.1	10.476	215	8.465	2.9	.114	20	290	COROMANT
19.80	.780	62.4	2.457	3	20	460.1-1980-059A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	20	290	DIN 6537 K
19.80	.780	85.2	3.354	4	20	460.1-1980-089A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	20	290	DIN 6537 L
20.00	.787	63.0	2.480	3	20	460.1-2000-060A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	20	290	DIN 6537 K
20.00	.787	85.0	3.346	4	20	460.1-2000-090A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	20	290	DIN 6537 L
20.00	.787	163.0	6.417	8	20	460.1-2000-150A1-XM	☆	☆	☆	☆	☆	☆	20.0	.787	269	10.591	266.0	10.472	215	8.465	3.0	.118	20	290	COROMANT

Cutting data: www.sandvik.coromant.com

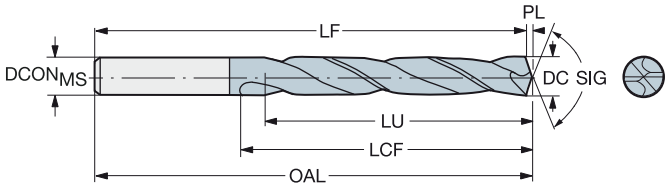
E9 E28 E14

CoroDrill® 460 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch									
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
3.00	.118	9.4	.370	3	6	460.1-0300-009A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K
3.00	.118	15.4	.606	5	6	460.1-0300-015A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L
3.10	.122	9.7	.382	3	6	460.1-0310-009A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	DIN 6537 K
3.10	.122	15.9	.626	5	6	460.1-0310-016A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.6	2.583	28	1.102	0.4	.016	DIN 6537 L
3.18	.125	10.0	.394	3	6	460.1-0318-010A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.18	.125	16.3	.642	5	6	460.1-0318-016A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.20	.126	10.1	.398	3	6	460.1-0320-010A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.20	.126	16.5	.650	5	6	460.1-0320-016A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.30	.130	10.4	.409	3	6	460.1-0330-010A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.30	.130	17.0	.669	5	6	460.1-0330-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.40	.134	10.7	.421	3	6	460.1-0340-010A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.40	.134	17.5	.689	5	6	460.1-0340-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.50	.138	11.0	.433	3	6	460.1-0350-011A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.50	.138	18.0	.709	5	6	460.1-0350-018A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.57	.141	11.2	.441	3	6	460.1-0357-011A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.60	.142	11.3	.445	3	6	460.1-0360-011A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.70	.146	11.6	.457	3	6	460.1-0370-011A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	DIN 6537 K
3.70	.146	19.0	.748	5	6	460.1-0370-019A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	DIN 6537 L
3.80	.150	11.9	.469	3	6	460.1-0380-011A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	DIN 6537 K
3.80	.150	19.5	.768	5	6	460.1-0380-019A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.5	2.894	36	1.417	0.5	.020	DIN 6537 L
3.90	.154	12.3	.484	3	6	460.1-0390-012A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
3.97	.156	12.5	.492	3	6	460.1-0397-012A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
3.97	.156	20.4	.803	5	6	460.1-0397-020A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.00	.157	12.6	.496	3	6	460.1-0400-012A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.00	.157	20.6	.811	5	6	460.1-0400-020A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.10	.161	12.9	.508	3	6	460.1-0410-012A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.10	.161	21.1	.831	5	6	460.1-0410-021A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.20	.165	13.2	.520	3	6	460.1-0420-013A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.20	.165	21.6	.850	5	6	460.1-0420-021A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.30	.169	13.5	.531	3	6	460.1-0430-013A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.30	.169	22.1	.870	5	6	460.1-0430-022A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.37	.172	13.7	.539	3	6	460.1-0437-013A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.37	.172	22.5	.886	5	6	460.1-0437-022A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.40	.173	13.8	.543	3	6	460.1-0440-013A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	DIN 6537 K
4.40	.173	22.6	.890	5	6	460.1-0440-022A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	DIN 6537 L
4.50	.177	14.2	.559	3	6	460.1-0450-014A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.50	.177	23.2	.913	5	6	460.1-0450-023A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.60	.181	14.5	.571	3	6	460.1-0460-014A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.60	.181	23.7	.933	5	6	460.1-0460-023A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.70	.185	14.6	.575	3	6	460.1-0470-014A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	DIN 6537 K
4.70	.185	24.2	.953	5	6	460.1-0470-024A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	DIN 6537 L
4.76	.187	15.0	.591	3	6	460.1-0476-014A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.76	.187	24.5	.965	5	6	460.1-0476-024A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.80	.189	15.1	.594	3	6	460.1-0480-014A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.80	.189	24.7	.972	5	6	460.1-0480-024A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
4.90	.193	15.4	.606	3	6	460.1-0490-015A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
4.90	.193	25.2	.992	5	6	460.1-0490-025A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.00	.197	15.7	.618	3	6	460.1-0500-015A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
5.00	.197	25.7	1.012	5	6	460.1-0500-025A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L
5.10	.201	16.0	.630	3	6	460.1-0510-015A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	DIN 6537 K
5.10	.201	26.2	1.032	5	6	460.1-0510-026A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.3	3.201	44	1.732	0.7	.028	DIN 6537 L

Cutting data: www.sandvik.coromant.com

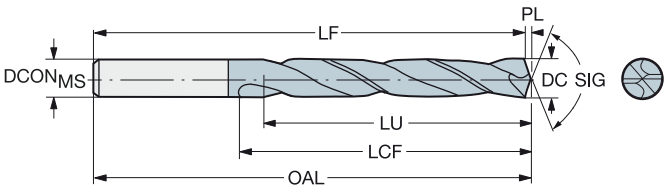
E9 E14

CoroDrill® 460 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch									
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
5.16	.203	16.2	.638	3	6	460.1-0516-016A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.16	.203	26.5	1.043	5	6	460.1-0516-026A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.20	.205	16.4	.646	3	6	460.1-0520-016A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.20	.205	26.8	1.055	5	6	460.1-0520-026A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.50	.217	17.3	.681	3	6	460.1-0550-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.50	.217	28.3	1.114	5	6	460.1-0550-028A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.56	.219	17.5	.689	3	6	460.1-0556-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.56	.219	28.6	1.126	5	6	460.1-0556-028A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.60	.220	17.6	.693	3	6	460.1-0560-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	DIN 6537 K
5.60	.220	28.8	1.134	5	6	460.1-0560-028A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	DIN 6537 L
5.80	.228	17.6	.693	3	6	460.1-0580-017A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
5.80	.228	29.9	1.177	5	6	460.1-0580-029A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
5.95	.234	17.3	.681	2	6	460.1-0595-018A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
5.95	.234	30.6	1.205	5	6	460.1-0595-030A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
6.00	.236	18.9	.744	3	6	460.1-0600-018A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	DIN 6537 K
6.00	.236	30.9	1.217	5	6	460.1-0600-030A0-XM	☆	☆	☆	☆	☆	☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	DIN 6537 L
6.10	.240	19.2	.756	3	8	460.1-0610-018A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.10	.240	31.4	1.236	5	8	460.1-0610-031A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.20	.244	19.5	.768	3	8	460.1-0620-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.20	.244	31.9	1.256	5	8	460.1-0620-031A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.30	.248	19.8	.780	3	8	460.1-0630-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.35	.250	20.0	.787	3	8	460.1-0635-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.35	.250	32.7	1.287	5	8	460.1-0635-032A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.1	3.547	53	2.087	0.9	.035	DIN 6537 L
6.40	.252	20.1	.791	3	8	460.1-0640-019A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	DIN 6537 K
6.50	.256	20.5	.807	3	8	460.1-0650-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.50	.256	33.5	1.319	5	8	460.1-0650-033A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.60	.260	20.8	.819	3	8	460.1-0660-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.60	.260	34.0	1.339	5	8	460.1-0660-033A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.70	.264	21.1	.831	3	8	460.1-0670-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.70	.264	34.5	1.358	5	8	460.1-0670-034A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.75	.266	21.2	.835	3	8	460.1-0675-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.75	.266	34.7	1.366	5	8	460.1-0675-034A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.80	.268	21.4	.843	3	8	460.1-0680-020A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.80	.268	35.0	1.378	5	8	460.1-0680-034A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
6.90	.272	21.7	.854	3	8	460.1-0690-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
6.90	.272	35.5	1.398	5	8	460.1-0690-035A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.00	.276	22.0	.866	3	8	460.1-0700-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	DIN 6537 K
7.00	.276	36.0	1.417	5	8	460.1-0700-035A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	DIN 6537 L
7.10	.280	22.3	.878	3	8	460.1-0710-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	DIN 6537 K
7.14	.281	22.5	.886	3	8	460.1-0714-021A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.14	.281	36.8	1.449	5	8	460.1-0714-036A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.30	.287	23.0	.906	3	8	460.1-0730-022A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.30	.287	37.6	1.480	5	8	460.1-0730-037A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.40	.291	23.3	.917	3	8	460.1-0740-022A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.40	.291	38.1	1.500	5	8	460.1-0740-037A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.50	.295	23.6	.929	3	8	460.1-0750-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.50	.295	38.6	1.520	5	8	460.1-0750-038A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.54	.297	23.7	.933	3	8	460.1-0754-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.54	.297	38.8	1.528	5	8	460.1-0754-038A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	DIN 6537 L
7.70	.303	24.2	.953	3	8	460.1-0770-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	DIN 6537 K
7.80	.307	24.6	.969	3	8	460.1-0780-023A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.80	.307	40.2	1.583	5	8	460.1-0780-039A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L

Cutting data: www.sandvik.coromant.com

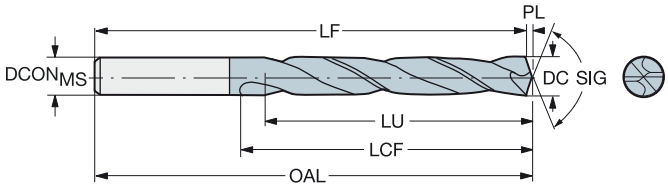
E9 E14

CoroDrill® 460 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°



													Dimensions, mm, inch								
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
7.90	.311	24.9	.980	3	8	460.1-0790-024A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.90	.311	40.7	1.602	5	8	460.1-0790-040A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
7.94	.313	25.0	.984	3	8	460.1-0794-024A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
7.94	.313	40.9	1.610	5	8	460.1-0794-040A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
8.00	.315	25.2	.992	3	8	460.1-0800-024A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	DIN 6537 K
8.00	.315	41.2	1.622	5	8	460.1-0800-040A0-XM	☆	☆	☆	☆	☆	☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	DIN 6537 L
8.10	.319	25.5	1.004	3	10	460.1-0810-024A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.10	.319	41.7	1.642	5	10	460.1-0810-041A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.20	.323	25.8	1.016	3	10	460.1-0820-025A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.20	.323	42.2	1.661	5	10	460.1-0820-041A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.33	.328	26.2	1.032	3	10	460.1-0833-025A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.40	.331	26.4	1.039	3	10	460.1-0840-025A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	DIN 6537 K
8.40	.331	43.2	1.701	5	10	460.1-0840-042A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.8	4.008	61	2.402	1.2	.047	DIN 6537 L
8.50	.335	26.8	1.055	3	10	460.1-0850-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.50	.335	43.8	1.724	5	10	460.1-0850-043A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.60	.339	27.1	1.067	3	10	460.1-0860-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.60	.339	44.3	1.744	5	10	460.1-0860-043A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.70	.343	27.4	1.079	3	10	460.1-0870-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.70	.343	44.8	1.764	5	10	460.1-0870-044A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.73	.344	27.5	1.083	3	10	460.1-0873-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.73	.344	44.9	1.768	5	10	460.1-0873-044A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.80	.346	27.7	1.091	3	10	460.1-0880-026A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
8.80	.346	45.3	1.783	5	10	460.1-0880-044A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
8.90	.350	45.8	1.803	5	10	460.1-0890-045A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.00	.354	28.3	1.114	3	10	460.1-0900-027A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	DIN 6537 K
9.00	.354	46.3	1.823	5	10	460.1-0900-045A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.10	.358	46.8	1.843	5	10	460.1-0910-046A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	DIN 6537 L
9.30	.366	29.3	1.154	3	10	460.1-0930-028A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.30	.366	47.9	1.886	5	10	460.1-0930-047A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.40	.370	29.6	1.165	3	10	460.1-0940-028A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.40	.370	48.4	1.906	5	10	460.1-0940-047A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.50	.374	29.9	1.177	3	10	460.1-0950-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.50	.374	48.7	1.917	5	10	460.1-0950-048A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.53	.375	30.0	1.181	3	10	460.1-0953-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.53	.375	48.6	1.913	5	10	460.1-0953-048A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.60	.378	30.2	1.189	3	10	460.1-0960-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.60	.378	48.5	1.909	5	10	460.1-0960-048A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.70	.382	30.5	1.201	3	10	460.1-0970-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	DIN 6537 K
9.70	.382	48.4	1.906	4	10	460.1-0970-049A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	DIN 6537 L
9.80	.386	30.9	1.217	3	10	460.1-0980-029A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
9.80	.386	48.3	1.902	4	10	460.1-0980-049A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
9.92	.391	48.1	1.894	4	10	460.1-0992-050A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
10.00	.394	31.5	1.240	3	10	460.1-1000-030A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	DIN 6537 K
10.00	.394	48.0	1.890	4	10	460.1-1000-050A0-XM	☆	☆	☆	☆	☆	☆	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	DIN 6537 L
10.10	.398	31.8	1.252	3	12	460.1-1010-030A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.10	.398	52.0	2.047	5	12	460.1-1010-051A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.20	.402	32.1	1.264	3	12	460.1-1020-031A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.20	.402	52.5	2.067	5	12	460.1-1020-051A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.30	.406	32.4	1.276	3	12	460.1-1030-031A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.30	.406	53.0	2.087	5	12	460.1-1030-052A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.32	.406	53.1	2.091	5	12	460.1-1032-052A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L

Cutting data: www.sandvik.coromant.com

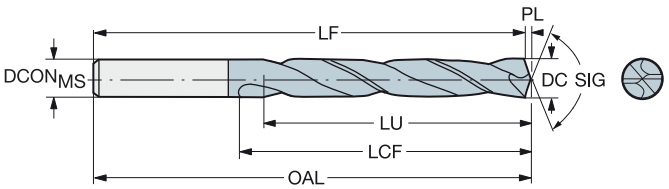
E9 E14

CoroDrill® 460 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch									
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
10.40	.409	32.7	1.287	3	12	460.1-1040-031A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	DIN 6537 K
10.40	.409	53.5	2.106	5	12	460.1-1040-052A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.5	4.587	71	2.795	1.5	.059	DIN 6537 L
10.50	.413	33.1	1.303	3	12	460.1-1050-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.50	.413	54.1	2.130	5	12	460.1-1050-053A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.60	.417	33.4	1.315	3	12	460.1-1060-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.72	.422	33.7	1.327	3	12	460.1-1072-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
10.72	.422	55.2	2.173	5	12	460.1-1072-054A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
10.80	.425	34.0	1.339	3	12	460.1-1080-032A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
11.00	.433	34.6	1.362	3	12	460.1-1100-033A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	DIN 6537 K
11.00	.433	56.6	2.228	5	12	460.1-1100-055A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	DIN 6537 L
11.11	.437	35.0	1.378	3	12	460.1-1111-033A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.11	.437	57.2	2.252	5	12	460.1-1111-056A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.20	.441	35.3	1.390	3	12	460.1-1120-034A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.20	.441	57.6	2.268	5	12	460.1-1120-056A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.40	.449	35.9	1.413	3	12	460.1-1140-034A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.40	.449	57.3	2.256	5	12	460.1-1140-057A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.50	.453	36.2	1.425	3	12	460.1-1150-035A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.50	.453	57.2	2.252	4	12	460.1-1150-058A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.60	.457	36.5	1.437	3	12	460.1-1160-035A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	DIN 6537 K
11.60	.457	57.1	2.248	4	12	460.1-1160-058A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	DIN 6537 L
11.80	.465	37.2	1.465	3	12	460.1-1180-035A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
11.80	.465	56.8	2.236	4	12	460.1-1180-059A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
11.91	.469	56.7	2.232	4	12	460.1-1191-060A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
12.00	.472	37.8	1.488	3	12	460.1-1200-036A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	DIN 6537 K
12.00	.472	56.6	2.228	4	12	460.1-1200-060A0-XM	☆	☆	☆	☆	☆	☆	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	DIN 6537 L
12.10	.476	38.1	1.500	3	14	460.1-1210-036A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.10	.476	62.3	2.453	5	14	460.1-1210-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.20	.480	38.4	1.512	3	14	460.1-1220-037A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.20	.480	62.4	2.457	5	14	460.1-1220-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.2	4.811	77	3.032	1.8	.071	DIN 6537 L
12.30	.484	38.7	1.524	3	14	460.1-1230-037A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	DIN 6537 K
12.50	.492	39.4	1.551	3	14	460.1-1250-038A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.50	.492	62.0	2.441	4	14	460.1-1250-063A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.70	.500	40.0	1.575	3	14	460.1-1270-038A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.70	.500	61.8	2.433	4	14	460.1-1270-064A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
12.80	.504	40.3	1.587	3	14	460.1-1280-038A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
12.80	.504	61.6	2.425	4	14	460.1-1280-064A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
13.00	.512	40.9	1.610	3	14	460.1-1300-039A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	DIN 6537 K
13.00	.512	61.4	2.417	4	14	460.1-1300-065A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.1	4.807	77	3.032	1.9	.075	DIN 6537 L
13.10	.516	41.2	1.622	3	14	460.1-1310-039A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.10	.516	61.3	2.413	4	14	460.1-1310-066A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.49	.531	42.5	1.673	3	14	460.1-1349-041A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.49	.531	60.8	2.394	4	14	460.1-1349-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.50	.531	42.5	1.673	3	14	460.1-1350-041A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	DIN 6537 K
13.50	.531	60.8	2.394	4	14	460.1-1350-061A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	DIN 6537 L
13.80	.543	43.4	1.709	3	14	460.1-1380-041A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
14.00	.551	44.1	1.736	3	14	460.1-1400-042A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	DIN 6537 K
14.00	.551	63.0	2.480	4	14	460.1-1400-063A0-XM	☆	☆	☆	☆	☆	☆	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	DIN 6537 L
14.25	.561	44.9	1.768	3	16	460.1-1425-043A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K
14.25	.561	68.8	2.709	4	16	460.1-1425-071A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L
14.29	.563	45.0	1.772	3	16	460.1-1429-043A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	DIN 6537 K
14.29	.563	68.7	2.705	4	16	460.1-1429-072A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.9	5.154	83	3.268	2.1	.083	DIN 6537 L

Cutting data: www.sandvik.coromant.com

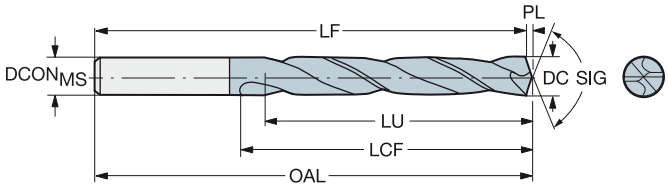
E9 E14

CoroDrill® 460 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°



							P	M	K	N	S	H	Dimensions, mm, inch										
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
14.50	.571	45.7	1.799	3	16	460.1-1450-044A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.50	.571	68.5	2.697	4	16	460.1-1450-073A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
14.68	.578	46.2	1.819	3	16	460.1-1468-044A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
14.80	.583	46.6	1.835	3	16	460.1-1480-044A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
15.00	.591	47.2	1.858	3	16	460.1-1500-045A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.8	4.441	65	2.559	2.2	.087	DIN 6537 K
15.00	.591	68.0	2.677	4	16	460.1-1500-068A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.8	5.150	83	3.268	2.2	.087	DIN 6537 L
15.10	.594	47.6	1.874	3	16	460.1-1510-045A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.50	.610	48.8	1.921	3	16	460.1-1550-047A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	DIN 6537 K
15.50	.610	67.5	2.657	4	16	460.1-1550-070A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	DIN 6537 L
15.80	.622	49.2	1.937	3	16	460.1-1580-047A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
15.80	.622	67.2	2.646	4	16	460.1-1580-071A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
15.88	.625	49.1	1.933	3	16	460.1-1588-047A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
16.00	.630	49.0	1.929	3	16	460.1-1600-048A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	DIN 6537 K
16.00	.630	67.0	2.638	4	16	460.1-1600-072A0-XM	☆	☆	☆	☆	☆	☆	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	DIN 6537 L
16.27	.641	51.2	2.016	3	18	460.1-1627-049A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.6	4.748	73	2.874	2.4	.094	DIN 6537 K
16.50	.650	52.0	2.047	3	18	460.1-1650-050A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.50	.650	76.5	3.012	4	18	460.1-1650-074A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
16.67	.656	52.5	2.067	3	18	460.1-1667-050A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
16.67	.656	76.3	3.004	4	18	460.1-1667-075A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.00	.669	53.5	2.106	3	18	460.1-1700-051A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.00	.669	76.0	2.992	4	18	460.1-1700-077A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.5	5.532	93	3.661	2.5	.098	DIN 6537 L
17.07	.672	53.7	2.114	3	18	460.1-1707-051A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.5	4.744	73	2.874	2.5	.098	DIN 6537 K
17.46	.687	75.5	2.972	4	18	460.1-1746-079A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.50	.689	55.1	2.169	3	18	460.1-1750-053A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	DIN 6537 K
17.50	.689	75.5	2.972	4	18	460.1-1750-079A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	DIN 6537 L
17.80	.701	55.2	2.173	3	18	460.1-1780-053A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
18.00	.709	56.7	2.232	3	18	460.1-1800-054A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	DIN 6537 K
18.00	.709	78.6	3.094	4	18	460.1-1800-081A0-XM	☆	☆	☆	☆	☆	☆	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	DIN 6537 L
18.50	.728	58.3	2.295	3	20	460.1-1850-056A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.00	.748	59.8	2.354	3	20	460.1-1900-057A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.2	5.047	79	3.110	2.8	.110	DIN 6537 K
19.00	.748	85.8	3.378	4	20	460.1-1900-086A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.2	5.913	101	3.976	2.8	.110	DIN 6537 L
19.50	.768	61.4	2.417	3	20	460.1-1950-059A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	DIN 6537 K
19.50	.768	85.4	3.362	4	20	460.1-1950-088A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	DIN 6537 L
19.80	.780	85.2	3.354	4	20	460.1-1980-089A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L
20.00	.787	63.0	2.480	3	20	460.1-2000-060A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	131	5.157	128.0	5.039	79	3.110	3.0	.118	DIN 6537 K
20.00	.787	85.0	3.346	4	20	460.1-2000-090A0-XM	☆	☆	☆	☆	☆	☆	20.0	.787	153	6.024	150.0	5.906	101	3.976	3.0	.118	DIN 6537 L

Cutting data: www.sandvik.coromant.com

E9 E14

CoroDrill® 860-GM

High performance drills optimized for multi-materials

Application

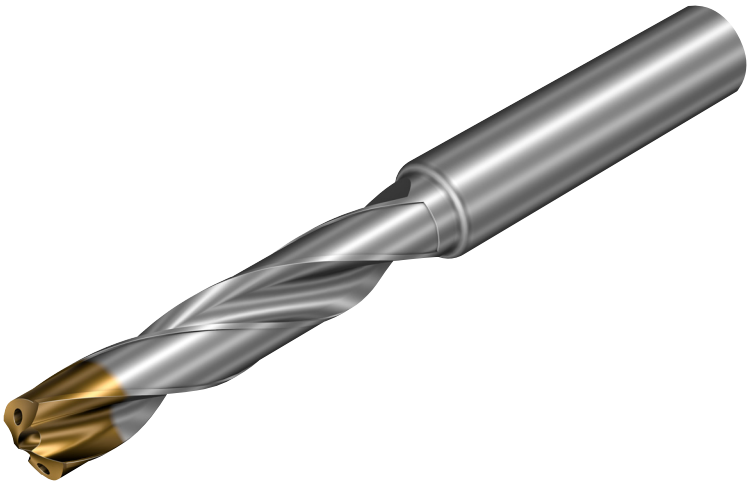
- For a wide range of materials in all industry segments, e.g., general machining, die and mold, automotive, energy and power generation
- Internal and external coolant

O C

B

ISO application area:

P M K N S H



Features and benefits

- Polished flutes for efficient chip evacuation
- High productivity and consistent tool life
- Exceptional value with no compromise on quality
- Excellent hole quality
- High penetration rate
- Low cutting forces

C

www.sandvik.coromant.com/corodrill860

D

Recommendations

It is recommended to use hydraulic precision chucks.
It is recommended to use internal coolant, minimum recommended pressure 20 bar

For chucks, see our Rotating Tools catalog.

E

E14

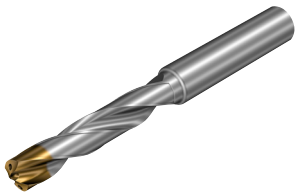
SANDVIK Coromant

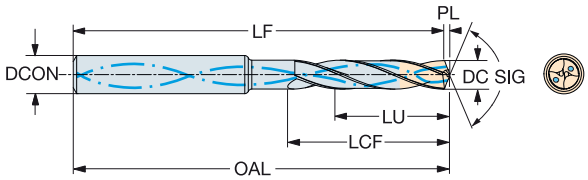
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°





							P	M	K	N	S	H	Dimensions, mm, inch								
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.00	.118	24.5	.965	8	6	860.1-0300-024A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016
3.10	.122	9.8	.386	3	6	860.1-0310-009A1-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.10	.122	16.0	.630	5	6	860.1-0310-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.10	.122	25.3	.996	8	6	860.1-0310-025A1-GM	★	★		☆	☆	★	6.0	.236	79	3.110	78.6	3.094	37	1.457	0.4	.016
3.17	.125	10.0	.394	3	6	860.1-0317-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.17	.125	16.4	.646	5	6	860.1-0317-016A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.18	.125	26.0	1.024	8	6	860.1-0318-026A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.20	.126	10.1	.398	3	6	860.1-0320-010A1-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.20	.126	16.5	.650	5	6	860.1-0320-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.20	.126	26.1	1.028	8	6	860.1-0320-026A1-GM	★	★		☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.30	.130	10.5	.413	3	6	860.1-0330-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.30	.130	17.1	.673	5	6	860.1-0330-017A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.30	.130	27.0	1.063	8	6	860.1-0330-027A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.40	.134	10.8	.425	3	6	860.1-0340-010A1-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.40	.134	17.6	.693	5	6	860.1-0340-017A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.40	.134	27.8	1.094	8	6	860.1-0340-027A1-GM	★	★		☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.45	.136	11.0	.433	3	6	860.1-0345-010A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.45	.136	17.8	.701	5	6	860.1-0345-017A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	28.6	1.126	8	6	860.1-0350-028A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.57	.141	11.3	.445	3	6	860.1-0357-011A1-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.57	.141	18.5	.728	5	6	860.1-0357-018A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.57	.141	29.2	1.150	8	6	860.1-0357-028A1-GM	★	★		☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.60	.142	11.4	.449	3	6	860.1-0360-011A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.60	.142	18.6	.732	5	6	860.1-0360-018A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	11.7	.461	3	6	860.1-0370-011A1-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.70	.146	19.1	.752	5	6	860.1-0370-019A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	30.2	1.189	8	6	860.1-0370-028A1-GM	★	★	★	☆	☆	★	6.0	.236	79	3.110	78.5	3.091	37	1.457	0.5	.020
3.80	.150	12.0	.472	3	6	860.1-0380-012A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024
3.80	.150	19.6	.772	5	6	860.1-0380-019A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024
3.80	.150	31.0	1.220	8	6	860.1-0380-031A1-GM	★	★		☆	☆	★	6.0	.236	90	3.543	89.5	3.524	48	1.890	0.5	.020
3.90	.154	12.4	.488	3	6	860.1-0390-012A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
3.90	.154	20.2	.795	5	6	860.1-0390-020A1-GM	★	★		☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
3.97	.156	20.5	.807	5	6	860.1-0397-020A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
3.97	.156	32.4	1.276	8	6	860.1-0397-032A1-GM	★	★		☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-GM	★	★		☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.00	.157	32.7	1.287	8	6	860.1-0400-032A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.10	.161	13.0	.512	3	6	860.1-0410-013A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.10	.161	21.2	.835	5	6	860.1-0410-021A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.10	.161	33.5	1.319	8	6	860.1-0410-033A1-GM	★	★		☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.20	.165	13.3	.524	3	6	860.1-0420-013A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.20	.165	21.7	.854	5	6	860.1-0420-021A1-GM	★	★		☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.20	.165	34.3	1.350	8	6	860.1-0420-034A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.30	.169	13.6	.535	3	6	860.1-0430-013A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.30	.169	22.2	.874	5	6	860.1-0430-022A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.30	.169	35.1	1.382	8	6	860.1-0430-035A1-GM	★	★		☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.36	.172	13.8	.543	3	6	860.1-0436-013A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.36	.172	22.5	.886	5	6	860.1-0436-022A1-GM	★	★		☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.37	.172	35.7	1.406	8	6	860.1-0437-035A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.4	3.520	48	1.890	0.6	.024
4.40	.173	14.0	.551	3	6	860.1-0440-014A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.40	.173	22.8	.898	5	6	860.1-0440-022A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.50	.177	14.3	.563	3	6	860.1-0450-014A1-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.50	.177	23.3	.917	5	6	860.1-0450-023A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.50	.177	36.8	1.449	8	6	860.1-0450-036A1-GM	★	★		☆	☆	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028

B76 E9 E28 E14

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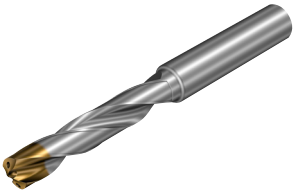
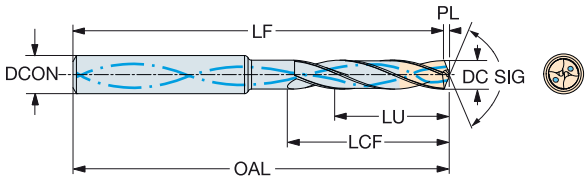
Internal coolant supply

TCHA H9
SIG 140°





DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	P	M	K	N	S	H	Dimensions, mm, inch DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
							X1BM	X1BM	X1BM	X1BM	X1BM	X1BM										
4.55	.179	14.4	.567	3	6	860.1-0455-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.60	.181	14.6	.575	3	6	860.1-0460-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.60	.181	37.6	1.480	8	6	860.1-0460-037A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028
4.70	.185	14.9	.587	3	6	860.1-0470-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.70	.185	24.3	.957	5	6	860.1-0470-024A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.70	.185	38.4	1.512	8	6	860.1-0470-038A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.3	3.516	48	1.890	0.7	.028
4.76	.187	15.1	.594	3	6	860.1-0476-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.76	.187	24.6	.969	5	6	860.1-0476-024A1-GM	★	★	★	☆	☆	★	6.0	.236	74	2.913	73.2	2.882	44	1.732	0.8	.031
4.76	.187	38.9	1.532	8	6	860.1-0476-038A1-GM	★	★	★	☆	☆	★	6.0	.236	90	3.543	89.3	3.516	62	2.441	0.7	.028
4.80	.189	15.2	.598	3	6	860.1-0480-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.80	.189	24.8	.976	5	6	860.1-0480-024A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
4.80	.189	39.2	1.543	8	6	860.1-0480-039A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.3	4.067	62	2.441	0.7	.028
4.90	.193	15.5	.610	3	6	860.1-0490-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.90	.193	25.3	.996	5	6	860.1-0490-025A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.00	.197	15.9	.626	3	6	860.1-0500-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	25.9	1.020	5	6	860.1-0500-025A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.00	.197	40.9	1.610	8	6	860.1-0500-040A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.2	4.063	62	2.441	0.8	.031
5.10	.201	16.2	.638	3	6	860.1-0510-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.10	.201	26.4	1.039	5	6	860.1-0510-026A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.10	.201	41.7	1.642	8	6	860.1-0510-041A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.16	.203	16.4	.646	3	6	860.1-0516-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.16	.203	26.7	1.051	5	6	860.1-0516-026A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.20	.205	26.9	1.059	5	6	860.1-0520-026A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	42.5	1.673	8	6	860.1-0520-042A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.25	.207	27.4	1.079	5	6	860.1-0525-027A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	16.8	.661	3	6	860.1-0530-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.30	.209	27.4	1.079	5	6	860.1-0530-027A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	43.3	1.705	8	6	860.1-0530-043A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.40	.213	17.1	.673	3	6	860.1-0540-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.40	.213	28.0	1.102	5	6	860.1-0540-027A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.40	.213	44.1	1.736	8	6	860.1-0540-044A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.50	.217	17.5	.689	3	6	860.1-0550-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	28.5	1.122	5	6	860.1-0550-028A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.50	.217	45.4	1.787	8	6	860.1-0550-045A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.55	.219	28.8	1.134	5	6	860.1-0555-028A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.56	.219	17.6	.693	3	6	860.1-0556-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.56	.219	28.8	1.134	5	6	860.1-0556-028A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.56	.219	45.4	1.787	8	6	860.1-0556-045A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.1	4.059	62	2.441	0.9	.035
5.60	.220	17.8	.701	3	6	860.1-0560-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.60	.220	29.0	1.142	5	6	860.1-0560-029A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
5.60	.220	45.8	1.803	8	6	860.1-0560-045A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.70	.224	18.1	.713	3	6	860.1-0570-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.70	.224	29.5	1.161	5	6	860.1-0570-029A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
5.70	.224	46.6	1.835	8	6	860.1-0570-046A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.80	.228	18.4	.724	3	6	860.1-0580-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.80	.228	30.0	1.181	5	6	860.1-0580-030A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	80.9	3.187	44	1.732	1.1	.042
5.80	.228	47.4	1.866	8	6	860.1-0580-047A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.90	.232	18.7	.736	3	6	860.1-0590-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.90	.232	48.2	1.898	8	6	860.1-0590-048A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039
5.95	.234	18.9	.744	3	6	860.1-0595-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	64.9	2.556	28	1.102	1.1	.043
6.00	.236	19.0	.748	3	6	860.1-0600-016A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	64.9	2.555	28	1.102	1.1	.043
6.00	.236	31.0	1.220	5	6	860.1-0600-031A1-GM	★	★	★	☆	☆	★	6.0	.236	82	3.228	80.9	3.185	44	1.732	1.1	.043
6.00	.236	49.0	1.929	8	6	860.1-0600-049A1-GM	★	★	★	☆	☆	★	6.0	.236	104	4.094	103.0	4.055	62	2.441	1.0	.039

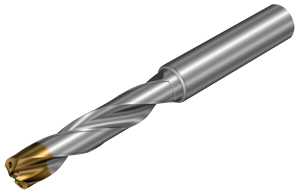
B76 E9 E28 E14

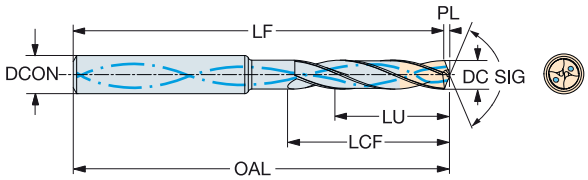
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°





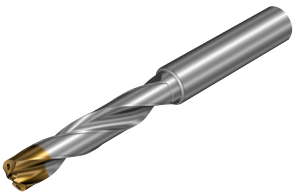
							P	M	K	N	S	H	Dimensions, mm, inch								
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
6.10	.240	19.4	.764	3	8	860.1-0610-019A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.044
6.10	.240	31.6	1.244	5	8	860.1-0610-031A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.044
6.10	.240	49.9	1.965	8	8	860.1-0610-049A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	125.0	4.921	84	3.307	1.0	.039
6.20	.244	19.7	.776	3	8	860.1-0620-019A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.9	3.066	34	1.339	1.1	.044
6.20	.244	32.1	1.264	5	8	860.1-0620-032A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.9	3.538	53	2.087	1.1	.044
6.20	.244	50.7	1.996	8	8	860.1-0620-050A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043
6.30	.248	20.0	.787	3	8	860.1-0630-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.065	34	1.339	1.1	.045
6.30	.248	32.6	1.283	5	8	860.1-0630-032A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.9	3.538	53	2.087	1.1	.045
6.30	.248	51.5	2.028	8	8	860.1-0630-051A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043
6.35	.250	20.2	.795	3	8	860.1-0635-020A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.8	3.065	34	1.339	1.2	.045
6.35	.250	32.9	1.295	5	8	860.1-0635-032A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.2	.045
6.35	.250	52.0	2.047	8	8	860.1-0635-051A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043
6.40	.252	20.3	.799	3	8	860.1-0640-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.064	34	1.339	1.2	.046
6.40	.252	33.1	1.303	5	8	860.1-0640-033A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.8	3.537	53	2.087	1.2	.046
6.40	.252	52.3	2.059	8	8	860.1-0640-052A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043
6.50	.256	20.6	.811	3	8	860.1-0650-020A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.8	3.064	34	1.339	1.2	.047
6.50	.256	33.6	1.323	5	8	860.1-0650-033A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.536	53	2.087	1.2	.047
6.50	.256	53.1	2.091	8	8	860.1-0650-053A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043
6.60	.260	21.0	.827	3	8	860.1-0660-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.047
6.60	.260	34.2	1.346	5	8	860.1-0660-034A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
6.60	.260	54.0	2.126	8	8	860.1-0660-054A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043
6.70	.264	21.3	.839	3	8	860.1-0670-020A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.8	3.062	34	1.339	1.2	.048
6.70	.264	34.7	1.366	5	8	860.1-0670-034A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.048
6.70	.264	54.8	2.157	8	8	860.1-0670-054A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.9	4.917	84	3.307	1.1	.043
6.75	.266	21.4	.843	3	8	860.1-0675-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.062	34	1.339	1.2	.048
6.75	.266	35.0	1.378	5	8	860.1-0675-034A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.8	3.534	53	2.087	1.2	.048
6.80	.268	21.6	.850	3	8	860.1-0680-020A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.062	34	1.339	1.2	.049
6.80	.268	35.2	1.386	5	8	860.1-0680-035A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.8	3.534	53	2.087	1.2	.049
6.80	.268	55.6	2.189	8	8	860.1-0680-055A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047
6.90	.272	21.9	.862	3	8	860.1-0690-020A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.7	3.061	34	1.339	1.3	.049
6.90	.272	35.7	1.406	5	8	860.1-0690-035A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.7	3.533	53	2.087	1.3	.049
6.90	.272	56.4	2.220	8	8	860.1-0690-056A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047
7.00	.276	22.2	.874	3	8	860.1-0700-022A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.060	41	1.614	1.3	.050
7.00	.276	36.2	1.425	5	8	860.1-0700-036A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.7	3.533	53	2.087	1.3	.050
7.00	.276	57.2	2.252	8	8	860.1-0700-057A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047
7.10	.280	22.5	.886	3	8	860.1-0710-022A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051
7.10	.280	36.7	1.445	5	8	860.1-0710-036A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051
7.10	.280	58.0	2.283	8	8	860.1-0710-058A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047
7.14	.281	22.7	.894	3	8	860.1-0714-022A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051
7.14	.281	58.4	2.299	8	8	860.1-0714-058A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.8	4.913	84	3.307	1.2	.047
7.20	.283	22.9	.902	3	8	860.1-0720-022A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.052
7.20	.283	37.3	1.469	5	8	860.1-0720-037A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.7	3.531	53	2.087	1.3	.052
7.30	.287	23.2	.913	3	8	860.1-0730-023A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.058	41	1.614	1.3	.052
7.30	.287	37.8	1.488	5	8	860.1-0730-037A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.7	3.530	53	2.087	1.3	.052
7.40	.291	23.5	.925	3	8	860.1-0740-023A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.057	41	1.614	1.3	.053
7.40	.291	38.3	1.508	5	8	860.1-0740-038A1-GM	★	★		☆	☆	★	8.0	.315	91	3.583	89.7	3.530	53	2.087	1.3	.053
7.40	.291	60.5	2.382	8	8	860.1-0740-060A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051
7.50	.295	23.8	.937	3	8	860.1-0750-023A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.6	3.057	41	1.614	1.4	.054
7.50	.295	38.8	1.528	5	8	860.1-0750-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.6	3.529	53	2.087	1.4	.054
7.50	.295	61.3	2.413	8	8	860.1-0750-061A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051
7.54	.297	24.0	.945	3	8	860.1-0754-023A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.6	3.056	41	1.614	1.4	.054
7.60	.299	24.1	.949	3	8	860.1-0760-024A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.6	3.056	41	1.614	1.4	.054
7.60	.299	39.3	1.547	5	8	860.1-0760-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.6	3.528	53	2.087	1.4	.054
7.70	.303	24.5	.965	3	8	860.1-0770-024A1-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.6	3.055	41	1.614	1.4	.055
7.70	.303	39.9	1.571	5	8	860.1-0770-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.6	3.528	53	2.087	1.4	.055
7.70	.303	63.0	2.480	8	8	860.1-0770-063A1-GM	★	★		☆	☆	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051

B76 E9 E28 E14

CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



TCHA H9
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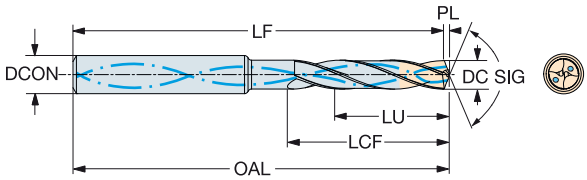


DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	S X1BM	H X1BM	Dimensions, mm, inch $DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
7.80	.307	24.8	.976	3	8	860.1-0780-024A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.056
7.80	.307	40.4	1.591	5	8	860.1-0780-038A1-GM	★	★	★		☆	★	8.0	.315	91	3.583	89.6	3.527	53	2.087	1.4	.056
7.80	.307	63.8	2.512	8	8	860.1-0780-063A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.7	4.909	84	3.307	1.3	.051
7.90	.311	25.1	.988	3	8	860.1-0790-025A1-GM	★	★	★		☆	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.057
7.90	.311	64.6	2.543	8	8	860.1-0790-064A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.6	4.906	84	3.307	1.4	.055
7.94	.313	25.2	.992	3	8	860.1-0794-025A1-GM	★	★	★		☆	★	8.0	.315	79	3.110	77.6	3.053	41	1.614	1.4	.057
7.94	.313	41.1	1.618	5	8	860.1-0794-038A1-GM	★	★	★	☆	☆	★	8.0	.315	91	3.583	89.6	3.526	53	2.087	1.4	.057
7.94	.313	65.0	2.559	8	8	860.1-0794-064A1-GM	★	★	★		☆	★	8.0	.315	126	4.961	124.6	4.906	84	3.307	1.4	.055
8.00	.315	25.4	1.000	3	8	860.1-0800-025A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.5	3.053	41	1.614	1.5	.057
8.00	.315	41.4	1.630	5	8	860.1-0800-038A1-GM	★	★	★		☆	★	8.0	.315	91	3.583	89.5	3.525	53	2.087	1.5	.057
8.00	.315	65.4	2.575	8	8	860.1-0800-065A1-GM	★	★	★	☆	☆	★	8.0	.315	126	4.961	124.6	4.906	84	3.307	1.4	.055
8.10	.319	25.7	1.012	3	10	860.1-0810-025A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.5	.058
8.10	.319	42.0	1.654	5	10	860.1-0810-041A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.5	3.997	61	2.402	1.5	.058
8.10	.319	66.2	2.606	8	10	860.1-0810-066A1-GM	★	★	★		☆	★	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055
8.20	.323	26.0	1.024	3	10	860.1-0820-026A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059
8.20	.323	42.4	1.669	5	10	860.1-0820-042A1-GM	★	★	★		☆	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059
8.20	.323	67.0	2.638	8	10	860.1-0820-067A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055
8.30	.327	26.4	1.039	3	10	860.1-0830-026A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.059
8.30	.327	43.3	1.705	5	10	860.1-0830-043A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059
8.30	.327	67.9	2.673	8	10	860.1-0830-067A1-GM	★	★	★		☆	★	10.0	.394	152	5.984	150.6	5.929	106	4.173	1.4	.055
8.40	.331	26.7	1.051	3	10	860.1-0840-026A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.060
8.40	.331	43.5	1.713	5	10	860.1-0840-043A1-GM	★	★	★		☆	★	10.0	.394	103	4.055	101.5	3.995	61	2.402	1.5	.060
8.50	.335	27.0	1.063	3	10	860.1-0850-027A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.443	47	1.850	1.5	.061
8.50	.335	44.0	1.732	5	10	860.1-0850-044A1-GM	★	★	★		☆	★	10.0	.394	103	4.055	101.5	3.994	61	2.402	1.5	.061
8.50	.335	69.5	2.736	8	10	860.1-0850-069A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059
8.60	.339	27.3	1.075	3	10	860.1-0860-027A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062
8.60	.339	44.5	1.752	5	10	860.1-0860-044A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.4	3.994	61	2.402	1.6	.062
8.60	.339	70.3	2.768	8	10	860.1-0860-070A1-GM	★	★	★		☆	★	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059
8.70	.343	27.6	1.087	3	10	860.1-0870-027A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062
8.70	.343	45.0	1.772	5	10	860.1-0870-044A1-GM	★	★	★		☆	★	10.0	.394	103	4.055	101.4	3.993	61	2.402	1.6	.062
8.70	.343	71.1	2.799	8	10	860.1-0870-071A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.5	5.925	106	4.173	1.5	.059
8.73	.344	27.7	1.091	3	10	860.1-0873-027A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063
8.73	.344	71.4	2.811	8	10	860.1-0873-071A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.4	5.922	106	4.173	1.6	.063
8.80	.346	28.0	1.102	3	10	860.1-0880-028A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063
8.80	.346	45.6	1.795	5	10	860.1-0880-044A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063
8.90	.350	28.3	1.114	3	10	860.1-0890-028A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.440	47	1.850	1.6	.064
9.00	.354	28.6	1.126	3	10	860.1-0900-028A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.4	3.439	47	1.850	1.6	.064
9.00	.354	46.6	1.835	5	10	860.1-0900-044A1-GM	★	★	★		☆	★	10.0	.394	103	4.055	101.4	3.991	61	2.402	1.6	.064
9.00	.354	73.6	2.898	8	10	860.1-0900-073A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.4	5.920	106	4.173	1.6	.064
9.13	.359	29.0	1.142	3	10	860.1-0913-029A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.3	3.439	47	1.850	1.7	.065
9.20	.362	29.2	1.150	3	10	860.1-0920-029A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.438	47	1.850	1.7	.066
9.30	.366	29.5	1.161	3	10	860.1-0930-029A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.7	.067
9.30	.366	49.0	1.929	5	10	860.1-0930-044A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.3	3.989	61	2.402	1.7	.067
9.40	.370	49.0	1.929	5	10	860.1-0940-044A1-GM	★	★	★		☆	★	10.0	.394	103	4.055	101.3	3.988	61	2.402	1.7	.067
9.40	.370	76.9	3.028	8	10	860.1-0940-076A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.3	5.917	106	4.173	1.7	.067
9.50	.374	30.2	1.189	3	10	860.1-0950-030A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068
9.50	.374	49.0	1.929	5	10	860.1-0950-044A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.3	3.987	61	2.402	1.7	.068
9.50	.374	77.7	3.059	8	10	860.1-0950-077A1-GM	★	★	★		☆	★	10.0	.394	152	5.984	150.3	5.916	106	4.173	1.7	.068
9.52	.375	30.2	1.189	3	10	860.1-0952-030A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068
9.52	.375	49.0	1.929	5	10	860.1-0952-044A1-GM	★	★	★		☆	★	10.0	.394	103	4.055	101.3	3.987	61	2.402	1.7	.068
9.52	.375	77.8	3.063	8	10	860.1-0952-077A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.3	5.916	106	4.173	1.7	.068
9.60	.378	30.5	1.201	3	10	860.1-0960-030A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.3	3.435	47	1.850	1.7	.069
9.60	.378	49.0	1.929	5	10	860.1-0960-044A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.3	3.986	61	2.402	1.7	.069
9.70	.382	30.8	1.213	3	10	860.1-0970-030A1-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.069
9.70	.382	49.0	1.929	5	10	860.1-0970-044A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.2	3.986	61	2.402	1.8	.069
9.70	.382	79.3	3.122	8	10	860.1-0970-079A1-GM	★	★	★		☆	★	10.0	.394	152	5.984	150.2	5.915	106	4.173	1.8	.069

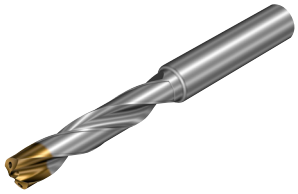
B76 E9 E28 E14

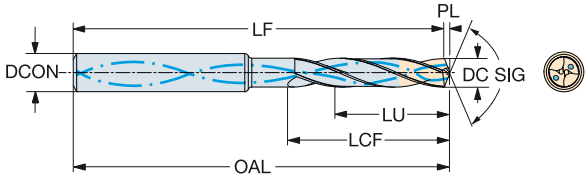
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°





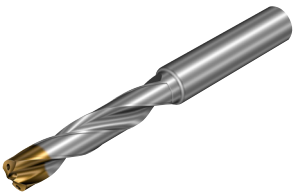
													Dimensions, mm, inch								
							P	M	K	N	S	H										
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
9.80	.386	31.1	1.224	3	10	860.1-0980-030A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.070
9.80	.386	49.0	1.929	5	10	860.1-0980-044A1-GM	★	★		☆	☆	★	10.0	.394	103	4.055	101.2	3.985	61	2.402	1.8	.070
9.80	.386	80.1	3.154	8	10	860.1-0980-080A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.2	5.914	106	4.173	1.8	.070
9.90	.390	31.5	1.240	3	10	860.1-0990-029A1-GM	★	★		☆	☆	★	10.0	.394	89	3.504	87.2	3.433	47	1.850	1.8	.071
9.90	.390	49.0	1.929	4	10	860.1-0990-043A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.2	3.984	61	2.402	1.8	.071
9.92	.391	31.5	1.240	3	10	860.1-0992-029A1-GM	★	★		☆	☆	★	10.0	.394	89	3.504	87.2	3.433	47	1.850	1.8	.071
9.92	.391	81.1	3.193	8	10	860.1-0992-081A1-GM	★	★	★	☆	☆	★	10.0	.394	152	5.984	150.2	5.913	106	4.173	1.8	.071
10.00	.394	31.8	1.252	3	10	860.1-1000-029A1-GM	★	★		☆	☆	★	10.0	.394	89	3.504	87.2	3.432	47	1.850	1.8	.072
10.00	.394	50.0	1.969	5	10	860.1-1000-043A1-GM	★	★	★	☆	☆	★	10.0	.394	103	4.055	101.2	3.983	61	2.402	1.8	.072
10.00	.394	81.8	3.220	8	10	860.1-1000-081A1-GM	★	★		☆	☆	★	10.0	.394	152	5.984	150.2	5.913	106	4.173	1.8	.072
10.10	.398	32.1	1.264	3	12	860.1-1010-032A1-GM	★	★	★	☆	☆	★	12.0	.472	89	3.504	87.2	3.432	55	2.165	1.8	.072
10.10	.398	52.3	2.059	5	12	860.1-1010-052A1-GM	★	★		☆	☆	★	12.0	.472	103	4.055	101.2	3.983	71	2.795	1.8	.072
10.10	.398	82.6	3.252	8	12	860.1-1010-082A1-GM	★	★	★	☆	☆	★	12.0	.472	152	5.984	150.2	5.912	128	5.039	1.8	.072
10.20	.402	32.4	1.276	3	12	860.1-1020-032A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.1	3.943	55	2.165	1.9	.073
10.20	.402	52.8	2.079	5	12	860.1-1020-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.573	71	2.795	1.9	.073
10.20	.402	83.4	3.283	8	12	860.1-1020-083A1-GM	★	★		☆	☆	★	12.0	.472	180	7.087	178.1	7.014	128	5.039	1.9	.073
10.30	.406	32.7	1.287	3	12	860.1-1030-032A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.942	55	2.165	1.9	.074
10.30	.406	53.3	2.098	5	12	860.1-1030-052A1-GM	★	★		☆	☆	★	12.0	.472	118	4.646	116.1	4.572	71	2.795	1.9	.074
10.30	.406	84.2	3.315	8	12	860.1-1030-084A1-GM	★	★	★	☆	☆	★	12.0	.472	180	7.087	178.1	7.013	128	5.039	1.9	.074
10.32	.406	32.8	1.291	3	12	860.1-1032-032A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.1	3.942	55	2.165	1.9	.074
10.32	.406	53.4	2.102	5	12	860.1-1032-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.572	71	2.795	1.9	.074
10.40	.409	33.0	1.299	3	12	860.1-1040-033A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075
10.40	.409	53.8	2.118	5	12	860.1-1040-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075
10.50	.413	33.4	1.315	3	12	860.1-1050-033A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075
10.50	.413	54.4	2.142	5	12	860.1-1050-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.570	71	2.795	1.9	.075
10.50	.413	85.9	3.382	8	12	860.1-1050-085A1-GM	★	★		☆	☆	★	12.0	.472	180	7.087	178.1	7.011	128	5.039	1.9	.075
10.60	.417	33.7	1.327	3	12	860.1-1060-033A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.940	55	2.165	1.9	.076
10.70	.421	34.0	1.339	3	12	860.1-1070-034A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.1	3.939	55	2.165	1.9	.077
10.70	.421	56.0	2.205	5	12	860.1-1070-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.569	71	2.795	1.9	.077
10.71	.422	34.0	1.339	3	12	860.1-1071-034A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.1	3.939	55	2.165	1.9	.077
10.71	.422	56.0	2.205	5	12	860.1-1071-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.1	4.569	71	2.795	1.9	.077
10.80	.425	34.3	1.350	3	12	860.1-1080-034A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.0	3.938	55	2.165	2.0	.077
10.80	.425	56.0	2.205	5	12	860.1-1080-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.0	4.568	71	2.795	2.0	.077
10.80	.425	88.3	3.476	8	12	860.1-1080-088A1-GM	★	★		☆	☆	★	12.0	.472	180	7.087	178.0	7.009	128	5.039	2.0	.077
11.00	.433	35.0	1.378	3	12	860.1-1100-035A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079
11.00	.433	56.0	2.205	5	12	860.1-1100-052A1-GM	★	★		☆	☆	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079
11.00	.433	90.0	3.543	8	12	860.1-1100-090A1-GM	★	★	★	☆	☆	★	12.0	.472	180	7.087	178.0	7.008	128	5.039	2.0	.079
11.10	.437	35.3	1.390	3	12	860.1-1110-035A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	100.0	3.936	55	2.165	2.0	.080
11.10	.437	56.0	2.205	5	12	860.1-1110-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	116.0	4.566	71	2.795	2.0	.080
11.10	.437	90.8	3.575	8	12	860.1-1110-090A1-GM	★	★		☆	☆	★	12.0	.472	180	7.087	178.0	7.007	128	5.039	2.0	.080
11.11	.437	35.3	1.390	3	12	860.1-1111-035A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.0	3.936	55	2.165	2.0	.080
11.11	.437	56.0	2.205	5	12	860.1-1111-052A1-GM	★	★		☆	☆	★	12.0	.472	118	4.646	116.0	4.566	71	2.795	2.0	.080
11.20	.441	35.6	1.402	3	12	860.1-1120-035A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.0	3.936	55	2.165	2.0	.080
11.20	.441	56.0	2.205	5	12	860.1-1120-052A1-GM	★	★		☆	☆	★	12.0	.472	118	4.646	116.0	4.565	71	2.795	2.0	.080
11.30	.445	56.5	2.224	5	12	860.1-1130-052A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	115.9	4.565	71	2.795	2.1	.081
11.50	.453	36.5	1.437	3	12	860.1-1150-035A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	99.9	3.933	55	2.165	2.1	.082
11.50	.453	56.0	2.205	4	12	860.1-1150-051A1-GM	★	★	★	☆	☆	★	12.0	.472	118	4.646	115.9	4.563	71	2.795	2.1	.082
11.50	.453	94.0	3.701	8	12	860.1-1150-094A1-GM	★	★		☆	☆	★	12.0	.472	180	7.087	177.9	7.004	128	5.039	2.1	.082
11.60	.457	36.9	1.453	3	12	860.1-1160-035A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	99.9	3.933	55	2.165	2.1	.083
11.70	.461	37.2	1.465	3	12	860.1-1170-035A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	99.9	3.932	55	2.165	2.1	.084
11.80	.465	37.5	1.476	3	12	860.1-1180-035A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	99.9	3.931	55	2.165	2.1	.085
11.80	.465	56.0	2.205	4	12	860.1-1180-051A1-GM	★	★		☆	☆	★	12.0	.472	118	4.646	115.9	4.561	71	2.795	2.1	.085
11.80	.465	96.5	3.799	8	12	860.1-1180-096A1-GM	★	★	★	☆	☆	★	12.0	.472	180	7.087	177.9	7.002	128	5.039	2.1	.085
11.90	.469	56.0	2.205	4	12	860.1-1190-051A1-GM	★	★		☆	☆	★	12.0	.472	118	4.646	115.8	4.560	71	2.795	2.2	.085
11.90	.469	97.3	3.831	8	12	860.1-1190-097A1-GM	★	★	★	☆	☆	★	12.0	.472	180	7.087	177.8	7.001	128	5.039	2.2	.085
12.00	.472	38.1	1.500	3	12	860.1-1200-035A1-GM	★	★		☆	☆	★	12.0	.472	102	4.016	99.8	3.930	55	2.165	2.2	.086
12.00	.472	56.0	2.205	4	12	860.1-1200-051A1-GM	★	★	★	☆	☆	★	12.0	.551	118	4.646	115.8	4.560	71	2.795	2.2	.086
12.00	.472	98.1	3.862	8	12	860.1-1200-098A1-GM	★	★		☆	☆	★	12.0	.472	180	7.087	177.8	7.001	128	5.039	2.2	.086

B76 E9 E28 E14

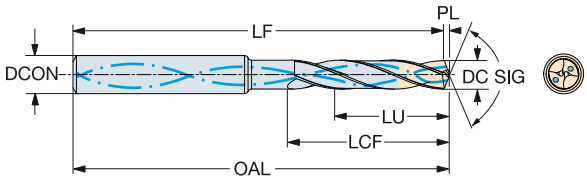
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply



TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	S X1BM	H X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
12.10	.476	60.5	2.382	5	14	860.1-1210-056A1-GM	★	★	★	☆	☆	★	14.0	.551	118	4.646	115.8	4.559	77	3.032	2.2	.087
12.20	.480	38.8	1.528	3	14	860.1-1220-038A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.8	4.125	60	2.362	2.2	.087
12.20	.480	61.0	2.402	5	14	860.1-1220-056A1-GM	★	★	★	☆	☆	★	14.0	.551	124	4.882	121.8	4.794	77	3.032	2.2	.087
12.30	.484	39.1	1.539	3	14	860.1-1230-039A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.8	4.124	60	2.362	2.2	.088
12.30	.484	100.6	3.961	8	14	860.1-1230-100A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.8	7.865	151	5.945	2.2	.088
12.40	.488	39.4	1.551	3	14	860.1-1240-039A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.7	4.124	60	2.362	2.3	.089
12.50	.492	39.7	1.563	3	14	860.1-1250-039A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.7	4.123	60	2.362	2.3	.090
12.50	.492	62.0	2.441	4	14	860.1-1250-056A1-GM	★	★	★	☆	☆	★	14.0	.551	124	4.882	121.7	4.792	77	3.032	2.3	.090
12.50	.492	102.3	4.028	8	14	860.1-1250-102A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.7	7.863	151	5.945	2.3	.090
12.70	.500	40.4	1.591	3	14	860.1-1270-039A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.091
12.70	.500	60.0	2.362	4	14	860.1-1270-056A1-GM	★	★	★	☆	☆	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.3	.091
12.70	.500	103.9	4.091	8	14	860.1-1270-103A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.7	7.862	151	5.945	2.3	.091
12.80	.504	104.7	4.122	8	14	860.1-1280-104A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.7	7.861	151	5.945	2.3	.092
13.00	.512	43.0	1.693	3	14	860.1-1300-038A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.6	4.119	60	2.362	2.4	.093
13.00	.512	60.0	2.362	4	14	860.1-1300-055A1-GM	★	★	★	☆	☆	★	14.0	.551	124	4.882	121.6	4.789	77	3.032	2.4	.093
13.00	.512	106.3	4.185	8	14	860.1-1300-106A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.6	7.860	151	5.945	2.4	.093
13.10	.516	60.0	2.362	4	14	860.1-1310-055A1-GM	★	★	★	☆	☆	★	14.0	.551	124	4.882	121.6	4.788	77	3.032	2.4	.094
13.25	.522	43.0	1.693	3	14	860.1-1325-038A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.4	.095
13.30	.524	43.0	1.693	3	14	860.1-1330-036A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.6	4.118	60	2.362	2.4	.095
13.50	.531	43.0	1.693	3	14	860.1-1350-038A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.5	4.116	60	2.362	2.5	.097
13.50	.531	60.0	2.362	4	14	860.1-1350-055A1-GM	★	★	★	☆	☆	★	14.0	.551	124	4.882	121.5	4.785	77	3.032	2.5	.097
13.50	.531	110.4	4.346	8	14	860.1-1350-110A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.5	7.856	151	5.945	2.5	.097
13.75	.541	43.0	1.693	3	14	860.1-1375-038A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.5	4.114	60	2.362	2.5	.099
13.80	.543	112.9	4.445	8	14	860.1-1380-112A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.5	7.854	151	5.945	2.5	.099
14.00	.551	43.0	1.693	3	14	860.1-1400-038A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.5	4.112	60	2.362	2.5	.100
14.00	.551	60.0	2.362	4	14	860.1-1400-055A1-GM	★	★	★	☆	☆	★	14.0	.551	124	4.882	121.5	4.782	77	3.032	2.5	.100
14.00	.551	114.5	4.508	8	14	860.1-1400-114A1-GM	★	★	★	☆	☆	★	14.0	.551	202	7.953	199.5	7.852	151	5.945	2.5	.100
14.25	.561	45.3	1.783	3	16	860.1-1425-042A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.4	4.425	65	2.559	2.6	.102
14.25	.561	63.4	2.496	4	16	860.1-1425-060A1-GM	★	★	★	☆	☆	★	16.0	.630	133	5.236	130.4	5.134	83	3.268	2.6	.102
14.29	.563	45.4	1.787	3	16	860.1-1429-042A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.4	4.425	65	2.559	2.6	.102
14.50	.571	45.2	1.780	3	16	860.1-1450-042A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.4	4.424	65	2.559	2.6	.104
14.50	.571	63.2	2.488	4	16	860.1-1450-060A1-GM	★	★	★	☆	☆	★	16.0	.630	133	5.236	130.4	5.132	83	3.268	2.6	.104
15.00	.591	45.0	1.772	3	16	860.1-1500-041A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.3	4.420	65	2.559	2.7	.107
15.00	.591	63.0	2.480	4	16	860.1-1500-059A1-GM	★	★	★	☆	☆	★	16.0	.630	133	5.236	130.3	5.129	83	3.268	2.7	.107
15.50	.610	45.0	1.772	2	16	860.1-1550-041A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.2	4.417	65	2.559	2.8	.111
15.87	.625	45.0	1.772	2	16	860.1-1587-041A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.1	4.414	65	2.559	2.9	.114
15.87	.625	63.0	2.480	3	16	860.1-1587-059A1-GM	★	★	★	☆	☆	★	16.0	.630	133	5.236	130.1	5.123	83	3.268	2.9	.114
16.00	.630	48.0	1.890	3	16	860.1-1600-041A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.1	4.413	65	2.559	2.9	.115
16.00	.630	63.0	2.480	3	16	860.1-1600-059A1-GM	★	★	★	☆	☆	★	16.0	.630	133	5.236	130.1	5.122	83	3.268	2.9	.115
16.00	.630	130.9	5.154	8	16	860.1-1600-130A1-GM	★	★	★	☆	☆	★	16.0	.630	227	8.937	224.1	8.822	172	6.772	2.9	.115

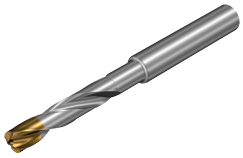
B76 E9 E28 E14

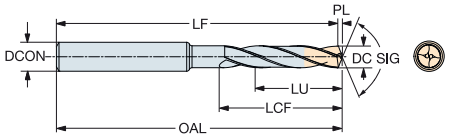
CoroDrill® 860 solid carbide drill

For multi-materials

External coolant supply

TCHA H9
SIG 140°





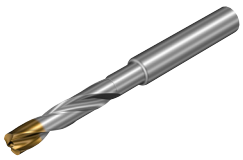
							P	M	K	N	S	H	Dimensions, mm, inch								
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
3.00	.118	9.5	.374	3	6	860.1-0300-009A0-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.00	.118	15.5	.610	5	6	860.1-0300-015A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.10	.122	9.8	.386	3	6	860.1-0310-009A0-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.10	.122	16.0	.630	5	6	860.1-0310-016A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.20	.126	10.1	.398	3	6	860.1-0320-010A0-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020
3.20	.126	16.5	.650	5	6	860.1-0320-016A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020
3.30	.130	10.5	.413	3	6	860.1-0330-010A0-GM	★	★	★	☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.30	.130	17.1	.673	5	6	860.1-0330-017A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.38	.133	17.5	.689	5	6	860.1-0338-017A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.40	.134	10.8	.425	3	6	860.1-0340-010A0-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.40	.134	17.6	.693	5	6	860.1-0340-017A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.50	.138	11.1	.437	3	6	860.1-0350-011A0-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.50	.138	18.1	.713	5	6	860.1-0350-018A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.60	.142	11.4	.449	3	6	860.1-0360-011A0-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.60	.142	18.6	.732	5	6	860.1-0360-018A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.70	.146	11.7	.461	3	6	860.1-0370-011A0-GM	★	★		☆	☆	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024
3.70	.146	19.1	.752	5	6	860.1-0370-019A0-GM	★		★	☆		☆	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024
3.80	.150	12.0	.472	3	6	860.1-0380-012A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024
3.80	.150	19.6	.772	5	6	860.1-0380-019A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024
3.90	.154	12.4	.488	3	6	860.1-0390-012A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
3.90	.154	20.2	.795	5	6	860.1-0390-020A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.00	.157	12.7	.500	3	6	860.1-0400-012A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.00	.157	20.7	.815	5	6	860.1-0400-020A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.10	.161	13.0	.512	3	6	860.1-0410-013A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.10	.161	21.2	.835	5	6	860.1-0410-021A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.20	.165	13.3	.524	3	6	860.1-0420-013A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.20	.165	21.7	.854	5	6	860.1-0420-021A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.30	.169	13.6	.535	3	6	860.1-0430-013A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.30	.169	22.2	.874	5	6	860.1-0430-022A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028
4.40	.173	14.0	.551	3	6	860.1-0440-014A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028
4.50	.177	14.3	.563	3	6	860.1-0450-014A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.50	.177	23.3	.917	5	6	860.1-0450-023A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.60	.181	14.6	.575	3	6	860.1-0460-014A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.60	.181	23.8	.937	5	6	860.1-0460-023A0-GM	★		★	☆		☆	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031
4.70	.185	14.9	.587	3	6	860.1-0470-014A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031
4.80	.189	15.2	.598	3	6	860.1-0480-015A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
4.80	.189	24.8	.976	5	6	860.1-0480-024A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
4.90	.193	15.5	.610	3	6	860.1-0490-015A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	15.9	.626	3	6	860.1-0500-015A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031
5.00	.197	25.9	1.020	5	6	860.1-0500-025A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031
5.10	.201	16.2	.638	3	6	860.1-0510-016A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.10	.201	26.4	1.039	5	6	860.1-0510-026A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.20	.205	16.5	.650	3	6	860.1-0520-016A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.20	.205	26.9	1.059	5	6	860.1-0520-026A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.30	.209	16.8	.661	3	6	860.1-0530-016A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.30	.209	27.4	1.079	5	6	860.1-0530-027A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.40	.213	17.1	.673	3	6	860.1-0540-016A0-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	17.5	.689	3	6	860.1-0550-016A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035
5.50	.217	28.5	1.122	5	6	860.1-0550-028A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035
5.60	.220	17.8	.701	3	6	860.1-0560-016A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.60	.220	29.0	1.142	5	6	860.1-0560-029A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
5.80	.228	18.4	.724	3	6	860.1-0580-016A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
5.90	.232	30.5	1.201	5	6	860.1-0590-030A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
6.00	.236	19.0	.748	3	6	860.1-0600-016A0-GM	★	★		☆	☆	★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039
6.00	.236	31.0	1.220	5	6	860.1-0600-031A0-GM	★		★	☆		☆	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039
6.10	.240	19.4	.764	3	8	860.1-0610-019A0-GM	★	★		☆	☆	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039
6.10	.240	31.6	1.244	5	8	860.1-0610-031A0-GM	★		★	☆		☆	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039
6.20	.244	19.7	.776	3	8	860.1-0620-019A0-GM	★	★		☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.20	.244	32.1	1.264	5	8	860.1-0620-032A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043

B76 E9 E28 E14

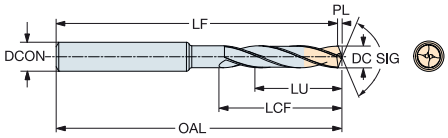
CoroDrill® 860 solid carbide drill

For multi-materials

External coolant supply



TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P X1BM	M X1BM	K X1BM	N X1BM	S X1BM	H X1BM	Dimensions, mm, inch $DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
6.30	.248	20.0	.787	3	8	860.1-0630-020A0-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.30	.248	32.6	1.283	5	8	860.1-0630-032A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.40	.252	33.1	1.303	5	8	860.1-0640-033A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.50	.256	20.6	.811	3	8	860.1-0650-020A0-GM	★	★	★		☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.50	.256	33.6	1.323	5	8	860.1-0650-033A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.60	.260	21.0	.827	3	8	860.1-0660-020A0-GM	★	★	★		☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.70	.264	21.3	.839	3	8	860.1-0670-020A0-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043
6.70	.264	34.7	1.366	5	8	860.1-0670-034A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043
6.80	.268	21.6	.850	3	8	860.1-0680-020A0-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.8	3.063	34	1.339	1.2	.047
6.80	.268	35.2	1.386	5	8	860.1-0680-035A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
6.90	.272	35.7	1.406	5	8	860.1-0690-035A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
7.00	.276	22.2	.874	3	8	860.1-0700-022A0-GM	★	★	★		☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047
7.00	.276	36.2	1.425	5	8	860.1-0700-036A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047
7.10	.280	22.5	.886	3	8	860.1-0710-022A0-GM	★	★	★		☆	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047
7.20	.283	22.9	.902	3	8	860.1-0720-022A0-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.052
7.50	.295	38.8	1.528	5	8	860.1-0750-038A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051
7.70	.303	24.5	.965	3	8	860.1-0770-024A0-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.6	3.055	41	1.614	1.4	.055
7.80	.307	24.8	.976	3	8	860.1-0780-024A0-GM	★	★	★		☆	★	8.0	.315	79	3.110	77.6	3.054	41	1.614	1.4	.056
8.00	.315	25.4	1.000	3	8	860.1-0800-025A0-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	77.5	3.053	41	1.614	1.5	.057
8.00	.315	41.4	1.630	5	8	860.1-0800-038A0-GM	★		★	☆		☆	8.0	.315	91	3.583	89.6	3.528	53	2.087	1.4	.055
8.10	.319	25.7	1.012	3	10	860.1-0810-025A0-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.5	.058
8.20	.323	26.0	1.024	3	10	860.1-0820-026A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059
8.30	.327	26.4	1.039	3	10	860.1-0830-026A0-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.059
8.30	.327	43.0	1.693	5	10	860.1-0830-043A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055
8.40	.331	26.7	1.051	3	10	860.1-0840-026A0-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.5	.060
8.50	.335	27.0	1.063	3	10	860.1-0850-027A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.5	3.443	47	1.850	1.5	.061
8.50	.335	44.0	1.732	5	10	860.1-0850-044A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.5	3.994	61	2.402	1.5	.061
8.60	.339	27.3	1.075	3	10	860.1-0860-027A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062
8.60	.339	44.5	1.752	5	10	860.1-0860-044A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.4	3.994	61	2.402	1.6	.062
8.70	.343	27.6	1.087	3	10	860.1-0870-027A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.6	.062
8.70	.343	45.0	1.772	5	10	860.1-0870-044A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.4	3.993	61	2.402	1.6	.062
8.80	.346	28.0	1.102	3	10	860.1-0880-028A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063
8.80	.346	45.6	1.795	5	10	860.1-0880-044A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063
9.00	.354	28.6	1.126	3	10	860.1-0900-028A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.4	3.439	47	1.850	1.6	.064
9.00	.354	46.6	1.835	5	10	860.1-0900-044A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.4	3.991	61	2.402	1.6	.064
9.30	.366	29.5	1.161	3	10	860.1-0930-029A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.3	3.437	47	1.850	1.7	.067
9.50	.374	30.2	1.189	3	10	860.1-0950-030A0-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.3	3.436	47	1.850	1.7	.068
9.50	.374	49.0	1.929	5	10	860.1-0950-044A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.3	3.987	61	2.402	1.7	.068
9.80	.386	31.1	1.224	3	10	860.1-0980-030A0-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.2	3.434	47	1.850	1.8	.070
10.00	.394	31.8	1.252	3	10	860.1-1000-029A0-GM	★	★	★		☆	★	10.0	.394	89	3.504	87.2	3.432	47	1.850	1.8	.072
10.00	.394	50.0	1.969	5	10	860.1-1000-043A0-GM	★		★	☆		☆	10.0	.394	103	4.055	101.2	3.983	61	2.402	1.8	.072
10.20	.402	32.4	1.276	3	12	860.1-1020-032A0-GM	★	★	★		☆	★	12.0	.472	102	4.016	100.1	3.943	55	2.165	1.9	.073
10.20	.402	52.8	2.079	5	12	860.1-1020-052A0-GM	★		★	☆		☆	12.0	.472	118	4.646	116.1	4.573	71	2.795	1.9	.073
10.30	.406	53.3	2.098	5	12	860.1-1030-052A0-GM	★		★	☆		☆	12.0	.472	118	4.646	116.1	4.572	71	2.795	1.9	.074
10.40	.409	33.0	1.299	3	12	860.1-1040-033A0-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075
10.40	.409	53.8	2.118	5	12	860.1-1040-052A0-GM	★		★	☆		☆	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075
10.50	.413	33.4	1.315	3	12	860.1-1050-033A0-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075
10.50	.413	54.4	2.142	5	12	860.1-1050-052A0-GM	★		★	☆		☆	12.0	.472	118	4.646	116.1	4.570	71	2.795	1.9	.075
10.80	.425	56.0	2.205	5	12	860.1-1080-052A0-GM	★		★	☆		☆	12.0	.472	118	4.646	116.0	4.568	71	2.795	2.0	.077
11.00	.433	35.0	1.378	3	12	860.1-1100-035A0-GM	★	★	★		☆	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079
11.00	.433	56.0	2.205	5	12	860.1-1100-052A0-GM	★		★	☆		☆	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079
12.00	.472	38.1	1.500	3	12	860.1-1200-035A0-GM	★	★	★		☆	★	12.0	.472	102	4.016	99.8	3.930	55	2.165	2.2	.086
12.00	.472	56.0	2.205	4	12	860.1-1200-051A0-GM	★		★	☆		☆	12.0	.472	118	4.646	115.8	4.560	71	2.795	2.2	.086
12.50	.492	39.7	1.563	3	14	860.1-1250-039A0-GM	★	★	★		☆	★	14.0	.551	107	4.213	104.7	4.123	60	2.362	2.3	.090
12.60	.496	40.0	1.575	3	14	860.1-1260-039A0-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.090
13.00	.512	43.0	1.693	3	14	860.1-1300-038A0-GM	★	★	★		☆	★	14.0	.551	107	4.213	104.6	4.119	60	2.362	2.4	.093
14.00	.551	43.0	1.693	3	14	860.1-1400-038A0-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	104.5	4.112	60	2.362	2.5	.100
14.00	.551	60.0	2.362	4	14	860.1-1400-055A0-GM	★		★	☆		☆	14.0	.551	124	4.882	121.5	4.782	77	3.032	2.5	.100

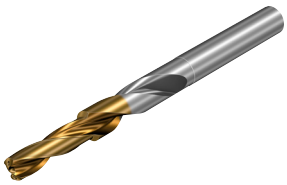
B76 E9 E28 E14

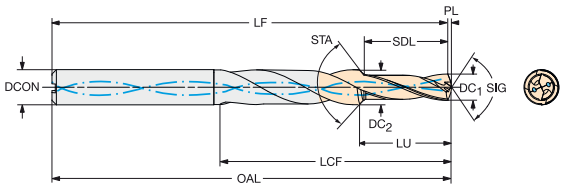
CoroDrill® 860 solid carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°





Step and chamfer drill

											P	M	K	N	S	H	Dimensions, mm, inch										
DC_1	DC_1"	DC_2	DC_2"	SDL	SDL"	STA	LU	LU"	CZC_{MS}	Ordering code	X1BM	X1BM	X1BM	X1BM	X1BM	X1BM	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"
3.35	.132	4.50	.177	10.10	.398	90°	11.3	.445	6	860.2-0335-011A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	61.4	2.417	19	.748	0.6	.024
3.40	.134	4.60	.181	10.20	.402	90°	11.4	.449	6	860.2-0340-011A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.4	2.575	19	.748	0.6	.024
4.25	.167	5.70	.224	12.80	.504	90°	14.3	.563	6	860.2-0425-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028
4.30	.169	5.80	.228	13.00	.512	90°	14.5	.571	6	860.2-0430-014A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.3	2.571	23	.906	0.7	.028
4.65	.183	5.90	.232	14.00	.551	90°	15.5	.610	6	860.2-0465-015A1-GM	★	★	★	☆	☆	★	6.0	.236	66	2.598	65.2	2.567	23	.906	0.8	.031
5.00	.197	6.80	.268	15.00	.591	90°	16.8	.661	8	860.2-0500-016A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	78.2	3.079	28	1.102	0.8	.031
5.10	.201	6.90	.272	15.30	.602	90°	17.1	.673	8	860.2-0510-017A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
5.50	.217	7.40	.291	16.60	.654	90°	18.6	.732	8	860.2-0550-018A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
5.55	.219	7.50	.295	16.70	.657	90°	18.7	.736	8	860.2-0555-018A1-GM	★	★	★	☆	☆	★	8.0	.315	79	3.110	78.1	3.075	28	1.102	0.9	.035
6.60	.260	8.90	.350	19.90	.783	90°	22.3	.878	10	860.2-0660-022A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.9	3.461	37	1.457	1.1	.043
6.75	.266	9.10	.358	20.30	.799	90°	22.7	.894	10	860.2-0675-022A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
6.85	.270	9.20	.362	20.60	.811	90°	23.0	.906	10	860.2-0685-023A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
6.90	.272	9.30	.366	20.70	.815	90°	23.2	.913	10	860.2-0690-023A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
7.00	.276	9.50	.374	21.10	.831	90°	23.6	.929	10	860.2-0700-023A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.8	3.457	37	1.457	1.2	.047
7.40	.291	9.80	.386	22.20	.874	90°	24.7	.972	10	860.2-0740-024A1-GM	★	★	★	☆	☆	★	10.0	.394	89	3.504	87.7	3.453	37	1.457	1.3	.051
8.00	.315	10.80	.425	24.00	.945	90°	26.9	1.059	12	860.2-0800-026A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.6	3.961	42	1.654	1.4	.055
8.50	.335	11.50	.453	25.50	1.004	90°	28.5	1.122	12	860.2-0850-028A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
8.60	.339	11.60	.457	25.80	1.016	90°	28.9	1.138	12	860.2-0860-028A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
8.70	.343	11.70	.461	26.10	1.028	90°	29.2	1.150	12	860.2-0870-029A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
9.00	.354	11.80	.465	27.00	1.063	90°	30.0	1.181	12	860.2-0900-030A1-GM	★	★	★	☆	☆	★	12.0	.472	102	4.016	100.5	3.957	42	1.654	1.5	.059
10.25	.404	13.80	.543	30.80	1.213	90°	34.4	1.354	14	860.2-1025-034A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.30	.406	13.80	.543	31.00	1.220	90°	34.6	1.362	14	860.2-1030-034A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.40	.409	13.80	.543	31.20	1.228	90°	34.8	1.370	14	860.2-1040-034A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
10.50	.413	13.80	.543	31.60	1.244	90°	35.2	1.386	14	860.2-1050-035A1-GM	★	★	★	☆	☆	★	14.0	.551	107	4.213	105.2	4.142	52	2.047	1.8	.071
12.00	.472	15.80	.622	36.00	1.417	90°	40.1	1.579	16	860.2-1200-040A1-GM	★	★	★	☆	☆	★	16.0	.630	115	4.528	112.9	4.445	59	2.323	2.1	.083
14.00	.551	18.90	.744	42.10	1.657	90°	47.1	1.854	20	860.2-1400-047A1-GM	★	★	★	☆	☆	★	20.0	.787	131	5.157	128.6	5.063	78	3.071	2.4	.094

B76 E9 E28 E14

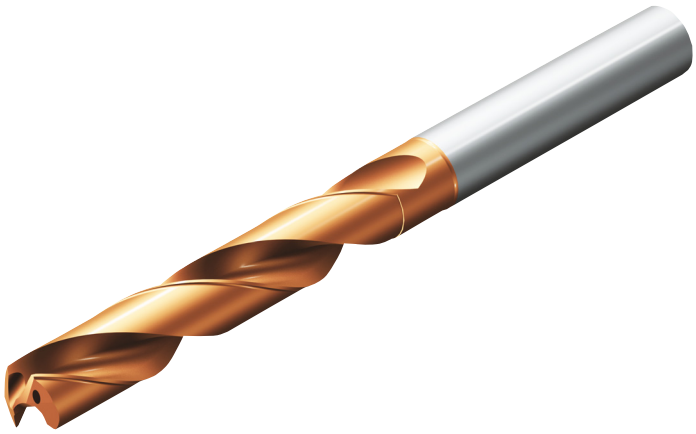
CoroDrill® 860

High performance drills optimized for steel

O C

Application

860-PM: Long- and short-chipping steel materials, such as unalloyed steels, low carbon steels, low-alloy steels, high-alloy steels, and steel castings



ISO application area:

P

Features and benefits

- Optimized cutting data
- Low cost per hole
- Improved performance reliability
- Trouble-free chip evacuation
- Long tool life, controlled wear formation
- Consistent hole tolerance
- Can be reconditioned up to 3 times to its original specification

www.sandvik.coromant.com/corodrill860

Recommendations

It is recommended to use hydraulic precision chucks.
It is recommended to use internal coolant, minimum recommended pressure 20 bar

For chucks, see our Rotating Tools catalog.

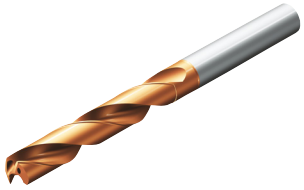
E14

SANDVIK Coromant

CoroDrill® 860 solid carbide drill

For steel

Internal coolant supply



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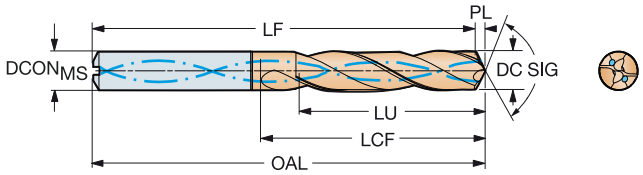
SIG 147°



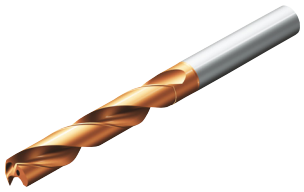
DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	P 4234	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
3.00	.118	9.5	.374	3	6	860.1-0300-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.00	.118	15.5	.610	5	6	860.1-0300-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.00	.118	24.5	.965	8	6	860.1-0300-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.10	.122	9.8	.386	3	6	860.1-0310-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.10	.122	16.0	.630	5	6	860.1-0310-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.10	.122	25.3	.996	8	6	860.1-0310-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.17	.125	10.0	.394	3	6	860.1-0317-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.17	.125	16.4	.646	5	6	860.1-0317-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.17	.125	25.9	1.020	8	6	860.1-0317-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.20	.126	10.1	.398	3	6	860.1-0320-016A1-PM	★	6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.20	.126	16.5	.650	5	6	860.1-0320-021A1-PM	★	6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.20	.126	26.1	1.028	8	6	860.1-0320-029A1-PM	★	6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.30	.130	10.5	.413	3	6	860.1-0330-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.30	.130	17.1	.673	5	6	860.1-0330-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.30	.130	27.0	1.063	8	6	860.1-0330-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.40	.134	10.8	.425	3	6	860.1-0340-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.40	.134	17.6	.693	5	6	860.1-0340-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.40	.134	27.5	1.083	8	6	860.1-0340-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.45	.136	27.4	1.079	7	6	860.1-0345-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.50	.138	11.1	.437	3	6	860.1-0350-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.50	.138	18.1	.713	5	6	860.1-0350-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.50	.138	27.3	1.075	7	6	860.1-0350-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.55	.140	11.2	.441	3	6	860.1-0355-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.57	.141	27.1	1.067	7	6	860.1-0357-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.60	.142	27.1	1.067	7	6	860.1-0360-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.70	.146	11.7	.461	3	6	860.1-0370-016A1-PM	★	6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.70	.146	19.1	.752	5	6	860.1-0370-021A1-PM	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.70	.146	27.9	1.098	7	6	860.1-0370-029A1-PM	★	6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	COROMANT
3.80	.150	12.1	.476	3	6	860.1-0380-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
3.80	.150	31.1	1.224	8	6	860.1-0380-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
3.90	.154	20.2	.795	5	6	860.1-0390-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
3.90	.154	31.9	1.256	8	6	860.1-0390-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
3.97	.156	32.4	1.276	8	6	860.1-0397-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
4.00	.157	12.7	.500	3	6	860.1-0400-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.00	.157	20.7	.815	5	6	860.1-0400-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.00	.157	32.7	1.287	8	6	860.1-0400-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
4.10	.161	13.0	.512	3	6	860.1-0410-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.10	.161	21.2	.835	5	6	860.1-0410-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.10	.161	33.5	1.319	8	6	860.1-0410-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT
4.20	.165	13.3	.524	3	6	860.1-0420-018A1-PM	★	6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.20	.165	21.7	.854	5	6	860.1-0420-027A1-PM	★	6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.20	.165	34.3	1.350	8	6	860.1-0420-037A1-PM	★	6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT
4.30	.169	13.7	.539	3	6	860.1-0430-018A1-PM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031	20	290	DIN 6537 K
4.30	.169	22.3	.878	5	6	860.1-0430-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.30	.169	35.2	1.386	8	6	860.1-0430-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	45	1.772	0.8	.031	20	290	COROMANT
4.40	.173	22.8	.898	5	6	860.1-0440-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.40	.173	36.0	1.417	8	6	860.1-0440-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	45	1.772	0.8	.031	20	290	COROMANT
4.50	.177	14.3	.563	3	6	860.1-0450-018A1-PM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031	20	290	DIN 6537 K
4.50	.177	23.3	.917	5	6	860.1-0450-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.50	.177	36.8	1.449	8	6	860.1-0450-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT
4.55	.179	23.5	.925	5	6	860.1-0455-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L

B76 E9 E28 E14

CoroDrill® 860 solid carbide drill

For steel

Internal coolant supply



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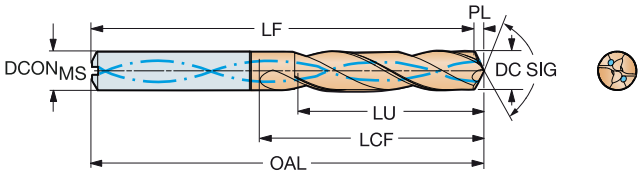
SIG 147°



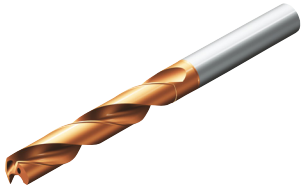
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P 4234	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
4.60	.181	14.6	.575	3	6	860.1-0460-018A1-PM	★	6.0	.236	66	2.598	65.2	2.567	24	.945	0.8	.031	20	290	DIN 6537 K
4.60	.181	23.8	.937	5	6	860.1-0460-027A1-PM	★	6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.60	.181	36.8	1.449	8	6	860.1-0460-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT
4.70	.185	36.6	1.441	7	6	860.1-0470-037A1-PM	★	6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT
4.76	.187	15.0	.591	3	6	860.1-0476-019A1-PM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
4.76	.187	36.5	1.437	7	6	860.1-0476-037A1-PM	★	6.0	.236	97	3.819	96.2	3.787	46	1.811	0.8	.031	20	290	COROMANT
4.76	.187	38.8	1.528	8	6	860.1-0476-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT
4.80	.189	15.2	.598	3	6	860.1-0480-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
4.80	.189	24.8	.976	5	6	860.1-0480-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
4.80	.189	39.2	1.543	8	6	860.1-0480-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT
4.90	.193	15.5	.610	3	6	860.1-0490-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
4.90	.193	25.3	.996	5	6	860.1-0490-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
4.90	.193	40.0	1.575	8	6	860.1-0490-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT
5.00	.197	15.8	.622	3	6	860.1-0500-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.00	.197	25.8	1.016	5	6	860.1-0500-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.00	.197	40.8	1.606	8	6	860.1-0500-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.10	.201	16.1	.634	3	6	860.1-0510-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.10	.201	26.3	1.035	5	6	860.1-0510-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.10	.201	41.6	1.638	8	6	860.1-0510-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.16	.203	26.6	1.047	5	6	860.1-0516-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.16	.203	42.1	1.657	8	6	860.1-0516-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.20	.205	16.4	.646	3	6	860.1-0520-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.20	.205	26.8	1.055	5	6	860.1-0520-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.20	.205	42.4	1.669	8	6	860.1-0520-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.30	.209	16.7	.657	3	6	860.1-0530-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.30	.209	27.3	1.075	5	6	860.1-0530-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.40	.213	17.0	.669	3	6	860.1-0540-019A1-PM	★	6.0	.236	72	2.835	65.2	2.567	28	1.102	0.8	.031	20	290	COROMANT
5.40	.213	27.8	1.094	5	6	860.1-0540-037A1-PM	★	6.0	.236	87	3.425	81.2	3.197	44	1.732	0.8	.031	20	290	COROMANT
5.40	.213	44.0	1.732	8	6	860.1-0540-047A1-PM	★	6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.50	.217	17.4	.685	3	6	860.1-0550-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.50	.217	28.4	1.118	5	6	860.1-0550-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.50	.217	44.9	1.768	8	6	860.1-0550-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	57	2.244	0.9	.035	20	290	COROMANT
5.56	.219	28.7	1.130	5	6	860.1-0555-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.56	.219	17.5	.689	3	6	860.1-0556-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.56	.219	28.7	1.130	5	6	860.1-0556-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.56	.219	45.3	1.783	8	6	860.1-0556-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.60	.220	17.7	.697	3	6	860.1-0560-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.60	.220	28.9	1.138	5	6	860.1-0560-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.60	.220	45.7	1.799	8	6	860.1-0560-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.70	.224	29.4	1.157	5	6	860.1-0570-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.70	.224	46.5	1.831	8	6	860.1-0570-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.80	.228	17.6	.693	3	6	860.1-0580-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.80	.228	29.9	1.177	5	6	860.1-0580-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.80	.228	47.3	1.862	8	6	860.1-0580-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.90	.232	17.4	.685	2	6	860.1-0590-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.90	.232	30.4	1.197	5	6	860.1-0590-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
5.90	.232	47.4	1.866	8	6	860.1-0590-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT
5.95	.234	17.3	.681	2	6	860.1-0595-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
5.95	.234	30.7	1.209	5	6	860.1-0595-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
6.00	.236	18.9	.744	3	6	860.1-0600-019A1-PM	★	6.0	.236	72	2.835	65.1	2.563	28	1.102	0.9	.035	20	290	COROMANT
6.00	.236	30.9	1.217	5	6	860.1-0600-037A1-PM	★	6.0	.236	87	3.425	81.1	3.193	44	1.732	0.9	.035	20	290	COROMANT
6.00	.236	48.9	1.925	8	6	860.1-0600-047A1-PM	★	6.0	.236	97	3.819	96.1	3.783	58	2.283	0.9	.035	20	290	COROMANT

B76 E9 E28 E14

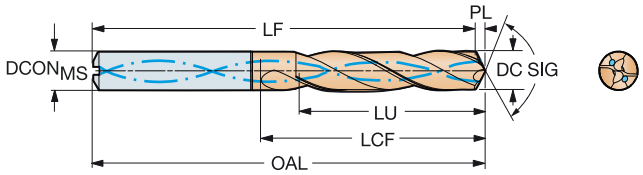
CoroDrill® 860 solid carbide drill

For steel

Internal coolant supply



TCHA H8
SIG 147°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P 4234	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
6.10	.240	19.3	.760	3	8	860.1-0610-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.10	.240	31.5	1.240	5	8	860.1-0610-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.10	.240	49.8	1.961	8	8	860.1-0610-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	66	2.598	1.0	.039	20	290	COROMANT
6.20	.244	19.6	.772	3	8	860.1-0620-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.20	.244	32.0	1.260	5	8	860.1-0620-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.20	.244	50.6	1.992	8	8	860.1-0620-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.30	.248	19.9	.783	3	8	860.1-0630-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.30	.248	32.5	1.280	5	8	860.1-0630-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.30	.248	51.4	2.024	8	8	860.1-0630-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.35	.250	20.1	.791	3	8	860.1-0635-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.35	.250	32.8	1.291	5	8	860.1-0635-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.35	.250	51.8	2.039	8	8	860.1-0635-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.40	.252	20.2	.795	3	8	860.1-0640-024A1-PM	★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.40	.252	33.0	1.299	5	8	860.1-0640-040A1-PM	★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.40	.252	52.2	2.055	8	8	860.1-0640-055A1-PM	★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.50	.256	20.6	.811	3	8	860.1-0650-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.50	.256	33.6	1.323	5	8	860.1-0650-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.50	.256	53.1	2.091	8	8	860.1-0650-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.60	.260	20.9	.823	3	8	860.1-0660-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.60	.260	34.1	1.343	5	8	860.1-0660-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.60	.260	53.9	2.122	8	8	860.1-0660-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.70	.264	21.2	.835	3	8	860.1-0670-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.70	.264	34.6	1.362	5	8	860.1-0670-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.70	.264	54.7	2.154	8	8	860.1-0670-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.75	.266	21.3	.839	3	8	860.1-0675-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.75	.266	34.8	1.370	5	8	860.1-0675-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.75	.266	55.1	2.169	8	8	860.1-0675-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.80	.268	21.5	.846	3	8	860.1-0680-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.80	.268	35.1	1.382	5	8	860.1-0680-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.80	.268	55.5	2.185	8	8	860.1-0680-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.90	.272	21.8	.858	3	8	860.1-0690-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.90	.272	35.6	1.402	5	8	860.1-0690-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.90	.272	56.3	2.217	8	8	860.1-0690-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT
7.00	.276	22.1	.870	3	8	860.1-0700-024A1-PM	★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
7.00	.276	36.1	1.421	5	8	860.1-0700-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.00	.276	57.1	2.248	8	8	860.1-0700-055A1-PM	★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT
7.10	.280	22.4	.882	3	8	860.1-0710-028A1-PM	★	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.10	.280	36.6	1.441	5	8	860.1-0710-040A1-PM	★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.14	.281	22.6	.890	3	8	860.1-0714-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.14	.281	36.9	1.453	5	8	860.1-0714-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.14	.281	58.3	2.295	8	8	860.1-0714-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.20	.283	22.8	.898	3	8	860.1-0720-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.20	.283	37.2	1.465	5	8	860.1-0720-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.30	.287	37.7	1.484	5	8	860.1-0730-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.30	.287	59.6	2.346	8	8	860.1-0730-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.40	.291	23.4	.921	3	8	860.1-0740-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.40	.291	38.2	1.504	5	8	860.1-0740-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.40	.291	60.4	2.378	8	8	860.1-0740-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.50	.295	23.7	.933	3	8	860.1-0750-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.50	.295	38.7	1.524	5	8	860.1-0750-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.50	.295	61.2	2.409	8	8	860.1-0750-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.54	.297	38.9	1.532	5	8	860.1-0754-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L

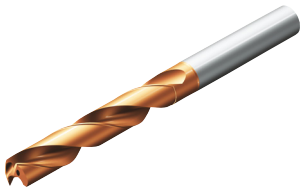
B76 E9 E28 E14

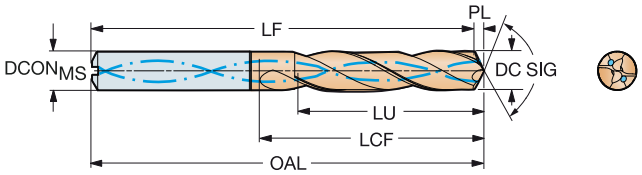
CoroDrill® 860 solid carbide drill

For steel

Internal coolant supply

TCHA H8
SIG 147°





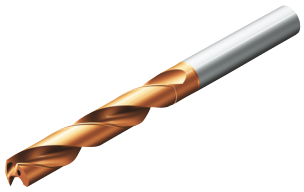
DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	P 4234	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
							Dimensions, mm, inch													
7.60	.299	24.0	.945	3	8	860.1-0760-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.60	.299	62.0	2.441	8	8	860.1-0760-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.70	.303	24.3	.957	3	8	860.1-0770-028A1-PM	★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.70	.303	39.7	1.563	5	8	860.1-0770-040A1-PM	★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.70	.303	62.8	2.472	8	8	860.1-0770-064A1-PM	★	8.0	.315	116	4.567	114.8	4.520	78	3.071	1.2	.047	20	290	COROMANT
7.80	.307	24.7	.972	3	8	860.1-0780-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
7.80	.307	40.3	1.587	5	8	860.1-0780-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
7.80	.307	63.7	2.508	8	8	860.1-0780-064A1-PM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT
7.90	.311	25.0	.984	3	8	860.1-0790-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
7.90	.311	40.8	1.606	5	8	860.1-0790-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
7.94	.313	25.1	.988	3	8	860.1-0794-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
7.94	.313	41.0	1.614	5	8	860.1-0794-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
7.94	.313	64.8	2.551	8	8	860.1-0794-064A1-PM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT
8.00	.315	25.3	.996	3	8	860.1-0800-028A1-PM	★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
8.00	.315	41.3	1.626	5	8	860.1-0800-040A1-PM	★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
8.00	.315	65.3	2.571	8	8	860.1-0800-064A1-PM	★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT
8.10	.319	25.6	1.008	3	10	860.1-0810-031A1-PM	★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.10	.319	41.8	1.646	5	10	860.1-0810-045A1-PM	★	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.10	.319	66.1	2.602	8	10	860.1-0810-080A1-PM	★	10.0	.394	139	5.472	137.7	5.421	94	3.701	1.3	.051	20	290	COROMANT
8.15	.321	42.1	1.657	5	10	860.1-0815-045A1-PM	★	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.20	.323	25.9	1.020	3	10	860.1-0820-031A1-PM	★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.20	.323	42.3	1.665	5	10	860.1-0820-045A1-PM	★	10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.20	.323	66.9	2.634	8	10	860.1-0820-080A1-PM	★	10.0	.394	139	5.472	137.7	5.421	94	3.701	1.3	.051	20	290	COROMANT
8.30	.327	26.3	1.035	3	10	860.1-0830-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.30	.327	42.9	1.689	5	10	860.1-0830-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.30	.327	67.8	2.669	8	10	860.1-0830-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	94	3.701	1.4	.055	20	290	COROMANT
8.33	.328	43.0	1.693	5	10	860.1-0833-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.40	.331	26.6	1.047	3	10	860.1-0840-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.40	.331	43.4	1.709	5	10	860.1-0840-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.40	.331	68.6	2.701	8	10	860.1-0840-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	94	3.701	1.4	.055	20	290	COROMANT
8.50	.335	26.9	1.059	3	10	860.1-0850-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.50	.335	43.9	1.728	5	10	860.1-0850-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.50	.335	69.4	2.732	8	10	860.1-0850-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.60	.339	27.2	1.071	3	10	860.1-0860-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.60	.339	44.4	1.748	5	10	860.1-0860-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.60	.339	70.2	2.764	8	10	860.1-0860-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.70	.343	27.5	1.083	3	10	860.1-0870-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.70	.343	44.9	1.768	5	10	860.1-0870-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.70	.343	71.0	2.795	8	10	860.1-0870-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.73	.344	27.6	1.087	3	10	860.1-0873-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.73	.344	45.1	1.776	5	10	860.1-0873-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.73	.344	71.3	2.807	8	10	860.1-0873-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.80	.346	27.8	1.094	3	10	860.1-0880-031A1-PM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.80	.346	45.4	1.787	5	10	860.1-0880-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.80	.346	71.8	2.827	8	10	860.1-0880-080A1-PM	★	10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.90	.350	45.9	1.807	5	10	860.1-0890-045A1-PM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
9.00	.354	28.5	1.122	3	10	860.1-0900-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.00	.354	46.5	1.831	5	10	860.1-0900-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.00	.354	73.5	2.894	8	10	860.1-0900-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT
9.10	.358	28.8	1.134	3	10	860.1-0910-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.10	.358	47.0	1.850	5	10	860.1-0910-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.10	.358	74.3	2.925	8	10	860.1-0910-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT

B76 E9 E28 E14

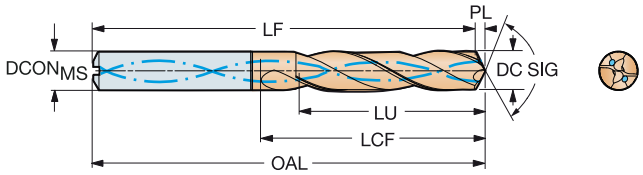
CoroDrill® 860 solid carbide drill

For steel

Internal coolant supply



TCHA H8
SIG 147°



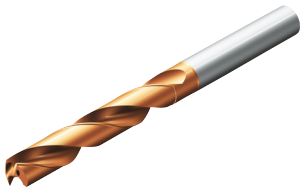
DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	P 4234	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
9.20	.362	29.1	1.146	3	10	860.1-0920-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.20	.362	47.5	1.870	5	10	860.1-0920-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.20	.362	75.1	2.957	8	10	860.1-0920-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT
9.30	.366	29.4	1.157	3	10	860.1-0930-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.30	.366	48.0	1.890	5	10	860.1-0930-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.30	.366	75.9	2.988	8	10	860.1-0930-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT
9.40	.370	29.7	1.169	3	10	860.1-0940-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.40	.370	48.5	1.909	5	10	860.1-0940-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.40	.370	76.7	3.020	8	10	860.1-0940-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT
9.50	.374	30.0	1.181	3	10	860.1-0950-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.50	.374	48.7	1.917	5	10	860.1-0950-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.50	.374	77.5	3.051	8	10	860.1-0950-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT
9.52	.375	30.1	1.185	3	10	860.1-0952-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.52	.375	48.6	1.913	5	10	860.1-0952-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.52	.375	77.7	3.059	8	10	860.1-0952-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT
9.55	.376	48.6	1.913	5	10	860.1-0955-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.60	.378	30.3	1.193	3	10	860.1-0960-031A1-PM	★	10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.60	.378	48.5	1.909	5	10	860.1-0960-045A1-PM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.60	.378	78.3	3.083	8	10	860.1-0960-080A1-PM	★	10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT
9.70	.382	30.7	1.209	3	10	860.1-0970-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.70	.382	79.2	3.118	8	10	860.1-0970-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.80	.386	31.0	1.220	3	10	860.1-0980-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.80	.386	48.3	1.902	4	10	860.1-0980-045A1-PM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
9.80	.386	80.0	3.150	8	10	860.1-0980-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.90	.390	31.3	1.232	3	10	860.1-0990-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.90	.390	48.1	1.894	4	10	860.1-0990-045A1-PM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
9.90	.390	80.8	3.181	8	10	860.1-0990-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.92	.391	81.0	3.189	8	10	860.1-0992-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
10.00	.394	31.6	1.244	3	10	860.1-1000-031A1-PM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
10.00	.394	48.0	1.890	4	10	860.1-1000-045A1-PM	★	10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
10.00	.394	81.6	3.213	8	10	860.1-1000-080A1-PM	★	10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
10.10	.398	31.9	1.256	3	12	860.1-1010-037A1-PM	★	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
10.10	.398	52.1	2.051	5	12	860.1-1010-053A1-PM	★	12.0	.472	118	4.646	116.4	4.583	71	2.795	1.6	.063	20	290	DIN 6537 L
10.10	.398	82.4	3.244	8	12	860.1-1010-098A1-PM	★	12.0	.472	163	6.417	161.4	6.354	114	4.488	1.6	.063	20	290	COROMANT
10.20	.402	32.3	1.272	3	12	860.1-1020-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.20	.402	52.7	2.075	5	12	860.1-1020-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.20	.402	83.3	3.280	8	12	860.1-1020-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	114	4.488	1.7	.067	20	290	COROMANT
10.30	.406	32.6	1.283	3	12	860.1-1030-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.30	.406	53.2	2.094	5	12	860.1-1030-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.30	.406	84.1	3.311	8	12	860.1-1030-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	114	4.488	1.7	.067	20	290	COROMANT
10.32	.406	32.6	1.283	3	12	860.1-1032-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.32	.406	53.3	2.098	5	12	860.1-1032-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.40	.409	32.9	1.295	3	12	860.1-1040-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.40	.409	53.7	2.114	5	12	860.1-1040-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.40	.409	84.9	3.343	8	12	860.1-1040-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	115	4.528	1.7	.067	20	290	COROMANT
10.50	.413	33.2	1.307	3	12	860.1-1050-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.50	.413	54.2	2.134	5	12	860.1-1050-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.50	.413	85.7	3.374	8	12	860.1-1050-098A1-PM	★	12.0	.472	163	6.417	161.3	6.350	115	4.528	1.7	.067	20	290	COROMANT
10.60	.417	54.7	2.154	5	12	860.1-1060-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.70	.421	33.8	1.331	3	12	860.1-1070-037A1-PM	★	12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.70	.421	55.2	2.173	5	12	860.1-1070-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.71	.422	55.3	2.177	5	12	860.1-1071-053A1-PM	★	12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L

B76 E9 E28 E14

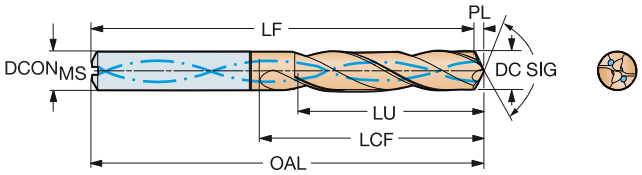
CoroDrill® 860 solid carbide drill

For steel

Internal coolant supply



TCHA H8
SIG 147°



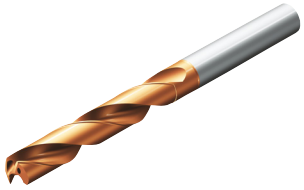
DC	DC"	LU	LU"	ULDR	CZCMS	Ordering code	P 4234	DCONMS	DCONMS"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
10.80	.425	34.2	1.346	3	12	860.1-1080-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
10.80	.425	55.8	2.197	5	12	860.1-1080-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
10.80	.425	88.2	3.472	8	12	860.1-1080-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
10.90	.429	56.3	2.217	5	12	860.1-1090-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.00	.433	34.8	1.370	3	12	860.1-1100-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.00	.433	56.8	2.236	5	12	860.1-1100-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.00	.433	89.8	3.535	8	12	860.1-1100-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.10	.437	35.1	1.382	3	12	860.1-1110-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.10	.437	57.3	2.256	5	12	860.1-1110-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.10	.437	90.6	3.567	8	12	860.1-1110-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.11	.437	35.1	1.382	3	12	860.1-1111-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.11	.437	90.7	3.571	8	12	860.1-1111-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.20	.441	35.4	1.394	3	12	860.1-1120-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.20	.441	57.6	2.268	5	12	860.1-1120-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.20	.441	91.4	3.598	8	12	860.1-1120-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.30	.445	35.7	1.406	3	12	860.1-1130-037A1-PM	★	12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.30	.445	57.4	2.260	5	12	860.1-1130-053A1-PM	★	12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.30	.445	92.2	3.630	8	12	860.1-1130-098A1-PM	★	12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.40	.449	36.1	1.421	3	12	860.1-1140-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.50	.453	36.4	1.433	3	12	860.1-1150-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.50	.453	57.2	2.252	4	12	860.1-1150-053A1-PM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.50	.453	93.9	3.697	8	12	860.1-1150-098A1-PM	★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT
11.60	.457	36.7	1.445	3	12	860.1-1160-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.70	.461	37.0	1.457	3	12	860.1-1170-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.70	.461	57.0	2.244	4	12	860.1-1170-053A1-PM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.80	.465	37.3	1.469	3	12	860.1-1180-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.80	.465	56.8	2.236	4	12	860.1-1180-053A1-PM	★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.80	.465	96.3	3.791	8	12	860.1-1180-098A1-PM	★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT
11.90	.469	37.6	1.480	3	12	860.1-1190-037A1-PM	★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.90	.469	97.1	3.823	8	12	860.1-1190-098A1-PM	★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT
12.00	.472	38.0	1.496	3	12	860.1-1200-037A1-PM	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079	20	290	DIN 6537 K
12.00	.472	56.6	2.228	4	12	860.1-1200-053A1-PM	★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079	20	290	DIN 6537 L
12.00	.472	98.0	3.858	8	12	860.1-1200-098A1-PM	★	12.0	.472	163	6.417	161.0	6.339	116	4.567	2.0	.079	20	290	COROMANT
12.10	.476	38.3	1.508	3	14	860.1-1210-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.10	.476	62.5	2.461	5	14	860.1-1210-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.10	.476	98.8	3.890	8	14	860.1-1210-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.20	.480	38.6	1.520	3	14	860.1-1220-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.20	.480	62.4	2.457	5	14	860.1-1220-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.20	.480	99.6	3.921	8	14	860.1-1220-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.30	.484	38.9	1.532	3	14	860.1-1230-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.30	.484	62.2	2.449	5	14	860.1-1230-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.30	.484	100.4	3.953	8	14	860.1-1230-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.50	.492	39.5	1.555	3	14	860.1-1250-040A1-PM	★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.50	.492	62.0	2.441	4	14	860.1-1250-057A1-PM	★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.50	.492	102.0	4.016	8	14	860.1-1250-115A1-PM	★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.60	.496	39.9	1.571	3	14	860.1-1260-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
12.70	.500	40.2	1.583	3	14	860.1-1270-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
12.70	.500	61.8	2.433	4	14	860.1-1270-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
12.70	.500	103.7	4.083	8	14	860.1-1270-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT
12.80	.504	40.5	1.594	3	14	860.1-1280-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
12.80	.504	61.6	2.425	4	14	860.1-1280-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
12.80	.504	104.5	4.114	8	14	860.1-1280-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT

B76 E9 E28 E14

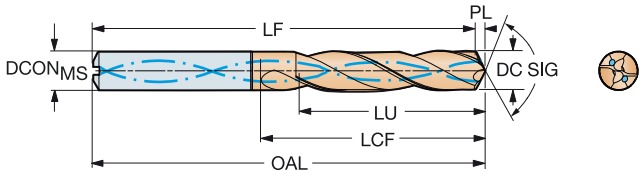
CoroDrill® 860 solid carbide drill

For steel

Internal coolant supply



TCHA H8
SIG 147°



DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	P 4234	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
13.00	.512	41.1	1.618	3	14	860.1-1300-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
13.00	.512	61.4	2.417	4	14	860.1-1300-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
13.00	.512	106.1	4.177	8	14	860.1-1300-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT
13.10	.516	41.4	1.630	3	14	860.1-1310-040A1-PM	★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
13.10	.516	61.3	2.413	4	14	860.1-1310-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
13.10	.516	106.9	4.209	8	14	860.1-1310-115A1-PM	★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT
13.25	.522	61.1	2.406	4	14	860.1-1325-057A1-PM	★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
13.50	.531	42.7	1.681	3	14	860.1-1350-040A1-PM	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.2	.087	20	290	DIN 6537 K
13.50	.531	60.8	2.394	4	14	860.1-1350-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L
13.50	.531	110.2	4.339	8	14	860.1-1350-115A1-PM	★	14.0	.551	182	7.165	179.8	7.079	134	5.276	2.2	.087	20	290	COROMANT
13.75	.541	60.5	2.382	4	14	860.1-1375-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L
13.80	.543	43.4	1.709	3	14	860.1-1380-040A1-PM	★	14.0	.551	107	4.213	104.8	4.126	60	2.362	2.2	.087	20	290	DIN 6537 K
13.80	.543	60.4	2.378	4	14	860.1-1380-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L
13.80	.543	112.6	4.433	8	14	860.1-1380-115A1-PM	★	14.0	.551	182	7.165	179.8	7.079	134	5.276	2.2	.087	20	290	COROMANT
13.89	.547	60.3	2.374	4	14	860.1-1389-057A1-PM	★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L
14.00	.551	44.3	1.744	3	14	860.1-1400-040A1-PM	★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.091	20	290	DIN 6537 K
14.00	.551	63.0	2.480	4	14	860.1-1400-057A1-PM	★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.3	.091	20	290	DIN 6537 L
14.00	.551	114.3	4.500	8	14	860.1-1400-115A1-PM	★	14.0	.551	182	7.165	179.7	7.075	134	5.276	2.3	.091	20	290	COROMANT
14.25	.561	45.0	1.772	3	16	860.1-1425-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K
14.25	.561	68.8	2.709	4	16	860.1-1425-062A1-PM	★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
14.29	.563	45.2	1.780	3	16	860.1-1429-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K
14.29	.563	68.7	2.705	4	16	860.1-1429-062A1-PM	★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
14.50	.571	45.8	1.803	3	16	860.1-1450-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K
14.50	.571	68.5	2.697	4	16	860.1-1450-062A1-PM	★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
14.69	.578	46.4	1.827	3	16	860.1-1469-044A1-PM	★	16.0	.630	115	4.528	112.7	4.437	65	2.559	2.3	.091	20	290	DIN 6537 K
14.80	.583	68.2	2.685	4	16	860.1-1480-062A1-PM	★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
15.00	.591	47.4	1.866	3	16	860.1-1500-044A1-PM	★	16.0	.630	115	4.528	112.6	4.433	65	2.559	2.4	.094	20	290	DIN 6537 K
15.00	.591	68.0	2.677	4	16	860.1-1500-062A1-PM	★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
15.50	.610	49.0	1.929	3	16	860.1-1550-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K
15.50	.610	67.5	2.657	4	16	860.1-1550-062A1-PM	★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L
15.80	.622	49.2	1.937	3	16	860.1-1580-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K
15.80	.622	67.2	2.646	4	16	860.1-1580-062A1-PM	★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L
15.87	.625	49.1	1.933	3	16	860.1-1587-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K
16.00	.630	49.0	1.929	3	16	860.1-1600-044A1-PM	★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K
16.00	.630	67.0	2.638	4	16	860.1-1600-062A1-PM	★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L
16.00	.630	130.5	5.138	8	16	860.1-1600-133A1-PM	★	16.0	.630	204	8.032	201.5	7.933	154	6.063	2.5	.098	20	290	COROMANT
16.50	.650	52.1	2.051	3	18	860.1-1650-050A1-PM	★	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	20	290	DIN 6537 K
16.50	.650	76.5	3.012	4	18	860.1-1650-070A1-PM	★	18.0	.709	143	5.630	140.4	5.528	93	3.661	2.6	.102	20	290	DIN 6537 L
16.80	.661	53.0	2.087	3	18	860.1-1680-050A1-PM	★	18.0	.709	123	4.843	120.4	4.740	73	2.874	2.6	.102	20	290	DIN 6537 K
17.00	.669	76.0	2.992	4	18	860.1-1700-070A1-PM	★	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L
17.50	.689	55.2	2.173	3	18	860.1-1750-050A1-PM	★	18.0	.709	123	4.843	120.3	4.736	73	2.874	2.7	.106	20	290	DIN 6537 K
17.50	.689	75.5	2.972	4	18	860.1-1750-070A1-PM	★	18.0	.709	143	5.630	140.3	5.524	93	3.661	2.7	.106	20	290	DIN 6537 L
17.80	.701	75.2	2.961	4	18	860.1-1780-070A1-PM	★	18.0	.709	143	5.630	140.2	5.520	93	3.661	2.8	.110	20	290	DIN 6537 L
18.00	.709	56.8	2.236	3	18	860.1-1800-050A1-PM	★	18.0	.709	123	4.843	120.2	4.732	73	2.874	2.8	.110	20	290	DIN 6537 K
18.00	.709	78.6	3.094	4	18	860.1-1800-070A1-PM	★	18.0	.709	143	5.630	140.2	5.520	93	3.661	2.8	.110	20	290	DIN 6537 L
18.50	.728	58.4	2.299	3	20	860.1-1850-055A1-PM	★	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K
18.80	.740	59.3	2.335	3	20	860.1-1880-055A1-PM	★	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K
18.80	.740	86.0	3.386	4	20	860.1-1880-077A1-PM	★	20.0	.787	153	6.024	150.1	5.909	101	3.976	2.9	.114	20	290	DIN 6537 L
19.00	.748	59.9	2.358	3	20	860.1-1900-055A1-PM	★	20.0	.787	131	5.157	128.1	5.043	79	3.110	2.9	.114	20	290	DIN 6537 K
20.00	.787	63.0	2.480	3	20	860.1-2000-055A1-PM	★	20.0	.787	131	5.157	127.9	5.035	79	3.110	3.1	.122	20	290	DIN 6537 K

B76 E9 E28 E14

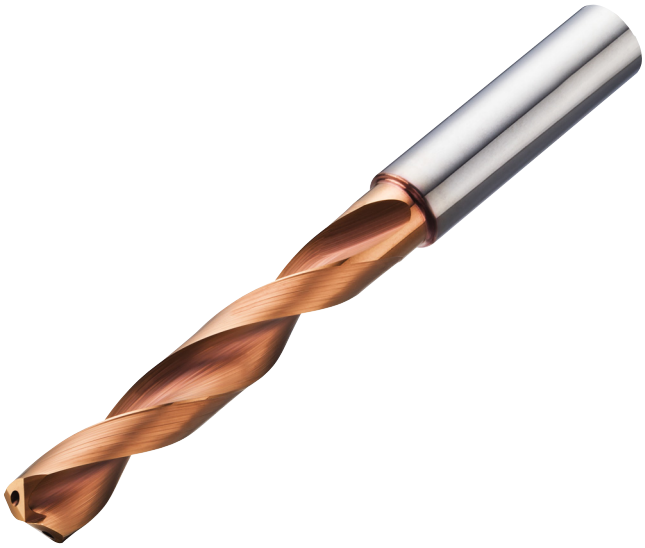
CoroDrill® 860

High performance drills optimized for stainless steel

O C

Application

860-MM: Long-chipping, stainless steel materials such as austenitic, super austenitic, ferritic, and duplex stainless steels



ISO application area:

M

Features and benefits

- Optimized cutting data
- Low cost per hole
- Improved performance reliability
- Trouble-free chip evacuation
- Long tool life, controlled wear formation
- Consistent hole tolerance
- Can be reconditioned up to 3 times to its original specification

www.sandvik.coromant.com/corodrill860

Recommendations

It is recommended to use hydraulic precision chucks.
It is recommended to use internal coolant, minimum recommended pressure 20 bar

For chucks, see our Rotating Tools catalog.

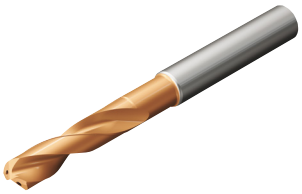
E14

SANDVIK Coromant

CoroDrill® 860 solid carbide drill

For stainless steel

Internal coolant supply



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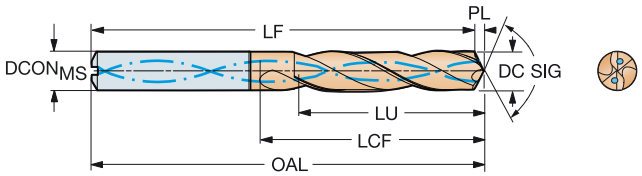
SIG 140°



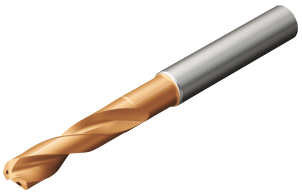
DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	M	2214	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
									Dimensions, mm, inch												
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-MM	★		6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-MM	★		6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.00	.118	24.0	.945	8	6	860.1-0300-024A1-MM	★		6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.10	.122	9.8	.386	3	6	860.1-0310-009A1-MM	★		6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.10	.122	25.0	.984	8	6	860.1-0310-025A1-MM	★		6.0	.236	74	2.913	73.5	2.894	34	1.339	0.5	.020	20	290	COROMANT
3.18	.125	16.4	.646	5	6	860.1-0318-016A1-MM	★		6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.20	.126	16.5	.650	5	6	860.1-0320-016A1-MM	★		6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.30	.130	10.4	.409	3	6	860.1-0330-010A1-MM	★		6.0	.236	62	2.441	61.5	2.421	20	.787	0.5	.020	20	290	DIN 6537 K
3.30	.130	17.0	.669	5	6	860.1-0330-017A1-MM	★		6.0	.236	66	2.598	65.5	2.579	28	1.102	0.5	.020	20	290	DIN 6537 L
3.30	.130	26.0	1.024	7	6	860.1-0330-026A1-MM	★		6.0	.236	74	2.913	73.5	2.894	35	1.378	0.5	.020	20	290	COROMANT
3.40	.134	27.0	1.063	7	6	860.1-0340-027A1-MM	★		6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-MM	★		6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-MM	★		6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.50	.138	28.0	1.102	8	6	860.1-0350-028A1-MM	★		6.0	.236	74	2.913	73.4	2.890	35	1.378	0.6	.024	20	290	COROMANT
3.60	.142	11.4	.449	3	6	860.1-0360-011A1-MM	★		6.0	.236	62	2.441	61.4	2.417	20	.787	0.6	.024	20	290	DIN 6537 K
3.70	.146	19.1	.752	5	6	860.1-0370-019A1-MM	★		6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 L
3.70	.146	30.0	1.181	8	6	860.1-0370-030A1-MM	★		6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	COROMANT
3.80	.150	12.0	.472	3	6	860.1-0380-011A1-MM	★		6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
3.80	.150	19.6	.772	5	6	860.1-0380-019A1-MM	★		6.0	.236	74	2.913	73.4	2.890	36	1.417	0.6	.024	20	290	DIN 6537 L
3.80	.150	30.0	1.181	7	6	860.1-0380-030A1-MM	★		6.0	.236	85	3.346	84.4	3.323	44	1.732	0.6	.024	20	290	COROMANT
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-MM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-MM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.00	.157	32.0	1.260	8	6	860.1-0400-032A1-MM	★		6.0	.236	85	3.346	84.3	3.319	44	1.732	0.7	.028	20	290	COROMANT
4.20	.165	13.3	.524	3	6	860.1-0420-013A1-MM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.20	.165	21.7	.854	5	6	860.1-0420-021A1-MM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.20	.165	34.0	1.339	8	6	860.1-0420-034A1-MM	★		6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT
4.30	.169	13.6	.535	3	6	860.1-0430-013A1-MM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.30	.169	22.2	.874	5	6	860.1-0430-022A1-MM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.30	.169	34.0	1.339	7	6	860.1-0430-034A1-MM	★		6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT
4.37	.172	13.8	.543	3	6	860.1-0437-013A1-MM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.37	.172	22.5	.886	5	6	860.1-0437-022A1-MM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.40	.173	13.9	.547	3	6	860.1-0440-013A1-MM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.40	.173	22.7	.894	5	6	860.1-0440-022A1-MM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.40	.173	35.0	1.378	7	6	860.1-0440-035A1-MM	★		6.0	.236	85	3.346	84.3	3.319	45	1.772	0.7	.028	20	290	COROMANT
4.50	.177	14.2	.559	3	6	860.1-0450-014A1-MM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.7	.028	20	290	DIN 6537 K
4.50	.177	23.2	.913	5	6	860.1-0450-023A1-MM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.7	.028	20	290	DIN 6537 L
4.50	.177	36.0	1.417	8	6	860.1-0450-036A1-MM	★		6.0	.236	85	3.346	84.3	3.319	46	1.811	0.7	.028	20	290	COROMANT
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-MM	★		6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.60	.181	37.0	1.457	8	6	860.1-0460-037A1-MM	★		6.0	.236	85	3.346	84.2	3.315	46	1.811	0.8	.031	20	290	COROMANT
4.70	.185	24.3	.957	5	6	860.1-0470-024A1-MM	★		6.0	.236	74	2.913	73.2	2.882	36	1.417	0.8	.031	20	290	DIN 6537 L
4.76	.187	15.1	.594	3	6	860.1-0476-014A1-MM	★		6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
4.80	.189	15.2	.598	3	6	860.1-0480-014A1-MM	★		6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
4.80	.189	38.0	1.496	7	6	860.1-0480-038A1-MM	★		6.0	.236	97	3.819	96.2	3.787	56	2.205	0.8	.031	20	290	COROMANT
4.90	.193	25.3	.996	5	6	860.1-0490-025A1-MM	★		6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.00	.197	15.8	.622	3	6	860.1-0500-015A1-MM	★		6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.00	.197	25.8	1.016	5	6	860.1-0500-025A1-MM	★		6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.00	.197	40.0	1.575	8	6	860.1-0500-040A1-MM	★		6.0	.236	97	3.819	96.2	3.787	57	2.244	0.8	.031	20	290	COROMANT
5.10	.201	16.1	.634	3	6	860.1-0510-015A1-MM	★		6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.10	.201	26.3	1.035	5	6	860.1-0510-026A1-MM	★		6.0	.236	82	3.228	81.2	3.197	44	1.732	0.8	.031	20	290	DIN 6537 L
5.16	.203	16.3	.642	3	6	860.1-0516-016A1-MM	★		6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-MM	★		6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K

B81 E9 E28 E14

CoroDrill® 860 solid carbide drill

For stainless steel

Internal coolant supply



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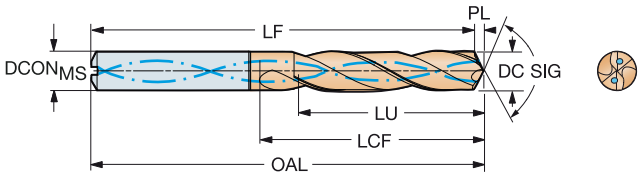


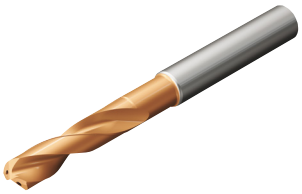
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	M	2214	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
									Dimensions, mm, inch												
5.20	.205	26.9	1.059	5	6	860.1-0520-026A1-MM		★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
5.30	.209	27.4	1.079	5	6	860.1-0530-027A1-MM		★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
5.50	.217	17.4	.685	3	6	860.1-0550-017A1-MM		★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K
5.50	.217	28.4	1.118	5	6	860.1-0550-028A1-MM		★	6.0	.236	82	3.228	81.1	3.193	44	1.732	0.9	.035	20	290	DIN 6537 L
5.50	.217	44.0	1.732	8	6	860.1-0550-044A1-MM		★	6.0	.236	97	3.819	96.1	3.783	57	2.244	0.9	.035	20	290	COROMANT
5.56	.219	17.6	.693	3	6	860.1-0556-017A1-MM		★	6.0	.236	66	2.598	65.1	2.563	28	1.102	0.9	.035	20	290	DIN 6537 K
5.80	.228	17.6	.693	3	6	860.1-0580-017A1-MM		★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039	20	290	DIN 6537 K
5.80	.228	46.0	1.811	7	6	860.1-0580-046A1-MM		★	6.0	.236	97	3.819	96.0	3.780	58	2.283	1.0	.039	20	290	COROMANT
5.90	.232	30.5	1.201	5	6	860.1-0590-030A1-MM		★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039	20	290	DIN 6537 L
6.00	.236	19.0	.748	3	6	860.1-0600-018A1-MM		★	6.0	.236	66	2.598	65.0	2.559	28	1.102	1.0	.039	20	290	DIN 6537 K
6.00	.236	31.0	1.220	5	6	860.1-0600-030A1-MM		★	6.0	.236	82	3.228	81.0	3.189	44	1.732	1.0	.039	20	290	DIN 6537 L
6.00	.236	48.0	1.890	8	6	860.1-0600-048A1-MM		★	6.0	.236	97	3.819	96.0	3.780	58	2.283	1.0	.039	20	290	COROMANT
6.10	.240	31.5	1.240	5	8	860.1-0610-031A1-MM		★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.10	.240	49.0	1.929	8	8	860.1-0610-049A1-MM		★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.20	.244	32.0	1.260	5	8	860.1-0620-031A1-MM		★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.20	.244	50.0	1.969	8	8	860.1-0620-050A1-MM		★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.35	.250	20.1	.791	3	8	860.1-0635-019A1-MM		★	8.0	.315	79	3.110	78.0	3.071	34	1.339	1.0	.039	20	290	DIN 6537 K
6.35	.250	32.8	1.291	5	8	860.1-0635-032A1-MM		★	8.0	.315	91	3.583	90.0	3.543	53	2.087	1.0	.039	20	290	DIN 6537 L
6.35	.250	51.0	2.008	8	8	860.1-0635-051A1-MM		★	8.0	.315	106	4.173	105.0	4.134	67	2.638	1.0	.039	20	290	COROMANT
6.50	.256	20.6	.811	3	8	860.1-0650-020A1-MM		★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.50	.256	33.6	1.323	5	8	860.1-0650-033A1-MM		★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.50	.256	52.0	2.047	8	8	860.1-0650-052A1-MM		★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.60	.260	20.9	.823	3	8	860.1-0660-020A1-MM		★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.60	.260	34.1	1.343	5	8	860.1-0660-033A1-MM		★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.70	.264	34.6	1.362	5	8	860.1-0670-034A1-MM		★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.75	.266	21.3	.839	3	8	860.1-0675-020A1-MM		★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.80	.268	21.5	.846	3	8	860.1-0680-020A1-MM		★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.80	.268	35.1	1.382	5	8	860.1-0680-034A1-MM		★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.80	.268	54.0	2.126	7	8	860.1-0680-054A1-MM		★	8.0	.315	106	4.173	104.9	4.130	67	2.638	1.1	.043	20	290	COROMANT
6.90	.272	21.8	.858	3	8	860.1-0690-021A1-MM		★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
6.90	.272	35.6	1.402	5	8	860.1-0690-035A1-MM		★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
6.90	.272	55.0	2.165	7	8	860.1-0690-055A1-MM		★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT
7.00	.276	22.1	.870	3	8	860.1-0700-021A1-MM		★	8.0	.315	79	3.110	77.9	3.067	34	1.339	1.1	.043	20	290	DIN 6537 K
7.00	.276	36.1	1.421	5	8	860.1-0700-035A1-MM		★	8.0	.315	91	3.583	89.9	3.539	53	2.087	1.1	.043	20	290	DIN 6537 L
7.00	.276	56.0	2.205	8	8	860.1-0700-056A1-MM		★	8.0	.315	106	4.173	104.9	4.130	68	2.677	1.1	.043	20	290	COROMANT
7.10	.280	57.0	2.244	8	8	860.1-0710-057A1-MM		★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.14	.281	22.6	.890	3	8	860.1-0714-021A1-MM		★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.14	.281	57.0	2.244	7	8	860.1-0714-057A1-MM		★	8.0	.315	116	4.567	114.8	4.520	77	3.032	1.2	.047	20	290	COROMANT
7.40	.291	23.4	.921	3	8	860.1-0740-022A1-MM		★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.50	.295	23.7	.933	3	8	860.1-0750-023A1-MM		★	8.0	.315	79	3.110	77.8	3.063	41	1.614	1.2	.047	20	290	DIN 6537 K
7.50	.295	38.7	1.524	5	8	860.1-0750-038A1-MM		★	8.0	.315	91	3.583	89.8	3.535	53	2.087	1.2	.047	20	290	DIN 6537 L
7.80	.307	24.7	.972	3	8	860.1-0780-023A1-MM		★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
7.80	.307	40.3	1.587	5	8	860.1-0780-039A1-MM		★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
7.80	.307	62.0	2.441	7	8	860.1-0780-062A1-MM		★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT
7.94	.313	64.0	2.520	8	8	860.1-0794-064A1-MM		★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT
8.00	.315	25.3	.996	3	8	860.1-0800-024A1-MM		★	8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
8.00	.315	41.3	1.626	5	8	860.1-0800-040A1-MM		★	8.0	.315	91	3.583	89.7	3.532	53	2.087	1.3	.051	20	290	DIN 6537 L
8.00	.315	64.0	2.520	8	8	860.1-0800-064A1-MM		★	8.0	.315	116	4.567	114.7	4.516	78	3.071	1.3	.051	20	290	COROMANT
8.10	.319	25.6	1.008	3	10	860.1-0810-024A1-MM		★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
8.10	.319	65.0	2.559	8	10	860.1-0810-065A1-MM		★	10.0	.394	139	5.472	137.7	5.421	94	3.701	1.3	.051	20	290	COROMANT
8.20	.323	25.9	1.020	3	10	860.1-0820-025A1-MM		★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K

B81 E9 E28 E14

CoroDrill® 860 solid carbide drill

For stainless steel

Internal coolant supply



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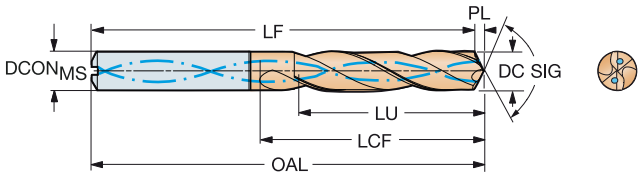


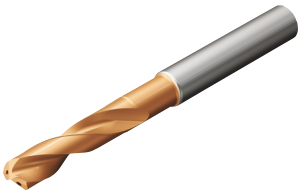
DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	M	2214	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
									Dimensions, mm, inch												
8.20	.323	42.3	1.665	5	10	860.1-0820-041A1-MM	★		10.0	.394	103	4.055	101.7	4.004	61	2.402	1.3	.051	20	290	DIN 6537 L
8.40	.331	43.4	1.709	5	10	860.1-0840-042A1-MM	★		10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.50	.335	26.9	1.059	3	10	860.1-0850-026A1-MM	★		10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.50	.335	43.9	1.728	5	10	860.1-0850-043A1-MM	★		10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.50	.335	68.0	2.677	8	10	860.1-0850-068A1-MM	★		10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.60	.339	27.2	1.071	3	10	860.1-0860-026A1-MM	★		10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.60	.339	44.4	1.748	5	10	860.1-0860-043A1-MM	★		10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.60	.339	69.0	2.717	8	10	860.1-0860-069A1-MM	★		10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.70	.343	27.5	1.083	3	10	860.1-0870-026A1-MM	★		10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.70	.343	44.9	1.768	5	10	860.1-0870-044A1-MM	★		10.0	.394	103	4.055	101.6	4.000	61	2.402	1.4	.055	20	290	DIN 6537 L
8.70	.343	70.0	2.756	8	10	860.1-0870-070A1-MM	★		10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
8.80	.346	27.8	1.094	3	10	860.1-0880-026A1-MM	★		10.0	.394	89	3.504	87.6	3.449	47	1.850	1.4	.055	20	290	DIN 6537 K
8.80	.346	70.0	2.756	7	10	860.1-0880-070A1-MM	★		10.0	.394	139	5.472	137.6	5.417	95	3.740	1.4	.055	20	290	COROMANT
9.00	.354	28.5	1.122	3	10	860.1-0900-027A1-MM	★		10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.00	.354	46.5	1.831	5	10	860.1-0900-045A1-MM	★		10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.00	.354	72.0	2.835	8	10	860.1-0900-072A1-MM	★		10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT
9.10	.358	73.0	2.874	8	10	860.1-0910-073A1-MM	★		10.0	.394	139	5.472	137.5	5.413	95	3.740	1.5	.059	20	290	COROMANT
9.30	.366	29.4	1.157	3	10	860.1-0930-028A1-MM	★		10.0	.394	89	3.504	87.5	3.445	47	1.850	1.5	.059	20	290	DIN 6537 K
9.30	.366	48.0	1.890	5	10	860.1-0930-047A1-MM	★		10.0	.394	103	4.055	101.5	3.996	61	2.402	1.5	.059	20	290	DIN 6537 L
9.40	.370	75.0	2.953	7	10	860.1-0940-075A1-MM	★		10.0	.394	139	5.472	137.5	5.413	96	3.780	1.5	.059	20	290	COROMANT
9.50	.374	30.1	1.185	3	10	860.1-0950-029A1-MM	★		10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.50	.374	48.7	1.917	5	10	860.1-0950-048A1-MM	★		10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
9.50	.374	76.0	2.992	8	10	860.1-0950-076A1-MM	★		10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.53	.375	76.0	2.992	7	10	860.1-0953-076A1-MM	★		10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.60	.378	30.4	1.197	3	10	860.1-0960-029A1-MM	★		10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.60	.378	77.0	3.032	8	10	860.1-0960-077A1-MM	★		10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
9.80	.386	31.0	1.220	3	10	860.1-0980-029A1-MM	★		10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
9.80	.386	48.3	1.902	4	10	860.1-0980-049A1-MM	★		10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
10.00	.394	31.6	1.244	3	10	860.1-1000-030A1-MM	★		10.0	.394	89	3.504	87.4	3.441	47	1.850	1.6	.063	20	290	DIN 6537 K
10.00	.394	48.0	1.890	4	10	860.1-1000-050A1-MM	★		10.0	.394	103	4.055	101.4	3.992	61	2.402	1.6	.063	20	290	DIN 6537 L
10.00	.394	80.0	3.150	8	10	860.1-1000-080A1-MM	★		10.0	.394	139	5.472	137.4	5.409	96	3.780	1.6	.063	20	290	COROMANT
10.10	.398	52.2	2.055	5	12	860.1-1010-051A1-MM	★		12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.20	.402	32.3	1.272	3	12	860.1-1020-031A1-MM	★		12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.20	.402	52.7	2.075	5	12	860.1-1020-051A1-MM	★		12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.30	.406	32.6	1.283	3	12	860.1-1030-031A1-MM	★		12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.30	.406	53.2	2.094	5	12	860.1-1030-052A1-MM	★		12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.30	.406	82.0	3.228	7	12	860.1-1030-082A1-MM	★		12.0	.472	163	6.417	161.3	6.350	114	4.488	1.7	.067	20	290	COROMANT
10.50	.413	33.2	1.307	3	12	860.1-1050-032A1-MM	★		12.0	.472	102	4.016	100.3	3.949	55	2.165	1.7	.067	20	290	DIN 6537 K
10.50	.413	54.2	2.134	5	12	860.1-1050-053A1-MM	★		12.0	.472	118	4.646	116.3	4.579	71	2.795	1.7	.067	20	290	DIN 6537 L
10.50	.413	84.0	3.307	8	12	860.1-1050-084A1-MM	★		12.0	.472	163	6.417	161.3	6.350	115	4.528	1.7	.067	20	290	COROMANT
10.80	.425	34.2	1.346	3	12	860.1-1080-032A1-MM	★		12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.00	.433	34.8	1.370	3	12	860.1-1100-033A1-MM	★		12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.00	.433	56.8	2.236	5	12	860.1-1100-055A1-MM	★		12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.00	.433	88.0	3.465	8	12	860.1-1100-088A1-MM	★		12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.10	.437	35.1	1.382	3	12	860.1-1110-033A1-MM	★		12.0	.472	102	4.016	100.2	3.945	55	2.165	1.8	.071	20	290	DIN 6537 K
11.11	.437	89.0	3.504	8	12	860.1-1111-089A1-MM	★		12.0	.472	163	6.417	161.2	6.346	115	4.528	1.8	.071	20	290	COROMANT
11.20	.441	57.6	2.268	5	12	860.1-1120-056A1-MM	★		12.0	.472	118	4.646	116.2	4.575	71	2.795	1.8	.071	20	290	DIN 6537 L
11.50	.453	36.4	1.433	3	12	860.1-1150-035A1-MM	★		12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.50	.453	57.2	2.252	4	12	860.1-1150-058A1-MM	★		12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.70	.461	37.0	1.457	3	12	860.1-1170-035A1-MM	★		12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K

B81 E9 E28 E14

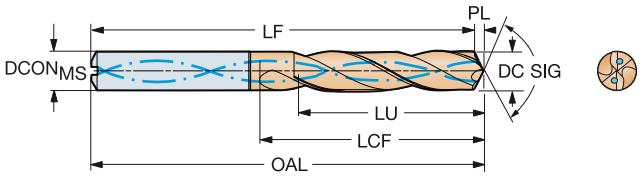
CoroDrill® 860 solid carbide drill

For stainless steel

Internal coolant supply



TCHA H8
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	M	2214	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
							Dimensions, mm, inch														
11.80	.465	37.3	1.469	3	12	860.1-1180-035A1-MM		★	12.0	.472	102	4.016	100.1	3.941	55	2.165	1.9	.075	20	290	DIN 6537 K
11.80	.465	56.8	2.236	4	12	860.1-1180-059A1-MM		★	12.0	.472	118	4.646	116.1	4.571	71	2.795	1.9	.075	20	290	DIN 6537 L
11.80	.465	94.0	3.701	7	12	860.1-1180-094A1-MM		★	12.0	.472	163	6.417	161.1	6.343	116	4.567	1.9	.075	20	290	COROMANT
12.00	.472	38.0	1.496	3	12	860.1-1200-036A1-MM		★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.0	.079	20	290	DIN 6537 K
12.00	.472	56.6	2.228	4	12	860.1-1200-060A1-MM		★	12.0	.472	118	4.646	116.0	4.567	71	2.795	2.0	.079	20	290	DIN 6537 L
12.00	.472	96.0	3.780	8	12	860.1-1200-096A1-MM		★	12.0	.472	163	6.417	161.0	6.339	116	4.567	2.0	.079	20	290	COROMANT
12.20	.480	38.6	1.520	3	14	860.1-1220-037A1-MM		★	14.0	.551	107	4.213	105.0	4.134	60	2.362	2.0	.079	20	290	DIN 6537 K
12.50	.492	62.0	2.441	4	14	860.1-1250-063A1-MM		★	14.0	.551	124	4.882	122.0	4.803	77	3.032	2.0	.079	20	290	DIN 6537 L
12.50	.492	100.0	3.937	8	14	860.1-1250-100A1-MM		★	14.0	.551	182	7.165	180.0	7.087	133	5.236	2.0	.079	20	290	COROMANT
12.70	.500	40.2	1.583	3	14	860.1-1270-038A1-MM		★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
12.70	.500	61.8	2.433	4	14	860.1-1270-064A1-MM		★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
12.80	.504	40.5	1.594	3	14	860.1-1280-038A1-MM		★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
13.00	.512	41.1	1.618	3	14	860.1-1300-039A1-MM		★	14.0	.551	107	4.213	104.9	4.130	60	2.362	2.1	.083	20	290	DIN 6537 K
13.00	.512	61.4	2.417	4	14	860.1-1300-065A1-MM		★	14.0	.551	124	4.882	121.9	4.799	77	3.032	2.1	.083	20	290	DIN 6537 L
13.00	.512	104.0	4.094	8	14	860.1-1300-104A1-MM		★	14.0	.551	182	7.165	179.9	7.083	134	5.276	2.1	.083	20	290	COROMANT
13.50	.531	60.8	2.394	4	14	860.1-1350-061A1-MM		★	14.0	.551	124	4.882	121.8	4.795	77	3.032	2.2	.087	20	290	DIN 6537 L
13.50	.531	108.0	4.252	8	14	860.1-1350-108A1-MM		★	14.0	.551	182	7.165	179.8	7.079	134	5.276	2.2	.087	20	290	COROMANT
14.00	.551	44.3	1.744	3	14	860.1-1400-042A1-MM		★	14.0	.551	107	4.213	104.7	4.122	60	2.362	2.3	.091	20	290	DIN 6537 K
14.00	.551	63.0	2.480	4	14	860.1-1400-063A1-MM		★	14.0	.551	124	4.882	121.7	4.791	77	3.032	2.3	.091	20	290	DIN 6537 L
14.00	.551	112.0	4.409	8	14	860.1-1400-112A1-MM		★	14.0	.551	182	7.165	179.7	7.075	134	5.276	2.3	.091	20	290	COROMANT
14.25	.561	68.8	2.709	4	16	860.1-1425-071A1-MM		★	16.0	.630	133	5.236	130.7	5.146	83	3.268	2.3	.091	20	290	DIN 6537 L
14.25	.561	114.0	4.488	8	16	860.1-1425-114A1-MM		★	16.0	.630	204	8.032	201.7	7.941	154	6.063	2.3	.091	20	290	COROMANT
14.50	.571	68.5	2.697	4	16	860.1-1450-073A1-MM		★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
14.68	.578	68.3	2.689	4	16	860.1-1468-073A1-MM		★	16.0	.630	133	5.236	130.6	5.142	83	3.268	2.4	.094	20	290	DIN 6537 L
15.00	.591	47.5	1.870	3	16	860.1-1500-045A1-MM		★	16.0	.630	115	4.528	112.5	4.429	65	2.559	2.5	.098	20	290	DIN 6537 K
15.00	.591	68.0	2.677	4	16	860.1-1500-068A1-MM		★	16.0	.630	133	5.236	130.5	5.138	83	3.268	2.5	.098	20	290	DIN 6537 L
15.80	.622	126.0	4.961	7	16	860.1-1580-126A1-MM		★	16.0	.630	204	8.032	201.4	7.929	154	6.063	2.6	.102	20	290	COROMANT

B81 E9 E28 E14

CoroDrill® 860

High performance drills optimized for aluminum

O C

Application

860-NM: Non-ferrous materials, such as aluminum alloys, magnesium and copper-based alloys, including bronze

ISO application area:

N

Features and benefits

- Optimized cutting data
- Low cost per hole
- Improved performance reliability
- Trouble-free chip evacuation
- Long tool life, controlled wear formation
- Consistent hole tolerance
- Can be reconditioned up to 3 times to its original specification

www.sandvik.coromant.com/corodrill860

Recommendations

It is recommended to use hydraulic precision chucks.
It is recommended to use internal coolant, minimum recommended pressure 20 bar

For chucks, see our Rotating Tools catalog.

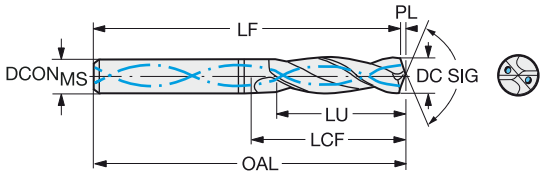
E14

CoroDrill® 860 solid carbide drill

For aluminum

Internal coolant supply

TCHA H7
SIG 130°



DC	DC"	LU	LU"	ULDR	CZCMS	Ordering code	N/H10F	DCONMS	DCONMS"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
3.00	.118	9.4	.370	3	6	860.1-0300-009A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.00	.118	24.4	.961	8	6	860.1-0300-024A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT
3.18	.125	10.0	.394	3	6	860.1-0318-010A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.18	.125	25.8	1.016	8	6	860.1-0318-025A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT
3.20	.126	10.0	.394	3	6	860.1-0320-010A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.20	.126	26.0	1.024	8	6	860.1-0320-026A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT
3.30	.130	10.3	.406	3	6	860.1-0330-010A1-NM	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.30	.130	26.8	1.055	8	6	860.1-0330-026A1-NM	★	6.0	.236	77	3.032	76.6	3.016	36	1.417	0.4	.016	20	290	COROMANT
3.50	.138	28.3	1.114	8	6	860.1-0350-028A1-NM	★	6.0	.236	77	3.032	76.5	3.012	36	1.417	0.5	.020	20	290	COROMANT
3.57	.141	28.1	1.106	7	6	860.1-0357-029A1-NM	★	6.0	.236	77	3.032	76.5	3.012	36	1.417	0.5	.020	20	290	COROMANT
3.70	.146	27.9	1.098	7	6	860.1-0370-030A1-NM	★	6.0	.236	77	3.032	76.5	3.012	36	1.417	0.5	.020	20	290	COROMANT
4.00	.157	12.5	.492	3	6	860.1-0400-012A1-NM	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
4.00	.157	32.5	1.280	8	6	860.1-0400-032A1-NM	★	6.0	.236	86	3.386	85.5	3.366	47	1.850	0.5	.020	20	290	COROMANT
4.10	.161	33.3	1.311	8	6	860.1-0410-033A1-NM	★	6.0	.236	86	3.386	85.5	3.366	47	1.850	0.5	.020	20	290	COROMANT
4.20	.165	13.2	.520	3	6	860.1-0420-013A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.20	.165	34.2	1.346	8	6	860.1-0420-034A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT
4.37	.172	13.7	.539	3	6	860.1-0437-013A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.37	.172	35.5	1.398	8	6	860.1-0437-035A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT
4.50	.177	14.1	.555	3	6	860.1-0450-014A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.50	.177	36.6	1.441	8	6	860.1-0450-036A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT
4.60	.181	14.4	.567	3	6	860.1-0460-014A1-NM	★	6.0	.236	66	2.598	65.4	2.575	24	.945	0.6	.024	20	290	DIN 6537 K
4.60	.181	37.4	1.472	8	6	860.1-0460-037A1-NM	★	6.0	.236	86	3.386	85.4	3.362	47	1.850	0.6	.024	20	290	COROMANT
4.76	.187	38.7	1.524	8	6	860.1-0476-038A1-NM	★	6.0	.236	99	3.898	98.4	3.874	60	2.362	0.6	.024	20	290	COROMANT
5.00	.197	15.7	.618	3	6	860.1-0500-015A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.00	.197	40.7	1.602	8	6	860.1-0500-040A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT
5.10	.201	16.0	.630	3	6	860.1-0510-015A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.10	.201	41.5	1.634	8	6	860.1-0510-041A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT
5.16	.203	42.0	1.654	8	6	860.1-0516-041A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT
5.20	.205	16.3	.642	3	6	860.1-0520-016A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.20	.205	42.3	1.665	8	6	860.1-0520-042A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT
5.50	.217	17.2	.677	3	6	860.1-0550-017A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.50	.217	44.7	1.760	8	6	860.1-0550-044A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT
5.56	.219	17.4	.685	3	6	860.1-0556-017A1-NM	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.56	.219	45.2	1.780	8	6	860.1-0556-044A1-NM	★	6.0	.236	99	3.898	98.3	3.870	60	2.362	0.7	.028	20	290	COROMANT
5.80	.228	17.6	.693	3	6	860.1-0580-017A1-NM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
5.80	.228	47.2	1.858	8	6	860.1-0580-046A1-NM	★	6.0	.236	99	3.898	98.2	3.866	60	2.362	0.8	.031	20	290	COROMANT
6.00	.236	18.8	.740	3	6	860.1-0600-018A1-NM	★	6.0	.236	66	2.598	65.2	2.567	28	1.102	0.8	.031	20	290	DIN 6537 K
6.00	.236	48.8	1.921	8	6	860.1-0600-048A1-NM	★	6.0	.236	99	3.898	98.2	3.866	60	2.362	0.8	.031	20	290	COROMANT
6.30	.248	19.7	.776	3	8	860.1-0630-019A1-NM	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K
6.30	.248	51.2	2.016	8	8	860.1-0630-050A1-NM	★	8.0	.315	121	4.764	120.2	4.732	80	3.150	0.8	.031	20	290	COROMANT
6.35	.250	19.9	.783	3	8	860.1-0635-019A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.35	.250	51.7	2.035	8	8	860.1-0635-051A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT
6.50	.256	20.4	.803	3	8	860.1-0650-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.50	.256	52.9	2.083	8	8	860.1-0650-052A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT
6.60	.260	20.7	.815	3	8	860.1-0660-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.60	.260	53.7	2.114	8	8	860.1-0660-053A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT
6.75	.266	21.1	.831	3	8	860.1-0675-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.75	.266	54.9	2.161	8	8	860.1-0675-054A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT
6.80	.268	21.3	.839	3	8	860.1-0680-020A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
6.80	.268	55.3	2.177	8	8	860.1-0680-054A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT
7.00	.276	21.9	.862	3	8	860.1-0700-021A1-NM	★	8.0	.315	79	3.110	78.1	3.075	34	1.339	0.9	.035	20	290	DIN 6537 K
7.00	.276	56.9	2.240	8	8	860.1-0700-056A1-NM	★	8.0	.315	121	4.764	120.1	4.728	80	3.150	0.9	.035	20	290	COROMANT

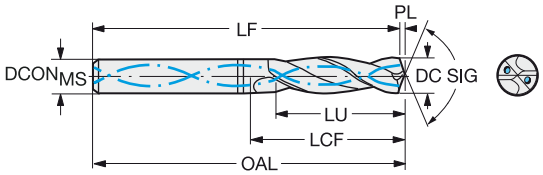
B76 E9 E28 E14

CoroDrill® 860 solid carbide drill

For aluminum

Internal coolant supply

TCHA H7
SIG 130°



								N	Dimensions, mm, inch													
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code		H10F	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
7.14	.281	22.4	.882	3	8	860.1-0714-021A1-NM		★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K
7.30	.287	22.9	.902	3	8	860.1-0730-022A1-NM		★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K
7.30	.287	59.4	2.339	8	8	860.1-0730-058A1-NM		★	8.0	.315	121	4.764	120.0	4.724	80	3.150	1.0	.039	20	290	COROMANT
7.40	.291	23.2	.913	3	8	860.1-0740-022A1-NM		★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K
7.40	.291	60.2	2.370	8	8	860.1-0740-059A1-NM		★	8.0	.315	121	4.764	120.0	4.724	80	3.150	1.0	.039	20	290	COROMANT
7.50	.295	23.5	.925	3	8	860.1-0750-023A1-NM		★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K
7.50	.295	61.0	2.402	8	8	860.1-0750-060A1-NM		★	8.0	.315	121	4.764	120.0	4.724	80	3.150	1.0	.039	20	290	COROMANT
7.94	.313	24.9	.980	3	8	860.1-0794-024A1-NM		★	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
7.94	.313	64.6	2.543	8	8	860.1-0794-064A1-NM		★	8.0	.315	121	4.764	119.9	4.720	80	3.150	1.1	.043	20	290	COROMANT
8.00	.315	25.1	.988	3	8	860.1-0800-024A1-NM		★	8.0	.315	79	3.110	77.9	3.067	41	1.614	1.1	.043	20	290	DIN 6537 K
8.00	.315	65.1	2.563	8	8	860.1-0800-064A1-NM		★	8.0	.315	121	4.764	119.9	4.720	80	3.150	1.1	.043	20	290	COROMANT
8.33	.328	26.1	1.028	3	10	860.1-0833-025A1-NM		★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K
8.33	.328	67.8	2.669	8	10	860.1-0833-067A1-NM		★	10.0	.394	145	5.709	143.9	5.665	100	3.937	1.1	.043	20	290	COROMANT
8.50	.335	26.6	1.047	3	10	860.1-0850-026A1-NM		★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K
8.50	.335	69.1	2.720	8	10	860.1-0850-068A1-NM		★	10.0	.394	145	5.709	143.9	5.665	100	3.937	1.1	.043	20	290	COROMANT
8.60	.339	27.0	1.063	3	10	860.1-0860-026A1-NM		★	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
8.60	.339	70.0	2.756	8	10	860.1-0860-069A1-NM		★	10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT
8.70	.343	70.8	2.787	8	10	860.1-0870-070A1-NM		★	10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT
8.80	.346	27.6	1.087	3	10	860.1-0880-026A1-NM		★	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
8.80	.346	71.6	2.819	8	10	860.1-0880-070A1-NM		★	10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT
9.00	.354	28.2	1.110	3	10	860.1-0900-027A1-NM		★	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
9.00	.354	73.2	2.882	8	10	860.1-0900-072A1-NM		★	10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT
9.13	.359	74.2	2.921	8	10	860.1-0913-073A1-NM		★	10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT
9.30	.366	29.1	1.146	3	10	860.1-0930-028A1-NM		★	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
9.30	.366	75.6	2.976	8	10	860.1-0930-074A1-NM		★	10.0	.394	145	5.709	143.8	5.661	100	3.937	1.2	.047	20	290	COROMANT
9.50	.374	29.8	1.173	3	10	860.1-0950-029A1-NM		★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
9.50	.374	77.3	3.043	8	10	860.1-0950-076A1-NM		★	10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT
9.53	.375	29.9	1.177	3	10	860.1-0953-029A1-NM		★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
9.53	.375	77.5	3.051	8	10	860.1-0953-076A1-NM		★	10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT
9.92	.391	80.7	3.177	8	10	860.1-0992-079A1-NM		★	10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT
10.00	.394	31.3	1.232	3	10	860.1-1000-030A1-NM		★	10.0	.394	89	3.504	87.7	3.453	47	1.850	1.3	.051	20	290	DIN 6537 K
10.00	.394	81.3	3.201	8	10	860.1-1000-080A1-NM		★	10.0	.394	145	5.709	143.7	5.657	100	3.937	1.3	.051	20	290	COROMANT
10.20	.402	32.0	1.260	3	12	860.1-1020-031A1-NM		★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K
10.20	.402	83.0	3.268	8	12	860.1-1020-082A1-NM		★	12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT
10.30	.406	32.3	1.272	3	12	860.1-1030-031A1-NM		★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K
10.30	.406	83.8	3.299	8	12	860.1-1030-082A1-NM		★	12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT
10.50	.413	32.9	1.295	3	12	860.1-1050-032A1-NM		★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K
10.50	.413	85.4	3.362	8	12	860.1-1050-084A1-NM		★	12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT
10.72	.422	33.6	1.323	3	12	860.1-1072-032A1-NM		★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K
10.72	.422	87.2	3.433	8	12	860.1-1072-086A1-NM		★	12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT
10.80	.425	87.8	3.457	8	12	860.1-1080-086A1-NM		★	12.0	.472	171	6.732	169.6	6.677	120	4.724	1.4	.055	20	290	COROMANT
11.00	.433	34.5	1.358	3	12	860.1-1100-033A1-NM		★	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
11.00	.433	89.5	3.524	8	12	860.1-1100-088A1-NM		★	12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT
11.10	.437	34.8	1.370	3	12	860.1-1110-033A1-NM		★	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
11.10	.437	90.3	3.555	8	12	860.1-1110-089A1-NM		★	12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT
11.11	.437	34.8	1.370	3	12	860.1-1111-033A1-NM		★	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
11.20	.441	35.1	1.382	3	12	860.1-1120-034A1-NM		★	12.0	.472	102	4.016	100.5	3.957	55	2.165	1.5	.059	20	290	DIN 6537 K
11.20	.441	91.1	3.587	8	12	860.1-1120-090A1-NM		★	12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT
11.50	.453	93.5	3.681	8	12	860.1-1150-092A1-NM		★	12.0	.472	171	6.732	169.5	6.673	120	4.724	1.5	.059	20	290	COROMANT
11.80	.465	37.0	1.457	3	12	860.1-1180-035A1-NM		★	12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
11.80	.465	96.0	3.780	8	12	860.1-1180-094A1-NM		★	12.0	.472	171	6.732	169.4	6.669	120	4.724	1.6	.063	20	290	COROMANT

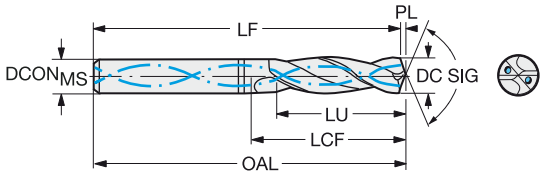
B76 E9 E28 E14

CoroDrill® 860 solid carbide drill

For aluminum

Internal coolant supply

TCHA H7
SIG 130°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	N	H10F	Dimensions, mm, inch										BAR	PSI	BSG
									$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"			
12.00	.472	37.6	1.480	3	12	860.1-1200-036A1-NM	★		12.0	.472	102	4.016	100.4	3.953	55	2.165	1.6	.063	20	290	DIN 6537 K
12.00	.472	97.6	3.843	8	12	860.1-1200-096A1-NM	★		12.0	.472	171	6.732	169.4	6.669	120	4.724	1.6	.063	20	290	COROMANT
12.10	.476	37.9	1.492	3	14	860.1-1210-036A1-NM	★		14.0	.551	107	4.213	105.4	4.150	60	2.362	1.6	.063	20	290	DIN 6537 K
12.30	.484	100.1	3.941	8	14	860.1-1230-098A1-NM	★		14.0	.551	190	7.480	188.4	7.417	140	5.512	1.6	.063	20	290	COROMANT
12.50	.492	39.2	1.543	3	14	860.1-1250-038A1-NM	★		14.0	.551	107	4.213	105.3	4.146	60	2.362	1.7	.067	20	290	DIN 6537 K
12.50	.492	101.7	4.004	8	14	860.1-1250-100A1-NM	★		14.0	.551	190	7.480	188.3	7.413	140	5.512	1.7	.067	20	290	COROMANT
12.70	.500	39.8	1.567	3	14	860.1-1270-038A1-NM	★		14.0	.551	107	4.213	105.3	4.146	60	2.362	1.7	.067	20	290	DIN 6537 K
12.70	.500	103.3	4.067	8	14	860.1-1270-102A1-NM	★		14.0	.551	190	7.480	188.3	7.413	140	5.512	1.7	.067	20	290	COROMANT
13.00	.512	40.7	1.602	3	14	860.1-1300-039A1-NM	★		14.0	.551	107	4.213	105.3	4.146	60	2.362	1.7	.067	20	290	DIN 6537 K
13.00	.512	105.7	4.161	8	14	860.1-1300-104A1-NM	★		14.0	.551	190	7.480	188.3	7.413	140	5.512	1.7	.067	20	290	COROMANT
13.10	.516	41.0	1.614	3	14	860.1-1310-039A1-NM	★		14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
13.10	.516	106.5	4.193	8	14	860.1-1310-105A1-NM	★		14.0	.551	190	7.480	188.2	7.409	140	5.512	1.8	.071	20	290	COROMANT
13.50	.531	42.3	1.665	3	14	860.1-1350-041A1-NM	★		14.0	.551	107	4.213	105.2	4.142	60	2.362	1.8	.071	20	290	DIN 6537 K
13.50	.531	109.8	4.323	8	14	860.1-1350-108A1-NM	★		14.0	.551	190	7.480	188.2	7.409	140	5.512	1.8	.071	20	290	COROMANT
13.89	.547	43.3	1.705	3	14	860.1-1389-042A1-NM	★		14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
14.00	.551	43.9	1.728	3	14	860.1-1400-042A1-NM	★		14.0	.551	107	4.213	105.1	4.138	60	2.362	1.9	.075	20	290	DIN 6537 K
14.00	.551	113.9	4.484	8	14	860.1-1400-112A1-NM	★		14.0	.551	190	7.480	188.1	7.406	140	5.512	1.9	.075	20	290	COROMANT
14.20	.559	44.5	1.752	3	16	860.1-1420-043A1-NM	★		16.0	.630	115	4.528	113.1	4.453	65	2.559	1.9	.075	20	290	DIN 6537 K
14.29	.563	44.8	1.764	3	16	860.1-1429-043A1-NM	★		16.0	.630	115	4.528	113.1	4.453	65	2.559	1.9	.075	20	290	DIN 6537 K
14.50	.571	45.4	1.787	3	16	860.1-1450-044A1-NM	★		16.0	.630	115	4.528	113.1	4.453	65	2.559	1.9	.075	20	290	DIN 6537 K
14.50	.571	117.9	4.642	8	16	860.1-1450-116A1-NM	★		16.0	.630	213	8.386	211.1	8.311	160	6.299	1.9	.075	20	290	COROMANT
14.68	.578	119.4	4.701	8	16	860.1-1468-117A1-NM	★		16.0	.630	213	8.386	211.0	8.307	160	6.299	2.0	.079	20	290	COROMANT
14.75	.581	46.2	1.819	3	16	860.1-1475-044A1-NM	★		16.0	.630	115	4.528	113.0	4.449	65	2.559	2.0	.079	20	290	DIN 6537 K
15.00	.591	47.0	1.850	3	16	860.1-1500-045A1-NM	★		16.0	.630	115	4.528	113.0	4.449	65	2.559	2.0	.079	20	290	DIN 6537 K
15.00	.591	122.0	4.803	8	16	860.1-1500-120A1-NM	★		16.0	.630	213	8.386	211.0	8.307	160	6.299	2.0	.079	20	290	COROMANT
15.50	.610	48.6	1.913	3	16	860.1-1550-047A1-NM	★		16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K
15.50	.610	126.1	4.965	8	16	860.1-1550-124A1-NM	★		16.0	.630	213	8.386	210.9	8.303	160	6.299	2.1	.083	20	290	COROMANT
16.00	.630	49.0	1.929	3	16	860.1-1600-048A1-NM	★		16.0	.630	115	4.528	112.9	4.445	65	2.559	2.1	.083	20	290	DIN 6537 K
16.00	.630	130.1	5.122	8	16	860.1-1600-128A1-NM	★		16.0	.630	213	8.386	210.9	8.303	160	6.299	2.1	.083	20	290	COROMANT
17.00	.669	53.3	2.098	3	18	860.1-1700-051A1-NM	★		18.0	.709	123	4.843	120.7	4.752	73	2.874	2.3	.091	20	290	DIN 6537 K
17.00	.669	138.3	5.445	8	18	860.1-1700-136A1-NM	★		18.0	.709	234	9.213	231.7	9.122	180	7.087	2.3	.091	20	290	COROMANT
17.50	.689	54.8	2.157	3	18	860.1-1750-053A1-NM	★		18.0	.709	123	4.843	120.7	4.752	73	2.874	2.3	.091	20	290	DIN 6537 K

B76 E9 E28 E14

CoroDrill® 860-SM

Optimized drilling for nickel-based alloys and titanium-based alloys

O C

Application

- Drilling tools suitable for cobalt chrome-, nickel-, and titanium-based alloys
- Up to 5 × diameter
- Hole tolerance: H9
- Optimized for high-performance applications

ISO application area:

S

Features and benefits

- Reliability and process security
- Predictable tool life
- Excellent repeatability
- An industry accredited product with a high quality reconditioning service
- Unique geometry for ISO S giving secure chip control

www.sandvik.coromant.com/corodrillr860

Recommendations

Stable tool holding with CoroChuck™ 930
20 bar coolant pressure
Rigid workpiece clamping

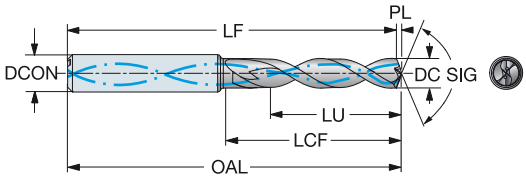
For chucks, see our Rotating Tools catalog.

CoroDrill® 860 solid carbide drill

For heat resistant super alloys

Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S	1210	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
							Dimensions, mm, inch														
3.00	.118	9.5	.374	3	6	860.1-0300-009A1-SM	★		6.0	.236	62	2.441	61.5	2.421	20	.787	0.6	.022	20	290	DIN 6537 K
3.00	.118	15.5	.610	5	6	860.1-0300-015A1-SM	★		6.0	.236	66	2.598	65.5	2.579	28	1.102	0.6	.022	20	290	DIN 6537 L
3.10	.122	9.9	.390	3	6	860.1-0310-009A1-SM	★		6.0	.236	62	2.441	61.5	2.420	20	.787	0.6	.022	20	290	DIN 6537 K
3.17	.125	16.4	.646	5	6	860.1-0317-016A1-SM	★		6.0	.236	66	2.598	65.5	2.578	28	1.102	0.6	.023	20	290	DIN 6537 L
3.18	.125	10.1	.398	3	6	860.1-0318-010A1-SM	★		6.0	.236	62	2.441	61.5	2.420	20	.787	0.6	.023	20	290	DIN 6537 K
3.20	.126	10.2	.402	3	6	860.1-0320-010A1-SM	★		6.0	.236	62	2.441	61.5	2.420	20	.787	0.6	.023	20	290	DIN 6537 K
3.20	.126	16.6	.654	5	6	860.1-0320-016A1-SM	★		6.0	.236	66	2.598	65.5	2.577	28	1.102	0.6	.023	20	290	DIN 6537 L
3.30	.130	10.5	.413	3	6	860.1-0330-010A1-SM	★		6.0	.236	62	2.441	61.5	2.419	20	.787	0.6	.024	20	290	DIN 6537 K
3.30	.130	17.1	.673	5	6	860.1-0330-017A1-SM	★		6.0	.236	66	2.598	65.5	2.577	28	1.102	0.6	.024	20	290	DIN 6537 L
3.40	.134	10.8	.425	3	6	860.1-0340-010A1-SM	★		6.0	.236	62	2.441	61.4	2.419	20	.787	0.6	.024	20	290	DIN 6537 K
3.50	.138	11.1	.437	3	6	860.1-0350-011A1-SM	★		6.0	.236	62	2.441	61.4	2.418	20	.787	0.6	.025	20	290	DIN 6537 K
3.50	.138	18.1	.713	5	6	860.1-0350-018A1-SM	★		6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.025	20	290	DIN 6537 L
3.57	.141	11.4	.449	3	6	860.1-0357-011A1-SM	★		6.0	.236	62	2.441	61.4	2.417	20	.787	0.7	.026	20	290	DIN 6537 K
3.60	.142	11.5	.453	3	6	860.1-0360-011A1-SM	★		6.0	.236	62	2.441	61.4	2.417	20	.787	0.7	.026	20	290	DIN 6537 K
3.70	.146	11.8	.465	3	6	860.1-0370-011A1-SM	★		6.0	.236	62	2.441	61.4	2.417	20	.787	0.7	.026	20	290	DIN 6537 K
3.70	.146	19.2	.756	5	6	860.1-0370-019A1-SM	★		6.0	.236	66	2.598	65.4	2.574	28	1.102	0.7	.026	20	290	DIN 6537 L
3.80	.150	11.7	.461	3	6	860.1-0380-011A1-SM	★		6.0	.236	66	2.598	65.4	2.573	20	.787	0.7	.027	20	290	DIN 6537 K
3.90	.154	11.6	.457	2	6	860.1-0390-011A1-SM	★		6.0	.236	66	2.598	65.4	2.573	20	.787	0.7	.028	20	290	DIN 6537 K
3.90	.154	19.6	.772	5	6	860.1-0390-019A1-SM	★		6.0	.236	74	2.913	73.4	2.888	28	1.102	0.7	.028	20	290	DIN 6537 L
4.00	.157	12.7	.500	3	6	860.1-0400-012A1-SM	★		6.0	.236	66	2.598	65.3	2.572	24	.945	0.7	.029	20	290	DIN 6537 K
4.00	.157	20.7	.815	5	6	860.1-0400-020A1-SM	★		6.0	.236	74	2.913	73.3	2.887	36	1.417	0.7	.029	20	290	DIN 6537 L
4.10	.161	13.0	.512	3	6	860.1-0410-013A1-SM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.8	.030	20	290	DIN 6537 K
4.15	.163	21.5	.846	5	6	860.1-0415-021A1-SM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.8	.030	20	290	DIN 6537 L
4.20	.165	13.4	.528	3	6	860.1-0420-013A1-SM	★		6.0	.236	66	2.598	65.3	2.571	24	.945	0.8	.030	20	290	DIN 6537 K
4.20	.165	21.8	.858	5	6	860.1-0420-021A1-SM	★		6.0	.236	74	2.913	73.3	2.886	36	1.417	0.8	.030	20	290	DIN 6537 L
4.30	.169	13.7	.539	3	6	860.1-0430-013A1-SM	★		6.0	.236	66	2.598	65.3	2.570	24	.945	0.8	.031	20	290	DIN 6537 K
4.37	.172	13.9	.547	3	6	860.1-0437-013A1-SM	★		6.0	.236	66	2.598	65.3	2.570	24	.945	0.8	.031	20	290	DIN 6537 K
4.40	.173	22.8	.898	5	6	860.1-0440-022A1-SM	★		6.0	.236	74	2.913	73.3	2.884	36	1.417	0.8	.031	20	290	DIN 6537 L
4.50	.177	14.3	.563	3	6	860.1-0450-014A1-SM	★		6.0	.236	66	2.598	65.3	2.569	24	.945	0.8	.032	20	290	DIN 6537 K
4.50	.177	23.3	.917	5	6	860.1-0450-023A1-SM	★		6.0	.236	74	2.913	73.3	2.884	36	1.417	0.8	.032	20	290	DIN 6537 L
4.60	.181	14.6	.575	3	6	860.1-0460-014A1-SM	★		6.0	.236	66	2.598	65.2	2.568	24	.945	0.8	.033	20	290	DIN 6537 K
4.60	.181	23.8	.937	5	6	860.1-0460-023A1-SM	★		6.0	.236	74	2.913	73.2	2.883	36	1.417	0.8	.033	20	290	DIN 6537 L
4.70	.185	15.0	.591	3	6	860.1-0470-014A1-SM	★		6.0	.236	66	2.598	65.2	2.567	24	.945	0.9	.034	20	290	DIN 6537 K
4.70	.185	24.4	.961	5	6	860.1-0470-024A1-SM	★		6.0	.236	74	2.913	73.2	2.882	36	1.417	0.9	.034	20	290	DIN 6537 L
4.76	.187	13.6	.535	2	6	860.1-0476-013A1-SM	★		6.0	.236	66	2.598	65.2	2.567	24	.945	0.9	.034	20	290	DIN 6537 K
4.76	.187	24.7	.972	5	6	860.1-0476-024A1-SM	★		6.0	.236	82	3.228	81.2	3.197	36	1.417	0.9	.034	20	290	DIN 6537 L
4.80	.189	15.3	.602	3	6	860.1-0480-015A1-SM	★		6.0	.236	66	2.598	65.2	2.567	28	1.102	0.9	.034	20	290	DIN 6537 K
4.80	.189	24.9	.980	5	6	860.1-0480-024A1-SM	★		6.0	.236	82	3.228	81.2	3.197	36	1.417	0.9	.034	20	290	DIN 6537 L
4.90	.193	15.6	.614	3	6	860.1-0490-015A1-SM	★		6.0	.236	66	2.598	65.2	2.566	28	1.102	0.9	.035	20	290	DIN 6537 K
4.90	.193	25.4	1.000	5	6	860.1-0490-025A1-SM	★		6.0	.236	82	3.228	81.2	3.196	44	1.732	0.9	.035	20	290	DIN 6537 L
5.00	.197	15.9	.626	3	6	860.1-0500-015A1-SM	★		6.0	.236	66	2.598	65.2	2.565	28	1.102	0.9	.036	20	290	DIN 6537 K
5.00	.197	25.9	1.020	5	6	860.1-0500-025A1-SM	★		6.0	.236	82	3.228	81.2	3.195	44	1.732	0.9	.036	20	290	DIN 6537 L
5.10	.201	16.2	.638	3	6	860.1-0510-016A1-SM	★		6.0	.236	66	2.598	65.2	2.565	28	1.102	0.9	.037	20	290	DIN 6537 K
5.10	.201	26.4	1.039	5	6	860.1-0510-026A1-SM	★		6.0	.236	82	3.228	81.2	3.195	44	1.732	0.9	.037	20	290	DIN 6537 L
5.16	.203	16.4	.646	3	6	860.1-0516-016A1-SM	★		6.0	.236	66	2.598	65.1	2.565	28	1.102	0.9	.037	20	290	DIN 6537 K
5.20	.205	16.5	.650	3	6	860.1-0520-016A1-SM	★		6.0	.236	66	2.598	65.1	2.564	28	1.102	1.0	.037	20	290	DIN 6537 K
5.25	.207	16.7	.657	3	6	860.1-0525-016A1-SM	★		6.0	.236	66	2.598	65.1	2.564	28	1.102	1.0	.038	20	290	DIN 6537 K
5.30	.209	16.9	.665	3	6	860.1-0530-016A1-SM	★		6.0	.236	66	2.598	65.1	2.563	28	1.102	1.0	.038	20	290	DIN 6537 K
5.30	.209	27.5	1.083	5	6	860.1-0530-027A1-SM	★		6.0	.236	82	3.228	81.1	3.193	44	1.732	1.0	.038	20	290	DIN 6537 L
5.40	.213	17.2	.677	3	6	860.1-0540-017A1-SM	★		6.0	.236	66	2.598	65.1	2.563	28	1.102	1.0	.039	20	290	DIN 6537 K
5.50	.217	17.5	.689	3	6	860.1-0550-017A1-SM	★		6.0	.236	66	2.598	65.1	2.562	28	1.102	1.0	.039	20	290	DIN 6537 K
5.50	.217	28.5	1.122	5	6	860.1-0550-028A1-SM	★		6.0	.236	82	3.228	81.1	3.192	44	1.732	1.0	.039	20	290	DIN 6537 L

B76 E9 E28 E14

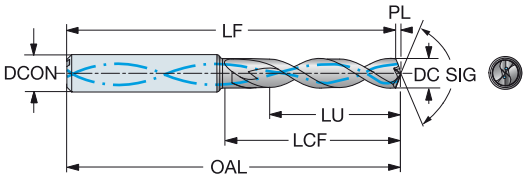
SANDVIK Coromant

CoroDrill® 860 solid carbide drill

For heat resistant super alloys

Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S	1210	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
									Dimensions, mm, inch												
5.55	.219	17.6	.693	3	6	860.1-0555-017A1-SM	★		6.0	.236	66	2.598	65.1	2.562	28	1.102	1.0	.040	20	290	DIN 6537 K
5.56	.219	17.6	.693	3	6	860.1-0556-017A1-SM	★		6.0	.236	66	2.598	65.1	2.562	28	1.102	1.0	.040	20	290	DIN 6537 K
5.56	.219	28.8	1.134	5	6	860.1-0556-028A1-SM	★		6.0	.236	82	3.228	81.1	3.192	44	1.732	1.0	.040	20	290	DIN 6537 L
5.60	.220	17.6	.693	3	6	860.1-0560-017A1-SM	★		6.0	.236	66	2.598	65.1	2.561	28	1.102	1.0	.040	20	290	DIN 6537 K
5.60	.220	29.0	1.142	5	6	860.1-0560-029A1-SM	★		6.0	.236	82	3.228	81.1	3.191	44	1.732	1.0	.040	20	290	DIN 6537 L
5.70	.224	17.6	.693	3	6	860.1-0570-017A1-SM	★		6.0	.236	66	2.598	65.1	2.561	28	1.102	1.0	.041	20	290	DIN 6537 K
5.70	.224	29.5	1.161	5	6	860.1-0570-029A1-SM	★		6.0	.236	82	3.228	81.1	3.191	44	1.732	1.0	.041	20	290	DIN 6537 L
5.80	.228	17.7	.697	3	6	860.1-0580-017A1-SM	★		6.0	.236	66	2.598	65.0	2.560	28	1.102	1.1	.042	20	290	DIN 6537 K
5.80	.228	30.1	1.185	5	6	860.1-0580-030A1-SM	★		6.0	.236	82	3.228	81.0	3.190	60	2.362	1.1	.042	20	290	DIN 6537 L
5.95	.234	17.7	.697	2	6	860.1-0595-017A1-SM	★		6.0	.236	66	2.598	65.0	2.559	28	1.102	1.1	.043	20	290	DIN 6537 K
6.00	.236	19.1	.752	3	6	860.1-0600-019A1-SM	★		6.0	.236	66	2.598	65.0	2.559	34	1.339	1.1	.043	20	290	DIN 6537 K
6.00	.236	31.1	1.224	5	6	860.1-0600-031A1-SM	★		6.0	.236	82	3.228	81.0	3.189	44	1.732	1.1	.043	20	290	DIN 6537 L
6.10	.240	19.4	.764	3	8	860.1-0610-019A1-SM	★		8.0	.315	79	3.110	78.0	3.070	34	1.339	1.1	.044	20	290	DIN 6537 K
6.10	.240	31.6	1.244	5	8	860.1-0610-031A1-SM	★		8.0	.315	91	3.583	90.0	3.543	53	2.087	1.1	.044	20	290	DIN 6537 L
6.20	.244	19.7	.776	3	8	860.1-0620-019A1-SM	★		8.0	.315	79	3.110	78.0	3.069	34	1.339	1.1	.044	20	290	DIN 6537 K
6.20	.244	32.1	1.264	5	8	860.1-0620-032A1-SM	★		8.0	.315	91	3.583	90.0	3.542	53	2.087	1.1	.044	20	290	DIN 6537 L
6.35	.250	20.2	.795	3	8	860.1-0635-020A1-SM	★		8.0	.315	79	3.110	77.9	3.069	34	1.339	1.2	.046	20	290	DIN 6537 K
6.35	.250	32.9	1.295	5	8	860.1-0635-032A1-SM	★		8.0	.315	91	3.583	89.9	3.541	53	2.087	1.2	.046	20	290	DIN 6537 L
6.40	.252	20.4	.803	3	8	860.1-0640-020A1-SM	★		8.0	.315	79	3.110	77.9	3.068	34	1.339	1.2	.046	20	290	DIN 6537 K
6.40	.252	33.2	1.307	5	8	860.1-0640-033A1-SM	★		8.0	.315	91	3.583	89.9	3.541	53	2.087	1.2	.046	20	290	DIN 6537 L
6.50	.256	20.7	.815	3	8	860.1-0650-020A1-SM	★		8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.046	20	290	DIN 6537 K
6.50	.256	33.7	1.327	5	8	860.1-0650-033A1-SM	★		8.0	.315	91	3.583	89.9	3.540	53	2.087	1.2	.046	20	290	DIN 6537 L
6.60	.260	21.0	.827	3	8	860.1-0660-021A1-SM	★		8.0	.315	79	3.110	77.9	3.067	34	1.339	1.2	.047	20	290	DIN 6537 K
6.60	.260	34.2	1.346	5	8	860.1-0660-034A1-SM	★		8.0	.315	91	3.583	89.9	3.539	44	1.732	1.2	.047	20	290	DIN 6537 L
6.70	.264	21.3	.839	3	8	860.1-0670-021A1-SM	★		8.0	.315	79	3.110	77.9	3.066	34	1.339	1.2	.048	20	290	DIN 6537 K
6.70	.264	34.7	1.366	5	8	860.1-0670-034A1-SM	★		8.0	.315	91	3.583	89.9	3.539	53	2.087	1.2	.048	20	290	DIN 6537 L
6.80	.268	21.6	.850	3	8	860.1-0680-021A1-SM	★		8.0	.315	79	3.110	77.9	3.065	34	1.339	1.2	.049	20	290	DIN 6537 K
6.80	.268	35.2	1.386	5	8	860.1-0680-035A1-SM	★		8.0	.315	91	3.583	89.9	3.538	53	2.087	1.2	.049	20	290	DIN 6537 L
6.90	.272	21.6	.850	3	8	860.1-0690-021A1-SM	★		8.0	.315	79	3.110	77.8	3.065	34	1.339	1.3	.050	20	290	DIN 6537 K
6.90	.272	35.8	1.409	5	8	860.1-0690-035A1-SM	★		8.0	.315	91	3.583	89.8	3.537	53	2.087	1.3	.050	20	290	DIN 6537 L
7.00	.276	21.6	.850	3	8	860.1-0700-021A1-SM	★		8.0	.315	79	3.110	77.8	3.064	34	1.339	1.3	.050	20	290	DIN 6537 K
7.00	.276	36.3	1.429	5	8	860.1-0700-036A1-SM	★		8.0	.315	91	3.583	89.8	3.537	53	2.087	1.3	.050	20	290	DIN 6537 L
7.10	.280	22.6	.890	3	8	860.1-0710-022A1-SM	★		8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.051	20	290	DIN 6537 K
7.10	.280	36.8	1.449	5	8	860.1-0710-036A1-SM	★		8.0	.315	91	3.583	89.8	3.536	53	2.087	1.3	.051	20	290	DIN 6537 L
7.14	.281	22.7	.894	3	8	860.1-0714-022A1-SM	★		8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.051	20	290	DIN 6537 K
7.14	.281	37.0	1.457	5	8	860.1-0714-036A1-SM	★		8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.051	20	290	DIN 6537 L
7.20	.283	22.9	.902	3	8	860.1-0720-022A1-SM	★		8.0	.315	79	3.110	77.8	3.063	41	1.614	1.3	.052	20	290	DIN 6537 K
7.20	.283	37.3	1.469	5	8	860.1-0720-037A1-SM	★		8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.052	20	290	DIN 6537 L
7.30	.287	23.2	.913	3	8	860.1-0730-023A1-SM	★		8.0	.315	79	3.110	77.8	3.062	41	1.614	1.3	.052	20	290	DIN 6537 K
7.30	.287	37.8	1.488	5	8	860.1-0730-037A1-SM	★		8.0	.315	91	3.583	89.8	3.535	53	2.087	1.3	.052	20	290	DIN 6537 L
7.40	.291	23.5	.925	3	8	860.1-0740-023A1-SM	★		8.0	.315	79	3.110	77.8	3.061	41	1.614	1.4	.053	20	290	DIN 6537 K
7.40	.291	38.3	1.508	5	8	860.1-0740-038A1-SM	★		8.0	.315	91	3.583	89.8	3.534	53	2.087	1.4	.053	20	290	DIN 6537 L
7.50	.295	23.9	.941	3	8	860.1-0750-023A1-SM	★		8.0	.315	79	3.110	77.7	3.061	41	1.614	1.4	.054	20	290	DIN 6537 K
7.50	.295	38.9	1.532	5	8	860.1-0750-038A1-SM	★		8.0	.315	91	3.583	89.7	3.533	53	2.087	1.4	.054	20	290	DIN 6537 L
7.60	.299	24.1	.949	3	8	860.1-0760-023A1-SM	★		8.0	.315	79	3.110	77.7	3.059	41	1.614	1.3	.051	20	290	DIN 6537 K
7.70	.303	24.5	.965	3	8	860.1-0770-024A1-SM	★		8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.055	20	290	DIN 6537 K
7.80	.307	24.8	.976	3	8	860.1-0780-024A1-SM	★		8.0	.315	79	3.110	77.7	3.059	41	1.614	1.4	.056	20	290	DIN 6537 K
7.94	.313	25.3	.996	3	8	860.1-0794-025A1-SM	★		8.0	.315	79	3.110	77.7	3.058	41	1.614	1.4	.057	20	290	DIN 6537 K
8.00	.315	25.5	1.004	3	8	860.1-0800-025A1-SM	★		8.0	.315	79	3.110	77.7	3.057	41	1.614	1.5	.057	20	290	DIN 6537 K
8.00	.315	40.9	1.610	5	8	860.1-0800-040A1-SM	★		8.0	.315	91	3.583	89.7	3.530	53	2.087	1.5	.057	20	290	DIN 6537 L
8.10	.319	25.8	1.016	3	10	860.1-0810-025A1-SM	★		10.0	.394	89	3.504	87.6	3.450	47	1.850	1.5	.058	20	290	DIN 6537 K
8.10	.319	42.0	1.654	5	10	860.1-0810-041A1-SM	★		10.0	.394	103	4.055	101.6	4.002	61	2.402	1.5	.058	20	290	DIN 6537 L

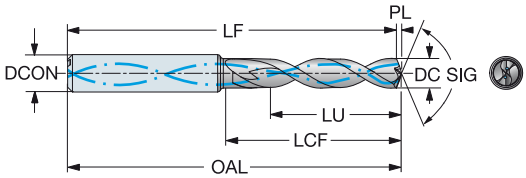
B76 E9 E28 E14

CoroDrill® 860 solid carbide drill

For heat resistant super alloys

Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S 1210	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
								Dimensions, mm, inch												
8.20	.323	26.1	1.028	3	10	860.1-0820-026A1-SM	★	10.0	.394	89	3.504	87.6	3.450	47	1.850	1.5	.059	20	290	DIN 6537 K
8.30	.327	26.4	1.039	3	10	860.1-0830-026A1-SM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.059	20	290	DIN 6537 K
8.33	.328	26.5	1.043	3	10	860.1-0833-026A1-SM	★	10.0	.394	89	3.504	87.6	3.449	47	1.850	1.5	.060	20	290	DIN 6537 K
8.40	.331	26.7	1.051	3	10	860.1-0840-026A1-SM	★	10.0	.394	89	3.504	87.6	3.448	47	1.850	1.5	.060	20	290	DIN 6537 K
8.40	.331	43.5	1.713	5	10	860.1-0840-043A1-SM	★	10.0	.394	103	4.055	101.6	4.000	61	2.402	1.5	.060	20	290	DIN 6537 L
8.45	.333	26.9	1.059	3	10	860.1-0845-026A1-SM	★	10.0	.394	89	3.504	87.6	3.448	47	1.850	1.5	.061	20	290	DIN 6537 K
8.50	.335	27.0	1.063	3	10	860.1-0850-027A1-SM	★	10.0	.394	89	3.504	87.6	3.448	47	1.850	1.6	.061	20	290	DIN 6537 K
8.50	.335	44.0	1.732	5	10	860.1-0850-044A1-SM	★	10.0	.394	103	4.055	101.6	3.999	53	2.087	1.6	.061	20	290	DIN 6537 L
8.60	.339	27.4	1.079	3	10	860.1-0860-027A1-SM	★	10.0	.394	89	3.504	87.6	3.447	47	1.850	1.6	.062	20	290	DIN 6537 K
8.60	.339	44.6	1.756	5	10	860.1-0860-044A1-SM	★	10.0	.394	103	4.055	101.6	3.998	61	2.402	1.6	.062	20	290	DIN 6537 L
8.65	.341	27.5	1.083	3	10	860.1-0865-027A1-SM	★	10.0	.394	89	3.504	87.6	3.447	47	1.850	1.6	.062	20	290	DIN 6537 K
8.70	.343	27.7	1.091	3	10	860.1-0870-027A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.062	20	290	DIN 6537 K
8.73	.344	27.8	1.094	3	10	860.1-0873-027A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.063	20	290	DIN 6537 K
8.73	.344	45.2	1.780	5	10	860.1-0873-045A1-SM	★	10.0	.394	103	4.055	101.5	3.998	61	2.402	1.6	.063	20	290	DIN 6537 L
8.80	.346	28.0	1.102	3	10	860.1-0880-028A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.063	20	290	DIN 6537 K
8.85	.348	28.2	1.110	3	10	860.1-0885-028A1-SM	★	10.0	.394	89	3.504	87.5	3.446	47	1.850	1.6	.063	20	290	DIN 6537 K
9.00	.354	28.6	1.126	3	10	860.1-0900-028A1-SM	★	10.0	.394	89	3.504	87.5	3.444	47	1.850	1.6	.065	20	290	DIN 6537 K
9.00	.354	46.2	1.819	5	10	860.1-0900-046A1-SM	★	10.0	.394	103	4.055	101.5	3.996	61	2.402	1.6	.065	20	290	DIN 6537 L
9.20	.362	29.3	1.154	3	10	860.1-0920-029A1-SM	★	10.0	.394	89	3.504	87.5	3.443	47	1.850	1.7	.066	20	290	DIN 6537 K
9.30	.366	29.6	1.165	3	10	860.1-0930-029A1-SM	★	10.0	.394	89	3.504	87.4	3.443	47	1.850	1.7	.067	20	290	DIN 6537 K
9.30	.366	46.3	1.823	4	10	860.1-0930-046A1-SM	★	10.0	.394	103	4.055	101.4	3.994	61	2.402	1.7	.067	20	290	DIN 6537 L
9.40	.370	29.9	1.177	3	10	860.1-0940-029A1-SM	★	10.0	.394	89	3.504	87.4	3.442	47	1.850	1.7	.067	20	290	DIN 6537 K
9.50	.374	30.2	1.189	3	10	860.1-0950-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068	20	290	DIN 6537 K
9.52	.375	30.3	1.193	3	10	860.1-0952-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068	20	290	DIN 6537 K
9.53	.375	30.3	1.193	3	10	860.1-0953-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.7	.068	20	290	DIN 6537 K
9.60	.378	30.5	1.201	3	10	860.1-0960-030A1-SM	★	10.0	.394	89	3.504	87.4	3.441	47	1.850	1.8	.069	20	290	DIN 6537 K
9.70	.382	30.9	1.217	3	10	860.1-0970-030A1-SM	★	10.0	.394	89	3.504	87.4	3.440	47	1.850	1.8	.070	20	290	DIN 6537 K
9.80	.386	31.2	1.228	3	10	860.1-0980-031A1-SM	★	10.0	.394	89	3.504	87.4	3.439	47	1.850	1.8	.070	20	290	DIN 6537 K
9.80	.386	46.4	1.827	4	10	860.1-0980-046A1-SM	★	10.0	.394	103	4.055	101.4	3.991	61	2.402	1.8	.070	20	290	DIN 6537 L
9.90	.390	46.5	1.831	4	10	860.1-0990-046A1-SM	★	10.0	.394	103	4.055	101.3	3.990	61	2.402	1.8	.071	20	290	DIN 6537 L
9.92	.391	31.6	1.244	3	10	860.1-0992-031A1-SM	★	10.0	.394	89	3.504	87.3	3.439	47	1.850	1.8	.071	20	290	DIN 6537 K
10.00	.394	31.8	1.252	3	10	860.1-1000-031A1-SM	★	10.0	.394	89	3.504	87.3	3.438	47	1.850	1.8	.072	20	290	DIN 6537 K
10.00	.394	46.5	1.831	4	10	860.1-1000-046A1-SM	★	10.0	.394	103	4.055	101.3	3.989	61	2.402	1.8	.072	20	290	DIN 6537 L
10.10	.398	32.1	1.264	3	12	860.1-1010-032A1-SM	★	12.0	.472	102	4.016	100.3	3.949	47	1.850	1.8	.072	20	290	DIN 6537 K
10.20	.402	32.5	1.280	3	12	860.1-1020-032A1-SM	★	12.0	.472	102	4.016	100.3	3.948	55	2.165	1.9	.073	20	290	DIN 6537 K
10.30	.406	32.8	1.291	3	12	860.1-1030-032A1-SM	★	12.0	.472	102	4.016	100.3	3.948	55	2.165	1.9	.074	20	290	DIN 6537 K
10.30	.406	53.4	2.102	5	12	860.1-1030-053A1-SM	★	12.0	.472	118	4.646	116.3	4.578	71	2.795	1.9	.074	20	290	DIN 6537 L
10.32	.406	32.8	1.291	3	12	860.1-1032-032A1-SM	★	12.0	.472	102	4.016	100.3	3.948	55	2.165	1.9	.074	20	290	DIN 6537 K
10.50	.413	33.4	1.315	3	12	860.1-1050-033A1-SM	★	12.0	.472	102	4.016	100.2	3.946	55	2.165	1.9	.075	20	290	DIN 6537 K
10.50	.413	54.2	2.134	5	12	860.1-1050-054A1-SM	★	12.0	.472	118	4.646	116.2	4.576	71	2.795	1.9	.075	20	290	DIN 6537 L
10.80	.425	34.4	1.354	3	12	860.1-1080-034A1-SM	★	12.0	.472	102	4.016	100.2	3.944	55	2.165	2.0	.078	20	290	DIN 6537 K
11.00	.433	35.0	1.378	3	12	860.1-1100-035A1-SM	★	12.0	.472	102	4.016	100.2	3.943	55	2.165	2.0	.079	20	290	DIN 6537 K
11.00	.433	54.2	2.134	4	12	860.1-1100-054A1-SM	★	12.0	.472	118	4.646	116.2	4.573	71	2.795	2.0	.079	20	290	DIN 6537 L
11.11	.437	35.4	1.394	3	12	860.1-1111-035A1-SM	★	12.0	.472	102	4.016	100.1	3.943	55	2.165	2.0	.080	20	290	DIN 6537 K
11.20	.441	35.6	1.402	3	12	860.1-1120-035A1-SM	★	12.0	.472	102	4.016	100.1	3.942	55	2.165	2.0	.080	20	290	DIN 6537 K
11.50	.453	36.6	1.441	3	12	860.1-1150-036A1-SM	★	12.0	.472	102	4.016	100.1	3.940	55	2.165	2.1	.082	20	290	DIN 6537 K
11.80	.465	37.5	1.476	3	12	860.1-1180-037A1-SM	★	12.0	.472	102	4.016	100.0	3.938	55	2.165	2.2	.085	20	290	DIN 6537 K
12.00	.472	38.2	1.504	3	12	860.1-1200-038A1-SM	★	12.0	.472	102	4.016	100.0	3.937	55	2.165	2.2	.086	20	290	DIN 6537 K
12.00	.472	54.3	2.138	4	12	860.1-1200-054A1-SM	★	12.0	.472	118	4.646	116.0	4.567	61	2.402	2.2	.086	20	290	DIN 6537 L

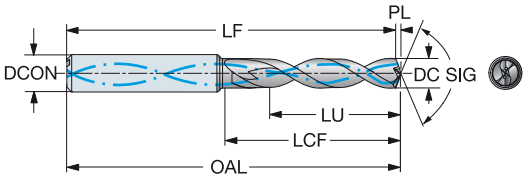
B76 E9 E28 E14

CoroDrill® 860 solid carbide drill

For heat resistant super alloys

Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	S	1210	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
									Dimensions, mm, inch												
12.10	.476	38.5	1.516	3	14	**860.1-1210-038A1-SM**	★		14.0	.551	107	4.213	105.0	4.133	60	2.362	2.2	.087	20	290	DIN 6537 K
12.20	.480	38.8	1.528	3	14	**860.1-1220-038A1-SM**	★		14.0	.551	107	4.213	105.0	4.132	55	2.165	2.2	.087	20	290	DIN 6537 K
12.40	.488	39.5	1.555	3	14	**860.1-1240-039A1-SM**	★		14.0	.551	107	4.213	104.9	4.131	60	2.362	2.3	.089	20	290	DIN 6537 K
12.50	.492	39.8	1.567	3	14	**860.1-1250-039A1-SM**	★		14.0	.551	107	4.213	104.9	4.130	60	2.362	2.3	.089	20	290	DIN 6537 K
12.70	.500	40.4	1.591	3	14	**860.1-1270-040A1-SM**	★		14.0	.551	107	4.213	104.9	4.129	60	2.362	2.3	.091	20	290	DIN 6537 K
12.70	.500	57.6	2.268	4	14	**860.1-1270-057A1-SM**	★		14.0	.551	124	4.882	121.9	4.798	71	2.795	2.3	.091	20	290	DIN 6537 L
12.90	.508	40.6	1.598	3	14	**860.1-1290-040A1-SM**	★		14.0	.551	107	4.213	104.8	4.128	60	2.362	2.4	.093	20	290	DIN 6537 K
13.00	.512	40.5	1.594	3	14	**860.1-1300-040A1-SM**	★		14.0	.551	107	4.213	104.8	4.127	60	2.362	2.4	.093	20	290	DIN 6537 K
13.25	.522	40.5	1.594	3	14	**860.1-1325-040A1-SM**	★		14.0	.551	107	4.213	104.8	4.125	60	2.362	2.4	.095	20	290	DIN 6537 K
13.50	.531	40.6	1.598	3	14	**860.1-1350-040A1-SM**	★		14.0	.551	107	4.213	104.7	4.124	60	2.362	2.5	.097	20	290	DIN 6537 K
13.70	.539	40.6	1.598	2	14	**860.1-1370-040A1-SM**	★		14.0	.551	107	4.213	104.7	4.122	60	2.362	2.5	.098	20	290	DIN 6537 K
13.70	.539	57.6	2.268	4	14	**860.1-1370-057A1-SM**	★		14.0	.551	124	4.882	121.7	4.792	77	3.032	2.5	.098	20	290	DIN 6537 L
13.75	.541	40.6	1.598	2	14	**860.1-1375-040A1-SM**	★		14.0	.551	107	4.213	104.7	4.122	60	2.362	2.5	.098	20	290	DIN 6537 K
14.00	.551	40.6	1.598	2	14	**860.1-1400-040A1-SM**	★		14.0	.551	107	4.213	104.7	4.120	60	2.362	2.6	.100	20	290	DIN 6537 K
15.50	.610	43.6	1.717	2	16	**860.1-1550-043A1-SM**	★		16.0	.630	115	4.528	112.4	4.425	65	2.559	2.8	.111	20	290	DIN 6537 K
15.87	.625	50.5	1.988	3	16	**860.1-1587-061A1-SM**	★		16.0	.630	133	5.236	130.3	5.132	83	3.268	2.9	.114	20	290	DIN 6537 L

B76 E9 E28 E14

CoroDrill® 861

High stability deep hole drilling up to 30 × DC

O C

Application

- Achievable hole tolerance H8–H9
- Drilling depths: 12–30 × drill diameter
- Clamp with high precision chucks only
- A wide range of workpiece materials
- Conventional drilling, cross holes, angled faces
- Automotive: crankshafts, engine blocks, cylinder heads
- 20 bar coolant pressure

ISO application area:

P M K N

Features and benefits

- Specially designed point geometry helps to reduce thrust forces
- Consistent edge preparation protects the cutting edge from premature chipping and flaking
- Double offset margin patented geometry offers greater stability to the drilling operation
- Internal coolant holes deliver coolant directly to the tip of the drill, even at deep drilling depths
- Can be reconditioned to tools original specification for extended tool life

www.sandvik.coromant.com/corodrill861

Recommendations

Use CoroChuck® 930 with your CoroDrill® 861 to maintain efficient production through quick and easy tool setups and changes

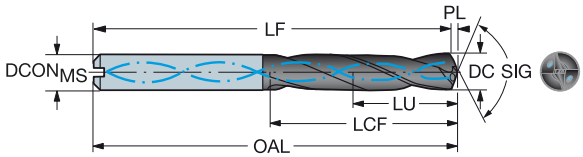
E14

CoroDrill® 861 solid-carbide drill

For multi-materials

Pilot drill – Internal coolant supply

TCHA H9
SIG 150°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P GC34	M GC34	K GC34	N GC34	Dimensions, mm, inch $DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
3.00	.118	9.4	.370	3	6	861.1-0300-009A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.18	.125	9.9	.390	3	6	861.1-0318-010A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.30	.130	10.3	.406	3	6	861.1-0330-010A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.50	.138	10.9	.429	3	6	861.1-0350-011A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.57	.141	11.1	.437	3	6	861.1-0357-011A1-GP	★	★	★	★	6.0	.236	62	2.441	61.6	2.425	20	.787	0.4	.016	20	290	DIN 6537 K
3.80	.150	11.9	.469	3	6	861.1-0380-011A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
3.97	.156	12.4	.488	3	6	861.1-0397-012A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
4.00	.157	12.5	.492	3	6	861.1-0400-012A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
4.20	.165	13.1	.516	3	6	861.1-0420-013A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
4.36	.172	13.6	.535	3	6	861.1-0436-013A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
4.50	.177	14.0	.551	3	6	861.1-0450-014A1-GP	★	★	★	★	6.0	.236	66	2.598	65.5	2.579	24	.945	0.5	.020	20	290	DIN 6537 K
4.76	.187	14.9	.587	3	6	861.1-0476-014A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K
4.80	.189	15.0	.591	3	6	861.1-0480-014A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K
5.00	.197	15.6	.614	3	6	861.1-0500-015A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K
5.16	.203	16.1	.634	3	6	861.1-0516-015A1-GP	★	★	★	★	6.0	.236	66	2.598	65.4	2.575	28	1.102	0.6	.024	20	290	DIN 6537 K
5.50	.217	17.2	.677	3	6	861.1-0550-017A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.56	.219	17.3	.681	3	6	861.1-0556-017A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
5.80	.228	17.6	.693	3	6	861.1-0580-017A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
6.00	.236	18.7	.736	3	6	861.1-0600-018A1-GP	★	★	★	★	6.0	.236	66	2.598	65.3	2.571	28	1.102	0.7	.028	20	290	DIN 6537 K
6.35	.250	19.8	.780	3	8	861.1-0635-019A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K
6.50	.256	20.3	.799	3	8	861.1-0650-020A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K
6.75	.266	21.1	.831	3	8	861.1-0675-020A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K
6.80	.268	21.2	.835	3	8	861.1-0680-020A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K
7.00	.276	21.8	.858	3	8	861.1-0700-021A1-GP	★	★	★	★	8.0	.315	79	3.110	78.2	3.079	34	1.339	0.8	.031	20	290	DIN 6537 K
7.14	.281	22.3	.878	3	8	861.1-0714-021A1-GP	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	41	1.614	0.9	.035	20	290	DIN 6537 K
7.50	.295	23.4	.921	3	8	861.1-0750-023A1-GP	★	★	★	★	8.0	.315	79	3.110	78.1	3.075	41	1.614	0.9	.035	20	290	DIN 6537 K
7.94	.313	24.8	.976	3	8	861.1-0794-024A1-GP	★	★	★	★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K
8.00	.315	25.0	.984	3	8	861.1-0800-024A1-GP	★	★	★	★	8.0	.315	79	3.110	78.0	3.071	41	1.614	1.0	.039	20	290	DIN 6537 K
8.50	.335	26.5	1.043	3	10	861.1-0850-026A1-GP	★	★	★	★	10.0	.394	89	3.504	88.0	3.465	47	1.850	1.0	.039	20	290	DIN 6537 K
9.00	.354	28.1	1.106	3	10	861.1-0900-027A1-GP	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K
9.50	.374	29.6	1.165	3	10	861.1-0950-029A1-GP	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K
9.53	.375	29.7	1.169	3	10	861.1-0953-029A1-GP	★	★	★	★	10.0	.394	89	3.504	87.9	3.461	47	1.850	1.1	.043	20	290	DIN 6537 K
10.00	.394	31.2	1.228	3	10	861.1-1000-030A1-GP	★	★	★	★	10.0	.394	89	3.504	87.8	3.457	47	1.850	1.2	.047	20	290	DIN 6537 K
10.50	.413	32.8	1.291	3	12	861.1-1050-032A1-GP	★	★	★	★	12.0	.472	102	4.016	100.7	3.965	55	2.165	1.3	.051	20	290	DIN 6537 K
11.00	.433	34.3	1.350	3	12	861.1-1100-033A1-GP	★	★	★	★	12.0	.472	102	4.016	100.7	3.965	55	2.165	1.3	.051	20	290	DIN 6537 K
11.11	.437	34.7	1.366	3	12	861.1-1111-033A1-GP	★	★	★	★	12.0	.472	102	4.016	100.7	3.965	55	2.165	1.3	.051	20	290	DIN 6537 K
11.50	.453	35.9	1.413	3	12	861.1-1150-035A1-GP	★	★	★	★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K
12.00	.472	37.4	1.472	3	12	861.1-1200-036A1-GP	★	★	★	★	12.0	.472	102	4.016	100.6	3.961	55	2.165	1.4	.055	20	290	DIN 6537 K

Cutting data: www.sandvik.coromant.com

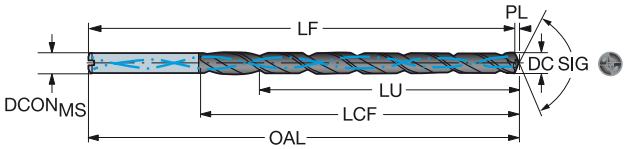
E9 E28 E14

CoroDrill® 861 solid-carbide drill

For multi-materials

Deep hole drill – Internal coolant supply

TCHA H9
SIG 140°



							P	M	K	N	Dimensions, mm, inch										BAR	PSI	
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"			BSG
3.00	.118	36.5	1.437	12	6	861.1-0300-036A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT
3.00	.118	45.5	1.791	15	6	861.1-0300-045A1-GM	★	★	★	★	6.0	.236	96	3.780	95.5	3.760	54	2.126	0.5	.020	20	290	COROMANT
3.00	.118	60.5	2.382	20	6	861.1-0300-060A1-GM	★	★	★	★	6.0	.236	111	4.370	110.5	4.350	69	2.717	0.5	.020	20	290	COROMANT
3.00	.118	90.5	3.563	30	6	861.1-0300-090A1-GM	★	★	★	★	6.0	.236	141	5.551	140.5	5.532	99	3.898	0.5	.020	20	290	COROMANT
3.10	.122	37.7	1.484	12	6	861.1-0310-037A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT
3.18	.125	38.6	1.520	12	6	861.1-0318-038A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT
3.18	.125	48.1	1.894	15	6	861.1-0318-048A1-GM	★	★	★	★	6.0	.236	99	3.898	98.6	3.882	57	2.244	0.5	.020	20	290	COROMANT
3.18	.125	64.0	2.520	20	6	861.1-0318-064A1-GM	★	★	★	★	6.0	.236	115	4.528	114.5	4.508	73	2.874	0.5	.020	20	290	COROMANT
3.18	.125	95.8	3.772	30	6	861.1-0318-095A1-GM	★	★	★	★	6.0	.236	147	5.787	146.3	5.760	105	4.134	0.5	.020	20	290	COROMANT
3.20	.126	38.9	1.532	12	6	861.1-0320-038A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT
3.30	.130	40.1	1.579	12	6	861.1-0330-040A1-GM	★	★	★	★	6.0	.236	94	3.701	93.5	3.681	52	2.047	0.5	.020	20	290	COROMANT
3.30	.130	50.0	1.969	15	6	861.1-0330-050A1-GM	★	★	★	★	6.0	.236	101	3.976	100.9	3.972	59	2.323	0.5	.020	20	290	COROMANT
3.30	.130	66.5	2.618	20	6	861.1-0330-066A1-GM	★	★	★	★	6.0	.236	118	4.646	117.4	4.622	76	2.992	0.5	.020	20	290	COROMANT
3.40	.134	41.4	1.630	12	6	861.1-0340-041A1-GM	★	★	★	★	6.0	.236	94	3.701	93.4	3.677	52	2.047	0.6	.024	20	290	COROMANT
3.50	.138	42.6	1.677	12	6	861.1-0350-042A1-GM	★	★	★	★	6.0	.236	94	3.701	93.4	3.677	52	2.047	0.6	.024	20	290	COROMANT
3.50	.138	53.1	2.091	15	6	861.1-0350-053A1-GM	★	★	★	★	6.0	.236	105	4.134	104.4	4.110	63	2.480	0.6	.024	20	290	COROMANT
3.50	.138	70.6	2.780	20	6	861.1-0350-070A1-GM	★	★	★	★	6.0	.236	123	4.843	121.9	4.799	81	3.189	0.6	.024	20	290	COROMANT
3.50	.138	105.6	4.157	30	6	861.1-0350-105A1-GM	★	★	★	★	6.0	.236	158	6.220	156.9	6.177	116	4.567	0.6	.024	20	290	COROMANT
3.57	.141	54.2	2.134	15	6	861.1-0357-054A1-GM	★	★	★	★	6.0	.236	106	4.173	105.7	4.161	64	2.520	0.6	.024	20	290	COROMANT
3.57	.141	72.0	2.835	20	6	861.1-0357-071A1-GM	★	★	★	★	6.0	.236	124	4.882	123.6	4.866	82	3.228	0.6	.024	20	290	COROMANT
3.70	.146	43.9	1.728	11	6	861.1-0370-044A1-GM	★	★	★	★	6.0	.236	94	3.701	93.4	3.677	52	2.047	0.6	.024	20	290	COROMANT
3.80	.150	46.2	1.819	12	6	861.1-0380-046A1-GM	★	★	★	★	6.0	.236	109	4.291	108.4	4.268	67	2.638	0.6	.024	20	290	COROMANT
3.80	.150	57.6	2.268	15	6	861.1-0380-057A1-GM	★	★	★	★	6.0	.236	110	4.331	109.8	4.323	68	2.677	0.6	.024	20	290	COROMANT
3.80	.150	76.6	3.016	20	6	861.1-0380-076A1-GM	★	★	★	★	6.0	.236	129	5.079	128.8	5.071	87	3.425	0.6	.024	20	290	COROMANT
3.97	.156	48.3	1.902	12	6	861.1-0397-048A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT
3.97	.156	60.2	2.370	15	6	861.1-0397-060A1-GM	★	★	★	★	6.0	.236	113	4.449	112.8	4.441	71	2.795	0.7	.028	20	290	COROMANT
3.97	.156	80.0	3.150	20	6	861.1-0397-079A1-GM	★	★	★	★	6.0	.236	133	5.236	132.6	5.220	91	3.583	0.7	.028	20	290	COROMANT
3.97	.156	119.7	4.713	30	6	861.1-0397-119A1-GM	★	★	★	★	6.0	.236	173	6.811	172.3	6.783	131	5.157	0.7	.028	20	290	COROMANT
4.00	.157	48.7	1.917	12	6	861.1-0400-048A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT
4.00	.157	60.7	2.390	15	6	861.1-0400-060A1-GM	★	★	★	★	6.0	.236	114	4.488	113.3	4.461	72	2.835	0.7	.028	20	290	COROMANT
4.00	.157	80.7	3.177	20	6	861.1-0400-080A1-GM	★	★	★	★	6.0	.236	134	5.276	133.3	5.248	92	3.622	0.7	.028	20	290	COROMANT
4.00	.157	120.7	4.752	30	6	861.1-0400-120A1-GM	★	★	★	★	6.0	.236	174	6.850	173.3	6.823	132	5.197	0.7	.028	20	290	COROMANT
4.10	.161	49.9	1.965	12	6	861.1-0410-049A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT
4.20	.165	51.1	2.012	12	6	861.1-0420-050A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT
4.20	.165	63.7	2.508	15	6	861.1-0420-063A1-GM	★	★	★	★	6.0	.236	118	4.646	116.9	4.602	76	2.992	0.7	.028	20	290	COROMANT
4.20	.165	84.7	3.335	20	6	861.1-0420-084A1-GM	★	★	★	★	6.0	.236	139	5.472	137.9	5.429	97	3.819	0.7	.028	20	290	COROMANT
4.30	.169	52.3	2.059	12	6	861.1-0430-052A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT
4.37	.172	53.1	2.091	12	6	861.1-0437-052A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT
4.37	.172	66.2	2.606	15	6	861.1-0437-065A1-GM	★	★	★	★	6.0	.236	121	4.764	119.9	4.720	79	3.110	0.7	.028	20	290	COROMANT
4.37	.172	88.0	3.465	20	6	861.1-0437-087A1-GM	★	★	★	★	6.0	.236	142	5.591	141.7	5.579	100	3.937	0.7	.028	20	290	COROMANT
4.37	.172	131.7	5.185	30	6	861.1-0437-131A1-GM	★	★	★	★	6.0	.236	186	7.323	185.4	7.299	144	5.669	0.7	.028	20	290	COROMANT
4.50	.177	54.7	2.154	12	6	861.1-0450-054A1-GM	★	★	★	★	6.0	.236	109	4.291	108.3	4.264	67	2.638	0.7	.028	20	290	COROMANT
4.50	.177	68.2	2.685	15	6	861.1-0450-068A1-GM	★	★	★	★	6.0	.236	123	4.843	122.3	4.815	81	3.189	0.7	.028	20	290	COROMANT
4.50	.177	90.7	3.571	20	6	861.1-0450-090A1-GM	★	★	★	★	6.0	.236	146	5.748	144.8	5.701	104	4.094	0.7	.028	20	290	COROMANT
4.50	.177	135.7	5.343	30	6	861.1-0450-135A1-GM	★	★	★	★	6.0	.236	191	7.520	189.8	7.472	149	5.866	0.7	.028	20	290	COROMANT
4.60	.181	56.0	2.205	12	6	861.1-0460-055A1-GM	★	★	★	★	6.0	.236	109	4.291	108.2	4.260	67	2.638	0.8	.031	20	290	COROMANT
4.76	.187	57.9	2.280	12	6	861.1-0476-057A1-GM	★	★	★	★	6.0	.236	128	5.039	127.2	5.008	86	3.386	0.8	.031	20	290	COROMANT
4.76	.187	72.2	2.843	15	6	861.1-0476-071A1-GM	★	★	★	★	6.0	.236	128	5.039	126.9	4.996	86	3.386	0.8	.031	20	290	COROMANT
4.76	.187	96.0	3.780	20	6	861.1-0476-095A1-GM	★	★	★	★	6.0	.236	152	5.984	150.7	5.933	110	4.331	0.8	.031	20	290	COROMANT
4.76	.187	143.6	5.654	30	6	861.1-0476-143A1-GM	★	★	★	★	6.0	.236	199	7.835	198.4	7.811	157	6.181	0.8	.031	20	290	COROMANT

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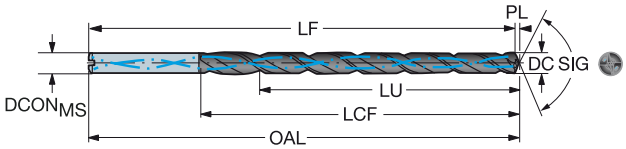


DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P GC34	M GC34	K GC34	N GC34	Dimensions, mm, inch $DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
4.80	.189	58.4	2.299	12	6	861.1-0480-058A1-GM	★	★	★	★	6.0	.236	128	5.039	127.2	5.008	86	3.386	0.8	.031	20	290	COROMANT
4.80	.189	72.8	2.866	15	6	861.1-0480-072A1-GM	★	★	★	★	6.0	.236	128	5.039	127.6	5.024	86	3.386	0.8	.031	20	290	COROMANT
4.80	.189	96.8	3.811	20	6	861.1-0480-096A1-GM	★	★	★	★	6.0	.236	152	5.984	151.6	5.969	110	4.331	0.8	.031	20	290	COROMANT
5.00	.197	60.8	2.394	12	6	861.1-0500-060A1-GM	★	★	★	★	6.0	.236	128	5.039	127.2	5.008	86	3.386	0.8	.031	20	290	COROMANT
5.00	.197	75.8	2.984	15	6	861.1-0500-075A1-GM	★	★	★	★	6.0	.236	132	5.197	131.2	5.165	90	3.543	0.8	.031	20	290	COROMANT
5.00	.197	100.8	3.969	20	6	861.1-0500-100A1-GM	★	★	★	★	6.0	.236	157	6.181	156.2	6.150	115	4.528	0.8	.031	20	290	COROMANT
5.00	.197	150.8	5.937	30	6	861.1-0500-150A1-GM	★	★	★	★	6.0	.236	207	8.150	206.2	8.118	165	6.496	0.8	.031	20	290	COROMANT
5.10	.201	62.0	2.441	12	6	861.1-0510-061A1-GM	★	★	★	★	6.0	.236	128	5.039	127.2	5.008	86	3.386	0.8	.031	20	290	COROMANT
5.16	.203	62.8	2.472	12	6	861.1-0516-062A1-GM	★	★	★	★	6.0	.236	128	5.039	127.2	5.008	86	3.386	0.8	.031	20	290	COROMANT
5.16	.203	78.2	3.079	15	6	861.1-0516-077A1-GM	★	★	★	★	6.0	.236	135	5.315	134.0	5.276	93	3.661	0.8	.031	20	290	COROMANT
5.16	.203	104.0	4.094	20	6	861.1-0516-103A1-GM	★	★	★	★	6.0	.236	161	6.339	159.8	6.291	119	4.685	0.8	.031	20	290	COROMANT
5.16	.203	155.6	6.126	30	6	861.1-0516-155A1-GM	★	★	★	★	6.0	.236	212	8.346	211.4	8.323	170	6.693	0.8	.031	20	290	COROMANT
5.20	.205	63.3	2.492	12	6	861.1-0520-062A1-GM	★	★	★	★	6.0	.236	128	5.039	127.1	5.004	86	3.386	0.9	.035	20	290	COROMANT
5.50	.217	66.9	2.634	12	6	861.1-0550-066A1-GM	★	★	★	★	6.0	.236	128	5.039	127.1	5.004	86	3.386	0.9	.035	20	290	COROMANT
5.50	.217	83.4	3.283	15	6	861.1-0550-083A1-GM	★	★	★	★	6.0	.236	141	5.551	140.1	5.516	99	3.898	0.9	.035	20	290	COROMANT
5.50	.217	110.9	4.366	20	6	861.1-0550-110A1-GM	★	★	★	★	6.0	.236	169	6.654	167.6	6.598	127	5.000	0.9	.035	20	290	COROMANT
5.50	.217	165.9	6.532	30	6	861.1-0550-165A1-GM	★	★	★	★	6.0	.236	224	8.819	222.6	8.764	182	7.165	0.9	.035	20	290	COROMANT
5.56	.219	67.6	2.661	12	6	861.1-0556-067A1-GM	★	★	★	★	6.0	.236	128	5.039	127.1	5.004	86	3.386	0.9	.035	20	290	COROMANT
5.56	.219	84.3	3.319	15	6	861.1-0556-083A1-GM	★	★	★	★	6.0	.236	142	5.591	141.1	5.555	100	3.937	0.9	.035	20	290	COROMANT
5.56	.219	112.0	4.409	20	6	861.1-0556-111A1-GM	★	★	★	★	6.0	.236	170	6.693	168.9	6.650	128	5.039	0.9	.035	20	290	COROMANT
5.80	.228	70.6	2.780	12	6	861.1-0580-070A1-GM	★	★	★	★	6.0	.236	128	5.039	127.0	5.000	86	3.386	1.0	.039	20	290	COROMANT
5.80	.228	88.0	3.465	15	6	861.1-0580-087A1-GM	★	★	★	★	6.0	.236	146	5.748	145.4	5.724	104	4.094	1.0	.039	20	290	COROMANT
5.80	.228	117.0	4.606	20	6	861.1-0580-116A1-GM	★	★	★	★	6.0	.236	175	6.890	174.4	6.866	133	5.236	1.0	.039	20	290	COROMANT
6.00	.236	73.0	2.874	12	6	861.1-0600-072A1-GM	★	★	★	★	6.0	.236	128	5.039	127.0	5.000	86	3.386	1.0	.039	20	290	COROMANT
6.00	.236	91.0	3.583	15	6	861.1-0600-090A1-GM	★	★	★	★	6.0	.236	150	5.906	149.0	5.866	108	4.252	1.0	.039	20	290	COROMANT
6.00	.236	121.0	4.764	20	6	861.1-0600-120A1-GM	★	★	★	★	6.0	.236	180	7.087	179.0	7.047	138	5.433	1.0	.039	20	290	COROMANT
6.00	.236	181.0	7.126	30	6	861.1-0600-180A1-GM	★	★	★	★	6.0	.236	240	9.449	239.0	9.409	198	7.795	1.0	.039	20	290	COROMANT
6.10	.240	74.2	2.921	12	8	861.1-0610-073A1-GM	★	★	★	★	8.0	.315	158	6.220	157.0	6.181	116	4.567	1.0	.039	20	290	COROMANT
6.20	.244	75.4	2.969	12	8	861.1-0620-074A1-GM	★	★	★	★	8.0	.315	158	6.220	157.0	6.181	116	4.567	1.0	.039	20	290	COROMANT
6.30	.248	76.6	3.016	12	8	861.1-0630-076A1-GM	★	★	★	★	8.0	.315	158	6.220	157.0	6.181	116	4.567	1.0	.039	20	290	COROMANT
6.35	.250	77.2	3.039	12	8	861.1-0635-076A1-GM	★	★	★	★	8.0	.315	158	6.220	157.0	6.181	116	4.567	1.0	.039	20	290	COROMANT
6.35	.250	96.3	3.791	15	8	861.1-0635-095A1-GM	★	★	★	★	8.0	.315	156	6.142	155.3	6.114	114	4.488	1.0	.039	20	290	COROMANT
6.35	.250	128.0	5.039	20	8	861.1-0635-127A1-GM	★	★	★	★	8.0	.315	188	7.402	187.0	7.362	146	5.748	1.0	.039	20	290	COROMANT
6.35	.250	191.5	7.539	30	8	861.1-0635-191A1-GM	★	★	★	★	8.0	.315	252	9.921	250.5	9.862	210	8.268	1.0	.039	20	290	COROMANT
6.50	.256	79.1	3.114	12	8	861.1-0650-078A1-GM	★	★	★	★	8.0	.315	158	6.220	156.9	6.177	116	4.567	1.1	.043	20	290	COROMANT
6.50	.256	98.6	3.882	15	8	861.1-0650-098A1-GM	★	★	★	★	8.0	.315	159	6.260	157.9	6.217	117	4.606	1.1	.043	20	290	COROMANT
6.50	.256	131.1	5.161	20	8	861.1-0650-130A1-GM	★	★	★	★	8.0	.315	192	7.559	190.4	7.496	150	5.906	1.1	.043	20	290	COROMANT
6.50	.256	196.1	7.720	30	8	861.1-0650-195A1-GM	★	★	★	★	8.0	.315	257	10.118	255.4	10.055	215	8.465	1.1	.043	20	290	COROMANT
6.60	.260	80.3	3.161	12	8	861.1-0660-079A1-GM	★	★	★	★	8.0	.315	158	6.220	156.9	6.177	116	4.567	1.1	.043	20	290	COROMANT
6.70	.264	81.5	3.209	12	8	861.1-0670-080A1-GM	★	★	★	★	8.0	.315	158	6.220	156.9	6.177	116	4.567	1.1	.043	20	290	COROMANT
6.75	.266	82.1	3.232	12	8	861.1-0675-081A1-GM	★	★	★	★	8.0	.315	158	6.220	156.9	6.177	116	4.567	1.1	.043	20	290	COROMANT
6.75	.266	102.3	4.028	15	8	861.1-0675-101A1-GM	★	★	★	★	8.0	.315	163	6.417	162.3	6.390	121	4.764	1.1	.043	20	290	COROMANT
6.75	.266	136.0	5.354	20	8	861.1-0675-135A1-GM	★	★	★	★	8.0	.315	197	7.756	196.1	7.720	155	6.102	1.1	.043	20	290	COROMANT
6.75	.266	203.5	8.012	30	8	861.1-0675-202A1-GM	★	★	★	★	8.0	.315	265	10.433	263.5	10.374	223	8.780	1.1	.043	20	290	COROMANT
6.80	.268	82.7	3.256	12	8	861.1-0680-082A1-GM	★	★	★	★	8.0	.315	158	6.220	156.9	6.177	116	4.567	1.1	.043	20	290	COROMANT
6.80	.268	103.1	4.059	15	8	861.1-0680-102A1-GM	★	★	★	★	8.0	.315	164	6.457	163.3	6.429	122	4.803	1.1	.043	20	290	COROMANT
6.80	.268	137.1	5.398	20	8	861.1-0680-136A1-GM	★	★	★	★	8.0	.315	198	7.795	197.3	7.768	156	6.142	1.1	.043	20	290	COROMANT
6.90	.272	83.9	3.303	12	8	861.1-0690-083A1-GM	★	★	★	★	8.0	.315	158	6.220	156.9	6.177	116	4.567	1.1	.043	20	290	COROMANT
7.00	.276	85.1	3.350	12	8	861.1-0700-084A1-GM	★	★	★	★	8.0	.315	158	6.220	156.9	6.177	116	4.567	1.1	.043	20	290	COROMANT
7.00	.276	106.1	4.177	15	8	861.1-0700-105A1-GM	★	★	★	★	8.0	.315	168	6.614	166.9	6.571	126	4.961	1.1	.043	20	290	COROMANT
7.00	.276	141.1	5.555	20	8	861.1-0700-140A1-GM	★	★	★	★	8.0	.315	203	7.992	201.9	7.949	161	6.339	1.1	.043	20	290	COROMANT
7.00	.276	211.1	8.311	30	8	861.1-0700-210A1-GM	★	★	★	★	8.0	.315	273	10.748	271.9	10.705	231	9.094	1.1	.043	20	290	COROMANT

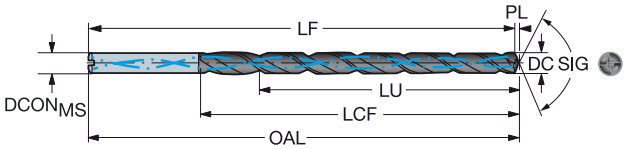
B84 E9 E28 E14

CoroDrill® 861 solid-carbide drill

For multi-materials

Deep hole drill – Internal coolant supply

TCHA H9
SIG 140°



							P	M	K	N	Dimensions, mm, inch												
DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	GC34	GC34	GC34	GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
7.14	.281	86.9	3.421	12	8	861.1-0714-086A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT
7.14	.281	108.3	4.264	15	8	861.1-0714-107A1-GM	★	★	★	★	8.0	.315	171	6.732	169.4	6.669	129	5.079	1.2	.047	20	290	COROMANT
7.14	.281	144.1	5.673	20	8	861.1-0714-143A1-GM	★	★	★	★	8.0	.315	206	8.110	205.1	8.075	164	6.457	1.2	.047	20	290	COROMANT
7.14	.281	215.5	8.484	30	8	861.1-0714-214A1-GM	★	★	★	★	8.0	.315	278	10.945	276.6	10.890	236	9.291	1.2	.047	20	290	COROMANT
7.40	.291	90.0	3.543	12	8	861.1-0740-089A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT
7.50	.295	91.2	3.591	12	8	861.1-0750-090A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT
7.50	.295	113.7	4.476	15	8	861.1-0750-113A1-GM	★	★	★	★	8.0	.315	177	6.969	175.8	6.921	135	5.315	1.2	.047	20	290	COROMANT
7.50	.295	151.2	5.953	20	8	861.1-0750-150A1-GM	★	★	★	★	8.0	.315	215	8.465	213.3	8.398	173	6.811	1.2	.047	20	290	COROMANT
7.50	.295	226.2	8.906	30	8	861.1-0750-225A1-GM	★	★	★	★	8.0	.315	290	11.417	288.3	11.350	248	9.764	1.2	.047	20	290	COROMANT
7.60	.299	92.4	3.638	12	8	861.1-0760-091A1-GM	★	★	★	★	8.0	.315	158	6.220	156.8	6.173	116	4.567	1.2	.047	20	290	COROMANT
7.70	.303	93.7	3.689	12	8	861.1-0770-092A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT
7.80	.307	94.9	3.736	12	8	861.1-0780-094A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT
7.94	.313	96.6	3.803	12	8	861.1-0794-095A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT
7.94	.313	120.4	4.740	15	8	861.1-0794-119A1-GM	★	★	★	★	8.0	.315	185	7.283	183.6	7.228	143	5.630	1.3	.051	20	290	COROMANT
7.94	.313	160.1	6.303	20	8	861.1-0794-159A1-GM	★	★	★	★	8.0	.315	225	8.858	223.3	8.791	183	7.205	1.3	.051	20	290	COROMANT
7.94	.313	239.4	9.425	30	8	861.1-0794-238A1-GM	★	★	★	★	8.0	.315	304	11.969	302.7	11.917	262	10.315	1.3	.051	20	290	COROMANT
8.00	.315	97.3	3.831	12	8	861.1-0800-096A1-GM	★	★	★	★	8.0	.315	158	6.220	156.7	6.169	116	4.567	1.3	.051	20	290	COROMANT
8.00	.315	121.3	4.776	15	8	861.1-0800-120A1-GM	★	★	★	★	8.0	.315	186	7.323	184.7	7.272	144	5.669	1.3	.051	20	290	COROMANT
8.00	.315	161.3	6.350	20	8	861.1-0800-160A1-GM	★	★	★	★	8.0	.315	226	8.898	224.7	8.846	184	7.244	1.3	.051	20	290	COROMANT
8.00	.315	241.3	9.500	30	8	861.1-0800-240A1-GM	★	★	★	★	8.0	.315	306	12.047	304.7	11.996	264	10.394	1.3	.051	20	290	COROMANT
8.10	.319	98.5	3.878	12	10	861.1-0810-097A1-GM	★	★	★	★	10.0	.394	192	7.559	190.7	7.508	146	5.748	1.3	.051	20	290	COROMANT
8.20	.323	99.7	3.925	12	10	861.1-0820-098A1-GM	★	★	★	★	10.0	.394	192	7.559	190.7	7.508	146	5.748	1.3	.051	20	290	COROMANT
8.33	.328	101.4	3.992	12	10	861.1-0833-100A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT
8.40	.331	102.2	4.024	12	10	861.1-0840-101A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT
8.50	.335	103.4	4.071	12	10	861.1-0850-102A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT
8.50	.335	128.9	5.075	15	10	861.1-0850-128A1-GM	★	★	★	★	10.0	.394	199	7.835	197.6	7.780	153	6.024	1.4	.055	20	290	COROMANT
8.50	.335	171.4	6.748	20	10	861.1-0850-170A1-GM	★	★	★	★	10.0	.394	242	9.528	240.1	9.453	196	7.717	1.4	.055	20	290	COROMANT
8.60	.339	104.6	4.118	12	10	861.1-0860-103A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT
8.70	.343	105.8	4.165	12	10	861.1-0870-104A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT
8.73	.344	106.2	4.181	12	10	861.1-0873-105A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT
8.80	.346	107.0	4.213	12	10	861.1-0880-106A1-GM	★	★	★	★	10.0	.394	192	7.559	190.6	7.504	146	5.748	1.4	.055	20	290	COROMANT
9.00	.354	109.5	4.311	12	10	861.1-0900-108A1-GM	★	★	★	★	10.0	.394	192	7.559	190.5	7.500	146	5.748	1.5	.059	20	290	COROMANT
9.00	.354	136.5	5.374	15	10	861.1-0900-135A1-GM	★	★	★	★	10.0	.394	208	8.189	206.5	8.130	162	6.378	1.5	.059	20	290	COROMANT
9.00	.354	181.5	7.146	20	10	861.1-0900-180A1-GM	★	★	★	★	10.0	.394	253	9.961	251.5	9.902	207	8.150	1.5	.059	20	290	COROMANT
9.13	.359	111.0	4.370	12	10	861.1-0913-110A1-GM	★	★	★	★	10.0	.394	192	7.559	190.5	7.500	146	5.748	1.5	.059	20	290	COROMANT
9.30	.366	113.1	4.453	12	10	861.1-0930-112A1-GM	★	★	★	★	10.0	.394	192	7.559	190.5	7.500	146	5.748	1.5	.059	20	290	COROMANT
9.50	.374	115.6	4.551	12	10	861.1-0950-114A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT
9.50	.374	144.1	5.673	15	10	861.1-0950-143A1-GM	★	★	★	★	10.0	.394	217	8.543	215.4	8.480	171	6.732	1.6	.063	20	290	COROMANT
9.50	.374	191.6	7.543	20	10	861.1-0950-190A1-GM	★	★	★	★	10.0	.394	265	10.433	262.9	10.350	219	8.622	1.6	.063	20	290	COROMANT
9.53	.375	115.9	4.563	12	10	861.1-0953-114A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT
9.53	.375	144.4	5.685	15	10	861.1-0953-143A1-GM	★	★	★	★	10.0	.394	217	8.543	215.9	8.500	171	6.732	1.6	.063	20	290	COROMANT
9.53	.375	192.1	7.563	20	10	861.1-0953-191A1-GM	★	★	★	★	10.0	.394	265	10.433	263.5	10.374	219	8.622	1.6	.063	20	290	COROMANT
9.80	.386	119.2	4.693	12	10	861.1-0980-118A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT
9.92	.391	120.7	4.752	12	10	861.1-0992-119A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT
10.00	.394	121.6	4.787	12	10	861.1-1000-120A1-GM	★	★	★	★	10.0	.394	192	7.559	190.4	7.496	146	5.748	1.6	.063	20	290	COROMANT
10.00	.394	151.6	5.969	15	10	861.1-1000-150A1-GM	★	★	★	★	10.0	.394	226	8.898	224.4	8.835	180	7.087	1.6	.063	20	290	COROMANT
10.00	.394	201.6	7.937	20	10	861.1-1000-200A1-GM	★	★	★	★	10.0	.394	276	10.866	274.4	10.803	230	9.055	1.6	.063	20	290	COROMANT
10.20	.402	124.1	4.886	12	12	861.1-1020-122A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT
10.30	.406	125.3	4.933	12	12	861.1-1030-124A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT
10.32	.406	125.5	4.941	12	12	861.1-1032-124A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT
10.40	.409	126.5	4.980	12	12	861.1-1040-125A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT

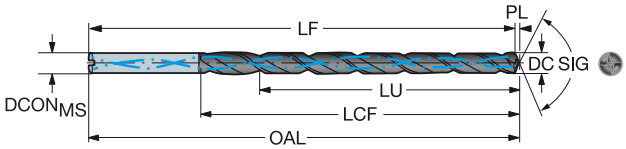
B84 E9 E28 E14

CoroDrill® 861 solid-carbide drill

For multi-materials

Deep hole drill – Internal coolant supply

TCHA H9
SIG 140°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	P GC34	M GC34	K GC34	N GC34	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
							Dimensions, mm, inch																
10.50	.413	127.7	5.028	12	12	861.1-1050-126A1-GM	★	★	★	★	12.0	.472	228	8.976	226.3	8.909	176	6.929	1.7	.067	20	290	COROMANT
10.50	.413	159.2	6.268	15	12	861.1-1050-158A1-GM	★	★	★	★	12.0	.472	240	9.449	238.3	9.382	189	7.441	1.7	.067	20	290	COROMANT
10.50	.413	211.7	8.335	20	12	861.1-1050-210A1-GM	★	★	★	★	12.0	.472	293	11.535	290.8	11.449	242	9.528	1.7	.067	20	290	COROMANT
10.72	.422	130.3	5.130	12	12	861.1-1072-129A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT
11.00	.433	133.8	5.268	12	12	861.1-1100-132A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT
11.00	.433	166.8	6.567	15	12	861.1-1100-165A1-GM	★	★	★	★	12.0	.472	249	9.803	247.2	9.732	198	7.795	1.8	.071	20	290	COROMANT
11.00	.433	221.8	8.732	20	12	861.1-1100-220A1-GM	★	★	★	★	12.0	.472	304	11.969	302.2	11.898	253	9.961	1.8	.071	20	290	COROMANT
11.11	.437	135.2	5.323	12	12	861.1-1111-133A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT
11.11	.437	168.5	6.634	15	12	861.1-1111-167A1-GM	★	★	★	★	12.0	.472	251	9.882	249.2	9.811	200	7.874	1.8	.071	20	290	COROMANT
11.11	.437	224.1	8.823	20	12	861.1-1111-222A1-GM	★	★	★	★	12.0	.472	307	12.087	304.8	12.000	256	10.079	1.8	.071	20	290	COROMANT
11.20	.441	136.2	5.362	12	12	861.1-1120-134A1-GM	★	★	★	★	12.0	.472	228	8.976	226.2	8.906	176	6.929	1.8	.071	20	290	COROMANT
11.50	.453	139.9	5.508	12	12	861.1-1150-138A1-GM	★	★	★	★	12.0	.472	228	8.976	226.1	8.902	176	6.929	1.9	.075	20	290	COROMANT
11.50	.453	174.4	6.866	15	12	861.1-1150-173A1-GM	★	★	★	★	12.0	.472	258	10.158	256.1	10.083	207	8.150	1.9	.075	20	290	COROMANT
11.50	.453	231.9	9.130	20	12	861.1-1150-230A1-GM	★	★	★	★	12.0	.472	316	12.441	313.6	12.347	265	10.433	1.9	.075	20	290	COROMANT
11.80	.465	143.5	5.650	12	12	861.1-1180-142A1-GM	★	★	★	★	12.0	.472	228	8.976	226.1	8.902	176	6.929	1.9	.075	20	290	COROMANT
12.00	.472	146.0	5.748	12	12	861.1-1200-144A1-GM	★	★	★	★	12.0	.472	228	8.976	226.0	8.898	176	6.929	2.0	.079	20	290	COROMANT
12.00	.472	182.0	7.165	15	12	861.1-1200-180A1-GM	★	★	★	★	12.0	.472	267	10.512	265.0	10.433	216	8.504	2.0	.079	20	290	COROMANT
12.00	.472	242.0	9.528	20	12	861.1-1200-240A1-GM	★	★	★	★	12.0	.472	327	12.874	325.0	12.795	276	10.866	2.0	.079	20	290	COROMANT
12.30	.484	149.7	5.894	12	14	861.1-1230-148A1-GM	★	★	★	★	14.0	.551	258	10.158	256.0	10.079	207	8.150	2.0	.079	20	290	COROMANT
12.50	.492	152.0	5.984	12	14	861.1-1250-150A1-GM	★	★	★	★	14.0	.551	258	10.158	256.0	10.079	207	8.150	2.0	.079	20	290	COROMANT
12.70	.500	154.5	6.083	12	14	861.1-1270-152A1-GM	★	★	★	★	14.0	.551	258	10.158	255.9	10.075	207	8.150	2.1	.083	20	290	COROMANT
13.00	.512	158.1	6.224	12	14	861.1-1300-156A1-GM	★	★	★	★	14.0	.551	258	10.158	255.9	10.075	207	8.150	2.1	.083	20	290	COROMANT
13.10	.516	159.3	6.272	12	14	861.1-1310-157A1-GM	★	★	★	★	14.0	.551	258	10.158	255.9	10.075	207	8.150	2.1	.083	20	290	COROMANT
13.50	.531	164.2	6.465	12	14	861.1-1350-162A1-GM	★	★	★	★	14.0	.551	258	10.158	255.8	10.071	207	8.150	2.2	.087	20	290	COROMANT
13.89	.547	169.0	6.654	12	14	861.1-1389-167A1-GM	★	★	★	★	14.0	.551	258	10.158	255.7	10.067	207	8.150	2.3	.091	20	290	COROMANT
14.00	.551	170.3	6.705	12	14	861.1-1400-168A1-GM	★	★	★	★	14.0	.551	258	10.158	255.7	10.067	207	8.150	2.3	.091	20	290	COROMANT
14.50	.571	176.4	6.945	12	16	861.1-1450-174A1-GM	★	★	★	★	16.0	.630	291	11.457	288.6	11.362	236	9.291	2.4	.094	20	290	COROMANT
15.00	.591	182.5	7.185	12	16	861.1-1500-180A1-GM	★	★	★	★	16.0	.630	291	11.457	288.5	11.358	236	9.291	2.5	.098	20	290	COROMANT
15.50	.610	188.5	7.421	12	16	861.1-1550-186A1-GM	★	★	★	★	16.0	.630	291	11.457	288.5	11.358	236	9.291	2.5	.098	20	290	COROMANT
15.88	.625	193.1	7.602	12	16	861.1-1588-191A1-GM	★	★	★	★	16.0	.630	291	11.457	288.4	11.354	236	9.291	2.6	.102	20	290	COROMANT
16.00	.630	194.6	7.661	12	16	861.1-1600-192A1-GM	★	★	★	★	16.0	.630	291	11.457	288.4	11.354	236	9.291	2.6	.102	20	290	COROMANT

B84 E9 E28 E14

CoroDrill® 862

Solid carbide drill with internal coolant supply for micro holes

Application

- Achievable hole tolerance: H8-H9
- Suitable for all materials
- Drill lengths: 8–12 × drill diameter

O C

ISO application area:

P M K N S

Benefits and features

- High performance in steel, stainless steel, cast iron, and aluminum
- Engineered tool geometry and surface treatment for efficient chip removal
- Good hole entry and exit, tight hole tolerance
- ACM (Advanced Chip Management) flute geometry for small and manageable chips
- Specially designed point geometry reduces thrust forces
- Smooth drill surface enables fast and efficient chip evacuation
- Internal coolant holes deliver coolant directly to the tip of the drill, even at deep drilling depths

www.sandvik.coromant.com/corodrill862

Recommendations

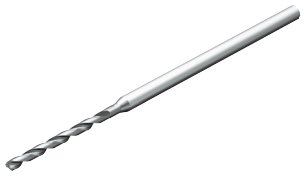
Use CoroChuck® 930 with your CoroDrill® 862 to maintain efficient production through quick and easy tool setups and changes

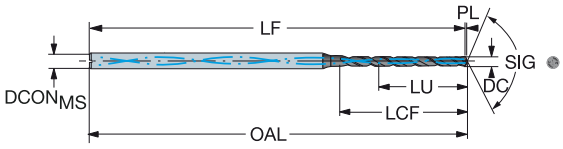
CoroDrill® 862 solid-carbide drill

For multi-materials

Internal coolant supply

TCHA H9
SIG 140°





DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	P GC34	M GC34	K GC34	N GC34	S GC34	Dimensions, mm, inch DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
1.85	.073	14.5	.571	7	3	862.1-0185-015A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	20	.787	0.3	.012	40	580	COROMANT
1.85	.073	22.5	.886	12	3	862.1-0185-022A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	30	1.181	0.3	.012	40	580	COROMANT
1.90	.075	14.3	.563	7	3	862.1-0190-015A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	20	.787	0.3	.012	40	580	COROMANT
1.90	.075	23.1	.909	12	3	862.1-0190-023A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	30	1.181	0.3	.012	40	580	COROMANT
1.98	.078	14.2	.559	7	3	862.1-0198-016A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	20	.787	0.3	.012	40	580	COROMANT
1.98	.078	24.0	.945	12	3	862.1-0198-024A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	30	1.181	0.3	.012	40	580	COROMANT
2.00	.079	16.3	.642	8	3	862.1-0200-016A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT
2.00	.079	24.3	.957	12	3	862.1-0200-024A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT
2.05	.081	16.7	.657	8	3	862.1-0205-016A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT
2.05	.081	24.9	.980	12	3	862.1-0205-025A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT
2.08	.082	16.8	.661	8	3	862.1-0208-017A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT
2.08	.082	25.3	.996	12	3	862.1-0208-025A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT
2.10	.083	16.8	.661	8	3	862.1-0210-017A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	22	.866	0.3	.012	40	580	COROMANT
2.10	.083	25.5	1.004	12	3	862.1-0210-025A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.7	2.862	32	1.260	0.3	.012	40	580	COROMANT
2.15	.085	16.6	.654	7	3	862.1-0215-017A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.6	2.858	22	.866	0.4	.016	40	580	COROMANT
2.15	.085	26.2	1.032	12	3	862.1-0215-026A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.6	2.858	32	1.260	0.4	.016	40	580	COROMANT
2.18	.086	16.6	.654	7	3	862.1-0218-017A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.6	2.858	22	.866	0.4	.016	40	580	COROMANT
2.20	.087	16.5	.650	7	3	862.1-0220-018A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.6	2.858	22	.866	0.4	.016	40	580	COROMANT
2.20	.087	26.5	1.043	12	3	862.1-0220-026A1-GM	★	★	★	★	★	3.0	.118	73	2.874	72.6	2.858	32	1.260	0.4	.016	40	580	COROMANT
2.25	.089	18.4	.724	8	3	862.1-0225-018A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT
2.25	.089	27.4	1.079	12	3	862.1-0225-027A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT
2.26	.089	18.5	.728	8	3	862.1-0226-018A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT
2.30	.091	18.8	.740	8	3	862.1-0230-018A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT
2.30	.091	28.0	1.102	12	3	862.1-0230-028A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT
2.38	.094	19.0	.748	7	3	862.1-0238-019A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT
2.38	.094	29.0	1.142	12	3	862.1-0238-029A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT
2.40	.094	19.0	.748	7	3	862.1-0240-019A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT
2.40	.094	29.2	1.150	12	3	862.1-0240-029A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT
2.44	.096	18.9	.744	7	3	862.1-0244-020A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT
2.44	.096	29.7	1.169	12	3	862.1-0244-029A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT
2.50	.098	18.8	.740	7	3	862.1-0250-020A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	25	.984	0.4	.016	40	580	COROMANT
2.50	.098	29.8	1.173	11	3	862.1-0250-030A1-GM	★	★	★	★	★	3.0	.118	78	3.071	77.6	3.055	36	1.417	0.4	.016	40	580	COROMANT
2.58	.102	20.6	.811	7	3	862.1-0258-021A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT
2.58	.102	31.4	1.236	12	3	862.1-0258-031A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT
2.60	.102	20.5	.807	7	3	862.1-0260-021A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT
2.60	.102	31.5	1.240	12	3	862.1-0260-031A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT
2.64	.104	20.4	.803	7	3	862.1-0264-021A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT
2.64	.104	31.4	1.236	11	3	862.1-0264-032A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT
2.70	.106	20.3	.799	7	3	862.1-0270-022A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	27	1.063	0.4	.016	40	580	COROMANT
2.70	.106	31.3	1.232	11	3	862.1-0270-032A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	38	1.496	0.4	.016	40	580	COROMANT
2.71	.107	22.1	.870	8	3	862.1-0271-022A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.6	3.291	30	1.181	0.4	.016	40	580	COROMANT
2.80	.110	22.9	.902	8	3	862.1-0280-022A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT
2.80	.110	34.1	1.343	12	3	862.1-0280-034A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT
2.82	.111	23.0	.906	8	3	862.1-0282-023A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT
2.82	.111	34.3	1.350	12	3	862.1-0282-034A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT
2.87	.113	22.8	.898	7	3	862.1-0287-023A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT
2.87	.113	34.8	1.370	12	3	862.1-0287-034A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT
2.90	.114	22.8	.898	7	3	862.1-0290-023A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT
2.90	.114	34.8	1.370	12	3	862.1-0290-035A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT
2.95	.116	22.6	.890	7	3	862.1-0295-024A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	30	1.181	0.5	.020	40	580	COROMANT
2.95	.116	34.6	1.362	11	3	862.1-0295-035A1-GM	★	★	★	★	★	3.0	.118	84	3.307	83.5	3.287	42	1.654	0.5	.020	40	580	COROMANT

B92 E9 E28

CoroDrill® 863

Drills for CNC, ADU, and robotic machines in aerospace assembly materials

Application

- CNC and ADU operations
- CVD, PCD, and carbide options available
- Material types: Composite, aluminum, titanium, heat resistant super alloys, and stainless steel

O C

ISO application area:

M N S O

Benefits and features

- Low-thrust geometries reduce hole delamination and exit burr
- Stocked items are perfect for testing capability in specific applications
- Point geometry of CFRP cutters can successfully exit woven and unidirectional CFRP

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Available products

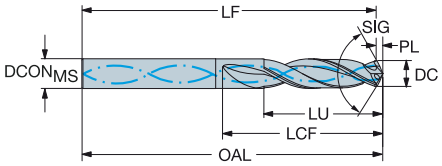
- CoroDrill® 863-O: Designed for long life in CFRP stacks
- CoroDrill® 863-OS: Designed for good chip management in CFRP/Titanium stacks
- CoroDrill® 863-N: Designed for high speed machining in aluminum stacks
- CoroDrill® 863-MS: Designed for hard metal stack applications

CoroDrill® 863 solid carbide drill

For CNC & ADU machining in aerospace assembly materials

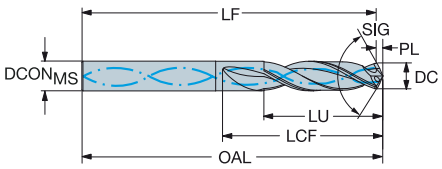
Internal coolant supply

TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



DC	DC"	LU	LU"	ULDR	CZCMS	Ordering code	N H10F	DCONMS	DCONMS"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
4.83	.190	20.0	.787	4	5	863.1-0483-020A1-N	★	5.0	.197	58	2.283	56.6	2.226	28	1.102	1.5	.057	9	130	COROMANT
4.85	.191	20.0	.787	4	5	863.1-0485-020A1-N	★	5.0	.197	58	2.283	56.6	2.226	28	1.102	1.5	.057	9	130	COROMANT
6.35	.250	26.0	1.024	4	6	863.1-0635-026A1-N	★	6.0	.236	75	2.953	73.1	2.876	37	1.457	2.0	.077	9	130	COROMANT
6.37	.251	26.0	1.024	4	6	863.1-0637-026A1-N	★	6.0	.236	75	2.953	73.1	2.876	37	1.457	2.0	.077	9	130	COROMANT
7.94	.313	32.0	1.260	4	8	863.1-0794-032A1-N	★	8.0	.315	81	3.189	78.6	3.094	43	1.693	2.4	.095	9	130	COROMANT
7.97	.314	32.0	1.260	4	8	863.1-0796-032A1-N	★	8.0	.315	81	3.189	78.6	3.094	43	1.693	2.4	.095	9	130	COROMANT
9.53	.375	39.0	1.535	4	10	863.1-0953-039A1-N	★	10.0	.394	93	3.661	90.1	3.548	51	2.008	2.9	.113	9	130	COROMANT
9.55	.376	39.0	1.535	4	10	863.1-0955-039A1-N	★	10.0	.394	93	3.661	90.1	3.548	51	2.008	2.9	.113	9	130	COROMANT
11.12	.438	43.0	1.693	3	12	863.1-1112-043A1-N	★	12.0	.472	105	4.134	101.6	4.002	58	2.283	3.4	.132	9	130	COROMANT
11.14	.439	43.0	1.693	3	12	863.1-1114-043A1-N	★	12.0	.472	105	4.134	101.6	4.002	58	2.283	3.4	.132	9	130	COROMANT

TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



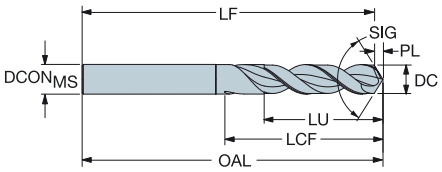
DC	DC"	LU	LU"	ULDR	CZCMS	Ordering code	N H10F	S H10F	O H10F	DCONMS	DCONMS"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
4.83	.190	20.0	.787	4	5	863.1-0483-020A1-OS	☆	★	★	5.0	.197	58	2.283	55.7	2.193	28	1.102	2.3	.091	9	130	COROMANT
4.85	.191	20.0	.787	4	5	863.1-0485-020A1-OS	☆	★	★	5.0	.197	58	2.283	55.7	2.193	28	1.102	2.3	.091	9	130	COROMANT
6.35	.250	26.0	1.024	4	6	863.1-0635-026A1-OS	☆	★	★	6.0	.236	75	2.953	72.3	2.845	37	1.457	2.7	.107	9	130	COROMANT
6.37	.251	26.0	1.024	4	6	863.1-0637-026A1-OS	☆	★	★	6.0	.236	75	2.953	72.3	2.845	37	1.457	2.7	.108	9	130	COROMANT
7.94	.313	32.0	1.260	4	8	863.1-0794-032A1-OS	☆	★	★	8.0	.315	81	3.189	77.7	3.059	43	1.693	3.3	.130	9	130	COROMANT
7.97	.314	32.0	1.260	4	8	863.1-0796-032A1-OS	☆	★	★	8.0	.315	81	3.189	77.7	3.059	43	1.693	3.3	.130	9	130	COROMANT
9.53	.375	39.0	1.535	4	10	863.1-0953-039A1-OS	☆	★	★	10.0	.394	93	3.661	89.1	3.506	51	2.008	3.9	.155	9	130	COROMANT
9.55	.376	39.0	1.535	4	10	863.1-0955-039A1-OS	☆	★	★	10.0	.394	93	3.661	89.1	3.506	51	2.008	3.9	.155	9	130	COROMANT
11.12	.438	43.0	1.693	3	12	863.1-1112-043A1-OS	☆	★	★	12.0	.472	105	4.134	100.4	3.952	58	2.283	4.6	.182	9	130	COROMANT
11.14	.439	43.0	1.693	3	12	863.1-1114-043A1-OS	☆	★	★	12.0	.472	105	4.134	100.4	3.952	58	2.283	4.6	.182	9	130	COROMANT

B83 E9 E28

CoroDrill® 863 solid carbide drill

For CNC & ADU machining in aerospace assembly materials

TCDC	h7
TCHA	H8
TCHAL	3
TCHAU	3
SIG	90°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	N20C	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	PL	PL"	BSG
							0	Dimensions, mm, inch								
3.30	.130	17.9	.705	5	6	863.1-0330-017A0-O	★	6.0	.236	66	2.598	64.6	2.543	1.4	.056	COROMANT
4.85	.191	26.3	1.035	5	6	863.1-0485-024A0-O	★	6.0	.236	82	3.228	79.9	3.146	2.1	.082	COROMANT
6.37	.251	34.6	1.362	5	8	863.1-0637-032A0-O	★	8.0	.315	91	3.583	88.3	3.475	2.7	.107	COROMANT
7.96	.313	43.2	1.701	5	8	863.1-0796-039A0-O	★	8.0	.315	91	3.583	87.6	3.448	3.4	.135	COROMANT
9.55	.376	51.9	2.043	5	10	863.1-0955-048A0-O	★	10.0	.394	103	4.055	98.9	3.894	4.1	.161	COROMANT

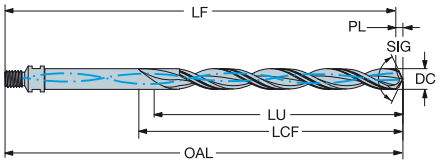
B83 E9

CoroDrill® 863 solid carbide drill

For CNC & ADU machining in aerospace assembly materials

Threaded coupling

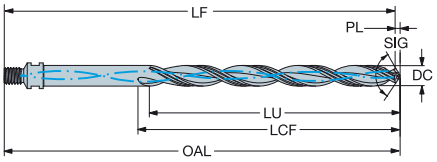
TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



Internal coolant supply

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	M H10F	N H10F	S H10F	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
4.83	.190	30.0	1.181	6	5/16-24	863.1-0483-030B1-MS	★	☆	★	152	6.000	141.9	5.586	101	4.000	1.7	.068	9	130	COROMANT
4.85	.191	30.0	1.181	6	5/16-24	863.1-0485-030B1-MS	★	☆	★	152	6.000	141.3	5.564	101	4.000	1.7	.068	9	130	COROMANT
6.35	.250	39.0	1.535	6	5/16-24	863.1-0635-039B1-MS	★	☆	★	152	6.000	141.4	5.566	101	4.000	2.2	.088	9	130	COROMANT
6.37	.251	39.0	1.535	6	5/16-24	863.1-0637-039B1-MS	★	☆	★	152	6.000	141.3	5.563	101	4.000	2.2	.088	9	130	COROMANT
7.94	.313	48.0	1.890	6	5/16-24	863.1-0794-048B1-MS	★	☆	★	152	6.000	140.8	5.544	101	4.000	2.7	.108	9	130	COROMANT
7.97	.314	48.0	1.890	6	5/16-24	863.1-0796-048B1-MS	★	☆	★	152	6.000	140.8	5.543	101	4.000	2.8	.108	9	130	COROMANT
9.53	.375	58.0	2.283	6	5/16-24	863.1-0953-058B1-MS	★	☆	★	152	6.000	140.3	5.522	101	4.000	3.3	.129	9	130	COROMANT
9.55	.376	58.0	2.283	6	5/16-24	863.1-0955-058B1-MS	★	☆	★	152	6.000	140.3	5.523	101	4.000	3.3	.129	9	130	COROMANT
11.12	.438	67.0	2.638	6	7/16-20	863.1-1112-067B1-MS	★	☆	★	152	6.000	138.1	5.438	101	4.000	3.8	.151	9	130	COROMANT
11.14	.439	67.0	2.638	6	7/16-20	863.1-1114-067B1-MS	★	☆	★	152	6.000	138.1	5.435	101	4.000	3.8	.151	9	130	COROMANT

TCDC 0-0,008
TCHA H8
TCHAL 4
TCHAU 4
SIG 135°



Internal coolant supply

DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	N H10F	S H10F	O H10F	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BAR	PSI	BSG
4.83	.190	30.0	1.181	6	5/16-24	863.1-0483-030B1-OS	☆	★	★	152	6.000	142.3	5.600	101	4.000	1.3	.051	9	130	COROMANT
4.85	.191	30.0	1.181	6	5/16-24	863.1-0485-030B1-OS	☆	★	★	152	6.000	142.3	5.600	101	4.000	1.3	.051	9	130	COROMANT
6.35	.250	39.0	1.535	6	5/16-24	863.1-0635-039B1-OS	☆	★	★	152	6.000	141.8	5.582	101	4.000	1.8	.069	9	130	COROMANT
6.37	.251	39.0	1.535	6	5/16-24	863.1-0637-039B1-OS	☆	★	★	152	6.000	141.8	5.582	101	4.000	1.8	.069	9	130	COROMANT
7.94	.313	48.0	1.890	6	5/16-24	863.1-0794-048B1-OS	☆	★	★	152	6.000	141.3	5.564	101	4.000	2.2	.087	9	130	COROMANT
7.97	.314	48.0	1.890	6	5/16-24	863.1-0796-048B1-OS	☆	★	★	152	6.000	141.4	5.567	101	4.000	2.2	.087	9	130	COROMANT
9.53	.375	58.0	2.283	6	5/16-24	863.1-0953-058B1-OS	☆	★	★	152	6.000	140.9	5.548	101	4.000	2.7	.106	9	130	COROMANT
9.55	.376	58.0	2.283	6	5/16-24	863.1-0955-058B1-OS	☆	★	★	152	6.000	140.9	5.546	101	4.000	2.7	.106	9	130	COROMANT
11.12	.438	67.0	2.638	6	7/16-20	863.1-1112-067B1-OS	☆	★	★	152	6.000	138.8	5.465	101	4.000	3.1	.120	9	130	COROMANT
11.14	.439	67.0	2.638	6	7/16-20	863.1-1114-067B1-OS	☆	★	★	152	6.000	138.8	5.466	101	4.000	3.1	.120	9	130	COROMANT

B83 E9 E28

CoroDrill® 452

Solid carbide drills, reamers, and countersinks

Application

- Portable hand-held machines
- Aerospace rivet and bolt holes
- Carbon fiber reinforced plastics (CFRP)
- Carbon fiber reinforced plastic/metallic-stack materials

O C

ISO application area:

M N S O

Benefits and features

- Close hole tolerances, good surface finish
- Tools optimized for CFRP and metallic-stack materials
- Low-thrust geometries reduce risk of hole delamination and burrs

www.sandvik.coromant.com/corodrill452

A family of tools for rivet and bolt holes. Options such as step drills, reamers, and countersinks are available.

Available products

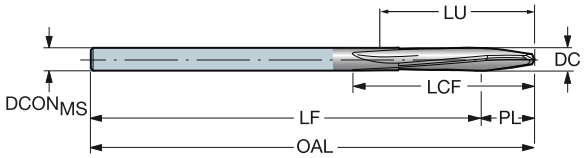
- CoroDrill® 452.1-C: Designed for drilling CFRP stacks
- CoroDrill® 452.1-CM: Designed for drilling CFRP/metal stacks
- CoroDrill® 452.R-CM: Designed for reaming CFRP/metal stacks
- CoroDrill® 452.C1: Designed for countersinking CFRP

CoroDrill® 452 solid-carbide drill

For handheld machines

For aerospace assembly materials

TCHA H9
SIG 118°



DC	DC"	LU	LU"	ULDR	CZC_{MS}	Ordering code	H10F	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
							O	Dimensions, mm, inch										
2.50	.098	50.0	1.968	20	2	**452.1-0250-044A0-C**	★	2.5	.098	101	4.000	96.1	3.782	56	2.218	5.5	.218	COROMANT
3.26	.129	51.7	2.035	15	3	**452.1-0326-044A0-C**	★	3.3	.128	101	4.000	94.4	3.715	58	2.285	7.2	.285	COROMANT
4.17	.164	53.7	2.114	12	4	**452.1-0417-044A0-C**	★	4.2	.164	101	4.000	92.4	3.636	60	2.364	9.2	.364	COROMANT
4.83	.190	55.2	2.172	11	4	**452.1-0483-044A0-C**	★	4.8	.190	101	4.000	90.9	3.578	61	2.422	10.7	.422	COROMANT
5.56	.219	56.8	2.235	10	7/32	**452.1-0556-044A0-C**	★	5.6	.219	101	4.000	89.3	3.515	63	2.485	12.3	.485	COROMANT
6.35	.250	58.6	2.305	9	1/4	**452.1-0635-044A0-C**	★	6.4	.250	101	4.000	87.5	3.445	64	2.555	14.1	.555	COROMANT
7.94	.313	62.1	2.444	7	5/16	**452.1-0794-044A0-C**	★	7.9	.313	101	4.000	84.0	3.306	68	2.694	17.6	.694	COROMANT

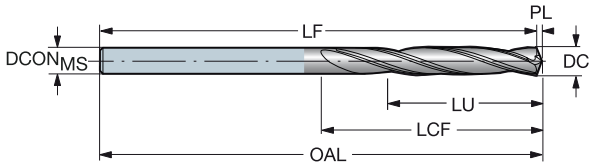
B94 E9

CoroDrill® 452 solid-carbide drill

For handheld machines

For aerospace assembly materials

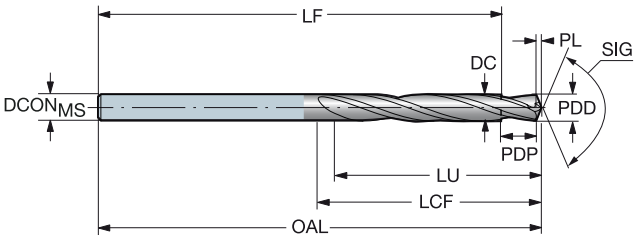
TCHA H9
SIG 135°



DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	M H10F	N H10F	S H10F	O H10F	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	BSG
2.50	.098	44.5	1.750	17	2	452.1-0250-044A0-CM	★	★	★	★	2.5	.098	101	4.000	101.1	3.980	50	2.000	0.5	.020	COROMANT
3.26	.129	44.5	1.750	13	3	452.1-0326-044A0-CM	★	★	★	★	3.3	.128	101	4.000	100.9	3.972	50	2.000	0.7	.027	COROMANT
4.17	.164	44.5	1.750	10	4	452.1-0417-044A0-CM	★	★	★	★	4.2	.164	101	4.000	100.7	3.965	50	2.000	0.9	.034	COROMANT
4.83	.190	44.5	1.750	9	4	452.1-0483-044A0-CM	★	★	★	★	4.8	.190	101	4.000	100.6	3.961	50	2.000	1.0	.039	COROMANT
5.56	.219	44.5	1.750	7	7/32	452.1-0556-044A0-CM	★	★	★	★	5.6	.219	101	4.000	100.5	3.955	50	2.000	1.2	.045	COROMANT
6.35	.250	44.5	1.750	6	1/4	452.1-0635-044A0-CM	★	★	★	★	6.4	.250	101	4.000	100.3	3.949	50	2.000	1.3	.052	COROMANT
7.94	.313	44.5	1.750	5	5/16	452.1-0794-044A0-CM	★	★	★	★	7.9	.313	101	4.000	100.0	3.937	50	2.000	1.6	.065	COROMANT

Dimensions, mm, inch

TCHA H9
SIG 135°



DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	M H10F	N H10F	S H10F	O H10F	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	PDD	PDD"	PDP	PDP"	BSG
4.17	.164	44.5	1.750	10	4	452.4-0417-034A0-CM	★	★	★	★	4.2	.164	101	4.000	91.3	3.594	50	2.000	0.7	.028	3.37	.133	9.53	.375	COROMANT
4.83	.190	44.5	1.752	9	4	452.4-0483-034A0-CM	★	★	★	★	4.8	.190	101	4.000	91.2	3.589	50	2.000	0.8	.033	4.06	.160	9.53	.375	COROMANT
5.56	.219	44.5	1.750	7	7/32	452.4-0556-034A0-CM	★	★	★	★	5.6	.219	101	4.000	91.0	3.583	50	2.000	1.0	.039	4.76	.188	9.53	.375	COROMANT
6.35	.250	44.5	1.750	7	1/4	452.4-0635-034A0-CM	★	★	★	★	6.4	.250	101	4.000	90.8	3.576	50	2.000	1.2	.045	5.56	.219	9.53	.375	COROMANT
7.94	.313	44.5	1.750	5	5/16	452.4-0794-034A0-CM	★	★	★	★	7.9	.313	101	4.000	90.5	3.563	50	2.000	1.5	.058	7.15	.281	9.53	.375	COROMANT

Dimensions, mm, inch

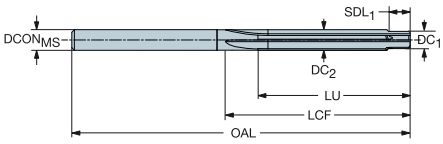
B94 E9

CoroDrill® 452 solid-carbide reamer

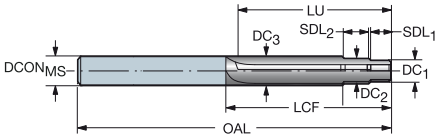
For handheld machines

For aerospace assembly materials

452.R..45



452.R..32

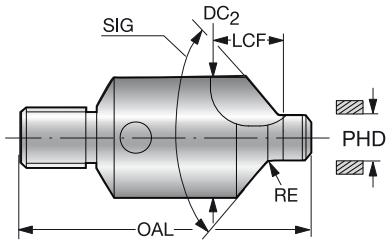


DC1	DC1"	DC2	DC2"	DC3	DC3"	LU	LU"	CZCMS	Ordering code	M H10F	N H10F	S H10F	O H10F	DCONMS	DCONMS"	OAL	OAL"	SDL1	SDL1"	SDL2	SDL2"	LCF	LCF"	BSG
Dimensions, mm, inch																								
3.10	.122	4.10	.161			45.00	1.772	4	452.R-0410-045A0-CM	★	★	☆	★	4.10	.161	100.00	3.937	3.74	.147			50.00	1.969	COROMANT
4.10	.161	5.10	.201			45.00	1.772	5	452.R-0510-045A0-CM	★	★	☆	★	5.10	.201	100.00	3.937	5.00	.197			50.00	1.969	COROMANT
5.10	.201	6.10	.240			45.00	1.772	6	452.R-0610-045A0-CM	★	★	☆	★	6.10	.240	100.00	3.937	6.00	.236			50.00	1.969	COROMANT
5.54	.218	6.35	.250			45.00	1.772	1/4	452.R-0635-045A0-CM	★	★	☆	★	6.35	.250	100.00	3.937	7.00	.276			50.00	1.969	COROMANT
7.13	.281	7.94	.313			45.00	1.772	5/16	452.R-0794-045A0-CM	★	★	☆	★	7.94	.313	100.00	3.937	8.00	.315			50.00	1.969	COROMANT
2.57	.101	3.35	.132	4.17	.164	50.80	2.000	4	452.R-0417-032A0-CM	★	★	☆	★	4.17	.164	101.60	4.000	6.13	.241	5.95	.234	55.88	2.200	COROMANT
3.96	.156	4.74	.187	5.56	.219	50.80	2.000	7/32	452.R-0556-032A0-CM	★	★	☆	★	5.56	.219	101.60	4.000	6.02	.237	5.95	.234	55.88	2.200	COROMANT
4.75	.187	5.54	.218	6.35	.250	50.80	2.000	1/4	452.R-0635-032A0-CM	★	★	☆	★	6.35	.250	101.60	4.000	6.35	.250	6.35	.250	55.88	2.200	COROMANT
6.34	.250	5.54	.218	7.94	.313	50.80	2.000	5/16	452.R-0794-029A0-CM	★	★	☆	★	7.94	.313	101.60	4.000	7.92	.312	7.92	.312	55.88	2.200	COROMANT

CoroDrill® 452 countersink

For handheld machines

For aerospace assembly materials



PHD	PHD"	SIG	CZCMS	Ordering code	O CD10	DC1	DC1"	DC2	DC2"	OAL	OAL"	LCF	LCF"	RE	RE"
Dimensions, mm, inch															
4.14	.163	100°	1/4-28	452.C1-0414-100T-C	★	4.14	.163	10.00	.393	36.00	1.417	7.85	.309	0.90	.035
4.14	.163	130°	1/4-28	452.C1-0414-130T-C	★	4.14	.163	10.00	.393	36.00	1.417	12.10	.476	0.60	.024
4.80	.189	100°	1/4-28	452.C1-0480-100T-C	★	4.80	.189	10.00	.393	36.58	1.440	7.94	.312	0.90	.035
4.80	.189	130°	1/4-28	452.C1-0480-130T-C	★	4.80	.189	10.00	.393	36.58	1.440	11.88	.467	0.60	.024
5.53	.217	100°	1/4-28	452.C1-0553-100T-C	★	5.53	.217	10.00	.393	36.58	1.440	12.01	.472	0.90	.035
5.53	.217	130°	1/4-28	452.C1-0553-130T-C	★	5.53	.217	10.00	.393	36.58	1.440	12.01	.472	0.60	.024
6.32	.249	100°	1/4-28	452.C1-0632-100T-C	★	6.32	.249	14.00	.551	37.82	1.488	14.58	.574	0.90	.035
6.32	.249	130°	1/4-28	452.C1-0632-130T-C	★	6.32	.249	14.00	.551	37.82	1.488	14.53	.572	0.60	.024
7.91	.311	100°	1/4-28	452.C1-0791-100T-C	★	7.91	.311	18.00	.708	39.73	1.564	14.58	.574	1.15	.045
7.91	.311	130°	1/4-28	452.C1-0791-130T-C	★	7.91	.311	18.00	.708	39.73	1.564	14.58	.574	0.90	.035
12.68	.499	100°	3/8-24	452.C1-1268-100T-C	★	12.68	.499	26.00	1.023	49.00	1.929	23.77	.935	1.40	.055

B94 E9

CoroDrill® 400 and CoroDrill® 430

Highly productive hole-making in aluminum and cast iron

Flexible and precise tool solutions

The straight-flute CoroDrill® 400 is an optimized solution designed for broad use in the automotive industry. It has been meticulously engineered to meet demanding precision requirements.

O C

The spiral-flute CoroDrill® 430 is an optimized solution for broad use in the automotive industry. It has been meticulously engineered to meet demanding requirements for high precision.

ISO application area:

N

Benefits and features

- Easy chip removal
- Straightness of hole and surface finish improved due to double margin
- Multi-steps, chamfers, radius and forms can be achieved
- Easy to recondition
- Fast delivery
- Flexibility

www.sandvik.coromant.com/corodrill400

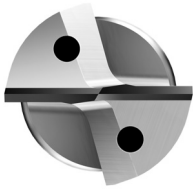
www.sandvik.coromant.com/corodrill430

Used in the automotive industry for:

Cylinder blocks, cylinder heads, cases, steering knuckles and brake cylinders
Aluminum silicon alloys and all grades of cast iron, including GCI, CGI and nodular
Pre-tapping hole sizes
Chamfer holes and multi-step forms

Straight Flute

For complex, multi-step forms and large step ratios



Three flutes

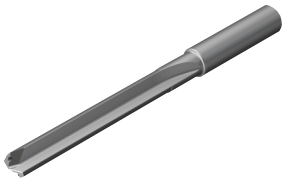
For opening out existing holes (core drilling)

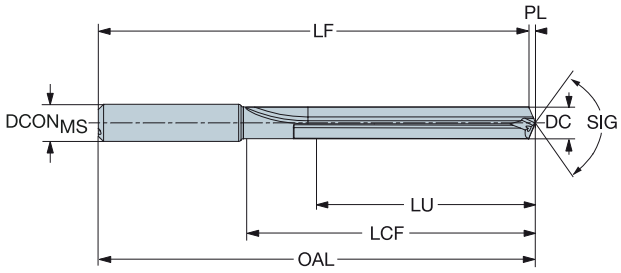
CoroDrill® 400 solid carbide drill

For aluminum

Internal coolant supply

TCHA H9
SIG 135°

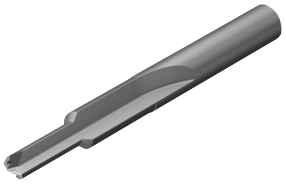


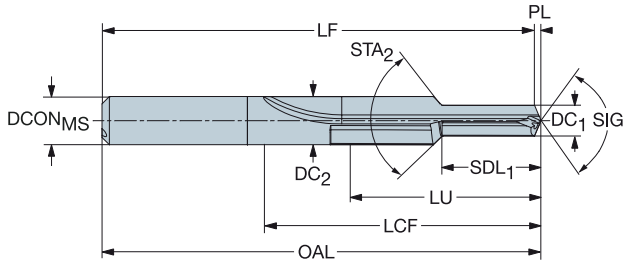


DC	DC"	LU	LU"	ULDR	CZC$_{MS}$	Ordering code	N		Dimensions, mm, inch													BSG
							N1BU	N1DU	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	SIG	BAR	PSI	
5.00	.197	30.0	1.181	6	6	400.1-0500-030A1-NM	★	★	6.0	.236	85	3.346	84.0	3.308	45	1.785	1.0	.038	135°	20	290	COROMANT
7.00	.276	50.0	1.969	7	8	400.1-0700-050A1-NM	★	★	8.0	.315	110	4.331	108.6	4.276	68	2.695	1.4	.054	135°	20	290	COROMANT
10.20	.402	70.0	2.756	6	12	400.1-1020-070A1-NM	★	★	12.0	.472	140	5.512	138.0	5.432	92	3.652	2.0	.080	135°	20	290	COROMANT
12.50	.492	75.0	2.953	6	14	400.1-1250-075A1-NM	★	★	14.0	.551	150	5.906	147.5	5.807	100	3.956	2.5	.099	135°	20	290	COROMANT

Internal coolant supply

TCHA H9
SIG 135°





DC$_1$	DC$_1$"	DC$_2$	DC$_2$"	SDL$_1$	SDL$_1$"	STA$_2$	LU	LU"	CZC$_{MS}$	Ordering code	N		Dimensions, mm, inch												BSG
											N1BU	N1DU	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	SIG	BAR	PSI	
5.00	.197	8.00	.315	15.00	.591	90°	31.0	1.220	8	400.4-0500-031A1-NM	★	★	8.0	.315	90	3.543	89.0	3.505	50	2.002	1.0	.038	135°	20	290	COROMANT
6.80	.268	10.00	.394	20.40	.803	90°	40.0	1.575	10	400.4-0680-040A1-NM	★	★	10.0	.394	105	4.134	103.7	4.081	62	2.452	1.3	.053	135°	20	290	COROMANT
8.50	.335	12.00	.472	25.50	1.004	90°	50.0	1.969	12	400.4-0850-050A1-NM	★	★	12.0	.472	125	4.921	123.3	4.855	74	2.940	1.7	.067	135°	20	290	COROMANT
10.20	.402	16.00	.630	30.60	1.205	90°	63.0	2.480	16	400.4-1020-063A1-NM	★	★	16.0	.630	145	5.709	143.0	5.629	91	3.605	2.0	.080	135°	20	290	COROMANT

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

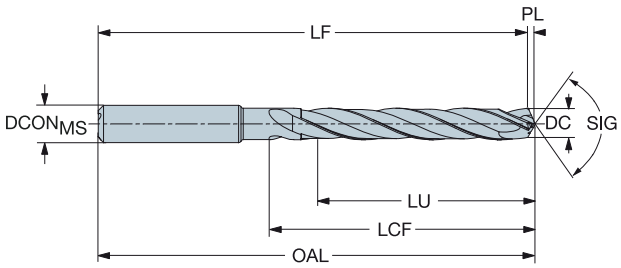
B94 E9

CoroDrill® 430 solid carbide drill

For aluminum

Internal coolant supply

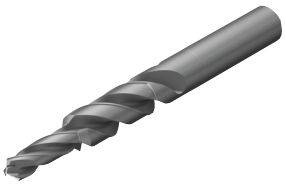
TCHA H9
SIG 135°

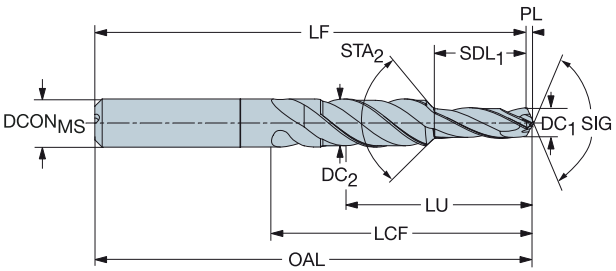


DC	DC"	LU	LU"	ULDR	CZCMS	Ordering code	N/T/BU	DCONMS	DCONMS"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	SIG	BAR	PSI	BSG
								Dimensions, mm, inch													
5.00	.197	30.0	1.181	6	6	430.1-0500-030A1-NM	★	6.0	.236	85	3.346	84.0	3.306	37	1.476	1.0	.041	135°	20	290	COROMANT
7.00	.276	50.0	1.969	7	8	430.1-0700-050A1-NM	★	8.0	.315	110	4.331	108.6	4.274	60	2.382	1.5	.057	135°	20	290	COROMANT
10.20	.402	70.0	2.756	6	12	430.1-1020-070A1-NM	★	12.0	.472	140	5.512	137.9	5.429	85	3.358	2.1	.083	135°	20	290	COROMANT
12.50	.492	75.0	2.953	6	14	430.1-1250-075A1-NM	★	14.0	.551	150	5.906	147.4	5.804	93	3.693	2.6	.102	135°	20	290	COROMANT

Internal coolant supply

TCHA H9
SIG 135°





DC1	DC1"	DC2	DC2"	SDL1	SDL1"	STA2	LU	LU"	CZCMS	Ordering code	N/T/BU	DCONMS	DCONMS"	OAL	OAL"	LF	LF"	LCF	LCF"	PL	PL"	SIG	BAR	PSI	BSG
												Dimensions, mm, inch													
5.00	.197	8.00	.315	15.00	.591	90°	31.0	1.220	8	430.4-0500-031A1-NM	★	8.0	.315	90	3.543	89.0	3.503	39	1.535	1.0	.041	135°	20	290	COROMANT
6.80	.268	10.00	.394	20.40	.803	90°	40.4	1.591	10	430.4-0680-040A1-NM	★	10.0	.394	105	4.134	103.6	4.078	50	1.984	1.4	.056	135°	20	290	COROMANT
8.50	.335	12.00	.472	25.50	1.004	90°	49.5	1.949	12	430.4-0850-050A1-NM	★	12.0	.472	125	4.921	123.2	4.852	61	2.421	1.8	.069	135°	20	290	COROMANT
10.20	.402	16.00	.630	30.60	1.205	90°	62.6	2.465	16	430.4-1020-063A1-NM	★	16.0	.630	145	5.709	142.9	5.626	78	3.094	2.1	.083	135°	20	290	COROMANT

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

B94 E9

Selecting your cutting data

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

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

Effects of cutting speed – v_c

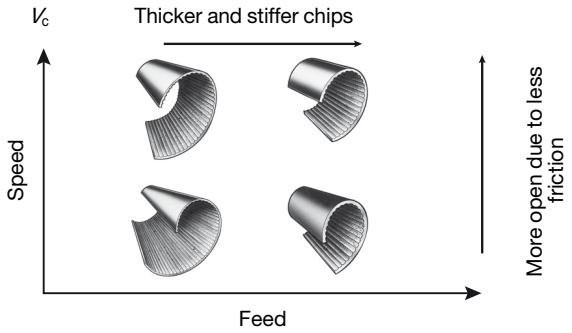
Cutting speed that is too high:
Rapid flank wear
Plastic deformation
Poor hole quality and bad hole tolerance

Cutting speed that is too low:
Built-up edge
Bad chip evacuation
Longer time in cut

Effects of feed – f_n

High feed rate:
Harder chip breaking
Less time in cut
Less tool wear but increased risk of drill breakages
Reduced hole quality

Low feed rate:
Preferable for long-chipping materials
Quality improvement
Accelerated tool wear
Longer time in cut



Achieving good hole quality

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

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

CoroDrill® 860-GM

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed, vc (ft/min)
P		**Unalloyed steel**		(min-start-max)
	P1.1.Z.AN	C = 0.05-0.10%	125	120-145-170
	P1.1.Z.AN	C = 0.1-0.25%	125	120-145-170
	P1.2.Z.AN	C = 0.25-0.55%	150	100-125-150
	P1.3.Z.AN	C = 0.55-0.80%	170	100-125-150
		High carbon steel		
	P1.3.Z.AN	Carbon tool steel	210	100-125-150
		Low alloy steel		
	P2.1.Z.AN	Non hardened	175	100-125-150
	P2.5.Z.HT.1	Hardened and tempered	275	80-100-120
	P2.5.Z.HT.2	Hardened and tempered	350	60-80-100
		High alloy steel		
	P3.0.Z.AN	Annealed	200	64-77-90
	P3.0.Z.HT.1	Hardened tool steel	300	64-77-90
		Steel castings		
	P1.5.C.UT	Unalloyed steel	150	64-77-90
	P2.6.C.UT	Low alloyed (alloying elements < 5%)	200	64-77-90

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
P		**Unalloyed steel**		(min-start-max)
	P1.1.Z.AN	C = 0.05-0.10%	125	393 - 475 - 557
	P1.1.Z.AN	C = 0.1-0.25%	125	393 - 475 - 557
	P1.2.Z.AN	C = 0.25-0.55%	150	328 - 410 - 492
	P1.3.Z.AN	C = 0.55-0.80%	170	328 - 410 - 492
		High carbon steel		
	P1.3.Z.AN	Carbon tool steel	210	328 - 410 - 492
		Low alloy steel		
	P2.1.Z.AN	Non hardened	175	328 - 410 - 492
	P2.5.Z.HT.1	Hardened and tempered	275	262 - 328 - 393
	P2.5.Z.HT.2	Hardened and tempered	350	196 - 262 - 328
		High alloy steel		
	P3.0.Z.AN	Annealed	200	209 - 252 - 295
	P3.0.Z.HT.1	Hardened tool steel	300	209 - 252 - 295
		Steel castings		
	P1.5.C.UT	Unalloyed steel	150	209 - 252 - 295
	P2.6.C.UT	Low alloyed (alloying elements < 5%)	200	209 - 252 - 295

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

Drill diameter, inch							
0.1181	0.1575	0.2362	0.315	0.3937	0.4724	0.6299	0.7874
Feed f_n inch/r							
(min-start-max)							
.0031-.0039-.0047	.0039-.0047-.0055	.0043-.0059-.0067	.0071-.0079-.0087	.0094-.0110-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0031-.0039-.0047	.0039-.0047-.0055	.0051-.0059-.0067	.0071-.0079-.0087	.0094-0.011-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0024-.0028-.0035	.0024-.0031-.0039	.0035-.0043-.0051	.0043-.0055-.0067	.0055-.0067-.0079	.0063-.0079-.0094	.0083-.0091-.0098	.0087-.0094-.0102
.0024-.0028-.0035	.0024-.0031-.0039	.0035-.0043-.0051	.0043-.0055-.0067	.0055-.0067-.0079	.0063-.0079-.0094	.0083-.0091-.0098	.0087-.0094-.0102
.0031-.0039-.0047	.0039-.0047-.0055	.0051-.0059-.0067	.0071-.0079-.0087	.0094-.0110-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0031-.0039-.0047	.0039-.0047-.0055	.0051-.0059-.0067	.0071-.0079-.0087	.0094-.0110-.0126	.0094-.0110-.0126	.0110-.0126-.0142	.0118-.0134-.0150
.0020-.0028-.0035	.0024-.0031-.0039	.0035-.0043-.0051	.0043-.0055-.0067	.0055-.0067-.0079	.0063-.0079-.0094	.0083-.0091-.0098	.0087-.0094-.0102

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed, vc (ft/min)
S		**Heat resistant super alloys – Nickel base**		(min-start-max)
	S2.0.Z.AN	Annealed or solution treated	250	15-20-25
	S2.0.Z.AG	Aged or solution treated and aged	350	10-15-20
	S2.0.C.NS	Cast or cast and aged	320	10-15-20
		Titanium alloys		
	S4.1.Z.UT	Austenitic	200	40-50-60
	S4.2.Z.AN	Annealed	180	40-50-60
	S4.3.Z.AG	Alloys in aged condition	245	30-40-50

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
S		**Heat resistant super alloys – Nickel base**		(min-start-max)
	S2.0.Z.AN	Annealed or solution treated	250	49-65-82
	S2.0.Z.AG	Aged or solution treated and aged	350	32-49-65
	S2.0.C.NS	Cast or cast and aged	320	32-49-65
		Titanium alloys		
	S4.1.Z.UT	Austenitic	200	131-164-196
	S4.2.Z.AN	Annealed	180	131-164-196
	S4.3.Z.AG	Alloys in aged condition	245	98-131-164

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

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

Inch values

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

CoroDrill® 860-GM

Metric values

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

Inch values

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

Metric values

Drill diameter, mm							
3	4	6	8	10	12	16	20
feed (f_n) inch/rev							
(min-start-max)							
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.12-0.15	0.12-0.15-0.18	0.12-0.15-0.18	0.12-0.15-0.18
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.11-0.13	0.10-0.11-0.13	0.12-0.13-0.15	0.12-0.13-0.15
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.12-0.15	0.12-0.15-0.18	0.12-0.15-0.18	0.12-0.15-0.18
0.06-0.08-0.10	0.06-0.08-0.10	0.06-0.08-0.10	0.08-0.10-0.12	0.10-0.11-0.13	0.10-0.11-0.13	0.12-0.13-0.15	0.12-0.13-0.15

Inch values

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

CoroDrill® 860-PM

Internal coolant supply, metric values

3 – 8 × DC

ISO	MC No.	Material	Hardness Brinell HB	Grade	Cutting speed (v_c), m/min
P		**Unalloyed steel**			(min-start-max)
	P1.1.Z.AN	C = 0.05–0.10%	125	4234	140-200-250
	P1.1.Z.AN	C = 0.1–0.25%	125	4234	140-200-250
	P1.2.Z.AN	C = 0.25–0.55%	150	4234	140-180-250
	P1.3.Z.AN	C = 0.55–0.80%	170	4234	140-180-250
		High carbon steel			
	P1.3.Z.AN	Carbon tool steel	210	4234	150-170-220
		Low alloy steel			
	P2.1.Z.AN	Non-hardened	175	4234	120-170-240
	P2.5.Z.HT	Hardened and tempered	275	4234	80-110-140
	P2.5.Z.HT	Hardened and tempered	350	4234	60-80-100
		High alloy steel			
	P3.0.Z.AN	Annealed	200	4234	60-120-140
	P3.0.Z.HT	Hardened tool steel	300	4234	60-80-100
		Steel castings			
	P1.5.C.UT	Unalloyed	150	4234	120-170-210
	P2.6.C.UT	Low-alloy (alloying elements ≤5%)	200	4234	120-160-220

CoroDrill® 860-NM

2 – 3 x DC

ISO	MC No.	Material	Cutting speed (v_c), m/min
N		**Aluminum based alloys**	(min-start-max)
	N1.1.Z.UT	Commercial pure	320-400-480
	N1.2.C.NS		320-400-480
	N1.2.S.UT		320-400-480
	N1.2.Z.AG	AlSi alloys, Si ≤ 1%	320-400-480
	N1.2.Z.UT	Wrought or wrought and coldworked, non-aging	320-400-480
	N1.3.C.AG	Cast or cast and aged	240-300-360
	N1.3.C.UT	Cast, non-aging	320-400-480
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	200-250-300
	N2.0.C.UT	**Magnesium based alloys**	200-250-300

7 – 8 × DC

ISO	MC No.	Material	Cutting speed (v_c), m/min
N		**Aluminum based alloys**	(min-start-max)
	N1.1.Z.UT	Commercial pure	320-400-480
	N1.2.C.NS		320-400-480
	N1.2.S.UT		320-400-480
	N1.2.Z.AG	AlSi alloys, Si ≤ 1%	320-400-480
	N1.2.Z.UT	Wrought or wrought and coldworked, non-aging	320-400-480
	N1.3.C.AG	Cast or cast and aged	240-300-360
	N1.3.C.UT	Cast, non-aging	320-400-480
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	200-250-300
	N2.0.C.UT	**Magnesium based alloys**	200-250-300

Cutting data recommendations are valid for internal coolant supply, which gives the best performance.

Preferred pressure min. 15 bar (218 PSI)

If external coolant supply is used:
- More important to adjust cutting data for good chip form and evacuation
- Lower penetration rates than what is possible with internal coolant may be necessary

CoroDrill® 860-PM

Internal coolant supply, metric values

3 – 8 × DC

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n), inch/rev							
(min-start-max)							
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.08-0.14-0.20	0.14-0.18-0.24	0.18-0.24-0.32	0.20-0.28-0.36	0.20-0.32-0.40	0.22-0.36-0.44	0.24-0.40-0.48	0.26-0.44-0.50
0.08-0.12-0.18	0.14-0.16-0.22	0.18-0.22-0.30	0.20-0.25-0.33	0.20-0.29-0.37	0.22-0.33-0.41	0.24-0.36-0.42	0.26-0.40-0.48
0.08-0.14-0.22	0.10-0.18-0.24	0.12-0.20-0.26	0.15-0.22-0.28	0.16-0.24-0.32	0.18-0.28-0.40	0.20-0.30-0.42	0.22-0.32-0.44
0.08-0.12-0.16	0.10-0.15-0.18	0.12-0.18-0.22	0.15-0.20-0.28	0.16-0.22-0.32	0.18-0.26-0.36	0.20-0.28-0.40	0.22-0.30-0.42
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48

CoroDrill® 860-NM

2 – 3 x DC

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n), inch/rev							
(min-start-max)							
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.20-0.25-0.30	0.260-0.325-0.390	0.426-0.533-0.639	0.64-0.80-0.96	0.8-1.0-1.2	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
0.144-0.180-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.180-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888

7 – 8 × DC

Drill diameter, mm							
3	4	6	8	10	12	16	20
Feed (f_n), inch/rev							
(min-start-max)							
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.144-0.18-0.216	0.176-0.220-0.264	0.254-0.317-0.380	0.344-0.430-0.516	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.592-0.740-0.888
0.12-0.15-0.18	0.144-0.180-0.216	0.20-0.25-0.30	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.44-0.55-0.66	0.464-0.580-0.696
0.12-0.15-0.18	0.144-0.180-0.216	0.20-0.25-0.30	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.44-0.55-0.66	0.464-0.580-0.696

CoroDrill® 860-PM

Internal coolant supply, inch values

3 – 8 × DC

ISO	MC No.	Material	Hardness Brinell HB	Grade	Cutting speed (v_c), ft/min
P		**Unalloyed steel**			(min-start-max)
	P1.1.Z.AN	C = 0.05–0.10%	125	4234	460-655-820
	P1.1.Z.AN	C = 0.1–0.25%	125	4234	460-655-820
	P1.2.Z.AN	C = 0.25–0.55%	150	4234	460-590-820
	P1.3.Z.AN	C = 0.55–0.80%	170	4234	460-590-755
		High carbon steel			
	P1.3.Z.AN	Carbon tool steel	210	4234	490-560-720
		Low alloy steel			
	P2.1.Z.AN	Non-hardened	175	4234	395-560-785
	P2.5.Z.HT	Hardened and tempered	275	4234	260-360-460
	P2.5.Z.HT	Hardened and tempered	350	4234	195-260-330
		High alloy steel			
	P3.0.Z.AN	Annealed	200	4234	195-395-460
	P3.0.Z.HT	Hardened tool steel	300	4234	195-260-330
		Steel castings			
	P1.5.C.UT	Unalloyed	150	4234	395-560-690
	P2.6.C.UT	Low-alloy (alloying elements ≤5%)	200	4234	395-525-720

CoroDrill® 860-NM

2 – 3 x DC

ISO	MC No.	Material	Cutting speed (v_c), ft/min
N		**Aluminum based alloys**	(min-start-max)
	N1.1.Z.UT	Commercial pure	1050-1312-1575
	N1.2.C.NS		1050-1312-1575
	N1.2.S.UT		1050-1312-1575
	N1.2.Z.AG	AlSi alloys, Si ≤ 1%	1050-1312-1575
	N1.2.Z.UT	Wrought or wrought and coldworked, non-aging	1050-1312-1575
	N1.3.C.AG	Cast or cast and aged	787-984-1181
	N1.3.C.UT	Cast, non-aging	1050-1312-1575
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	656-820-984
	N2.0.C.UT	**Magnesium based alloys**	656-820-984

7 – 8 × DC

ISO	MC No.	Material	Cutting speed (v_c), ft/min
N		**Aluminum based alloys**	(min-start-max)
	N1.1.Z.UT	Commercial pure	1050-1312-1575
	N1.2.C.NS		1050-1312-1575
	N1.2.S.UT		1050-1312-1575
	N1.2.Z.AG	AlSi alloys, Si ≤ 1%	1050-1312-1575
	N1.2.Z.UT	Wrought or wrought and coldworked, non-aging	1050-1312-1575
	N1.3.C.AG	Cast or cast and aged	787-984-1181
	N1.3.C.UT	Cast, non-aging	1050-1312-1575
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	656-820-984
	N2.0.C.UT	**Magnesium based alloys**	656-820-984

Cutting data recommendations are valid for internal coolant supply, which gives the best performance.

Preferred pressure min. 15 bar (218 PSI)

If external coolant supply is used:
- More important to adjust cutting data for good chip form and evacuation
- Lower penetration rates than what is possible with internal coolant may be necessary

CoroDrill® 860-PM

Internal coolant supply, inch values

3 – 8 × DC

Drill diameter, inch							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Feed (f_n), inch/r							
(min-start-max)							
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0024-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0126	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0031-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0118	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0031-.0055-.0079	.0055-.0071-.0094	.0071-.0094-.0126	.0079-.0110-.0142	.0079-.0126-.0157	.0087-.0142-.0173	.0094-.0157-.0189	.0102-.0173-.0197
.0031-.0047-.0071	.0055-.0063-.0087	.0071-.0087-.0118	.0079-.0098-.0130	.0079-.0114-.0146	.0087-.0130-.0161	.0094-.0142-.0165	.0105-.0157-.0189
.0031-.0055-.0087	.0039-.0071-.0094	.0047-.0079-.0102	.0059-.0087-.0110	.0063-.0094-.0126	.0071-.0110-.0157	.0079-.0118-.0165	.0087-.0126-.0173
.0031-.0047-.0063	.0039-.0059-.0071	.0047-.0071-.0087	.0059-.0079-.0110	.0063-.0087-.0126	.0071-.0102-.0142	.0079-.0110-.0157	.0087-.0118-.0165
.0031-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0118	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189
.0031-.0039-.0079	.0039-.0055-.0094	.0047-.0071-.0110	.0055-.0087-.0118	.0059-.0094-.0154	.0071-.0106-.0165	.0083-.0118-.0177	.0094-.0130-.0189

CoroDrill® 860-NM

2 – 3 x DC

Drill diameter, inch							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Feed (f_n), inch/r							
(min-start-max)							
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0079-.0098-.0118	.0102-.0128-.0154	.0168-.0210-.0252	.0252-.0315-.0378	.0346-.0315-.0378	.0346-.0433-.0520	.0378-.0472-.0567	.0378-.0472-.0567
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0220-.0169-.0203	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0220-.0169-.0203	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350

7 – 8 × DC

Drill diameter, inch							
.1181	.1575	.2362	.3150	.3937	.4724	.6299	.7874
Feed (f_n), inch/r							
(min-start-max)							
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0057-.0071-.0085	.0069-.0087-.0104	.0100-.0125-.0150	.0135-.0169-.0203	.0173-.0217-.0260	.0220-.0276-.0331	.0220-.0276-.0331	.0233-.0291-.0350
.0047-.0059-.0071	.0057-.0071-.0085	.0079-.0098-.0118	.0104-.0130-.0156	.0132-.0165-.0198	.0151-.0189-.0227	.0173-.0217-.0260	.0183-.0228-.0274
.0047-.0059-.0071	.0057-.0071-.0085	.0079-.0098-.0118	.0104-.0130-.0156	.0132-.0165-.0198	.0151-.0189-.0227	.0173-.0217-.0260	.0183-.0228-.0274

CoroDrill® 860-MM

Internal coolant supply

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (v_c), m/min
M		**Austenitic stainless steel**		(min-start-max)
	M1.0.C.UT	Cast+untreated	165	48 - 60 - 72
	M1.0.Z.AQ	Annealed/quenched	200	48 - 60 - 72
	M1.0.Z.PH	PH-hardened	350	44 - 55 - 66
	M1.1.Z.AQ	Machinability improved	165	48 - 60 - 72
	M1.2.Z.AQ	Free cutting	200	48 - 60 - 72
	M1.3.C.AQ	Ti-stabilized+cast	200	48 - 60 - 72
	M1.3.Z.AQ	Ti-stabilized	200	48 - 60 - 72
	M1.4.Z.AQ	High strength	250	64 - 80 - 96
		Super austenitic (Ni>20%) stainless steel		
	M2.0.C.AQ	Cast+annealed/quenched	165	48 - 60 - 72
	M2.0.Z.AQ	Annealed/quenched	200	48 - 60 - 72
		Duplex (austenitic/ferritic) stainless steel		
	M3.1.Z.AQ	>60% ferrite (N<0.10%)	250	64 - 80 - 96
	M3.2.Z.AQ	<60% ferrite (N≥0.10%)	250	64 - 80 - 96

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min
M		**Austenitic stainless steel**		(min-start-max)
	M1.0.C.UT	Cast+untreated	165	157 - 197 - 236
	M1.0.Z.AQ	Annealed/quenched	200	157 - 197 - 236
	M1.0.Z.PH	PH-hardened	350	144 - 180 - 217
	M1.1.Z.AQ	Machinability improved	165	157 - 197 - 236
	M1.2.Z.AQ	Free cutting	200	157 - 197 - 236
	M1.3.C.AQ	Ti-stabilized+cast	200	157 - 197 - 236
	M1.3.Z.AQ	Ti-stabilized	200	157 - 197 - 236
	M1.4.Z.AQ	High strength	250	210 - 262 - 315
		Super austenitic (Ni>20%) stainless steel		
	M2.0.C.AQ	Cast+annealed/quenched	165	157 - 197 - 236
	M2.0.Z.AQ	Annealed/quenched	200	157 - 197 - 236
		Duplex (austenitic/ferritic) stainless steel		
	M3.1.Z.AQ	>60% ferrite (N<0.10%)	250	210 - 262 - 315
	M3.2.Z.AQ	<60% ferrite (N≥0.10%)	250	210 - 262 - 315

Cutting data recommendations are valid for internal coolant supply, which gives the best performance.

Preferred pressure min. 15 bar (218 PSI)

If external coolant supply is used:
- More important to adjust cutting data for good chip form and evacuation
- Lower penetration rates than what is possible with internal coolant may be necessary

CoroDrill® 860-MM

Internal coolant supply

Metric values

Drill diameter, mm						
3	4	6	8	10	12	16
Feed (f_n), inch/rev						
(min-start-max)						
0.058-0.072-0.086	0.073-0.091-0.109	0.103-0.129-0.155	0.134-0.168-0.202	0.134-0.168-0.202	0.162-0.202-0.242	0.214-0.268-0.322
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.032-0.040-0.048	0.032-0.040-0.048	0.058-0.073-0.088	0.096-0.120-0.144	0.122-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.058-0.072-0.086	0.073-0.091-0.109	0.103-0.129-0.155	0.134-0.168-0.202	0.134-0.168-0.202	0.162-0.202-0.242	0.214-0.268-0.322
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.080- 0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.058-0.072-0.086	0.073-0.091-0.109	0.103-0.129-0.155	0.134-0.168-0.202	0.134-0.168-0.202	0.162-0.202-0.242	0.214-0.268-0.322
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240
0.080-0.100-0.120	0.080-0.100-0.120	0.088-0.110-0.132	0.096-0.120-0.144	0.112-0.140-0.168	0.128-0.160-0.192	0.160-0.200-0.240

Inch values

Drill diameter, inch						
.1181	.1575	.2362	.315	.3937	.4724	.6299
Feed (f_n), inch/r						
(min-start-max)						
.0023-.0028-.0034	.0029-.0036-.0043	.0041-.0051-.0061	.0053-.0066-.0080	.0053-.0066-.0080	.0064-.0080-.0095	.0084-.0106-.0127
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0013-.0016-.0019	.0013-.0016-.0019	.0023-.0029-.0035	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0023-.0028-.0034	.0029-.0036-.0043	.0041-.0051-.0061	.0053-.0066-.0080	.0053-.0066-.0080	.0064-.0080-.0095	.0084-.0106-.0127
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0023-.0028-.0034	.0029-.0036-.0043	.0041-.0051-.0061	.0053-.0066-.0080	.0053-.0066-.0080	.0064-.0080-.0095	.0084-.0106-.0127
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094
.0031-.0039-.0047	.0031-.0039-.0047	.0035-.0043-.0052	.0038-.0047-.0057	.0044-.0055-.0066	.0050-.0063-.0076	.0063-.0079-.0094

CoroDrill® 860-SM

Metric values

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

Inch values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min	Drill diameter, inch .1181–.2362	.2366–.3937	.3941–.5512	.5516–.7874
					Feed (f_n), inch/r			
S	S1.0.U.AN	Heat resistant super alloys	200	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S1.0.U.AG		280	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.AN	Nickel based alloys	250	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.AG		350	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.UT		275	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S2.0.Z.NS		320	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S3.0.Z.AN	Cobalt-based alloys	200	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S3.0.Z.AG		300	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S3.0.C.NS		320	49.2≥82.0	.0024-.0047	.0032-.0055	.0039-.0055	.0047-.0063
	S4.1.Z.UT	Titanium alloys	200	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.2.Z.AN		320	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.3.Z.AN		330	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.3.Z.AG		375	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.4.Z.AN		330	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118
	S4.4.Z.AG		410	131.2≥196.6	.0024-.0047	.0032-.0079	.0055-.0110	.0063-.0118

Cutting data recommendations are valid for internal coolant supply, which gives the best performance.

Preferred pressure min. 15 bar (218 PSI)

If external coolant supply is used:
- More important to adjust cutting data for good chip form and evacuation
- Lower penetration rates than what is possible with internal coolant may be necessary

CoroDrill® 863

Tool		M	N	S	O
863.1-A1-O	v_c m/min f_n mm/rev Peck drilling				60 - 120 0.050 - 0.100 No
863.1-A1-N	v_c m/min f_n mm/rev Peck drilling		200 - 400 0.150 - 0.300 No		
863.1-A1-OS	v_c m/min f_n mm/rev Peck drilling		60 - 120 0.050 - 0.100 Yes	15 - 30 0.050 - 0.100 Yes	60 - 120 0.050 - 0.100 No
863.1-B1-OS	v_c m/min f_n mm/rev Peck drilling		60 - 120 0.050 - 0.100 Yes	15 - 30 0.050 - 0.100 Yes	60 - 120 0.050 - 0.100 No
863.1-B1-MS	v_c m/min f_n mm/rev Peck drilling	15 - 30 0.050 - 0.100 Yes	60 - 120 0.050 - 0.100 Yes	15 - 30 0.050 - 0.100 Yes	

If the cutting tool goes through multiple stacks and the parameters cannot be changed per material. Use the slowest parameters through the entire stack.

CoroDrill® 863 solid carbide drill

Metric values

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

CoroDrill® 861 -GM

12 - 15 x D_c

Metric values

ISO	MC No.	Material	Hardness Brinell HB	Cutting speed (v_c), m/min Min.	Max
P		**Unalloyed steel**			
	P1.1.Z.AN	C=0.10-0.25%	125	80	156
	P1.2.Z.AN	C=0.25-0.55%	190	80	156
		Low alloy steel			
	P2.2.Z.AN	Annealed	240	64	120
	P2.5.Z.HT	Hardened and tempered	330	64	120
		High alloy steel			
	P3.0.Z.AN	Annealed	200	64	120
	P4.0.S.NS	**Sintered steels**	150	80	132
		Stainless steel			
	P5.1.Z.AN	Ferritic/Martensitic	200	20	120
M		**Stainless steel**			
	M1.0.Z.AQ	Austenitic	200	20	42
	M2.0.Z.AQ	Super austenitic Ni≥20%	200	20	36
	M3.2.Z.AQ	Duplex (austenitic/ferritic)	260	20	30
K					
	K1.1.C.NS	**Malleable cast iron (ferritic, pearlitic)**	200	60	90
		Gray cast iron			
	K2.1.C.UT	Low tensile strength	180	92	138
	K2.2.C.UT	High tensile strength	245	60	90
		Nodular cast iron			
	K3.1.C.UT	Ferritic	155	60	90
	K3.3.C.UT	Pearlitic	265	60	90
	K5.1.C.NS	**ADI**	300	60	90
N		**Aluminum based alloys**			
	N1.1.Z.UT	Commercial pure	30	216	324
	N1.2.Z.AG	AlSi alloys, Si ≤ 1%	100	216	324
	N1.3.C.AG	AlSi cast alloys, Si > 1% and < 13%	90	72	216
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	130	72	108
	N2.0.C.UT	**Magnesium based alloys**	70	72	216
		Copper based alloys			
	N3.1.U.UT	Non-leaded copper alloys (incl. electrolytic copper)	100	100	150
	N3.2.C.UT	Leaded brass & bronzes (Pb ≤ 1%)	90	176	264
	N3.3.U.UT	Free cutting copper based alloys (Pb>1%)	110	176	264
	N3.4.C.UT	high strength bronzes (>225HB)	300	80	120
	N4.0.C.UT	**Zinc based alloys**	70	176	264

CoroDrill® 861 -GM

12 - 15 x D_c

Metric values

Drill diameter, mm f_n mm/rev																			
3.00-3.99		**4.00-4.99**		**5.00-5.99**		**6.00-7.99**		**8.00-9.99**		**10.00-11.99**		**12.00-14.99**		**15.00-15.99**		**16.00-17.99**		**18.00-20.00**	
Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.10	0.13	0.12	0.15	0.13	0.17	0.15	0.20	0.20	0.26	0.25	0.33	0.28	0.38	0.31	0.42	0.32	0.43	0.34	0.45
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28	0.22	0.31	0.23	0.32	0.25	0.34
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28	0.22	0.31	0.23	0.32	0.25	0.34
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28	0.22	0.31	0.23	0.32	0.25	0.34
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39	0.41	0.43	0.42	0.44	0.44	0.46
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21	0.21	0.23	0.22	0.24	0.24	0.26
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29	0.30	0.32	0.31	0.33	0.33	0.35

CoroDrill® 861 -GM

20 - 30 x D_c

Metric values

ISO	MC No.	CMC No.	Material	Hardness Brinell HB	Cutting speed (v_c), m/min Min.	Max
P			**Unalloyed steel**			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	72	140
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	72	140
			Low alloy steel			
	P2.2.Z.AN	02.1	Annealed	240	58	135
	P2.5.Z.HT	02.2	Hardened and tempered	330	58	135
			High alloy steel			
	P3.0.Z.AN	03.11	Annealed	200	58	135
	P4.0.S.NS		**Sintered steels**	150	72	119
			Stainless steel			
	P5.1.Z.AN	05.11 /15.11	Ferritic/Martensitic	200	19	108
M			**Stainless steel**			
	M1.0.Z.AQ	05.21/15.21	Austenitic	200	19	38
	M2.0.Z.AQ	05.21/15.21	Super austenitic Ni≥20%	200	19	33
	M3.2.Z.AQ	05.52/15.52	Duplex (austenitic/ferritic)	260	19	28
K						
	K1.1.C.NS	07.1/07.2	**Malleable cast iron**	200	55	82
			Gray cast iron			
	K2.1.C.UT	08.1	Low tensile strength	180	92	138
	K2.2.C.UT	08.2	High tensile strength	245	55	82
			Nodular cast iron			
	K3.1.C.UT	09.1	Ferritic	155	55	82
	K3.3.C.UT	09.2	Pearlitic	265	55	82
	K5.1.C.NS		**ADI**	300	55	82
N			**Aluminum based alloys**			
	N1.1.Z.UT		Commercial pure	30	194	292
	N1.2.Z.AG		AlSi alloys, Si ≤ 1%	100	194	292
	N1.3.C.AG	30.21	AlSi cast alloys, Si > 1% and < 13%	90	65	194
	N1.4.C.NS		AlSi cast alloys, Si ≥ 13%	130	65	97
	N2.0.C.UT		**Magnesium based alloys**	70	65	194

CoroDrill® 861 -GM

20 - 30 x D_c

Metric values

Drill diameter, mm f_n mm/rev													
3.00-3.99		4.00-4.99		5.00-5.99		6.00-7.99		8.00-9.99		10.00-11.99		12.00	
Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.	Min.	Max.
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.07	0.10	0.08	0.12	0.09	0.13	0.11	0.15	0.14	0.20	0.17	0.25	0.20	0.28
0.04	0.07	0.05	0.08	0.06	0.09	0.07	0.11	0.09	0.14	0.11	0.17	0.13	0.20
0.04	0.07	0.05	0.08	0.06	0.09	0.07	0.11	0.09	0.14	0.11	0.17	0.13	0.20
0.04	0.07	0.05	0.08	0.06	0.09	0.07	0.11	0.09	0.14	0.11	0.17	0.13	0.20
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.06	0.08	0.07	0.09	0.08	0.10	0.10	0.12	0.13	0.15	0.16	0.18	0.19	0.21
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39
0.12	0.14	0.14	0.16	0.16	0.18	0.19	0.21	0.25	0.27	0.32	0.34	0.37	0.39
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29
0.09	0.11	0.11	0.13	0.12	0.14	0.14	0.16	0.19	0.21	0.24	0.26	0.27	0.29

CoroDrill® 861 -GM

12 - 15 x D_c

Inch values

ISO	MC No.	CMC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min Min.	Max.
P			**Unalloyed steel**			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	260	510
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	260	510
			Low alloy steel			
	P2.2.Z.AN	02.1	Annealed	240	210	395
	P2.5.Z.HT	02.2	Hardened and tempered	330	210	395
			High alloy steel			
	P3.0.Z.AN	03.11	Annealed	200	210	395
	P4.0.S.NS		**Sintered steels**	150	260	435
			Stainless steel			
	P5.1.Z.AN	05.11 /15.11	Ferritic/Martensitic	200	65	395
M			**Stainless steel**			
	M1.0.Z.AQ	05.21/15.21	Austenitic	200	65	140
	M2.0.Z.AQ	05.21/15.21	Super austenitic Ni≥20%	200	65	120
	M3.2.Z.AQ	05.52/15.52	Duplex (austenitic/ferritic)	260	65	100
K						
	K1.1.C.NS	07.1/07.2	**Malleable cast iron (ferritic, pearlitic)**	200	195	295
			Gray cast iron			
	K2.1.C.UT	08.1	Low tensile strength	180	300	455
	K2.2.C.UT	08.2	High tensile strength	245	195	295
			Nodular cast iron			
	K3.1.C.UT	09.1	Ferritic	155	195	295
	K3.2.C.UT	09.2	Pearlitic	265	195	295
	K5.1.C.NS		**ADI**	300	195	295
N			**Aluminum based alloys**			
	N1.1.Z.UT		Commercial pure	30	710	1065
	N1.2.Z.AG		AlSi alloys, Si ≤ 1%	100	710	1065
	N1.3.C.AG	30.21	AlSi cast alloys, Si > 1% and < 13%	90	235	710
	N1.4.C.NS		AlSi cast alloys, Si ≥ 13%	130	235	355
	N2.0.C.UT		**Magnesium based alloys**	70	235	710
			Copper based alloys			
	N3.1.U.UT		Non-leaded copper alloys (incl. electrolytic copper)	100	330	490
	N3.2.C.UT		Leaded brass & bronzes (Pb ≤ 1%)	90	575	865
	N3.3.U.UT		Free cutting copper based alloys (Pb>1%)	110	575	865
	N3.4.C.UT		high strength bronzes (>225HB)	300	260	395
	N4.0.C.UT		**Zinc based alloys**	70	575	865

CoroDrill® 861 -GM

12 - 15 x D_c

Inch values

Drill diameter, inch f_n inch/rev.																			
.1181-.1571		.1572-.1964		.1965-.2358		.2359-.3146		.3147-.3933		.3934-.4720		.4721-.5902		.5905-.6295		.6299-.7083		.7087-.7874	
Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0039	.0051	.0047	.0059	.0051	.0067	.0059	.0079	.0079	.0102	.0098	.0130	.0110	.0150	.0122	.0165	.0126	.0169	.0134	.0177
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011	.0087	.0122	.0091	.0126	.0098	.0134
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011	.0087	.0122	.0091	.0126	.0098	.0134
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011	.0087	.0122	.0091	.0126	.0098	.0134
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0047	.0055	.0055	.0063	.0063	.0071	.0354	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0047	.0055	.0055	.0063	.0063	.0071	.0354	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0047	.0055	.0055	0.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154	.0161	.0169	.0165	.0173	.0173	.0181
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083	.0083	.0091	.0087	.0094	.0094	.0102
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114	.0118	.0126	.0122	.0130	.0130	.0138

CoroDrill® 861 -GM

20 - 30 x D_c

Inch values

ISO	MC No.	CMC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min Min.	Max
P			**Unalloyed steel**			
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	235	460
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	235	460
			Low alloy steel			
	P2.2.Z.AN	02.1	Annealed	240	190	445
	P2.5.Z.HT	02.2	Hardened and tempered	330	190	445
			High alloy steel			
	P3.0.Z.AN	03.11	Annealed	200	190	445
	P4.0.S.NS		**Sintered steels**	150	235	390
			Stainless steel			
	P5.1.Z.AN	05.11 /15.11	Ferritic/Martensitic	200	60	355
M			**Stainless steel**			
	M1.0.Z.AQ	05.21/15.21	Austenitic	200	60	125
	M2.0.Z.AQ	05.21/15.21	Super austenitic Ni≥20%	200	60	110
	M3.2.Z.AQ	05.52/15.52	Duplex (austenitic/ferritic)	260	60	90
K						
	K1.1.C.NS	07.1/07.2	**Malleable cast iron (ferritic, pearlitic)**	200	180	270
			Gray cast iron			
	K2.1.C.UT	08.1	Low tensile strength	180	300	455
	K2.2.C.UT	08.2	High tensile strength	245	180	270
			Nodular cast iron			
	K3.1.C.UT	09.1	Ferritic	155	180	270
	K3.3.C.UT	09.2	Pearlitic	265	180	270
	K5.1.C.NS		**ADI**	300	180	270
N			**Aluminum based alloys**			
	N1.1.Z.UT		Commercial pure	30	635	960
	N1.2.Z.AG		AlSi alloys, Si ≤ 1%	100	635	960
	N1.3.C.AG		AlSi cast alloys, Si > 1% and < 13%	90	215	635
	N1.4.C.NS		AlSi cast alloys, Si ≥ 13%	130	215	320
	N2.0.C.UT		**Magnesium based alloys**	70	215	635

CoroDrill® 861 -GM

20 - 30 x D_c

Inch values

Drill diameter, inch f_n inch/rev.													
.1181-.1571		.1572-.1964		.1965-.2358		.2359-.3146		.3147-.3933		.3934-.4720		.4724	
Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max	Min.	Max.
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047.	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0028	.0039	.0031	.0047	.0035	.0051	.0043	.0059	.0055	.0079	.0067	.0098	.0079	.011
.0016	.0028	.002	.0031	.0024	.0035	.0028	.0043	.0035	.0055	.0043	.0067	.0051	.0079
.0016	.0028	.002	.0031.	.0024	.0035	.0028	.0043	.0035	.0055	.0043	.0067	.0051	.0079
.0016	.0028	.002	.0031	.0024	.0035	.0028	.0043	.0035	.0055	.0043	.0067	.0051	.0079
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154
.0024	.0031	.0028	.0035	.0031	.0035	.0039	.0047	.0051	.0059	.0063	.0071	.0075	
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0024	.0031	.0028	.0035	.0031	.0039	.0039	.0047	.0051	.0059	.0063	.0071	.0075	.0083
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154
.0047	.0055	.0055	.0063	.0063	.0071	.0075	.0083	.0098	.0106	.0126	.0134	.0146	.0154
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114
.0035	.0043	.0043	.0051	.0047	.0055	.0055	.0063	.0075	.0083	.0094	.0102	.0106	.0114

CoroDrill® 862

Metric values

ISO	MC No.	CMC No.	Material	Hardness Brinell HB	Cutting speed (v_c), m/min		Drill diameter, DC f_n mm/rev			
							1.85-2.49		2.50-2.99	
					min.	max.	min.	max.	min.	max.
P			**Unalloyed steel**							
	P1.1.Z.AN	01.1	C=0.1-0.25%	125	40	60	0.07	0.09	0.10	0.13
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	40	60	0.07	0.09	0.10	0.13
			Low alloy steel							
	P2.2.Z.AN	02.1	Annealed	240	32	60	0.06	0.08	0.09	0.11
	P2.5.Z.HT	02.2	Hardened and tempered	330	32	60	0.06	0.08	0.09	0.11
			High alloy steel							
	P3.0.Z.AN	03.11	Annealed	200	32	60	0.06	0.08	0.09	0.11
	P4.0.S.NS		**Sintered steels**	150	40	60	0.06	0.08	0.09	0.11
			Stainless steel							
	P5.1.Z.AN	05.11/15.11	Ferritic/martensitic	200	18	60	0.03	0.07	0.04	0.1
M			**Stainless steel**							
	M1.0.Z.AQ	05.21/15.21	Austenitic	200	18	26	0.02	0.04	0.03	0.05
	M2.0.Z.AQ	05.21/15.21	Super austenitic Ni≥20%	200	18	26	0.02	0.04	0.03	0.05
	M3.2.Z.AQ	05.52/15.52	Austenitic/Ferritic (Duplex)	260	18	26	0.02	0.04	0.03	0.05
K			**Malleable cast iron**							
	K1.1.C.NS	07.1/07.2	Ferritic Pearlitic	200	32	48	0.04	0.06	0.06	0.08
			Gray cast iron							
	K2.1.C.UT	08.1	Low tensile strength	180	40	60	0.08	0.10	0.12	0.14
	K2.2.C.UT	08.2	High tensile strength	245	32	48	0.04	0.06	0.06	0.08
			Nodular cast iron							
	K3.1.C.UT	09.1	Ferritic	155	32	48	0.04	0.06	0.06	0.08
	K3.3.C.UT	09.2	Pearlitic	265	32	48	0.04	0.06	0.06	0.08
	K4.2.C.UT		**CGI**	230	32	48	0.04	0.06	0.06	0.08
	K5.1.C.NS		**ADI**	300	32	48	0.04	0.06	0.06	0.08
S			**Heat resistant super alloys**							
	S1.0.U.AG		Iron Based	280	12	18	0.02	0.04	0.03	0.05
	S2.0.Z.AG	20.22	Ni based	350	12	18	0.02	0.04	0.03	0.05
	S4.3.Z.AN	23.22	Titanium based	330	12	18	0.02	0.04	0.03	0.05
N			**Aluminum based alloys**							
	N1.1.Z.UT		Commercial pure	30	48	72	0.09	0.11	0.14	0.16
	N1.2.Z.AG		AlSi alloys, Si ≤ 1%	100	48	72	0.09	0.11	0.14	0.16
	N1.3.C.AG	30.21	AlSi cast alloys, Si > 1% and < 13%	90	40	60	0.09	0.11	0.14	0.16
	N1.4.C.NS		AlSi cast alloys, Si ≥ 13%	130	40	60	0.09	0.11	0.14	0.16
	N2.0.C.UT		**Magnesium based alloys**	70	120	240	0.06	0.08	0.09	0.11

CoroDrill® 862

Inch values

ISO	MC No.	CMC No.	Material	Hardness Brinell HB	Cutting speed (V_c) ft/min		Drill diameter, DC f_n inch/rev. .0728-.0980		.0981-.1177	
					min.	max.	min.	max.	min.	max.
P			**Unalloyed steel**							
	P1.1.Z.AN	01.1	C=0.1-0.25%	125	130	195	.0028	.0035	.0039	.0051
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	130	195	.0028	.0035	.0039	.0051
			Low alloy steel							
	P2.2.Z.AN	02.1	Annealed	240	105	195	.0024	.0031	.0035	.0043
	P2.5.Z.HT	02.2	Hardened and tempered	330	105	195	.0024	.0031	.0035	.0043
			High alloy steel							
	P3.0.Z.AN	03.11	Annealed	200	105	195	.0024	.0031	.0035	.0043
	P4.0.S.NS		**Sintered steels**	150	130	195	.0024	.0031	.0035	.0043
			Stainless steel							
	P5.1.Z.AN	05.11 /15.11	Ferritic/martensitic	200	60	195	.0012	.0028	.0016	.0039
M			**Stainless steel**							
	M1.0.Z.AQ	05.21/15.21	Austenitic	200	60	85	.0008	.0016	.0012	.002
	M2.0.Z.AQ	05.21/15.21	Super austenitic Ni≥20%	200	60	85	.0008	.0016	.0012	.002
	M3.2.Z.AQ	05.52/15.52	Austenitic/Ferritic (Duplex)	260	60	85	.0008	.0016	.0012	.002
K			**Malleable cast iron**							
	K1.1.C.NS	07.1/07.2	Ferritic Pearlitic	200	105	155	.0016	.0024	.0024	.0031
			Gray cast iron							
	K2.1.C.UT	08.1	Low tensile strength	180	130	195	.0031	.0039	.0047	.0055
	K2.2.C.UT	08.2	High tensile strength	245	105	155	.0016	.0024	.0024	.0031
			Nodular cast iron							
	K3.1.C.UT	09.1	Ferritic	155	105	155	.0016	.0024	.0024	.0031
	K3.3C.UT	09.2	Pearlitic	265	105	155	.0016	.0024	.0024	.0031
	K4.2.C.UT		**CGI**	230	105	155	.0016	.0024	.0024	.0031
	K5.1.C.NS		**ADI**	300	105	155	.0016	.0024	.0024	.0031
S			**Heat resistant super alloys**							
	S1.0.U.AG		Iron Based	280	40	60	.0008	.0016	.0012	.002
	S2.0.Z.AG	20.22	Ni based	350	40	60	.0008	.0016	.0012	.002
	S4.3.Z.AN	23.22	Titanium based	330	40	60	.0008	.0016	.0012	.002
N			**Aluminum based alloys**							
	N1.1.Z.UT		Commercial pure	30	155	235	.0035	.0043	.0055	.0063
	N1.2.Z.AG		AlSi alloys, Si ≤ 1%	100	155	235	.0035	.0043	.0055	.0063
	N1.3.C.AG	30.21	AlSi cast alloys, Si > 1% and < 13%	90	130	195	.0035	.0043	.0055	.0063
	N1.4.C.NS		AlSi cast alloys, Si ≥ 13%	130	130	195	.0035	.0043	.0055	.0063
	N2.0.C.UT		**Magnesium based alloys**	70	395	785	.0024	.0031	.0035	.0043

CoroDrill® 400

Metric values

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

B

Inch values

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

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

CoroDrill® 430

Metric values

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

C

Inch values

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

D

GENERAL NOTE FOR ALL: to be programmed in design program

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

CoroDrill® 452

E

Cutting speed recommendations

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

Tapping

V
Versatile

CoroTap™ 200

Metric	C6-C10
Metric fine	C11-C13
UNC	C14-C15
UNF	C16-C17
G	C18

CoroTap™ 300

Metric	C19-C26
Metric fine	C27-C29
UNC	C30-C31
UNF	C33-C34
G	C36
NPT	C37
NPTF	C37

CoroTap™ 400

Metric	C38-C47
Metric fine	C48-C49
UNC	C50
UNF	C51
EGM	C52

O
Optimized

CoroTap™ 100

Metric	C53-C61
Metric fine	C62-C66
UNC	C67-C68
UNF	C69-C70
G	C71

CoroTap™ 200

Metric	C72-C85
Metric fine	C86-C89
MJ	C90
UNC	C91-C96
UNF	C96-C98
UNJC	C99
UNJF	C100

CoroTap™ 300

Metric	C101-C117
Metric fine	C118-C124
MJ	C125
UNC	C126-C131
UNF	C131-C136
G	C137
NPT	C138
UNJC	C139
UNJF	C140
EGUNF	C141
EGUNJF	C142

CoroTap™ 400

Metric	C143-C147
Metric fine	C148-C149
UNC	C150-C151
UNF	C152-C153

C
Customized

CoroTap™

CoroTap™ 100	E7
CoroTap™ 200	E7
CoroTap™ 300	E7
CoroTap™ 400	E7

O C

CoroTap™ 100

- Taps with straight flutes
- Mainly used for short chipping materials like cast iron
- Suitable for both through- and blind holes

V O C

CoroTap™ 300

- Taps with spiral flute grinding
- The spiral flute transports the chips out of the hole
- Best option for blind holes

V O C

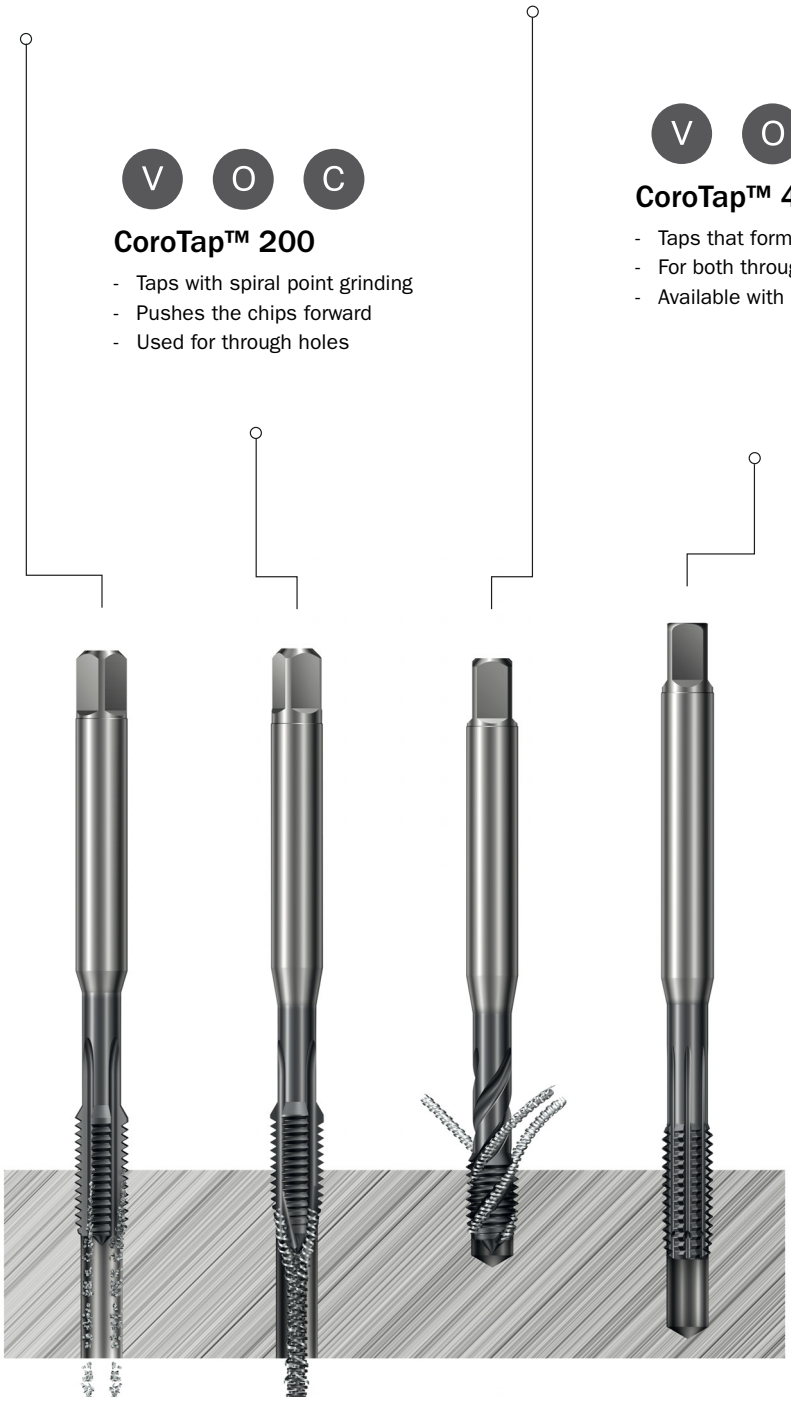
CoroTap™ 200

- Taps with spiral point grinding
- Pushes the chips forward
- Used for through holes

V O C

CoroTap™ 400

- Taps that form the thread instead of cutting
- For both through- and blind holes
- Available with and without oil grooves



Versatile

	Metric	Metric fine	UNC	UNF	G	Metric	Metric	Metric fine	UNC
CoroTap™	200	200	200	200	200	300	300	300	300
Tap range	M2 - M30	M4 - M30	No.2-1", No.4-1"	No.8-1", No.4-1"	No.1/8-1"	M2 - M36	M2 - M64	M4 - M30	No.4-1", No.2-1"
ISO application area	P M K N S	P M K N S	P M K N S	P M K N S	P M K N S	P N S	P M K N S	P M K N S	P M K N S
Through or blind hole									
THCHT	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3, E 1.5-2	C 2-3, E 1.5-2	C 2-3, E 1.5-2
TCTR	6H, 6G	6H	2B, 3BX	2B, 3BX	NORMAL	6H, 6HX	6H,6G	6H	2B, 3BX
ULDR	2.5-3.0 xD	2.5 xD	2.5 xD	2.5 xD	2.5 xD	1.5-2.0 x D	2.5-3.0 xD	2.5 xD	2.5 xD
Internal coolant	✗	✗	✗	✗	✗	✗	✗	✗	✗
External coolant	✓	✓	✓	✓	✓	✓	✓	✓	✓
Page	C7-C10	C11-C13	C14-C15	C16-C17	C18	C20-C22	C23-C26	C27-C29	C30-C31

	UNF	G	NPT	NPTF	Metric	Metric fine	UNC	UNF	EGM Insert
CoroTap™	300	300	300	300	400	400	400	400	400
Tap range	No.4-1", No.8 - 1"	1/8-1.1/2	1/16 - 1"	1/16 - 3/4"	M1 - M24	M5 - M16	No.4 - 1"	No.10-1	EGM3 - EGM12
ISO application area	P M K N S	P M K N S	P M K N S	P M K N S	P M N S	P M N S	P M N S	P M N S	P M N S
Through or blind hole									
THCHT	C 2-3, E 1.5-2	C 2-3	C 2-3	C 2-3	C 2-3, E 1.5-2	C 2-3	C 2-3	C 2-3	C 2-3
TCTR	2B, 3BX	NORMAL	NORMAL	NORMAL	6H, 6HX, 6GX	6HX, 6H	2B	2B	6HMOD
ULDR	2.5 xD	2.5 xD	1.5 x D	1.5 x D	3.0 - 3.5 xD	3.0 xD	3.0 xD	3.0 xD	3.0 xD
Internal coolant	✗	✗	✗	✗	✓	✗	✗	✗	✗
External coolant	✓	✓	✓	✓	✓	✓	✓	✓	✓
Page	C33-C34	C36	C37	C37	C39-C47	C48-C49	C50	C51	C52

Optimized

	Metric	Metric fine	UNC	UNF	G	Metric	Metric fine
CoroTap™	100	100	100	100	100	200	200
Tap range	M3 - M24	M8 - M20	1/4 - 7/8	1/4 - 7/8	No.1/8-1"	M1-M30	M4 - M30
ISO application area	K N H	K	K	K	K	P M N S	P M S
Through or blind hole							
THCHT	C 2-3, E 1.5-2	C 2-3, E 1.5-2	C 2-3, E1.5-2	C 2-3, E1.5-2	C 2-3	B 3.5-5	B 3.5-5, C 2-3
TCTR	6HX, 6H	6HX	2BX	2BX	NORMAL	6HX, 6H	6HX, 6H
ULDR	2.0-2.5 xD	2.5 xD	2.5 xD	2.5 xD	2.0 xD	2.0 - 3.0 xD	2.5 - 3.0 xD
BSG	DIN 371 DIN 376 C-DIN 371 DIN 371/ANSI DIN 376/ANSI	DIN 374 DIN 374/ANSI	DIN 2184-1/ANSI DIN 376/ANSI	DIN 2184-1/ANSI	DIN 5156	DIN 371 DIN 376 C-DIN 371 DIN/ANSI C-DIN/ANSI	DIN 371 DIN 374 DIN/ANSI
Internal coolant	✓	✓	✓	✓	✗	✓	✗
External coolant	✓	✓	✓	✓	✓	✓	✓
Page	C54-C61	C62-C66	C67-C68	C69-C70	C71	C73-C85	C86-C89

	MJ	UNC	UNF	UNJC	UNJF	Metric	Metric fine
CoroTap™	200	200	200	200	200	300	300
Tap range	M4 - M8	No.4-3/4, 1/4-1"	No.4-3/4, No.10-7/8	No.4- No.8	No.10 - 3/8", No.10 - 1/2"	M1.6-M30	M4-M30
ISO application area	S	P M N S	M N S	S	S	P M K N S H	P M N S
Through or blind hole							
THCHT	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	B 3.5-5	C 2-3	C 2-3
TCTR	4H	2BX 2B,3B	2B, 3BX	3BX	3B, 3BX	6HX, 6H	6HX, 6H
ULDR	2.0 xD	2.0 - 3.0 xD	2.0 - 2.5 xD	2.0 xD	2.0 xD	1.5 - 3.0 xD	1.5 - 3.0 xD
BSG	DIN 371	DIN/ANSI C-DIN/ANSI	DIN/ANSI	DIN/ANSI	DIN 2184-1 DIN/ANSI	C-DIN 371 DIN 371 DIN 376 DIN/ANSI	DIN 371 DIN 376 DIN/ANSI
Internal coolant	✗	✓	✗	✗	✗	✓	✗
External coolant	✓	✓	✓	✓	✓	✓	✓
Page	C90	C91-C96	C96-C98	C99	C100	C102-C117	C118-C124

Optimized

	MJ	UNC	UNF	G	NPT	NPTF	UNJC
O							
CoroTap™	300	300	300	300	300	300	300
Tap range	M3 - M8	No.2-1"	No.6-1"	1/8-1"	1/16-1"	1/16-3/4	No.10 -No.8
ISO application area	S	P M N S	P M N S	M	M	M	S
Through or blind hole							
THCHT	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3	C 2-3
TCTR	4H	2B,3B, 2BX	2B,3B, 2BX	NORMAL	NORMAL	NORMAL	3B
ULDR	1.5 xD	1.5 - 3.0 xD	1.5 - 3.0 xD	2.0 x D	1.5 x D	1.5 x D	1.5 x D
BSG	DIN 371	DIN 2184-1 DIN/ANSI C-DIN/ANSI	DIN 2184-1 DIN/ANSI C-DIN/ANSI	DIN 5156	DIN/ANSI	DIN/ANSI	DIN 2184-1
Internal coolant	✗	✓	✓	✗	✗	✗	✗
External coolant	✓	✓	✓	✓	✓	✓	✓
Page	C125	C126-C131	C131-C136	C137	C138	C142	C139

	UNJF	EGUNF	EGUNJF	Metric	Metric fine	UNC	UNF
O							
CoroTap™	300	300	300	400	400	400	400
Tap range	No.6 - 3/8"	No.10 - 1/4"	No.10 - 5/16"	M3-M16	M5-M16	No. 4-5/8"	No. 10-5/8"
ISO application area	S	S	S	P N	P	P	P
Through or blind hole							
THCHT	C 2-3	C 2-3	C 2-3	C 2-3, E 0.5-2	C 2-3	C 2-3, E 1.5-2	C 2-3, E 1.5-2
TCTR	3B	3B	3B	6HX, 6GX	6HX	2BX	2BX
ULDR	1.5 x D	2.0 x D	1.5 x D	3.0 xD	3.0 xD	3.0 xD	3.0 xD
BSG	DIN 2184-1	DIN 2184-1	DIN 2184-1	DIN 2174 DIN/ANSI	DIN 2174	DIN/ANSI	DIN/ANSI
Internal coolant	✗	✗	✗	✓	✓	✓	✓
External coolant	✓	✓	✓	✓	✓	✓	✓
Page	C140	C141	C142	C144-C147	C148-C149	C150-C151	C152-C153

CoroTap™ 200

Applications

- Only for through holes
- Available in many thread forms and standards
- Up to 3 × D depending on materials

V C

ISO application area:

P M K N S

Benefits and features

- Chamfer B (3.5–5 threads) for high process security
- Edge treatment for reduced axial force and torque makes the tool run more smoothly, reduces risk of cutting-edge chipping, and improves surface quality, tool life, and chip formation
- High speed powder steel taps for improved strength, wear resistance, and tool life
- Different coatings and grades are available

- Taps with spiral point grinding
- Pushes the chips forward
- Used for through holes

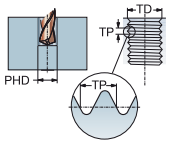
www.sandvik.coromant.com/corotap200

CoroChuck™ 970, see our Rotating Tools catalog.

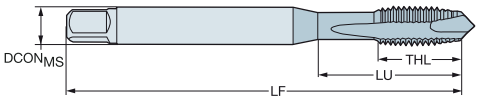
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376



ULDR 2.5
SUBSTRATE HSS-PM



TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 2	0.40	9.00	2.80 x 2.10	B	6H	T200-XM100DA-M2				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.8	2.00	45.0	6.0	2	1.6	DIN 371
		.354																																	.110	.079	1.772	.236		.063	
M 2.5	0.45	12.50	2.80 x 2.10	B	6H	T200-XM100DA-M2.5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.8	2.50	50.0	8.0	2	2.1	DIN 371
		.492																																	.110	.098	1.969	.315		.081	
M 3	0.50	18.00	3.50 x 2.70	B	6H	T200-XM100DA-M3				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.00	56.0	8.9	3	2.5	DIN 371
		.709																																	.138	.118	2.205	.350		.098	
M 3.5	0.60	20.00	4.00 x 3.00	B	6H	T200-XM100DA-M3.5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.0	3.50	56.0	10.8	3	2.9	DIN 371
		.787																																	.157	.138	2.205	.425		.114	
M 4	0.70	21.00	4.50 x 3.40	B	6H	T200-XM100DA-M4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.00	63.0	11.7	3	3.3	DIN 371
		.827																																	.177	.157	2.480	.461		.130	
M 4.5	0.75	25.00	6.00 x 4.90	B	6H	T200-XM100DA-M4.5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	4.50	70.0	13.0	3	3.8	DIN 371
		.984																																	.236	.177	2.756	.512		.150	
M 5	0.80	25.00	6.00 x 4.90	B	6H	T200-XM100DA-M5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.00	70.0	12.6	3	4.2	DIN 371
		.984																																	.236	.197	2.756	.496		.165	
M 6	1.00	30.00	6.00 x 4.90	B	6H	T200-XM100DA-M6				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	6.00	80.0	14.5	3	5.0	DIN 371
		1.181																																	.236	.236	3.150	.571		.197	
M 7	1.00	30.00	7.00 x 5.50	B	6H	T200-XM100DA-M7				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	7.00	80.0	14.5	3	6.0	DIN 371
		1.181																																	.276	.276	3.150	.571		.236	
M 8	1.25	35.00	8.00 x 6.20	B	6H	T200-XM100DA-M8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	8.00	90.0	17.4	3	6.8	DIN 371
		1.378																																	.315	.315	3.543	.685		.268	
M 10	1.50	39.00	10.00 x 8.00	B	6H	T200-XM100DA-M10				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	10.00	100.0	19.2	3	8.5	DIN 371
		1.535																																	.394	.394	3.937	.756		.335	
M 3	0.50	37.00	2.20 x 1.80	B	6H	T200-XM101DA-M3				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.2	3.00	56.0	10.0	3	2.5	DIN 376
		1.457																																	.087	.118	2.205	.394		.098	
M 4	0.70	43.00	2.80 x 2.10	B	6H	T200-XM101DA-M4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.8	4.00	63.0	11.9	3	3.3	DIN 376
		1.693																																	.110	.157	2.480	.469		.130	
M 5	0.80	49.00	3.50 x 2.70	B	6H	T200-XM101DA-M5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	5.00	70.0	13.2	3	4.2	DIN 376
		1.929																																	.138	.197	2.756	.520		.165	
M 6	1.00	59.00	4.50 x 3.40	B	6H	T200-XM101DA-M6				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	6.00	80.0	15.1	3	5.0	DIN 376
		2.323																																	.177	.236	3.150	.594		.197	
M 8	1.25	67.00	6.00 x 4.90	B	6H	T200-XM101DA-M8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	8.00	90.0	18.0	3	6.8	DIN 376
		2.638																																	.236	.315	3.543	.709		.268	
M 10	1.50	77.00	7.00 x 5.50	B	6H	T200-XM101DA-M10				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	100.0	20.0	3	8.5	DIN 376
		3.032																																	.276	.394	3.937	.787		.335	
M 12	1.75	83.00	9.00 x 7.00	B	6H	T200-XM101DA-M12				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376
		3.268																																	.354	.472	4.331	.906		.402	
M 14	2.00	81.00	11.00 x 9.00	B	6H	T200-XM101DA-M14				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	110.0	25.0	3	12.0	DIN 376
		3.189																																	.433	.551	4.331	.984		.472	
M 16	2.00	68.00	12.00 x 9.00	B	6H	T200-XM101DA-M16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	110.0	25.0	3	14.0	DIN 376
		2.677																																	.472	.630	4.331	.984		.551	
M 18	2.50	81.00	14.00 x 11.00	B	6H	T200-XM101DA-M18	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	18.00	125.0	30.0	4	15.5	DIN 376
		3.189																																	.551	.709	4.921	1.181		.610	
M 20	2.50	95.00	16.00 x 12.00	B	6H	T200-XM101DA-M20	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	140.0	30.0	4	17.5	DIN 376
		3.740																																	.630	.787	5.512	1.181		.689	
M 22	2.50	93.00	18.00 x 14.50	B	6H	T200-XM101DA-M22	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.00	140.0	34.0	4	19.5	DIN 376
		3.661																																	.709	.866	5.512	1.339		.768	
M 24	3.00	113.00	18.00 x 14.50	B	6H	T200-XM101DA-M24	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	24.00	160.0	38.0	4	21.0	DIN 376
		4.449																																	.709	.945	6.299	1.496		.827	
M 27	3.00	97.00	20.00 x 16.00	B	6H	T200-XM101DA-M27	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				20.0	27.00	160.0	38.0	4	24.0	DIN 376
		3.819																																	.787	1.063	6.299	1.496		.945	
M 30	3.50	115.00	22.00 x 18.00	B	6H	T200-XM101DA-M30	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				22.0	30.00	180.0	45.0	4	26.5	DIN 376
		4.528																																	.866	1.181	7.087	1.772		1.043	

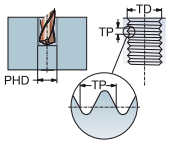
C162 C157 E9 E27 C154

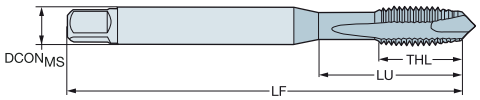
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HSS-PM





TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	18.00	3.50 x 2.70	B	6G	T200-XM104DA-M3				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.00	56.0	8.9	3	2.5	DIN 371
		.709																																			*.138*	*.118*	*2.205*	*.350*		*.098*	
M 4	0.70	21.00	4.50 x 3.40	B	6G	T200-XM104DA-M4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.00	63.0	12.0	3	3.3	DIN 371
		.827																																			*.177*	*.157*	*2.480*	*.472*		*.130*	
M 5	0.80	25.00	6.00 x 4.90	B	6G	T200-XM104DA-M5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.984																																			*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	30.00	6.00 x 4.90	B	6G	T200-XM104DA-M6				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		1.181																																			*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	B	6G	T200-XM104DA-M8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.378																																			*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	B	6G	T200-XM104DA-M10				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.535																																			*.394*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	83.00	9.00 x 7.00	B	6G	T200-XM105DA-M12				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	110.0	23.0	3	10.2	DIN 376
		3.268																																			*.354*	*.472*	*4.331*	*.906*		*.402*	
M 16	2.00	68.00	12.00 x 9.00	B	6G	T200-XM105DA-M16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	110.0	25.0	3	14.0	DIN 376
		2.677																																			*.472*	*.630*	*4.331*	*.984*		*.551*	
M 20	2.50	95.00	16.00 x 12.00	B	6G	T200-XM105DA-M20	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	140.0	30.0	4	17.5	DIN 376
		3.740																																			*.630*	*.787*	*5.512*	*1.181*		*.689*	

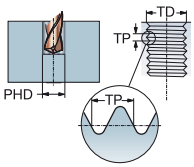
C162 C157 E9 E27 C154

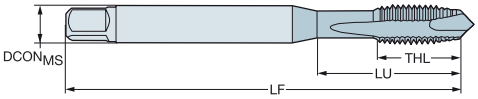
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD TIALN





P M K N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 3	0.50	18.00	3.50 x 2.70	B	6H	**E616M3**	3.5	3.00	112.0	9.0	3	DIN 371
		.709					*.138*	*.118*	*4.409*	*.354*		
M 4	0.70	21.00	4.50 x 3.40	B	6H	**E616M4**	4.5	4.00	112.0	12.0	3	DIN 371
		.827					*.177*	*.157*	*4.409*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	B	6H	**E616M5**	6.0	5.00	125.0	13.0	3	DIN 371
		.984					*.236*	*.197*	*4.921*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	B	6H	**E616M6**	6.0	6.00	125.0	15.0	3	DIN 371
		1.181					*.236*	*.236*	*4.921*	*.591*		
M 8	1.25	40.00	8.00 x 6.20	B	6H	**E616M8**	8.0	8.00	140.0	18.0	3	DIN 371
		1.575					*.315*	*.315*	*5.512*	*.709*		
M 10	1.50	50.00	10.00 x 8.00	B	6H	**E616M10**	10.0	10.00	160.0	20.0	3	DIN 371
		1.969					*.394*	*.394*	*6.299*	*.787*		
M 12	1.75	153.00	9.00 x 7.00	B	6H	**E616M12**	9.0	12.00	180.0	23.0	3	DIN 376
		6.024					*.354*	*.472*	*7.087*	*.906*		
M 14	2.00	151.00	11.00 x 9.00	B	6H	**E616M14**	11.0	14.00	180.0	25.0	3	DIN 376
		5.945					*.433*	*.551*	*7.087*	*.984*		
M 16	2.00	158.00	12.00 x 9.00	B	6H	**E616M16**	12.0	16.00	200.0	25.0	3	DIN 376
		6.220					*.472*	*.630*	*7.874*	*.984*		
M 20	2.50	179.00	16.00 x 12.00	B	6H	**E616M20**	16.0	20.00	224.0	30.0	4	DIN 376
		7.047					*.630*	*.787*	*8.819*	*1.181*		

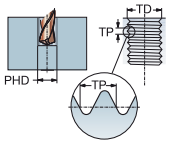
C162 C157 E9 C154

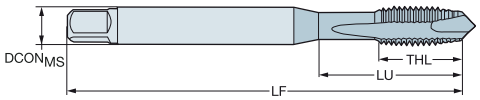
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





							P			M			K			N			S			Dimensions, mm, inch						
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	C110	C145	C150	C110	C145	C150	C110	C145	C150	C110	C145	C150	C110	C145	C150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 4	0.70	21.50	.168 x .131	B	6H	T200-XM100AA-M4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.3	4.00	63.0	13.6	3	3.3	DIN 371/ANSI
		.846																				*.168*	*.157*	*2.480*	*.535*		*.130*	
M 5	0.80	28.00	.194 x .152	B	6H	T200-XM100AA-M5	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	5.00	70.0	14.6	3	4.2	DIN 371/ANSI
		1.102																				*.194*	*.197*	*2.756*	*.575*		*.165*	
M 6	1.00	25.00	.255 x .191	B	6H	T200-XM100AA-M6	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.00	80.0	15.9	3	5.0	DIN 371/ANSI
		.984																				*.255*	*.236*	*3.150*	*.626*		*.197*	
M 8	1.25	34.00	.318 x .238	B	6H	T200-XM100AA-M8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	8.00	90.0	18.9	3	6.8	DIN 371/ANSI
		1.339																				*.318*	*.315*	*3.543*	*.744*		*.268*	
M 10	1.50	38.50	.381 x .286	B	6H	T200-XM100AA-M10	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	10.00	100.0	21.0	3	8.5	DIN 371/ANSI
		1.516																				*.381*	*.394*	*3.937*	*.827*		*.335*	
M 12	1.75	81.82	.367 x .275	B	6H	T200-XM101AA-M12	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.00	110.0	23.1	3	10.2	DIN 376/ANSI
		3.221																				*.367*	*.472*	*4.331*	*.909*		*.402*	
M 14	2.00	80.30	.429 x .322	B	6H	T200-XM101AA-M14	★			★			★			★			★			10.9	14.00	110.0	23.1	3	12.0	DIN 376/ANSI
		3.161																				*.429*	*.551*	*4.331*	*.909*		*.472*	
M 16	2.00	65.78	.480 x .360	B	6H	T200-XM101AA-M16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	12.2	16.00	110.0	23.1	3	14.0	DIN 376/ANSI
		2.590																				*.480*	*.630*	*4.331*	*.909*		*.551*	
M 18	2.50	79.00	.542 x .406	B	6H	T200-XM101AA-M18	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	13.8	18.00	125.0	30.0	4	15.5	DIN 376/ANSI
		3.110																				*.542*	*.709*	*4.921*	*1.181*		*.610*	
M 20	2.50	92.47	.652 x .489	B	6H	T200-XM101AA-M20	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	16.6	20.00	140.0	30.0	4	17.5	DIN 376/ANSI
		3.641																				*.652*	*.787*	*5.512*	*1.181*		*.689*	

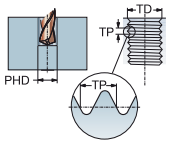
C162 C157 E9 E27 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: Metric fine

DIN 374

ULDR 2.5
SUBSTRATE HSS-PM



TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P B110	P B145	P B150	P C110	P C145	P C150	M B110	M B145	M B150	M C110	M C145	M C150	K B110	K B145	K B150	K C110	K C145	K C150	N B110	N B145	N B150	N C110	N C145	N C150	S B110	S B145	S B150	S C110	S C145	S C150	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 4x0.5	0.50	43.00	2.80 x 2.10	B	6H	T200-XM100DB-M4X050				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.8	4.00	63.0	11.9	3	3.5	DIN 374
		1.693																																			*.110*	*.157*	*2.480*	*.469*		*.138*	
MF 5x0.5	0.50	49.00	3.50 x 2.70	B	6H	T200-XM100DB-M5X050				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	5.00	70.0	13.2	3	4.5	DIN 374
		1.929																																			*.138*	*.197*	*2.756*	*.520*		*.177*	
MF 6x0.75	0.75	59.00	4.50 x 3.40	B	6H	T200-XM100DB-M6X075				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	6.00	80.0	15.1	3	5.3	DIN 374
		2.323																																			*.177*	*.236*	*3.150*	*.594*		*.209*	
MF 8x0.75	0.75	57.00	6.00 x 4.90	B	6H	T200-XM100DB-M8X075				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	8.00	80.0	14.9	3	7.3	DIN 374
		2.244																																			*.236*	*.315*	*3.150*	*.587*		*.287*	
MF 8x1	1.00	67.00	6.00 x 4.90	B	6H	T200-XM100DB-M8X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	8.00	90.0	18.0	3	7.0	DIN 374
		2.638																																			*.236*	*.315*	*3.543*	*.709*		*.276*	
MF 10x0.75	0.75	67.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X075				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	90.0	17.6	3	9.3	DIN 374
		2.638																																			*.276*	*.394*	*3.543*	*.693*		*.366*	
MF 10x1	1.00	67.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	90.0	17.6	3	9.0	DIN 374
		2.638																																			*.276*	*.394*	*3.543*	*.693*		*.354*	
MF 10x1.25	1.25	77.00	7.00 x 5.50	B	6H	T200-XM100DB-M10X125				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	100.0	19.8	3	8.8	DIN 374
		3.032																																			*.276*	*.394*	*3.937*	*.780*		*.346*	
MF 12x1	1.00	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	100.0	21.0	3	11.0	DIN 374
		2.874																																			*.354*	*.472*	*3.937*	*.827*		*.433*	
MF 12x1.25	1.25	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X125				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	100.0	21.0	3	10.8	DIN 374
		2.874																																			*.354*	*.472*	*3.937*	*.827*		*.425*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6H	T200-XM100DB-M12X150				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	100.0	21.0	3	10.5	DIN 374
		2.874																																			*.354*	*.472*	*3.937*	*.827*		*.413*	
MF 14x1	1.00	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	100.0	21.0	3	13.0	DIN 374
		2.795																																			*.433*	*.551*	*3.937*	*.827*		*.512*	
MF 14x1.25	1.25	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X125				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	100.0	21.0	3	12.8	DIN 374
		2.795																																			*.433*	*.551*	*3.937*	*.827*		*.504*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6H	T200-XM100DB-M14X150				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	100.0	21.0	3	12.5	DIN 374
		2.795																																			*.433*	*.551*	*3.937*	*.827*		*.492*	
MF 16x1	1.00	58.00	12.00 x 9.00	B	6H	T200-XM100DB-M16X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	100.0	21.0	3	15.0	DIN 374
		2.283																																			*.472*	*.630*	*3.937*	*.827*		*.591*	
MF 16x1.5	1.50	58.00	12.00 x 9.00	B	6H	T200-XM100DB-M16X150				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	100.0	21.0	3	14.5	DIN 374
		2.283																																			*.472*	*.630*	*3.937*	*.827*		*.571*	
MF 18x1	1.00	66.00	14.00 x 11.00	B	6H	T200-XM100DB-M18X100	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	18.00	110.0	24.0	4	17.0	DIN 374
		2.598																																			*.551*	*.709*	*4.331*	*.945*		*.669*	
MF 18x1.5	1.50	66.00	14.00 x 11.00	B	6H	T200-XM100DB-M18X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	18.00	110.0	24.0	4	16.5	DIN 374
		2.598																																			*.551*	*.709*	*4.331*	*.945*		*.650*	
MF 20x1	1.00	80.00	16.00 x 12.00	B	6H	T200-XM100DB-M20X100	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	125.0	24.0	4	19.0	DIN 374
		3.150																																			*.630*	*.787*	*4.921*	*.945*		*.748*	
MF 20x1.5	1.50	80.00	16.00 x 12.00	B	6H	T200-XM100DB-M20X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	125.0	24.0	4	18.5	DIN 374
		3.150																																			*.630*	*.787*	*4.921*	*.945*		*.728*	
MF 22x1.5	1.50	78.00	18.00 x 14.50	B	6H	T200-XM100DB-M22X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.00	125.0	25.0	4	20.5	DIN 374
		3.071																																			*.709*	*.866*	*4.921*	*.984*		*.807*	
MF 24x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M24X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	24.00	140.0	28.0	4	22.5	DIN 374
		3.661																																			*.709*	*.945*	*5.512*	*1.102*		*.886*	
MF 24x2	2.00	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M24X200	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	24.00	140.0	28.0	4	22.0	DIN 374
		3.661																																			*.709*	*.945*	*5.512*	*1.102*		*.866*	
MF 25x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M25X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	25.00	140.0	28.0	4	23.5	DIN 374
		3.661																																			*.709*	*.984*	*5.512*	*1.102*		*.925*	
MF 26x1.5	1.50	93.00	18.00 x 14.50	B	6H	T200-XM100DB-M26X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	26.00	140.0	28.0	4	24.5	DIN 374
		3.661																																			*.709*	*1.024*	*5.512*	*1.102*		*.965*	
MF 27x1.5	1.50	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M27X150		★	★					★	★					★	★					★	★					★	★				20.0	27.00	140.0	28.0	4	25.5	DIN 374
		3.032																																			*.787*	*1.063*	*5.512*	*1.102*		*1.004*	
MF 27x2	2.00	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M27X200	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				20.0	27.00	140.0	28.0	4	25.0	DIN 374
		3.032																																			*.787*	*1.063*	*5.512*	*1.102*		*.984*	

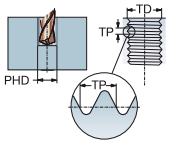
C162 C157 E9 E27 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: Metric fine

DIN 374

ULDR 2.5
SUBSTRATE HSS-PM



TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 28x1.5	1.50	77.00	20.00 x 16.00	B	6H	T200-XM100DB-M28X150	★						★						★						★						★						20.0	28.00	140.0	28.0	4	26.5	DIN 374
		3.032																																			*.787*	*1.102*	*5.512*	*1.102*		*1.043*	
MF 30x1.5	1.50	85.00	22.00 x 18.00	B	6H	T200-XM100DB-M30X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				22.0	30.00	150.0	28.0	4	28.5	DIN 374
		3.346																																			*.866*	*1.181*	*5.906*	*1.102*		*1.122*	
MF 30x2	2.00	85.00	22.00 x 18.00	B	6H	T200-XM100DB-M30X200	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				22.0	30.00	150.0	28.0	4	28.0	DIN 374
		3.346																																			*.866*	*1.181*	*5.906*	*1.102*		*1.102*	

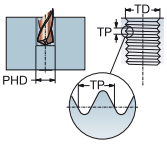
C162 C157 E9 E27 C154

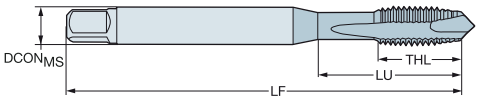
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric fine

DIN 374/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P C110	P C145	P C150	M C110	M C145	M C150	K C110	K C145	K C150	N C110	N C145	N C150	S C110	S C145	S C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 8x1	1.00	34.00	.318 x .238	B	6H	T200-XM100AB-M8X100	★		★	★		★	★		★	★		★	★		★	8.1	8.00	90.0	18.7	3	7.0	DIN 374/ANSI
		1.339																				*.318*	*.315*	*3.543*	*.736*		*.276*	
MF 10x1	1.00	37.50	.381 x .286	B	6H	T200-XM100AB-M10X100	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	10.00	90.0	18.0	3	9.0	DIN 374/ANSI
		1.476																				*.381*	*.394*	*3.543*	*.709*		*.354*	
MF 14x1.5	1.50	70.30	.429 x .322	B	6H	T200-XM101AB-M14X150		★	★		★	★		★	★		★	★		★	★	10.9	14.00	100.0	21.1	3	12.5	DIN 374/ANSI
		2.768																				*.429*	*.551*	*3.937*	*.831*		*.492*	
MF 18x1.5	1.50	64.00	.542 x .406	B	6H	T200-XM101AB-M18X150	★			★			★			★			★			13.8	18.00	110.0	23.9	4	16.5	DIN 374/ANSI
		2.520																				*.542*	*.709*	*4.331*	*.941*		*.650*	

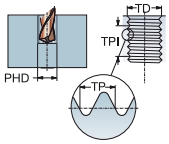
C162 C157 E9 E27 C154

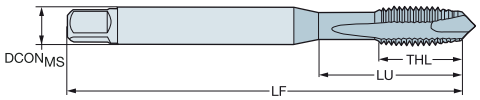
CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN 2184-1

ULDR 2.5
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	18.00	3.50 x 2.70	B	2B	T200-XM100DE-4-40				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	2.84	56.0	8.5	3	2.4	DIN 2184-1
		.709																																			*.138*	*.112*	*2.205*	*.335*		*.093*	
UNC #5-40	40.00	18.00	3.50 x 2.70	B	2B	T200-XM100DE-5-40				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.18	56.0	9.5	3	2.7	DIN 2184-1
		.709																																			*.138*	*.125*	*2.205*	*.374*		*.104*	
UNC #6-32	32.00	20.00	4.00 x 3.00	B	2B	T200-XM100DE-6-32				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.0	3.51	56.0	10.4	3	2.9	DIN 2184-1
		.787																																			*.157*	*.138*	*2.205*	*.409*		*.112*	
UNC #8-32	32.00	21.00	4.50 x 3.40	B	2B	T200-XM100DE-8-32				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.17	63.0	11.4	3	3.5	DIN 2184-1
		.827																																			*.177*	*.164*	*2.480*	*.449*		*.138*	
UNC #10-24	24.00	25.00	6.00 x 4.90	B	2B	T200-XM100DE-10-24				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	4.83	70.0	13.0	3	3.9	DIN 2184-1
		.984																																			*.236*	*.190*	*2.756*	*.512*		*.154*	
UNC #12-24	24.00	30.00	6.00 x 4.90	B	2B	T200-XM100DE-12-24				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.49	80.0	15.0	3	4.5	DIN 2184-1
		1.181																																			*.236*	*.216*	*3.150*	*.591*		*.177*	
UNC 1/4-20	20.00	30.00	7.00 x 5.50	B	2B	T200-XM100DE-1/4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	6.35	80.0	14.1	3	5.1	DIN 2184-1
		1.181																																			*.276*	*.250*	*3.150*	*.555*		*.201*	
UNC 5/16-18	18.00	35.00	8.00 x 6.20	B	2B	T200-XM100DE-5/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	7.94	90.0	17.4	3	6.6	DIN 2184-1
		1.378																																			*.315*	*.313*	*3.543*	*.685*		*.260*	
UNC 3/8-16	16.00	39.00	10.00 x 8.00	B	2B	T200-XM100DE-3/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	9.53	100.0	18.9	3	8.0	DIN 2184-1
		1.535																																			*.394*	*.375*	*3.937*	*.744*		*.315*	
UNC 7/16-14	14.00	76.00	8.00 x 6.20	B	2B	T200-XM101DE-7/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	11.11	100.0	20.0	3	9.4	DIN 2184-1
		2.992																																			*.315*	*.438*	*3.937*	*.787*		*.370*	
UNC 1/2-13	13.00	83.00	9.00 x 7.00	B	2B	T200-XM101DE-1/2				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.70	110.0	23.0	3	10.8	DIN 2184-1
		3.268																																			*.354*	*.500*	*4.331*	*.906*		*.425*	
UNC 5/8-11	11.00	68.00	12.00 x 9.00	B	2B	T200-XM101DE-5/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	15.88	110.0	25.0	3	13.5	DIN 2184-1
		2.677																																			*.472*	*.625*	*4.331*	*.984*		*.531*	
UNC 3/4-10	10.00	81.00	14.00 x 11.00	B	2B	T200-XM101DE-3/4	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	19.05	125.0	30.0	4	16.5	DIN 2184-1
		3.189																																			*.551*	*.750*	*4.921*	*1.181*		*.650*	
UNC 7/8-9	9.00	93.00	18.00 x 14.50	B	2B	T200-XM101DE-7/8	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.23	140.0	34.0	4	19.5	DIN 2184-1
		3.661																																			*.709*	*.875*	*5.512*	*1.339*		*.768*	
UNC 1"-8	8.00	113.00	18.00 x 14.50	B	2B	T200-XM101DE-1	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	25.40	160.0	38.0	4	22.3	DIN 2184-1
		4.449																																			*.709*	*1.000*	*6.299*	*1.496*		*.876*	

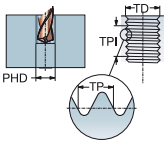
C162 C157 E9 E27 C154

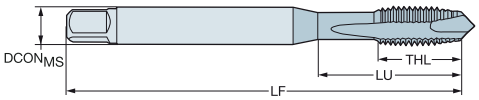
CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN 2184-1/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P C110	P C145	P C150	M C110	M C145	M C150	K C110	K C145	K C150	N C110	N C145	N C150	S C110	S C145	S C150	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC #2-56	56.00	11.99	.141 x .110	B	3BX	T200-XM100AE-2-56	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.18	45.0	7.0	2	1.9	DIN 2184-1/ANSI
		.472																				*.141*	*.086*	*1.772*	*.276*		*.073*	
UNC #4-40	40.00	17.00	.141 x .110	B	3BX	T200-XM100AE-4-40	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.84	56.0	9.5	3	2.4	DIN 2184-1/ANSI
		.669																				*.141*	*.112*	*2.205*	*.374*		*.093*	
UNC #5-40	40.00	17.50	.141 x .110	B	3BX	T200-XM100AE-5-40	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	3.51	56.0	8.9	3	2.7	DIN 2184-1/ANSI
		.689																				*.141*	*.138*	*2.205*	*.350*		*.104*	
UNC #6-32	32.00	20.50	.141 x .110	B	3BX	T200-XM100AE-6-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	3.51	56.0	11.6	3	2.9	DIN 2184-1/ANSI
		.807																				*.141*	*.138*	*2.205*	*.457*		*.112*	
UNC #8-32	32.00	21.50	.168 x .131	B	3BX	T200-XM100AE-8-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.3	4.17	63.0	13.6	3	3.5	DIN 2184-1/ANSI
		.846																				*.168*	*.164*	*2.480*	*.535*		*.138*	
UNC #10-24	24.00	28.00	.194 x .152	B	3BX	T200-XM100AE-10-24	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	4.83	70.0	14.8	3	3.9	DIN 2184-1/ANSI
		1.102																				*.194*	*.190*	*2.756*	*.583*		*.154*	
UNC #12-24	24.00	29.00	.220 x .165	B	3BX	T200-XM100AE-12-24	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	5.6	5.49	80.0	14.0	3	4.5	DIN 2184-1/ANSI
		1.142																				*.220*	*.216*	*3.150*	*.551*		*.177*	
UNC 1/4-20	20.00	25.00	.255 x .191	B	3BX	T200-XM100AE-1/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.35	80.0	15.9	3	5.1	DIN 2184-1/ANSI
		.984																				*.255*	*.250*	*3.150*	*.626*		*.201*	
UNC 5/16-18	18.00	34.00	.318 x .238	B	3BX	T200-XM100AE-5/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	7.94	90.0	19.0	3	6.6	DIN 2184-1/ANSI
		1.339																				*.318*	*.313*	*3.543*	*.748*		*.260*	
UNC 3/8-16	16.00	38.50	.381 x .286	B	3BX	T200-XM100AE-3/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	9.53	100.0	21.3	3	8.0	DIN 2184-1/ANSI
		1.516																				*.381*	*.375*	*3.937*	*.839*		*.315*	
UNC 7/16-14	14.00	72.59	.323 x .242	B	3BX	T200-XM101AE-7/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.2	11.11	100.0	20.1	3	9.4	DIN 2184-1/ANSI
		2.858																				*.323*	*.438*	*3.937*	*.791*		*.370*	
UNC 1/2-13	13.00	81.82	.367 x .275	B	3BX	T200-XM101AE-1/2	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.70	110.0	23.1	3	10.8	DIN 2184-1/ANSI
		3.221																				*.367*	*.500*	*4.331*	*.909*		*.425*	
UNC 9/16-12	12.00	80.30	.429 x .322	B	3BX	T200-XM101AE-9/16	★	★		★	★		★	★		★	★		★	★		10.9	14.29	110.0	23.1	3	12.2	DIN 2184-1/ANSI
		3.161																				*.429*	*.563*	*4.331*	*.909*		*.480*	
UNC 5/8-11	11.00	65.78	.480 x .360	B	3BX	T200-XM101AE-5/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	12.2	15.88	110.0	23.1	3	13.5	DIN 2184-1/ANSI
		2.590																				*.480*	*.625*	*4.331*	*.909*		*.531*	
UNC 3/4-10	10.00	77.47	.590 x .442	B	3BX	T200-XM101AE-3/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	15.0	19.05	125.0	30.0	4	16.5	DIN 2184-1/ANSI
		3.050																				*.590*	*.750*	*4.921*	*1.181*		*.650*	
UNC 7/8-9	9.00	90.95	.697 x .523	B	3BX	T200-XM101AE-7/8		★			★			★			★			★		17.7	22.23	140.0	34.0	4	19.5	DIN 2184-1/ANSI
		3.581																				*.697*	*.875*	*5.512*	*1.339*		*.768*	
UNC 1"-8	8.00	95.43	.800 x .600	B	3BX	T200-XM101AE-1	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	20.3	25.40	160.0	36.1	4	22.3	DIN 2184-1/ANSI
		3.757																				*.800*	*1.000*	*6.299*	*1.421*		*.876*	

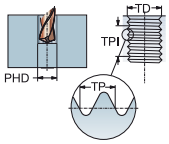
C162 C157 E9 E27 C154

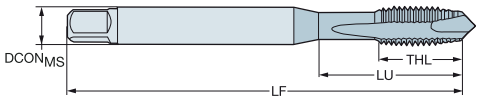
CoroTap™ 200 cutting tap with spiral point

Thread form: UNF

DIN 2184-1

ULDR 2.5
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF #8-36	36.00	21.00	4.50 x 3.40	B	2B	T200-XM100DF-8-36				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.17	63.0	11.4	3	3.5	DIN 2184-1
		.827																																			*.177*	*.164*	*2.480*	*.449*		*.138*	
UNF #10-32	32.00	25.00	6.00 x 4.90	B	2B	T200-XM100DF-10-32				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	4.83	70.0	12.2	3	4.1	DIN 2184-1
		.984																																			*.236*	*.190*	*2.756*	*.480*		*.161*	
UNF 1/4-28	28.00	30.00	7.00 x 5.50	B	2B	T200-XM100DF-1/4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	6.35	80.0	14.1	3	5.5	DIN 2184-1
		1.181																																			*.276*	*.250*	*3.150*	*.555*		*.217*	
UNF 5/16-24	24.00	35.00	8.00 x 6.20	B	2B	T200-XM100DF-5/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	7.94	90.0	17.4	3	6.9	DIN 2184-1
		1.378																																			*.315*	*.313*	*3.543*	*.685*		*.272*	
UNF 3/8-24	24.00	39.00	10.00 x 8.00	B	2B	T200-XM100DF-3/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	9.53	100.0	18.9	3	8.5	DIN 2184-1
		1.535																																			*.394*	*.375*	*3.937*	*.744*		*.335*	
UNF 7/16-20	20.00	76.00	8.00 x 6.20	B	2B	T200-XM101DF-7/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	11.11	100.0	20.0	3	9.9	DIN 2184-1
		2.992																																			*.315*	*.438*	*3.937*	*.787*		*.390*	
UNF 1/2-20	20.00	83.00	9.00 x 7.00	B	2B	T200-XM101DF-1/2				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.70	110.0	23.0	3	11.5	DIN 2184-1
		3.268																																			*.354*	*.500*	*4.331*	*.906*		*.453*	
UNF 5/8-18	18.00	68.00	12.00 x 9.00	B	2B	T200-XM101DF-5/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	15.88	110.0	25.0	3	14.5	DIN 2184-1
		2.677																																			*.472*	*.625*	*4.331*	*.984*		*.571*	
UNF 3/4-16	16.00	81.00	14.00 x 11.00	B	2B	T200-XM101DF-3/4	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	19.05	125.0	30.0	4	17.5	DIN 2184-1
		3.189																																			*.551*	*.750*	*4.921*	*1.181*		*.689*	
UNF 7/8-14	14.00	93.00	18.00 x 14.50	B	2B	T200-XM101DF-7/8	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.23	140.0	34.0	4	20.4	DIN 2184-1
		3.661																																			*.709*	*.875*	*5.512*	*1.339*		*.803*	
UNF 1"-12	12.00	113.00	18.00 x 14.50	B	2B	T200-XM101DF-1	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	25.40	160.0	38.0	4	23.3	DIN 2184-1
		4.449																																			*.709*	*1.000*	*6.299*	*1.496*		*.915*	

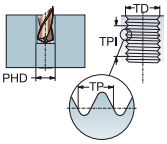
C162 C157 E9 E27 C154

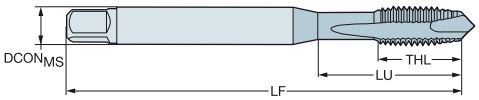
CoroTap™ 200 cutting tap with spiral point

Thread form: UNF

DIN 2184-1/ANSI

ULDR 2.5
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P C110	P C145	P C150	M C110	M C145	M C150	K C110	K C145	K C150	N C110	N C145	N C150	S C110	S C145	S C150	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF #4-48	48.00	17.00	.141 x .110	B	3BX	T200-XM100AF-4-48	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.84	56.0	9.4	3	2.4	DIN 2184-1/ANSI
		.669																				*.141*	*.112*	*2.205*	*.370*		*.094*	
UNF #6-40	40.00	20.50	.141 x .110	B	3BX	T200-XM100AF-6-40	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	3.51	56.0	11.5	3	3.0	DIN 2184-1/ANSI
		.807																				*.141*	*.138*	*2.205*	*.453*		*.116*	
UNF #8-36	36.00	21.50	.168 x .131	B	3BX	T200-XM100AF-8-36	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.3	4.17	63.0	13.5	3	3.5	DIN 2184-1/ANSI
		.846																				*.168*	*.164*	*2.480*	*.531*		*.138*	
UNF #10-32	32.00	28.00	.194 x .152	B	3BX	T200-XM100AF-10-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	4.83	70.0	14.7	3	4.1	DIN 2184-1/ANSI
		1.102																				*.194*	*.190*	*2.756*	*.579*		*.161*	
UNF #12-28	28.00	29.00	.220 x .165	B	3BX	T200-XM100AF-12-28	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	5.6	5.49	80.0	14.0	3	4.6	DIN 2184-1/ANSI
		1.142																				*.220*	*.216*	*3.150*	*.551*		*.181*	
UNF 1/4-28	28.00	25.00	.255 x .191	B	3BX	T200-XM100AF-1/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.35	80.0	15.7	3	5.5	DIN 2184-1/ANSI
		.984																				*.255*	*.250*	*3.150*	*.618*		*.217*	
UNF 5/16-24	24.00	34.00	.318 x .238	B	3BX	T200-XM100AF-5/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	7.94	90.0	18.8	3	6.9	DIN 2184-1/ANSI
		1.339																				*.318*	*.313*	*3.543*	*.740*		*.272*	
UNF 3/8-24	24.00	37.50	.381 x .286	B	3BX	T200-XM100AF-3/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	9.53	90.0	20.1	3	8.5	DIN 2184-1/ANSI
		1.476																				*.381*	*.375*	*3.543*	*.791*		*.335*	
UNF 7/16-20	20.00	72.59	.323 x .242	B	3BX	T200-XM101AF-7/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.2	11.11	100.0	20.1	3	9.9	DIN 2184-1/ANSI
		2.858																				*.323*	*.438*	*3.937*	*.791*		*.390*	
UNF 1/2-20	20.00	71.82	.367 x .275	B	3BX	T200-XM101AF-1/2	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.70	100.0	21.1	3	11.5	DIN 2184-1/ANSI
		2.828																				*.367*	*.500*	*3.937*	*.831*		*.453*	
UNF 9/16-18	18.00	70.30	.429 x .322	B	3BX	T200-XM101AF-9/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	10.9	14.29	100.0	21.1	3	12.9	DIN 2184-1/ANSI
		2.768																				*.429*	*.563*	*3.937*	*.831*		*.508*	
UNF 5/8-18	18.00	55.78	.480 x .360	B	3BX	T200-XM101AF-5/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	12.2	15.88	100.0	21.1	3	14.5	DIN 2184-1/ANSI
		2.196																				*.480*	*.625*	*3.937*	*.831*		*.571*	
UNF 3/4-16	16.00	62.47	.590 x .442	B	3BX	T200-XM101AF-3/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	15.0	19.05	110.0	23.9	4	17.5	DIN 2184-1/ANSI
		2.459																				*.590*	*.750*	*4.331*	*.941*		*.689*	
UNF 7/8-14	14.00	75.95	.697 x .523	B	3BX	T200-XM101AF-7/8	★	★		★	★		★	★		★	★		★	★		17.7	22.23	125.0	23.9	4	20.4	DIN 2184-1/ANSI
		2.990																				*.697*	*.875*	*4.921*	*.941*		*.803*	
UNF 1"-12	12.00	75.43	.800 x .600	B	3BX	T200-XM101AF-1-12	★	★		★	★		★	★		★	★		★	★		20.3	25.40	140.0	26.9	4	23.3	DIN 2184-1/ANSI
		2.970																				*.800*	*1.000*	*5.512*	*1.059*		*.915*	

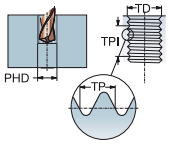
C162 C157 E9 E27 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: G

DIN 5156

ULDR 2.5
SUBSTRATE HSS-PM



TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
G 1/8-28	28.00	67.00	7.00 x 5.50	B	NORMAL	T200-XM100DK-1/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	9.73	90.0	18.0	3	8.8	DIN 5156
		2.638																																	*.276*	*.383*	*3.543*	*.709*		*.346*	
G 1/4-19	19.00	71.00	11.00 x 9.00	B	NORMAL	T200-XM100DK-1/4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	13.16	100.0	21.0	3	11.8	DIN 5156
		2.795																																	*.433*	*.518*	*3.937*	*.827*		*.465*	
G 3/8-19	19.00	58.00	12.00 x 9.00	B	NORMAL	T200-XM100DK-3/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.66	100.0	21.0	4	15.3	DIN 5156
		2.283																																	*.472*	*.656*	*3.937*	*.827*		*.600*	
G 1/2-14	14.00	80.00	16.00 x 12.00	B	NORMAL	T200-XM100DK-1/2	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.96	125.0	24.0	4	19.0	DIN 5156
		3.150																																	*.630*	*.825*	*4.921*	*.945*		*.748*	
G 5/8-14	14.00	78.00	18.00 x 14.50	B	NORMAL	T200-XM100DK-5/8	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.91	125.0	24.0	4	21.0	DIN 5156
		3.071																																	*.709*	*.902*	*4.921*	*.945*		*.827*	
G 3/4-14	14.00	77.00	20.00 x 16.00	B	NORMAL	T200-XM100DK-3/4	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				20.0	26.44	140.0	28.0	4	24.5	DIN 5156
		3.032																																	*.787*	*1.041*	*5.512*	*1.102*		*.965*	
G 7/8-14	14.00	85.00	22.00 x 18.00	B	NORMAL	T200-XM100DK-7/8		★						★						★						★						★					22.0	30.20	150.0	28.0	4	28.3	DIN 5156
		3.346																																	*.866*	*1.189*	*5.906*	*1.102*		*1.112*	
G 1"-11	11.00	93.00	25.00 x 20.00	B	NORMAL	T200-XM100DK-1	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				25.0	33.25	160.0	30.0	4	30.8	DIN 5156
		3.661																																	*.984*	*1.309*	*6.299*	*1.181*		*1.211*	

C162 C157 E9 E27 C154

SANDVIK Coromant

CoroTap™ 300

Applications

- Suitable for blind holes
- Available in many thread forms and standards
- Depths up to 3 × diameter

V C

ISO application area:

P M K N S

Benefits and features

- The design of the spiral flute secures a constant rake angle and gives a constant cutting process
- Back chamfer, used on taps with a high helix angle, reduces torque and chipping
- Taps with a high spiral angle give excellent chip evacuation and possibilities to thread up to 3 × diameter in blind holes
- Taps with a low spiral angle give strong edges and are suitable for tapping tough materials, generating short chips in blind holes
- High speed powder steel taps for improved strength, wear resistance, and tool life
- Solid carbide taps for long tool life and high productivity

- Taps with spiral flute grinding
- The spiral flute transports the chips out of the hole
- Best option for blind holes
- Different helix angle for different applications
- Flute used for both cutting fluid and chip evacuation
- Different threading depths due to application and geometry

www.sandvik.coromant.com/corotap300

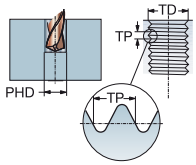
CoroChuck™ 970, see our Rotating Tools catalog.

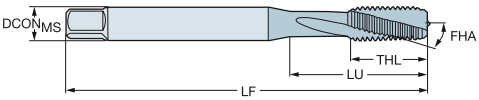
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E





P N

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 2	0.40	9.00	2.80 x 2.10	C	6H	E207M2	2.8	2.00	45.0	4.0	3	DIN 371
		.354					*.110*	*.079*	*1.772*	*.157*		
M 2.5	0.45	12.50	2.80 x 2.10	C	6H	E207M2.5	2.8	2.50	50.0	4.0	3	DIN 371
		.492					*.110*	*.098*	*1.969*	*.157*		
M 3	0.50	18.00	3.50 x 2.70	C	6H	E207M3	3.5	3.00	56.0	9.0	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.354*		
M 3.5	0.60	20.00	4.00 x 3.00	C	6H	E207M3.5	4.0	3.50	56.0	11.0	3	DIN 371
		.787					*.157*	*.138*	*2.205*	*.433*		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E207M4	4.5	4.00	63.0	12.0	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E207M5	6.0	5.00	70.0	13.0	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E207M6	6.0	6.00	80.0	15.0	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 7	1.00	30.00	7.00 x 5.50	C	6H	E207M7	7.0	7.00	80.0	15.0	3	DIN 371
		1.181					*.276*	*.276*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6H	E207M8	8.0	8.00	90.0	18.0	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E207M10	10.0	10.00	100.0	20.1	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.791*		
M 4	0.70	43.00	2.80 x 2.10	C	6H	E258M4	2.8	4.00	63.0	12.0	3	DIN 376
		1.693					*.110*	*.157*	*2.480*	*.472*		
M 5	0.80	49.00	3.50 x 2.70	C	6H	E258M5	3.5	5.00	70.0	13.0	3	DIN 376
		1.929					*.138*	*.197*	*2.756*	*.512*		
M 6	1.00	59.00	4.50 x 3.40	C	6H	E258M6	4.5	6.00	80.0	15.0	3	DIN 376
		2.323					*.177*	*.236*	*3.150*	*.591*		
M 8	1.25	67.00	6.00 x 4.90	C	6H	E258M8	6.0	8.00	90.0	18.0	3	DIN 376
		2.638					*.236*	*.315*	*3.543*	*.709*		
M 10	1.50	77.00	7.00 x 5.50	C	6H	E258M10	7.0	10.00	100.0	20.0	3	DIN 376
		3.032					*.276*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E258M12	9.0	12.00	110.0	23.0	3	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E258M14	11.0	14.00	110.0	25.0	3	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E258M16	12.0	16.00	110.0	25.0	3	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 18	2.50	81.00	14.00 x 11.00	C	6H	E258M18	14.0	18.00	125.0	30.0	3	DIN 376
		3.189					*.551*	*.709*	*4.921*	*1.181*		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E258M20	16.0	20.00	140.0	30.0	3	DIN 376
		3.740					*.630*	*.787*	*5.512*	*1.181*		
M 22	2.50	93.00	18.00 x 14.50	C	6H	E258M22	18.0	22.00	140.0	34.0	4	DIN 376
		3.661					*.709*	*.866*	*5.512*	*1.339*		
M 24	3.00	113.00	18.00 x 14.50	C	6H	E258M24	18.0	24.00	160.0	38.0	4	DIN 376
		4.449					*.709*	*.945*	*6.299*	*1.496*		
M 30	3.50	115.00	22.00 x 18.00	C	6H	E258M30	22.0	30.00	180.0	45.0	4	DIN 376
		4.528					*.866*	*1.181*	*7.087*	*1.772*		
M 36	4.00	131.00	28.00 x 22.00	C	6H	E258M36	28.0	36.00	200.0	55.0	4	DIN 376
		5.157					*1.102*	*1.417*	*7.874*	*2.165*		

C166 C157 E9 C154

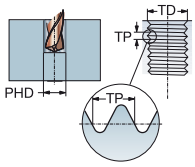
SANDVIK Coromant

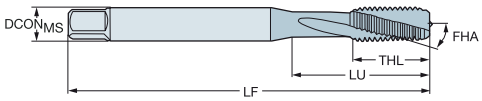
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E
COATING PVD TIN





P N S

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 3	0.50	18.00	3.50 x 2.70	C	6H	E212M3	3.5	3.00	56.0	9.0	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.354*		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E212M4	4.5	4.00	63.0	11.0	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.433*		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E212M5	6.0	5.00	70.0	13.0	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E212M6	6.0	6.00	80.0	15.0	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6H	E212M8	8.0	8.00	90.0	18.0	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E212M10	10.0	10.00	100.0	20.0	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E263M12	9.0	12.00	110.0	23.0	3	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E263M14	11.0	14.00	110.0	25.0	3	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E263M16	12.0	16.00	110.0	25.0	3	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 18	2.50	81.00	14.00 x 11.00	C	6H	E263M18	14.0	18.00	125.0	30.0	3	DIN 376
		3.189					*.551*	*.709*	*4.921*	*1.181*		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E263M20	16.0	20.00	140.0	30.0	3	DIN 376
		3.740					*.630*	*.787*	*5.512*	*1.181*		
M 22	2.50	93.00	18.00 x 14.50	C	6H	E263M22	18.0	22.00	140.0	34.0	4	DIN 376
		3.661					*.709*	*.866*	*5.512*	*1.339*		
M 24	3.00	113.00	18.00 x 14.50	C	6H	E263M24	18.0	24.00	160.0	38.0	4	DIN 376
		4.449					*.709*	*.945*	*6.299*	*1.496*		
M 27	3.00	97.00	20.00 x 16.00	C	6H	E263M27	20.0	27.00	160.0	38.0	4	DIN 376
		3.819					*.787*	*1.063*	*6.299*	*1.496*		
M 30	3.50	115.00	22.00 x 18.00	C	6H	E263M30	22.0	30.00	180.0	45.0	4	DIN 376
		4.528					*.866*	*1.181*	*7.087*	*1.772*		
M 33	3.50	113.00	25.00 x 20.00	C	6H	E263M33	25.0	33.00	180.0	50.0	4	DIN 376
		4.449					*.984*	*1.299*	*7.087*	*1.969*		
M 36	4.00	131.00	28.00 x 22.00	C	6H	E263M36	28.0	36.00	200.0	55.0	4	DIN 376
		5.157					*1.102*	*1.417*	*7.874*	*2.165*		

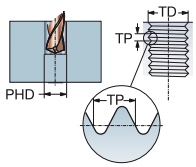
C166 C157 E9 C154

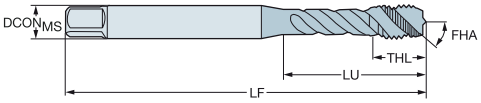
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 2.0
FHA 40°
SUBSTRATE HSS-E





P N

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6H	E195M3	3.5	3.00	56.0	5.9	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.232*		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E195M4	4.5	4.00	63.0	6.7	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.264*		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E195M5	6.0	5.00	70.0	7.7	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.303*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E195M6	6.0	6.00	80.0	10.0	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.394*		
M 8	1.25	35.00	8.00 x 6.20	C	6H	E195M8	8.0	8.00	90.0	11.6	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.457*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E195M10	10.0	10.00	100.0	15.1	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.594*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E245M12	9.0	12.00	110.0	16.0	3	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E245M14	11.0	14.00	110.0	20.0	3	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E245M16	12.0	16.00	110.0	20.0	3	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.787*		
M 18	2.50	81.00	14.00 x 11.00	C	6H	E245M18	14.0	18.00	125.0	25.0	4	DIN 376
		3.189					*.551*	*.709*	*4.921*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E245M20	16.0	20.00	140.0	25.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*.984*		
M 22	2.50	93.00	18.00 x 14.50	C	6H	E245M22	18.0	22.00	140.0	21.5	4	DIN 376
		3.661					*.709*	*.866*	*5.512*	*.846*		
M 24	3.00	113.00	18.00 x 14.50	C	6H	E245M24	18.0	24.00	160.0	25.5	4	DIN 376
		4.449					*.709*	*.945*	*6.299*	*1.004*		
M 30	3.50	115.00	22.00 x 18.00	C	6H	E245M30	22.0	30.00	180.0	31.0	4	DIN 376
		4.528					*.866*	*1.181*	*7.087*	*1.220*		

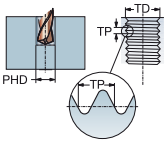
C166 C157 E9 C154

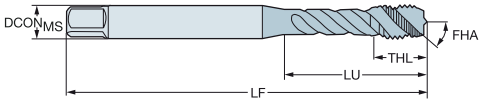
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 2	0.40	9.00	2.80 x 2.10	C	6H	T300-XM100DA-M2				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.8	2.00	45.0	4.0	3	1.6	DIN 371
		.354																																	.110	.079	1.772	.157		.063	
M 2.5	0.45	12.50	2.80 x 2.10	C	6H	T300-XM100DA-M2.5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.8	2.50	50.0	4.0	3	2.1	DIN 371
		.492																																	.110	.098	1.969	.157		.081	
M 3	0.50	18.00	3.50 x 2.70	C	6H	T300-XM100DA-M3				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.00	56.0	5.9	3	2.5	DIN 371
		.709																																	.138	.118	2.205	.232		.098	
M 3.5	0.60	20.00	4.00 x 3.00	C	6H	T300-XM100DA-M3.5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.0	3.50	56.0	6.3	3	2.9	DIN 371
		.787																																	.157	.138	2.205	.248		.114	
M 4	0.70	21.00	4.50 x 3.40	C	6H	T300-XM100DA-M4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.00	63.0	6.7	3	3.3	DIN 371
		.827																																	.177	.157	2.480	.264		.130	
M 5	0.80	21.00	6.00 x 4.90	C	6H	T300-XM100DA-M5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.00	70.0	7.7	3	4.2	DIN 371
		.827																																	.236	.197	2.756	.303		.165	
M 6	1.00	31.00	6.00 x 4.90	C	6H	T300-XM100DA-M6				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	6.00	80.0	10.0	3	5.0	DIN 371
		1.220																																	.236	.236	3.150	.394		.197	
M 7	1.00	31.00	7.00 x 5.50	C	6H	T300-XM100DA-M7				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	7.00	80.0	10.0	3	6.0	DIN 371
		1.220																																	.276	.276	3.150	.394		.236	
M 8	1.25	35.00	8.00 x 6.20	C	6H	T300-XM100DA-M8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	8.00	90.0	11.6	3	6.8	DIN 371
		1.378																																	.315	.315	3.543	.457		.268	
M 10	1.50	39.00	10.00 x 8.00	C	6H	T300-XM100DA-M10				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	10.00	100.0	15.1	3	8.5	DIN 371
		1.535																																	.394	.394	3.937	.594		.335	
M 6	1.00	59.00	4.50 x 3.40	C	6H	T300-XM101DA-M6				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	6.00	80.0	10.0	3	5.0	DIN 376
		2.323																																	.177	.236	3.150	.394		.197	
M 8	1.25	67.00	6.00 x 4.90	C	6H	T300-XM101DA-M8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	8.00	90.0	12.0	3	6.8	DIN 376
		2.638																																	.236	.315	3.543	.472		.268	
M 10	1.50	77.00	7.00 x 5.50	C	6H	T300-XM101DA-M10				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	100.0	15.0	3	8.5	DIN 376
		3.032																																	.276	.394	3.937	.591		.335	
M 12	1.75	83.00	9.00 x 7.00	C	6H	T300-XM101DA-M12				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	110.0	16.0	3	10.2	DIN 376
		3.268																																	.354	.472	4.331	.630		.402	
M 14	2.00	81.00	11.00 x 9.00	C	6H	T300-XM101DA-M14				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	110.0	20.0	3	12.0	DIN 376
		3.189																																	.433	.551	4.331	.787		.472	
M 16	2.00	68.00	12.00 x 9.00	C	6H	T300-XM101DA-M16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	110.0	20.0	4	14.0	DIN 376
		2.677																																	.472	.630	4.331	.787		.551	
M 18	2.50	81.00	14.00 x 11.00	C	6H	T300-XM101DA-M18	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	18.00	125.0	25.0	4	15.5	DIN 376
		3.189																																	.551	.709	4.921	.984		.610	
M 20	2.50	95.00	16.00 x 12.00	C	6H	T300-XM101DA-M20	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	140.0	25.0	4	17.5	DIN 376
		3.740																																	.630	.787	5.512	.984		.689	
M 22	2.50	93.00	18.00 x 14.50	C	6H	T300-XM101DA-M22	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.00	140.0	25.0	4	19.5	DIN 376
		3.661																																	.709	.866	5.512	.984		.768	
M 24	3.00	113.00	18.00 x 14.50	C	6H	T300-XM101DA-M24	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	24.00	160.0	30.0	4	21.0	DIN 376
		4.449																																	.709	.945	6.299	1.181		.827	
M 27	3.00	97.00	20.00 x 16.00	C	6H	T300-XM101DA-M27	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				20.0	27.00	160.0	30.0	4	24.0	DIN 376
		3.819																																	.787	1.063	6.299	1.181		.945	
M 30	3.50	115.00	22.00 x 18.00	C	6H	T300-XM101DA-M30	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				22.0	30.00	180.0	36.0	4	26.5	DIN 376
		4.528																																	.866	1.181	7.087	1.417		1.043	
M 33	3.50	113.00	25.00 x 20.00	C	6H	T300-XM101DA-M33	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				25.0	33.00	180.0	36.0	4	29.5	DIN 376
		4.449																																	.984	1.299	7.087	1.417		1.161	
M 36	4.00	131.00	28.00 x 22.00	C	6H	T300-XM101DA-M36	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				28.0	36.00	200.0	40.0	4	32.0	DIN 376
		5.157																																	1.102	1.417	7.874	1.575		1.260	
M 39	4.00	102.00	32.00 x 24.00	C	6H	T300-XM101DA-M39		★						★						★						★						★					32.0	39.00	200.0	40.0	4	35.0	DIN 376
		4.016																																	1.260	1.535	7.874	1.575		1.378	
M 42	4.50	102.00	32.00 x 24.00	C	6H	T300-XM101DA-M42		★	★					★	★					★	★					★	★					★	★				32.0	42.00	200.0	45.0	4	37.5	DIN 376
		4.016																																	1.260	1.654	7.874	1.772		1.476	
M 48	5.00	147.00	36.00 x 29.00	C	6H	T300-XM101DA-M48		★						★						★						★						★					36.0	48.00	250.0	50.0	4	43.0	DIN 376
		5.787																																	1.417	1.890	9.843	1.969		1.693	

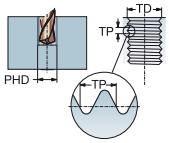
C166 C157 E9 E27 C154

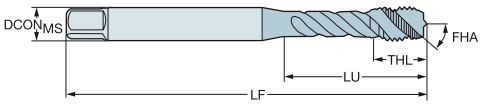
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P B110	P B145	P B150	P C110	P C145	P C150	M B110	M B145	M B150	M C110	M C145	M C150	K B110	K B145	K B150	K C110	K C145	K C150	N B110	N B145	N B150	N C110	N C145	N C150	S B110	S B145	S B150	S C110	S C145	S C150	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 52	5.00	120.00	40.00 x 32.00	C	6H	T300-XM101DA-M52		★	★					★	★					★	★					★	★					★	★				40.0	52.00	250.0	50.0	5	47.0	DIN 376
		4.724																																			*1.575*	*2.047*	*9.843*	*1.969*		*1.850*	
M 56	5.50	120.00	40.00 x 32.00	C	6H	T300-XM101DA-M56		★	★					★	★					★	★					★	★					★	★				40.0	56.00	250.0	55.0	5	50.5	DIN 376
		4.724																																			*1.575*	*2.205*	*9.843*	*2.165*		*1.988*	
M 64	6.00	178.00	50.00 x 39.00	C	6H	T300-XM101DA-M64		★						★						★						★						★					50.0	64.00	315.0	60.0	6	58.0	DIN 376
		7.008																																			*1.969*	*2.520*	*12.402*	*2.362*		*2.283*	
M 3	0.50	18.00	3.50 x 2.70	E	6H	T300-XM102DA-M3				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.00	56.0	5.9	3	2.5	DIN 371
		.709																																			*.138*	*.118*	*2.205*	*.232*		*.098*	
M 4	0.70	21.00	4.50 x 3.40	E	6H	T300-XM102DA-M4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.00	63.0	6.7	3	3.3	DIN 371
		.827																																			*.177*	*.157*	*2.480*	*.264*		*.130*	
M 5	0.80	21.00	6.00 x 4.90	E	6H	T300-XM102DA-M5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.00	70.0	7.7	3	4.2	DIN 371
		.827																																			*.236*	*.197*	*2.756*	*.303*		*.165*	
M 6	1.00	31.00	6.00 x 4.90	E	6H	T300-XM102DA-M6				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	6.00	80.0	10.0	3	5.0	DIN 371
		1.220																																			*.236*	*.236*	*3.150*	*.394*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	E	6H	T300-XM102DA-M8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	8.00	90.0	11.6	3	6.8	DIN 371
		1.378																																			*.315*	*.315*	*3.543*	*.457*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	E	6H	T300-XM102DA-M10				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	10.00	100.0	15.1	3	8.5	DIN 371
		1.535																																			*.394*	*.394*	*3.937*	*.594*		*.335*	
M 12	1.75	83.00	9.00 x 7.00	E	6H	T300-XM103DA-M12				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	110.0	16.0	3	10.2	DIN 376
		3.268																																			*.354*	*.472*	*4.331*	*.630*		*.402*	
M 14	2.00	81.00	11.00 x 9.00	E	6H	T300-XM103DA-M14				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	110.0	20.0	3	12.0	DIN 376
		3.189																																			*.433*	*.551*	*4.331*	*.787*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	E	6H	T300-XM103DA-M16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	110.0	20.0	4	14.0	DIN 376
		2.677																																			*.472*	*.630*	*4.331*	*.787*		*.551*	
M 20	2.50	95.00	16.00 x 12.00	E	6H	T300-XM103DA-M20	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	140.0	25.0	4	17.5	DIN 376
		3.740																																			*.630*	*.787*	*5.512*	*.984*		*.689*	
M 3	0.50	18.00	3.50 x 2.70	C	6G	T300-XM104DA-M3				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.00	56.0	5.9	3	2.5	DIN 371
		.709																																			*.138*	*.118*	*2.205*	*.232*		*.098*	
M 4	0.70	21.00	4.50 x 3.40	C	6G	T300-XM104DA-M4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.00	63.0	6.7	3	3.3	DIN 371
		.827																																			*.177*	*.157*	*2.480*	*.264*		*.130*	
M 5	0.80	25.00	6.00 x 4.90	C	6G	T300-XM104DA-M5				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.00	70.0	7.7	3	4.2	DIN 371
		.984																																			*.236*	*.197*	*2.756*	*.303*		*.165*	
M 6	1.00	31.00	6.00 x 4.90	C	6G	T300-XM104DA-M6				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	6.00	80.0	10.0	3	5.0	DIN 371
		1.220																																			*.236*	*.236*	*3.150*	*.394*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	C	6G	T300-XM104DA-M8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	8.00	90.0	12.0	3	6.8	DIN 371
		1.378																																			*.315*	*.315*	*3.543*	*.472*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	C	6G	T300-XM104DA-M10				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	10.00	100.0	15.1	3	8.5	DIN 371
		1.535																																			*.394*	*.394*	*3.937*	*.594*		*.335*	
M 12	1.75	83.00	9.00 x 7.00	C	6G	T300-XM105DA-M12				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	110.0	16.0	3	10.2	DIN 376
		3.268																																			*.354*	*.472*	*4.331*	*.630*		*.402*	
M 14	2.00	81.00	11.00 x 9.00	C	6G	T300-XM105DA-M14				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	110.0	20.0	3	12.0	DIN 376
		3.189																																			*.433*	*.551*	*4.331*	*.787*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	C	6G	T300-XM105DA-M16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	110.0	20.0	4	14.0	DIN 376
		2.677																																			*.472*	*.630*	*4.331*	*.787*		*.551*	
M 20	2.50	95.00	16.00 x 12.00	C	6G	T300-XM105DA-M20	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	140.0	25.0	4	17.5	DIN 376
		3.740																																			*.630*	*.787*	*5.512*	*.984*		*.689*	

C166 C157 E9 E27 C154

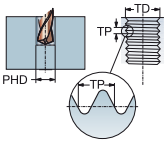
SANDVIK Coromant

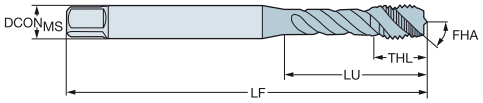
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371/ANSI, DIN 376/ANSI

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P C110	P C145	P C150	M C110	M C145	M C150	K C110	K C145	K C150	N C110	N C145	N C150	S C110	S C145	S C150	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 4	0.70	21.50	.194 x .152	C	6H	T300-XM100AA-M4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	4.00	63.0	8.4	3	3.3	DIN 371/ANSI
		.846																				.194	.157	2.480	.331		.130	
M 5	0.80	28.00	.194 x .152	C	6H	T300-XM100AA-M5	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	5.00	70.0	8.6	3	4.2	DIN 371/ANSI
		1.102																				.194	.197	2.756	.339		.165	
M 6	1.00	25.50	.255 x .191	C	6H	T300-XM100AA-M6	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.00	80.0	11.4	3	5.0	DIN 371/ANSI
		1.004																				.255	.236	3.150	.449		.197	
M 8	1.25	33.50	.318 x .238	C	6H	T300-XM100AA-M8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	8.00	90.0	12.9	3	6.8	DIN 371/ANSI
		1.319																				.318	.315	3.543	.508		.268	
M 10	1.50	38.50	.381 x .286	C	6H	T300-XM100AA-M10	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	10.00	100.0	16.1	3	8.5	DIN 371/ANSI
		1.516																				.381	.394	3.937	.634		.335	
M 12	1.75	81.82	.367 x .275	C	6H	T300-XM101AA-M12	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.00	110.0	18.0	3	10.2	DIN 376/ANSI
		3.221																				.367	.472	4.331	.709		.402	
M 14	2.00	80.30	.429 x .322	C	6H	T300-XM101AA-M14	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	10.9	14.00	110.0	20.1	3	12.0	DIN 376/ANSI
		3.161																				.429	.551	4.331	.791		.472	
M 16	2.00	65.78	.480 x .360	C	6H	T300-XM101AA-M16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	12.2	16.00	110.0	20.1	4	14.0	DIN 376/ANSI
		2.590																				.480	.630	4.331	.791		.551	
M 18	2.50	79.00	.542 x .406	C	6H	T300-XM101AA-M18	★		★	★		★	★		★	★		★	★		★	13.8	18.00	125.0	24.9	4	15.5	DIN 376/ANSI
		3.110																				.542	.709	4.921	.980		.610	
M 20	2.50	92.47	.652 x .489	C	6H	T300-XM101AA-M20	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	16.6	20.00	140.0	24.9	4	17.5	DIN 376/ANSI
		3.641																				.652	.787	5.512	.980		.689	
M 4	0.70	21.50	.168 x .131	E	6H	T300-XM102AA-M4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.3	4.00	63.0	8.4	3	3.3	DIN 371/ANSI
		.846																				.168	.157	2.480	.331		.130	
M 5	0.80	28.00	.194 x .152	E	6H	T300-XM102AA-M5	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	5.00	70.0	8.6	3	4.2	DIN 371/ANSI
		1.102																				.194	.197	2.756	.339		.165	
M 6	1.00	25.50	.255 x .191	E	6H	T300-XM102AA-M6	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.00	80.0	11.4	3	5.0	DIN 371/ANSI
		1.004																				.255	.236	3.150	.449		.197	
M 8	1.25	33.50	.318 x .238	E	6H	T300-XM102AA-M8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	8.00	90.0	12.9	3	6.8	DIN 371/ANSI
		1.319																				.318	.315	3.543	.508		.268	
M 10	1.50	38.50	.381 x .286	E	6H	T300-XM102AA-M10	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	10.00	100.0	16.1	3	8.5	DIN 371/ANSI
		1.516																				.381	.394	3.937	.634		.335	
M 12	1.75	81.82	.367 x .275	E	6H	T300-XM103AA-M12	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.00	110.0	18.0	3	10.2	DIN 376/ANSI
		3.221																				.367	.472	4.331	.709		.402	
M 14	2.00	80.30	.429 x .322	E	6H	T300-XM103AA-M14		★	★		★	★		★	★		★	★		★	★	10.9	14.00	110.0	20.1	3	12.0	DIN 376/ANSI
		3.161																				.429	.551	4.331	.791		.472	
M 16	2.00	65.78	.480 x .360	E	6H	T300-XM103AA-M16	★	★		★	★		★	★		★	★		★	★		12.2	16.00	110.0	20.1	4	14.0	DIN 376/ANSI
		2.590																				.480	.630	4.331	.791		.551	
M 18	2.50	79.00	.542 x .406	E	6H	T300-XM103AA-M18		★			★			★			★			★		13.8	18.00	125.0	24.9	4	15.5	DIN 376/ANSI
		3.110																				.542	.709	4.921	.980		.610	
M 20	2.50	92.47	.652 x .489	E	6H	T300-XM103AA-M20	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	16.6	20.00	140.0	24.9	4	17.5	DIN 376/ANSI
		3.641																				.652	.787	5.512	.980		.689	

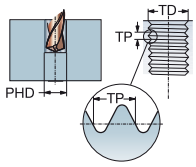
C166 C157 E9 E27 C154

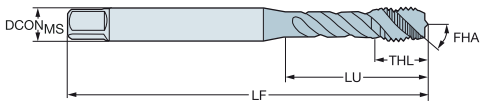
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 3.0
FHA 45°
SUBSTRATE HSS-E
COATING PVD TIALN





P M K N S

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6H	E615M3	3.5	3.00	112.0	6.0	3	DIN 371
		.709					*.138*	*.118*	*4.409*	*.236*		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E615M4	4.5	4.00	112.0	7.0	3	DIN 371
		.827					*.177*	*.157*	*4.409*	*.276*		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E615M5	6.0	5.00	125.0	8.0	3	DIN 371
		.984					*.236*	*.197*	*4.921*	*.315*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E615M6	6.0	6.00	125.0	10.0	3	DIN 371
		1.181					*.236*	*.236*	*4.921*	*.394*		
M 8	1.25	40.00	8.00 x 6.20	C	6H	E615M8	8.0	8.00	140.0	13.0	3	DIN 371
		1.575					*.315*	*.315*	*5.512*	*.512*		
M 10	1.50	50.00	10.00 x 8.00	C	6H	E615M10	10.0	10.00	160.0	15.0	3	DIN 371
		1.969					*.394*	*.394*	*6.299*	*.591*		
M 12	1.75	153.00	9.00 x 7.00	C	6H	E615M12	9.0	12.00	180.0	16.0	3	DIN 376
		6.024					*.354*	*.472*	*7.087*	*.630*		
M 14	2.00	151.00	11.00 x 9.00	C	6H	E615M14	11.0	14.00	180.0	20.0	3	DIN 376
		5.945					*.433*	*.551*	*7.087*	*.787*		
M 16	2.00	158.00	12.00 x 9.00	C	6H	E615M16	12.0	16.00	200.0	20.0	3	DIN 376
		6.220					*.472*	*.630*	*7.874*	*.787*		
M 20	2.50	179.00	16.00 x 12.00	C	6H	E615M20	16.0	20.00	224.0	25.0	4	DIN 376
		7.047					*.630*	*.787*	*8.819*	*.984*		

C166 C157 E9 C154

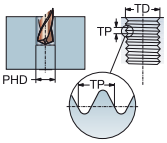
SANDVIK Coromant

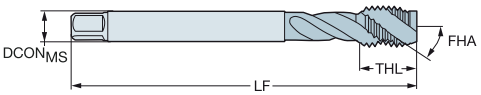
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





							P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150							
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code																															$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 4x0.5	0.50	43.00	2.80 x 2.10	C	6H	T300-XM100DB-M4X050				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	2.8	4.00	63.0	6.8	3	3.5	DIN 374
		1.693																																			*.110*	*.157*	*2.480*	*.268*		*.138*	
MF 5x0.5	0.50	49.00	3.50 x 2.70	C	6H	T300-XM100DB-M5X050				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	5.00	70.0	8.2	3	4.5	DIN 374
		1.929																																			*.138*	*.197*	*2.756*	*.323*		*.177*	
MF 6x0.75	0.75	59.00	4.50 x 3.40	C	6H	T300-XM100DB-M6X075				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	6.00	80.0	10.0	3	5.3	DIN 374
		2.323																																			*.177*	*.236*	*3.150*	*.394*		*.209*	
MF 8x0.75	0.75	57.00	6.00 x 4.90	C	6H	T300-XM100DB-M8X075				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	8.00	80.0	13.0	3	7.3	DIN 374
		2.244																																			*.236*	*.315*	*3.150*	*.512*		*.287*	
MF 8x1	1.00	67.00	6.00 x 4.90	C	6H	T300-XM100DB-M8X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	8.00	90.0	13.0	3	7.0	DIN 374
		2.638																																			*.236*	*.315*	*3.543*	*.512*		*.276*	
MF 10x0.75	0.75	67.00	7.00 x 5.50	C	6H	T300-XM100DB-M10X075				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	90.0	13.0	3	9.3	DIN 374
		2.638																																			*.276*	*.394*	*3.543*	*.512*		*.366*	
MF 10x1	1.00	67.00	7.00 x 5.50	C	6H	T300-XM100DB-M10X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	90.0	13.0	3	9.0	DIN 374
		2.638																																			*.276*	*.394*	*3.543*	*.512*		*.354*	
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6H	T300-XM100DB-M10X125				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	10.00	100.0	15.0	3	8.8	DIN 374
		3.032																																			*.276*	*.394*	*3.937*	*.591*		*.346*	
MF 12x1	1.00	73.00	9.00 x 7.00	C	6H	T300-XM100DB-M12X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	100.0	15.0	3	11.0	DIN 374
		2.874																																			*.354*	*.472*	*3.937*	*.591*		*.433*	
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6H	T300-XM100DB-M12X125				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	100.0	15.0	3	10.8	DIN 374
		2.874																																			*.354*	*.472*	*3.937*	*.591*		*.425*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6H	T300-XM100DB-M12X150				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.00	100.0	15.0	3	10.5	DIN 374
		2.874																																			*.354*	*.472*	*3.937*	*.591*		*.413*	
MF 14x1	1.00	71.00	11.00 x 9.00	C	6H	T300-XM100DB-M14X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	100.0	15.0	3	13.0	DIN 374
		2.795																																			*.433*	*.551*	*3.937*	*.591*		*.512*	
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6H	T300-XM100DB-M14X125				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	100.0	15.0	3	12.8	DIN 374
		2.795																																			*.433*	*.551*	*3.937*	*.591*		*.504*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6H	T300-XM100DB-M14X150				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	14.00	100.0	15.0	3	12.5	DIN 374
		2.795																																			*.433*	*.551*	*3.937*	*.591*		*.492*	
MF 16x1	1.00	58.00	12.00 x 9.00	C	6H	T300-XM100DB-M16X100				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	100.0	15.0	4	15.0	DIN 374
		2.283																																			*.472*	*.630*	*3.937*	*.591*		*.591*	
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6H	T300-XM100DB-M16X150				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.00	100.0	15.0	4	14.5	DIN 374
		2.283																																			*.472*	*.630*	*3.937*	*.591*		*.571*	
MF 18x1	1.00	66.00	14.00 x 11.00	C	6H	T300-XM100DB-M18X100	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	18.00	110.0	17.0	4	17.0	DIN 374
		2.598																																			*.551*	*.709*	*4.331*	*.669*		*.669*	
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6H	T300-XM100DB-M18X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	18.00	110.0	17.0	4	16.5	DIN 374
		2.598																																			*.551*	*.709*	*4.331*	*.669*		*.650*	
MF 20x1	1.00	80.00	16.00 x 12.00	C	6H	T300-XM100DB-M20X100	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	125.0	17.0	4	19.0	DIN 374
		3.150																																			*.630*	*.787*	*4.921*	*.669*		*.748*	
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6H	T300-XM100DB-M20X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.00	125.0	17.0	4	18.5	DIN 374
		3.150																																			*.630*	*.787*	*4.921*	*.669*		*.728*	
MF 22x1.5	1.50	78.00	18.00 x 14.50	C	6H	T300-XM100DB-M22X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.00	125.0	17.0	4	20.5	DIN 374
		3.071																																			*.709*	*.866*	*4.921*	*.669*		*.807*	
MF 24x1.5	1.50	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M24X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	24.00	140.0	20.0	4	22.5	DIN 374
		3.661																																			*.709*	*.945*	*5.512*	*.787*		*.886*	
MF 24x2	2.00	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M24X200	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	24.00	140.0	20.0	4	22.0	DIN 374
		3.661																																			*.709*	*.945*	*5.512*	*.787*		*.866*	
MF 25x1.5	1.50	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M25X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	25.00	140.0	20.0	4	23.5	DIN 374
		3.661																																			*.709*	*.984*	*5.512*	*.787*		*.925*	
MF 26x1.5	1.50	93.00	18.00 x 14.50	C	6H	T300-XM100DB-M26X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	26.00	140.0	20.0	4	24.5	DIN 374
		3.661																																			*.709*	*1.024*	*5.512*	*.787*		*.965*	
MF 27x1.5	1.50	77.00	20.00 x 16.00	C	6H	T300-XM100DB-M27X150	★	★					★	★					★	★					★	★					★	★					20.0	27.00	140.0	20.0	4	25.5	DIN 374
		3.032																																			*.787*	*1.063*	*5.512*	*.787*		*1.004*	
MF 27x2	2.00	77.00	20.00 x 16.00	C	6H	T300-XM100DB-M27X200	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				20.0	27.00	140.0	20.0	4	25.0	DIN 374
		3.032																																			*.787*	*1.063*	*5.512*	*.787*		*.984*	

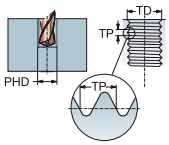
C166 C157 E9 E27 C154

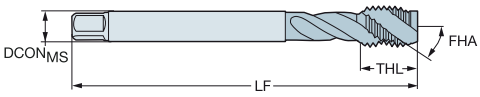
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P B110	P B145	P B150	P C110	P C145	P C150	M B110	M B145	M B150	M C110	M C145	M C150	K B110	K B145	K B150	K C110	K C145	K C150	N B110	N B145	N B150	N C110	N C145	N C150	S B110	S B145	S B150	S C110	S C145	S C150	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 28x1.5	1.50	77.00	20.00 x 16.00	C	6H	T300-XM100DB-M28X150		★						★						★						★						★					20.0	28.00	140.0	20.0	4	26.5	DIN 374
		3.032																																	*.787*	*1.102*	*5.512*	*.787*		*1.043*	
MF 30x1.5	1.50	85.00	22.00 x 18.00	C	6H	T300-XM100DB-M30X150	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				22.0	30.00	150.0	20.0	4	28.5	DIN 374
		3.346																																	*.866*	*1.181*	*5.906*	*.787*		*1.122*	
MF 30x2	2.00	85.00	22.00 x 18.00	C	6H	T300-XM100DB-M30X200	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				22.0	30.00	150.0	20.0	4	28.0	DIN 374
		3.346																																	*.866*	*1.181*	*5.906*	*.787*		*1.102*	

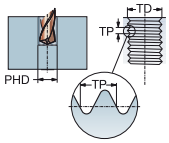
C166 C157 E9 E27 C154

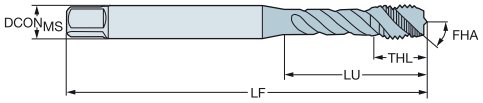
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374/ANSI

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P			M			K			N			S			Dimensions, mm, inch						
							C110	C145	C150	C110	C145	C150	C110	C145	C150	C110	C145	C150	C110	C145	C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 8x1	1.00	33.50	.318 x .238	C	6H	T300-XM100AB-M8X100	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	8.00	90.0	12.8	3	7.0	DIN 374/ANSI
		1.319																				*.318*	*.315*	*3.543*	*.504*		*.276*	
MF 10x1	1.00	37.50	.381 x .286	C	6H	T300-XM100AB-M10X100	★	★		★	★		★	★		★	★		★	★		9.7	10.00	90.0	13.0	3	9.0	DIN 374/ANSI
		1.476																				*.381*	*.394*	*3.543*	*.512*		*.354*	
MF 14x1.5	1.50	70.30	.429 x .322	C	6H	T300-XM101AB-M14X150	★			★			★			★			★			10.9	14.00	100.0	15.0	3	12.5	DIN 374/ANSI
		2.768																				*.429*	*.551*	*3.937*	*.591*		*.492*	
MF 18x1.5	1.50	64.00	.542 x .406	C	6H	T300-XM101AB-M18X150	★		★	★		★	★		★	★		★	★		★	13.8	18.00	110.0	17.0	4	16.5	DIN 374/ANSI
		2.520																				*.542*	*.709*	*4.331*	*.669*		*.650*	
MF 8x1	1.00	33.50	.318 x .238	E	6H	T300-XM102AB-M8X100	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	8.00	90.0	12.8	3	7.0	DIN 374/ANSI
		1.319																				*.318*	*.315*	*3.543*	*.504*		*.276*	
MF 10x1	1.00	37.50	.381 x .286	E	6H	T300-XM102AB-M10X100	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	10.00	90.0	13.0	3	9.0	DIN 374/ANSI
		1.476																				*.381*	*.394*	*3.543*	*.512*		*.354*	
MF 14x1.5	1.50	70.30	.429 x .322	E	6H	T300-XM103AB-M14X150	★	★		★	★		★	★		★	★		★	★		10.9	14.00	100.0	15.0	3	12.5	DIN 374/ANSI
		2.768																				*.429*	*.551*	*3.937*	*.591*		*.492*	
MF 18x1.5	1.50	64.00	.542 x .406	E	6H	T300-XM103AB-M18X150	★		★	★		★	★		★	★		★	★		★	13.8	18.00	110.0	17.0	4	16.5	DIN 374/ANSI
		2.520																				*.542*	*.709*	*4.331*	*.669*		*.650*	

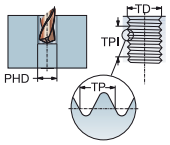
C166 C157 E9 E27 C154

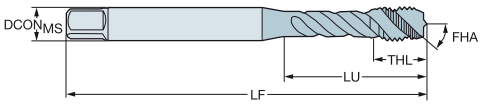
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN 2184-1

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	18.00	3.50 x 2.70	C	2B	T300-XM100DE-4-40				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	2.84	56.0	5.6	3	2.4	DIN 2184-1
		.709																																	*.138*	*.112*	*2.205*	*.220*		*.093*	
UNC #5-40	40.00	18.00	3.50 x 2.70	C	2B	T300-XM100DE-5-40				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	3.5	3.18	56.0	5.6	3	2.7	DIN 2184-1
		.709																																	*.138*	*.125*	*2.205*	*.220*		*.104*	
UNC #6-32	32.00	20.00	4.00 x 3.00	C	2B	T300-XM100DE-6-32				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.0	3.51	56.0	6.5	3	2.9	DIN 2184-1
		.787																																	*.157*	*.138*	*2.205*	*.256*		*.112*	
UNC #8-32	32.00	21.00	4.50 x 3.40	C	2B	T300-XM100DE-8-32				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.17	63.0	6.5	3	3.5	DIN 2184-1
		.827																																	*.177*	*.164*	*2.480*	*.256*		*.138*	
UNC #10-24	24.00	25.00	6.00 x 4.90	C	2B	T300-XM100DE-10-24				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	4.83	70.0	8.0	3	3.9	DIN 2184-1
		.984																																	*.236*	*.190*	*2.756*	*.315*		*.154*	
UNC #12-24	24.00	30.00	6.00 x 4.90	C	2B	T300-XM100DE-12-24				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	5.49	80.0	10.0	3	4.5	DIN 2184-1
		1.181																																	*.236*	*.216*	*3.150*	*.394*		*.177*	
UNC 1/4-20	20.00	30.00	7.00 x 5.50	C	2B	T300-XM100DE-1/4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	6.35	80.0	10.0	3	5.1	DIN 2184-1
		1.181																																	*.276*	*.250*	*3.150*	*.394*		*.201*	
UNC 5/16-18	18.00	35.00	8.00 x 6.20	C	2B	T300-XM100DE-5/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	7.94	90.0	12.0	3	6.6	DIN 2184-1
		1.378																																	*.315*	*.313*	*3.543*	*.472*		*.260*	
UNC 3/8-16	16.00	39.00	10.00 x 8.00	C	2B	T300-XM100DE-3/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	9.53	100.0	15.0	3	8.0	DIN 2184-1
		1.535																																	*.394*	*.375*	*3.937*	*.591*		*.315*	
UNC 7/16-14	14.00	75.75	8.00 x 6.20	C	2B	T300-XM101DE-7/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	11.11	100.0	15.0	3	9.4	DIN 2184-1
		2.982																																	*.315*	*.438*	*3.937*	*.591*		*.370*	
UNC 1/2-13	13.00	82.75	9.00 x 7.00	C	2B	T300-XM101DE-1/2				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.70	110.0	18.0	3	10.8	DIN 2184-1
		3.258																																	*.354*	*.500*	*4.331*	*.709*		*.425*	
UNC 5/8-11	11.00	67.75	12.00 x 9.00	C	2B	T300-XM101DE-5/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	15.88	110.0	20.0	4	13.5	DIN 2184-1
		2.667																																	*.472*	*.625*	*4.331*	*.787*		*.531*	
UNC 3/4-10	10.00	80.75	14.00 x 11.00	C	2B	T300-XM101DE-3/4	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	19.05	125.0	25.0	4	16.5	DIN 2184-1
		3.179																																	*.551*	*.750*	*4.921*	*.984*		*.650*	
UNC 7/8-9	9.00	92.75	18.00 x 14.50	C	2B	T300-XM101DE-7/8	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.23	140.0	25.0	4	19.5	DIN 2184-1
		3.652																																	*.709*	*.875*	*5.512*	*.984*		*.768*	
UNC 1"-8	8.00	112.75	18.00 x 14.50	C	2B	T300-XM101DE-1	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	25.40	160.0	30.0	4	22.3	DIN 2184-1
		4.439																																	*.709*	*1.000*	*6.299*	*1.181*		*.876*	

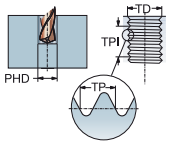
C166 C157 E9 E27 C154

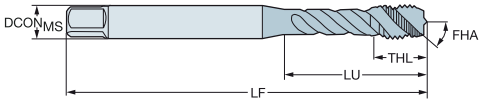
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN 2184-1/ANSI

ULDR 2.5
FHA 48°
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P C110	P C145	P C150	M C110	M C145	M C150	K C110	K C145	K C150	N C110	N C145	N C150	S C110	S C145	S C150	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC #2-56	56.00	11.99	.141 x .110	C	3BX	T300-XM100AE-2-56	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.18	45.0	4.0	3	1.9	DIN 2184-1/ANSI
		.472																				.141	.086	1.772	.157		.073	
UNC #4-40	40.00	17.50	.141 x .110	C	3BX	T300-XM100AE-4-40	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.84	56.0	7.1	3	2.4	DIN 2184-1/ANSI
		.689																				.141	.112	2.205	.280		.093	
UNC #5-40	40.00	17.50	.141 x .110	C	3BX	T300-XM100AE-5-40	★		★	★		★	★		★	★		★	★		★	3.6	3.18	56.0	6.6	3	2.7	DIN 2184-1/ANSI
		.689																				.141	.125	2.205	.260		.104	
UNC #6-32	32.00	20.50	.141 x .110	C	3BX	T300-XM100AE-6-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	3.51	56.0	7.2	3	2.9	DIN 2184-1/ANSI
		.807																				.141	.138	2.205	.283		.112	
UNC #8-32	32.00	21.50	.168 x .131	C	3BX	T300-XM100AE-8-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.3	4.17	63.0	7.7	3	3.5	DIN 2184-1/ANSI
		.846																				.168	.164	2.480	.303		.138	
UNC #10-24	24.00	28.00	.194 x .152	C	3BX	T300-XM100AE-10-24	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	4.83	70.0	9.1	3	3.9	DIN 2184-1/ANSI
		1.102																				.194	.190	2.756	.358		.154	
UNC #12-24	24.00	25.50	.220 x .165	C	3BX	T300-XM100AE-12-24	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	5.6	5.49	80.0	9.9	3	4.5	DIN 2184-1/ANSI
		1.004																				.220	.216	3.150	.390		.177	
UNC 1/4-20	20.00	25.00	.255 x .191	C	3BX	T300-XM100AE-1/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.35	80.0	11.0	3	5.1	DIN 2184-1/ANSI
		.984																				.255	.250	3.150	.433		.201	
UNC 5/16-18	18.00	34.00	.318 x .238	C	3BX	T300-XM100AE-5/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	7.94	90.0	13.1	3	6.6	DIN 2184-1/ANSI
		1.339																				.318	.313	3.543	.516		.260	
UNC 3/8-16	16.00	39.00	.381 x .286	C	3BX	T300-XM100AE-3/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	9.53	100.0	16.8	3	8.0	DIN 2184-1/ANSI
		1.535																				.381	.375	3.937	.661		.315	
UNC 7/16-14	14.00	72.59	.323 x .242	C	3BX	T300-XM101AE-7/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.2	11.11	100.0	15.0	3	9.4	DIN 2184-1/ANSI
		2.858																				.323	.438	3.937	.591		.370	
UNC 1/2-13	13.00	81.82	.367 x .275	C	3BX	T300-XM101AE-1/2	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.70	110.0	18.0	3	10.8	DIN 2184-1/ANSI
		3.221																				.367	.500	4.331	.709		.425	
UNC 9/16-12	12.00	80.30	.429 x .322	C	3BX	T300-XM101AE-9/16	★	★		★	★		★	★		★	★		★	★		10.9	14.29	110.0	20.1	3	12.2	DIN 2184-1/ANSI
		3.161																				.429	.563	4.331	.791		.480	
UNC 5/8-11	11.00	65.78	.480 x .360	C	3BX	T300-XM101AE-5/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	12.2	15.88	110.0	20.1	4	13.5	DIN 2184-1/ANSI
		2.590																				.480	.625	4.331	.791		.531	
UNC 3/4-10	10.00	77.47	.590 x .442	C	3BX	T300-XM101AE-3/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	15.0	19.05	125.0	24.9	4	16.5	DIN 2184-1/ANSI
		3.050																				.590	.750	4.921	.980		.650	
UNC 7/8-9	9.00	90.95	.697 x .523	C	3BX	T300-XM101AE-7/8	★	★		★	★		★	★		★	★		★	★		17.7	22.23	140.0	24.9	4	19.5	DIN 2184-1/ANSI
		3.581																				.697	.875	5.512	.980		.768	
UNC 1"-8	8.00	95.43	.800 x .600	C	3BX	T300-XM101AE-1	★	★		★	★		★	★		★	★		★	★		20.3	25.40	160.0	30.0	4	22.3	DIN 2184-1/ANSI
		3.757																				.800	1.000	6.299	1.181		.876	
UNC #2-56	56.00	15.00	.141 x .110	E	3BX	T300-XM102AE-2-56	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.18	45.0	4.0	3	1.9	DIN 2184-1/ANSI
		.591																				.141	.086	1.772	.157		.073	
UNC #4-40	40.00	17.50	.141 x .110	E	3BX	T300-XM102AE-4-40	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.84	56.0	7.1	3	2.4	DIN 2184-1/ANSI
		.689																				.141	.112	2.205	.280		.093	
UNC #5-40	40.00	17.50	.141 x .110	E	3BX	T300-XM102AE-5-40	★	★		★	★		★	★		★	★		★	★		3.6	3.18	56.0	6.6	3	2.7	DIN 2184-1/ANSI
		.689																				.141	.125	2.205	.260		.104	
UNC #6-32	32.00	20.50	.141 x .110	E	3BX	T300-XM102AE-6-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	3.51	56.0	7.2	3	2.9	DIN 2184-1/ANSI
		.807																				.141	.138	2.205	.283		.112	
UNC #8-32	32.00	21.50	.168 x .131	E	3BX	T300-XM102AE-8-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.3	4.17	63.0	7.7	3	3.5	DIN 2184-1/ANSI
		.846																				.168	.164	2.480	.303		.138	
UNC #10-24	24.00	28.00	.194 x .152	E	3BX	T300-XM102AE-10-24	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	4.83	70.0	9.1	3	3.9	DIN 2184-1/ANSI
		1.102																				.194	.190	2.756	.358		.154	
UNC #12-24	24.00	24.80	.255 x .191	E	3BX	T300-XM102AE-12-24		★	★		★	★		★	★		★	★		★	★	6.5	5.49	80.0	9.9	3	4.5	DIN 2184-1/ANSI
		.976																				.255	.216	3.150	.390		.177	
UNC 1/4-20	20.00	25.00	.255 x .191	E	3BX	T300-XM102AE-1/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.35	80.0	11.0	3	5.1	DIN 2184-1/ANSI
		.984																				.255	.250	3.150	.433		.201	
UNC 5/16-18	18.00	34.00	.318 x .238	E	3BX	T300-XM102AE-5/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	7.94	90.0	13.1	3	6.6	DIN 2184-1/ANSI
		1.339																				.318	.313	3.543	.516		.260	
UNC 3/8-16	16.00	39.00	.381 x .286	E	3BX	T300-XM102AE-3/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	9.53	100.0	16.8	3	8.0	DIN 2184-1/ANSI
		1.535																				.381	.375	3.937	.661		.315	

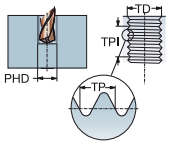
C166 C157 E9 E27 C154

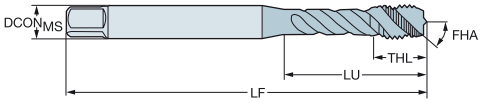
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN 2184-1/ANSI

ULDR 2.5
FHA 48°
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P C1:10	P C1:45	P C1:50	M C1:10	M C1:45	M C1:50	K C1:10	K C1:45	K C1:50	N C1:10	N C1:45	N C1:50	S C1:10	S C1:45	S C1:50	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC 7/16-14	14.00	72.59	.323 x .242	E	3BX	T300-XM103AE-7/16	★			★			★			★			★			8.2	11.11	100.0	15.0	3	9.4	DIN 2184-1/ANSI
		2.858																				*.323*	*.438*	*3.937*	*.591*		*.370*	
UNC 1/2-13	13.00	81.82	.367 x .275	E	3BX	T300-XM103AE-1/2	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.70	110.0	18.0	3	10.8	DIN 2184-1/ANSI
		3.221																				*.367*	*.500*	*4.331*	*.709*		*.425*	
UNC 9/16-12	12.00	80.30	.429 x .322	E	3BX	T300-XM103AE-9/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	10.9	14.29	110.0	20.1	3	12.2	DIN 2184-1/ANSI
		3.161																				*.429*	*.563*	*4.331*	*.791*		*.480*	
UNC 5/8-11	11.00	65.78	.480 x .360	E	3BX	T300-XM103AE-5/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	12.2	15.88	110.0	20.1	4	13.5	DIN 2184-1/ANSI
		2.590																				*.480*	*.625*	*4.331*	*.791*		*.531*	
UNC 3/4-10	10.00	77.47	.590 x .442	E	3BX	T300-XM103AE-3/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	15.0	19.05	125.0	24.9	4	16.5	DIN 2184-1/ANSI
		3.050																				*.590*	*.750*	*4.921*	*.980*		*.650*	
UNC 7/8-9	9.00	90.95	.697 x .523	E	3BX	T300-XM103AE-7/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	17.7	22.23	140.0	24.9	4	19.5	DIN 2184-1/ANSI
		3.581																				*.697*	*.875*	*5.512*	*.980*		*.768*	
UNC 1"-8	8.00	95.43	.800 x .600	E	3BX	T300-XM103AE-1	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	20.3	25.40	160.0	30.0	4	22.3	DIN 2184-1/ANSI
		3.757																				*.800*	*1.000*	*6.299*	*1.181*		*.876*	

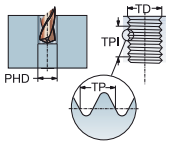
C166 C157 E9 E27 C154

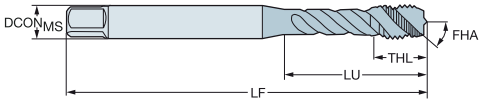
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

DIN 2184-1

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF #8-36	36.00	21.00	4.50 x 3.40	C	2B	T300-XM100DF-8-36				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	4.5	4.17	63.0	6.5	3	3.5	DIN 2184-1
		.827																																			*.177*	*.164*	*2.480*	*.256*		*.138*	
UNF #10-32	32.00	25.00	6.00 x 4.90	C	2B	T300-XM100DF-10-32				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	6.0	4.83	70.0	7.3	3	4.1	DIN 2184-1
		.984																																			*.236*	*.190*	*2.756*	*.287*		*.161*	
UNF 1/4-28	28.00	30.00	7.00 x 5.50	C	2B	T300-XM100DF-1/4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	6.35	80.0	10.0	3	5.5	DIN 2184-1
		1.181																																			*.276*	*.250*	*3.150*	*.394*		*.217*	
UNF 5/16-24	24.00	35.00	8.00 x 6.20	C	2B	T300-XM100DF-5/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	7.94	90.0	12.0	3	6.9	DIN 2184-1
		1.378																																			*.315*	*.313*	*3.543*	*.472*		*.272*	
UNF 3/8-24	24.00	39.00	10.00 x 8.00	C	2B	T300-XM100DF-3/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	10.0	9.53	100.0	15.0	3	8.5	DIN 2184-1
		1.535																																			*.394*	*.375*	*3.937*	*.591*		*.335*	
UNF 7/16-20	20.00	75.75	8.00 x 6.20	C	2B	T300-XM101DF-7/16				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	8.0	11.11	100.0	15.0	3	9.9	DIN 2184-1
		2.982																																			*.315*	*.438*	*3.937*	*.591*		*.390*	
UNF 1/2-20	20.00	83.00	9.00 x 7.00	C	2B	T300-XM101DF-1/2				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	9.0	12.70	110.0	18.0	3	11.5	DIN 2184-1
		3.268																																			*.354*	*.500*	*4.331*	*.709*		*.453*	
UNF 5/8-18	18.00	67.75	12.00 x 9.00	C	2B	T300-XM101DF-5/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	15.88	110.0	20.0	4	14.5	DIN 2184-1
		2.667																																			*.472*	*.625*	*4.331*	*.787*		*.571*	
UNF 3/4-16	16.00	77.50	14.00 x 11.00	C	2B	T300-XM101DF-3/4	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				14.0	19.05	125.0	25.0	4	17.5	DIN 2184-1
		3.051																																			*.551*	*.750*	*4.921*	*.984*		*.689*	
UNF 7/8-14	14.00	92.75	18.00 x 14.50	C	2B	T300-XM101DF-7/8	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				18.0	22.23	140.0	25.0	4	20.4	DIN 2184-1
		3.652																																			*.709*	*.875*	*5.512*	*.984*		*.803*	
UNF 1"-12	12.00	113.00	18.00 x 14.50	C	2B	T300-XM101DF-1	★	★					★	★					★	★					★	★					★	★					18.0	25.40	160.0	30.0	4	23.3	DIN 2184-1
		4.449																																			*.709*	*1.000*	*6.299*	*1.181*		*.915*	

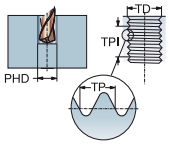
C166 C157 E9 E27 C154

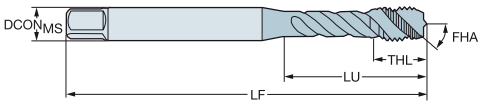
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

DIN 2184-1/ANSI

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P C110	P C145	P C150	M C110	M C145	M C150	K C110	K C145	K C150	N C110	N C145	N C150	S C110	S C145	S C150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF #4-48	48.00	17.50	.141 x .110	C	3BX	T300-XM100AF-4-48	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	3.6	2.84	56.0	7.1	3	2.4	DIN 2184-1/ANSI
		.689																				*.141*	*.112*	*2.205*	*.280*		*.094*	
UNF #6-40	40.00	20.50	.141 x .110	C	3BX	T300-XM100AF-6-40	★			★			★			★			★			3.6	3.51	56.0	7.1	3	3.0	DIN 2184-1/ANSI
		.807																				*.141*	*.138*	*2.205*	*.280*		*.116*	
UNF #8-36	36.00	21.50	.168 x .131	C	3BX	T300-XM100AF-8-36	★			★			★			★			★			4.3	4.17	63.0	7.7	3	3.5	DIN 2184-1/ANSI
		.846																				*.168*	*.164*	*2.480*	*.303*		*.138*	
UNF #10-32	32.00	28.00	.194 x .152	C	3BX	T300-XM100AF-10-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	4.83	70.0	8.9	3	4.1	DIN 2184-1/ANSI
		1.102																				*.194*	*.190*	*2.756*	*.350*		*.161*	
UNF #12-28	28.00	31.00	.220 x .165	C	3BX	T300-XM100AF-12-28	★	★		★	★		★	★		★	★		★	★		5.6	5.49	80.0	9.9	3	4.6	DIN 2184-1/ANSI
		1.220																				*.220*	*.216*	*3.150*	*.390*		*.181*	
UNF 1/4-28	28.00	25.00	.255 x .191	C	3BX	T300-XM100AF-1/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.35	80.0	10.8	3	5.5	DIN 2184-1/ANSI
		.984																				*.255*	*.250*	*3.150*	*.425*		*.217*	
UNF 5/16-24	24.00	34.00	.318 x .238	C	3BX	T300-XM100AF-5/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.1	7.94	90.0	12.9	3	6.9	DIN 2184-1/ANSI
		1.339																				*.318*	*.313*	*3.543*	*.508*		*.272*	
UNF 3/8-24	24.00	37.50	.381 x .286	C	3BX	T300-XM100AF-3/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	9.53	90.0	15.0	3	8.5	DIN 2184-1/ANSI
		1.476																				*.381*	*.375*	*3.543*	*.591*		*.335*	
UNF 7/16-20	20.00	72.59	.367 x .275	C	3BX	T300-XM101AF-7/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	11.11	100.0	15.0	3	9.9	DIN 2184-1/ANSI
		2.858																				*.367*	*.438*	*3.937*	*.591*		*.390*	
UNF 1/2-20	20.00	71.82	.367 x .275	C	3BX	T300-XM101AF-1/2	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.70	100.0	18.0	3	11.5	DIN 2184-1/ANSI
		2.828																				*.367*	*.500*	*3.937*	*.709*		*.453*	
UNF 9/16-18	18.00	70.30	.429 x .322	C	3BX	T300-XM101AF-9/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	10.9	14.29	100.0	19.1	3	12.9	DIN 2184-1/ANSI
		2.768																				*.429*	*.563*	*3.937*	*.752*		*.508*	
UNF 5/8-18	18.00	55.78	.480 x .360	C	3BX	T300-XM101AF-5/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	12.2	15.88	100.0	20.1	4	14.5	DIN 2184-1/ANSI
		2.196																				*.480*	*.625*	*3.937*	*.791*		*.571*	
UNF 3/4-16	16.00	62.47	.590 x .442	C	3BX	T300-XM101AF-3/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	15.0	19.05	110.0	24.9	4	17.5	DIN 2184-1/ANSI
		2.459																				*.590*	*.750*	*4.331*	*.980*		*.689*	
UNF 7/8-14	14.00	75.95	.697 x .523	C	3BX	T300-XM101AF-7/8	★		★	★		★	★		★	★		★	★		★	17.7	22.23	125.0	24.9	4	20.4	DIN 2184-1/ANSI
		2.990																				*.697*	*.875*	*4.921*	*.980*		*.803*	
UNF 1"-12	12.00	75.43	.800 x .600	C	3BX	T300-XM101AF-1-12			★			★			★			★			★	20.3	25.40	140.0	26.9	4	23.3	DIN 2184-1/ANSI
		2.970																				*.800*	*1.000*	*5.512*	*1.059*		*.915*	
UNF #4-48	48.00	17.50	.141 x .110	E	3BX	T300-XM102AF-4-48		★	★		★	★		★	★		★	★		★	★	3.6	2.84	56.0	7.1	3	2.4	DIN 2184-1/ANSI
		.689																				*.141*	*.112*	*2.205*	*.280*		*.094*	
UNF #6-40	40.00	20.50	.141 x .110	E	3BX	T300-XM102AF-6-40	★		★	★		★	★		★	★		★	★		★	3.6	3.51	56.0	7.1	3	3.0	DIN 2184-1/ANSI
		.807																				*.141*	*.138*	*2.205*	*.280*		*.116*	
UNF #8-36	36.00	21.50	.168 x .131	E	3BX	T300-XM102AF-8-36	★		★	★		★	★		★	★		★	★		★	4.3	4.17	63.0	7.7	3	3.5	DIN 2184-1/ANSI
		.846																				*.168*	*.164*	*2.480*	*.303*		*.138*	
UNF #10-32	32.00	28.00	.194 x .152	E	3BX	T300-XM102AF-10-32	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	4.9	4.83	70.0	8.9	3	4.1	DIN 2184-1/ANSI
		1.102																				*.194*	*.190*	*2.756*	*.350*		*.161*	
UNF #12-28	28.00	31.00	.220 x .165	E	3BX	T300-XM102AF-12-28	★	★		★	★		★	★		★	★		★	★		5.6	5.49	80.0	9.9	3	4.6	DIN 2184-1/ANSI
		1.220																				*.220*	*.216*	*3.150*	*.390*		*.181*	
UNF 1/4-28	28.00	25.00	.255 x .191	E	3BX	T300-XM102AF-1/4	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	6.5	6.35	80.0	10.8	3	5.5	DIN 2184-1/ANSI
		.984																				*.255*	*.250*	*3.150*	*.425*		*.217*	
UNF 5/16-24	24.00	34.00	.318 x .238	E	3BX	T300-XM102AF-5/16	★			★			★			★			★			8.1	7.94	90.0	12.9	3	6.9	DIN 2184-1/ANSI
		1.339																				*.318*	*.313*	*3.543*	*.508*		*.272*	
UNF 3/8-24	24.00	37.50	.381 x .286	E	3BX	T300-XM102AF-3/8	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.7	9.53	90.0	15.0	3	8.5	DIN 2184-1/ANSI
		1.476																				*.381*	*.375*	*3.543*	*.591*		*.335*	

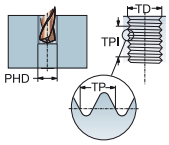
C166 C157 E9 E27 C154

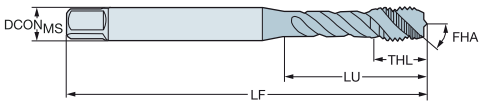
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

DIN 2184-1/ANSI

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P C110	P C145	P C150	M C110	M C145	M C150	K C110	K C145	K C150	N C110	N C145	N C150	S C110	S C145	S C150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF 7/16-20	20.00	72.59	.323 x .242	E	3BX	T300-XM103AF-7/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	8.2	11.11	100.0	15.0	3	9.9	DIN 2184-1/ANSI
		2.858																				*.323*	*.438*	*3.937*	*.591*		*.390*	
UNF 1/2-20	20.00	71.82	.367 x .275	E	3BX	T300-XM103AF-1/2	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	9.3	12.70	100.0	18.0	3	11.5	DIN 2184-1/ANSI
		2.828																				*.367*	*.500*	*3.937*	*.709*		*.453*	
UNF 9/16-18	18.00	70.30	.429 x .322	E	3BX	T300-XM103AF-9/16	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	10.9	14.29	100.0	19.1	3	12.9	DIN 2184-1/ANSI
		2.768																				*.429*	*.563*	*3.937*	*.752*		*.508*	
UNF 5/8-18	18.00	55.78	.480 x .360	E	3BX	T300-XM103AF-5/8	★	★		★	★		★	★		★	★		★	★		12.2	15.88	100.0	20.1	4	14.5	DIN 2184-1/ANSI
		2.196																				*.480*	*.625*	*3.937*	*.791*		*.571*	
UNF 3/4-16	16.00	62.47	.590 x .442	E	3BX	T300-XM103AF-3/4	★		★	★		★	★		★	★		★	★		★	15.0	19.05	110.0	24.9	4	17.5	DIN 2184-1/ANSI
		2.459																				*.590*	*.750*	*4.331*	*.980*		*.689*	
UNF 7/8-14	14.00	75.95	.697 x .523	E	3BX	T300-XM103AF-7/8	★			★			★			★			★			17.7	22.23	125.0	24.9	4	20.4	DIN 2184-1/ANSI
		2.990																				*.697*	*.875*	*4.921*	*.980*		*.803*	
UNF 1"-12	12.00	75.43	.800 x .600	E	3BX	T300-XM103AF-1-12	★			★			★			★			★			20.3	25.40	140.0	26.9	4	23.3	DIN 2184-1/ANSI
		2.970																				*.800*	*1.000*	*5.512*	*1.059*		*.915*	

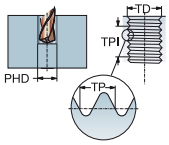
C166 C157 E9 E27 C154

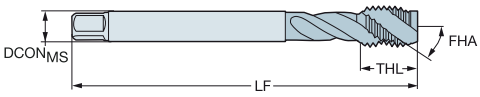
CoroTap™ 300 cutting tap with spiral flutes

Thread form: G

DIN 5156

ULDR 2.5
FHA 45°
SUBSTRATE HSS-PM





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P						M						K						N						S						Dimensions, mm, inch						
							B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	B110	B145	B150	C110	C145	C150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
G 1/8-28	28.00	67.00	7.00 x 5.50	C	NORMAL	T300-XM100DK-1/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	7.0	9.73	90.0	13.0	3	8.8	DIN 5156
		2.638																																			*.276*	*.383*	*3.543*	*.512*		*.346*	
G 1/4-19	19.00	71.00	11.00 x 9.00	C	NORMAL	T300-XM100DK-1/4				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	11.0	13.16	100.0	15.0	3	11.8	DIN 5156
		2.795																																			*.433*	*.518*	*3.937*	*.591*		*.465*	
G 3/8-19	19.00	58.00	12.00 x 9.00	C	NORMAL	T300-XM100DK-3/8				★	★	★				★	★	★				★	★	★				★	★	★				★	★	★	12.0	16.66	100.0	15.0	4	15.3	DIN 5156
		2.283																																			*.472*	*.656*	*3.937*	*.591*		*.600*	
G 1/2-14	14.00	80.00	16.00 x 12.00	C	NORMAL	T300-XM100DK-1/2	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				16.0	20.96	125.0	18.0	4	19.0	DIN 5156
		3.150																																			*.630*	*.825*	*4.921*	*.709*		*.748*	
G 5/8-14	14.00	78.00	18.00 x 14.50	C	NORMAL	T300-XM100DK-5/8	★	★					★	★					★	★					★	★					★	★					18.0	22.91	125.0	18.0	4	21.0	DIN 5156
		3.071																																			*.709*	*.902*	*4.921*	*.709*		*.827*	
G 3/4-14	14.00	77.00	20.00 x 16.00	C	NORMAL	T300-XM100DK-3/4	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				20.0	26.44	140.0	20.0	4	24.5	DIN 5156
		3.032																																			*.787*	*1.041*	*5.512*	*.787*		*.965*	
G 7/8-14	14.00	85.00	22.00 x 18.00	C	NORMAL	T300-XM100DK-7/8	★		★				★		★				★		★				★		★				★		★				22.0	30.20	150.0	20.0	4	28.3	DIN 5156
		3.346																																			*.866*	*1.189*	*5.906*	*.787*		*1.112*	
G 1"-11	11.00	93.00	25.00 x 20.00	C	NORMAL	T300-XM100DK-1	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				25.0	33.25	160.0	22.0	4	30.8	DIN 5156
		3.661																																			*.984*	*1.309*	*6.299*	*.866*		*1.211*	
G 1.1/8-11	11.00	101.00	28.00 x 22.00	C	NORMAL	T300-XM100DK-1.1/8			★					★							★						★						★				28.0	37.90	170.0	22.0	4	35.0	DIN 5156
		3.976																																			*1.102*	*1.492*	*6.693*	*.866*		*1.378*	
G 1.1/4-11	11.00	72.00	32.00 x 24.00	C	NORMAL	T300-XM100DK-1.1/4	★	★	★				★	★	★				★	★	★				★	★	★				★	★	★				32.0	41.91	170.0	22.0	4	39.5	DIN 5156
		2.835																																			*1.260*	*1.650*	*6.693*	*.866*		*1.555*	
G 1.1/2-11	11.00	87.00	36.00 x 29.00	C	NORMAL	T300-XM100DK-1.1/2		★	★					★	★					★	★					★	★					★	★				36.0	47.80	190.0	23.0	4	45.0	DIN 5156
		3.425																																			*1.417*	*1.882*	*7.480*	*.906*		*1.772*	

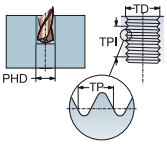
C166 C157 E9 E27 C154

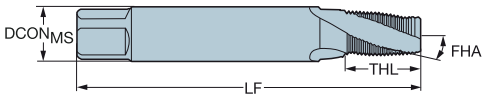
CoroTap™ 300 cutting tap with spiral flutes

Thread form: NPT

DIN 2184-1/ANSI

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E

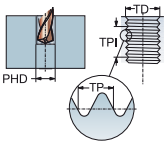


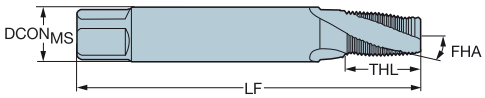


TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P B145	M B145	K B145	N B145	S B145	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
NPT 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	T300-XM100AL-1/16	★	★	★	★	★	8.0	7.72	80.0	14.0	3	6.3	DIN 2184-1/ANSI
		2.205										*.313*	*.304*	*3.150*	*.551*		*.248*	
NPT 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	T300-XM100AL-1/8	★	★	★	★	★	11.1	10.07	90.0	14.0	4	8.5	DIN 2184-1/ANSI
		2.520										*.437*	*.396*	*3.543*	*.551*		*.335*	
NPT 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	T300-XM100AL-1/4	★	★	★	★	★	14.3	13.37	100.0	20.0	4	11.0	DIN 2184-1/ANSI
		2.323										*.562*	*.526*	*3.937*	*.787*		*.433*	
NPT 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	T300-XM100AL-3/8	★	★	★	★	★	17.8	16.81	110.0	20.0	5	14.5	DIN 2184-1/ANSI
		2.638										*.700*	*.662*	*4.331*	*.787*		*.571*	
NPT 1/2-14	14.00	79.00	.687 x .515	C	NORMAL	T300-XM100AL-1/2	★	★	★	★	★	17.4	20.95	125.0	26.0	5	18.0	DIN 2184-1/ANSI
		3.110										*.687*	*.825*	*4.921*	*1.024*		*.709*	
NPT 3/4-14	14.00	78.00	.906 x .679	C	NORMAL	T300-XM100AL-3/4	★	★	★	★	★	23.0	26.29	140.0	26.0	5	23.0	DIN 2184-1/ANSI
		3.071										*.906*	*1.035*	*5.512*	*1.024*		*.906*	
NPT 1-11.5	11.50	58.00	1.125 x .843	C	NORMAL	T300-XM100AL-1	★	★	★	★	★	28.6	32.91	150.0	31.0	5	29.0	DIN 2184-1/ANSI
		2.283										*1.125*	*1.296*	*5.906*	*1.220*		*1.142*	

Thread form: NPTF

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E





TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P B145	M B145	K B145	N B145	S B145	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
NPTF 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	T300-XM100AM-1/16	★	★	★	★	★	8.0	7.64	80.0	14.0	3	6.2	DIN 2184-1/ANSI
		2.205										*.313*	*.301*	*3.150*	*.551*		*.244*	
NPTF 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	T300-XM100AM-1/8	★	★	★	★	★	11.1	9.98	90.0	14.0	4	8.4	DIN 2184-1/ANSI
		2.520										*.437*	*.393*	*3.543*	*.551*		*.331*	
NPTF 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	T300-XM100AM-1/4	★	★	★	★	★	14.3	13.31	100.0	20.0	4	10.9	DIN 2184-1/ANSI
		2.323										*.562*	*.524*	*3.937*	*.787*		*.429*	
NPTF 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	T300-XM100AM-3/8	★	★	★	★	★	17.8	16.75	110.0	20.0	5	14.3	DIN 2184-1/ANSI
		2.638										*.700*	*.660*	*4.331*	*.787*		*.561*	
NPTF 1/2-14	14.00	79.00	.687 x .515	C	NORMAL	T300-XM100AM-1/2	★	★	★	★	★	17.4	20.92	125.0	26.0	5	17.8	DIN 2184-1/ANSI
		3.110										*.687*	*.824*	*4.921*	*1.024*		*.699*	
NPTF 3/4-14	14.00	78.00	.906 x .679	C	NORMAL	T300-XM100AM-3/4	★	★	★	★	★	23.0	26.27	140.0	26.0	5	23.0	DIN 2184-1/ANSI
		3.071										*.906*	*1.034*	*5.512*	*1.024*		*.906*	

C166 C157 E9 E27 C154

CoroTap™ 400

Applications

- Suitable for both through holes and blind holes
- Available in many thread forms and standards
- Depths up to 3.5 × diameter

V C

ISO application area:

P M N S

Benefits and features

- Chamfer C (2–3 threads) and chamfer E (1.5–2 threads). Chamfer E mainly used in blind holes with low clearance
- High speed steel with cobalt taps for improved wear resistance
- High speed powder steel taps for improved strength, wear resistance, and tool life

- Taps that form the thread instead of cutting
- A chip-free solution
- All materials not suitable since there is need of certain ductility. Recommended tensile strength limit is 1200 N/mm^2
- For both through and blind holes
- Available with and without oil grooves

www.sandvik.coromant.com/corotap400

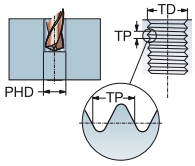
CoroChuck™ 970, see our Rotating Tools catalog.

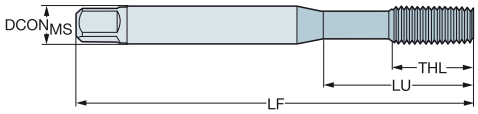
CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E





P N

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 1	0.25	20.00	2.50 x 2.10	C	5HX	E301M1	2.5	1.00	40.0	5.5	3	DIN 2174
		.787					*.098*	*.039*	*1.575*	*.217*		
M 1.2	0.25	20.00	2.50 x 2.10	C	5HX	E301M1.2	2.5	1.20	40.0	5.5	3	DIN 2174
		.787					*.098*	*.047*	*1.575*	*.217*		
M 1.4	0.30	20.00	2.50 x 2.10	C	5HX	E301M1.4	2.5	1.40	40.0	7.0	3	DIN 2174
		.787					*.098*	*.055*	*1.575*	*.276*		
M 1.6	0.35	20.00	2.50 x 2.10	C	6HX	E301M1.6	2.5	1.60	40.0	8.0	3	DIN 2174
		.787					*.098*	*.063*	*1.575*	*.315*		
M 1.7	0.35	20.00	2.50 x 2.10	C	6HX	E301M1.7	2.5	1.70	40.0	8.0	3	DIN 2174
		.787					*.098*	*.067*	*1.575*	*.315*		
M 1.8	0.35	20.00	2.50 x 2.10	C	6HX	E301M1.8	2.5	1.80	40.0	8.0	3	DIN 2174
		.787					*.098*	*.071*	*1.575*	*.315*		
M 2	0.40	11.00	2.80 x 2.10	C	6HX	E301M2	2.8	2.00	45.0	6.0	3	DIN 2174
		.433					*.110*	*.079*	*1.772*	*.236*		
M 2.2	0.45	12.00	2.80 x 2.10	C	6HX	E301M2.2	2.8	2.20	45.0	7.0	3	DIN 2174
		.472					*.110*	*.087*	*1.772*	*.276*		
M 2.3	0.40	12.00	2.80 x 2.10	C	6HX	E301M2.3	2.8	2.30	45.0	7.0	3	DIN 2174
		.472					*.110*	*.091*	*1.772*	*.276*		
M 2.5	0.45	14.00	2.80 x 2.10	C	6HX	E301M2.5	2.8	2.50	50.0	8.0	3	DIN 2174
		.551					*.110*	*.098*	*1.969*	*.315*		
M 2.6	0.45	14.00	2.80 x 2.10	C	6HX	E301M2.6	2.8	2.60	50.0	8.0	3	DIN 2174
		.551					*.110*	*.102*	*1.969*	*.315*		
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E301M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					*.138*	*.118*	*2.205*	*.354*		
M 3.5	0.60	20.00	4.00 x 3.00	C	6HX	E301M3.5	4.0	3.50	56.0	11.0	4	DIN 2174
		.787					*.157*	*.138*	*2.205*	*.433*		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E301M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E301M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E301M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E301M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E301M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E301M12	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	E301M16	12.0	16.00	110.0	25.0	6	DIN 2174
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 20	2.50	70.00	16.00 x 12.00	C	6HX	E301M20	16.0	20.00	140.0	30.0	7	DIN 2174
		2.756					*.630*	*.787*	*5.512*	*1.181*		
M 24	3.00	80.00	18.00 x 14.50	C	6HX	E301M24	18.0	24.00	160.0	36.0	8	DIN 2174
		3.150					*.709*	*.945*	*6.299*	*1.417*		

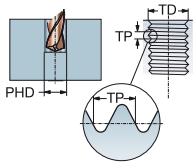
C170 C157 E9 C154

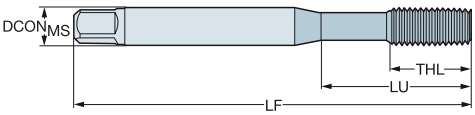
CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD TIN





P M N S

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 1	0.25	20.00	2.50 x 2.10	C	5HX	E302M1	2.5	1.00	40.0	5.5	3	DIN 2174
		.787					*.098*	*.039*	*1.575*	*.217*		
M 1.2	0.25	20.00	2.50 x 2.10	C	5HX	E302M1.2	2.5	1.20	40.0	5.5	3	DIN 2174
		.787					*.098*	*.047*	*1.575*	*.217*		
M 1.4	0.30	20.00	2.50 x 2.10	C	5HX	E302M1.4	2.5	1.40	40.0	7.0	3	DIN 2174
		.787					*.098*	*.055*	*1.575*	*.276*		
M 1.6	0.35	20.00	2.50 x 2.10	C	6HX	E302M1.6	2.5	1.60	40.0	8.0	3	DIN 2174
		.787					*.098*	*.063*	*1.575*	*.315*		
M 1.7	0.35	20.00	2.50 x 2.10	C	6HX	E302M1.7	2.5	1.70	40.0	8.0	3	DIN 2174
		.787					*.098*	*.067*	*1.575*	*.315*		
M 1.8	0.35	20.00	2.50 x 2.10	C	6HX	E302M1.8	2.5	1.80	40.0	8.0	3	DIN 2174
		.787					*.098*	*.071*	*1.575*	*.315*		
M 2	0.40	11.00	2.80 x 2.10	C	6HX	E302M2	2.8	2.00	45.0	6.0	3	DIN 2174
		.433					*.110*	*.079*	*1.772*	*.236*		
M 2.2	0.45	12.00	2.80 x 2.10	C	6HX	E302M2.2	2.8	2.20	45.0	7.0	3	DIN 2174
		.472					*.110*	*.087*	*1.772*	*.276*		
M 2.3	0.40	12.00	2.80 x 2.10	C	6HX	E302M2.3	2.8	2.30	45.0	7.0	3	DIN 2174
		.472					*.110*	*.091*	*1.772*	*.276*		
M 2.5	0.45	14.00	2.80 x 2.10	C	6HX	E302M2.5	2.8	2.50	50.0	8.0	3	DIN 2174
		.551					*.110*	*.098*	*1.969*	*.315*		
M 2.6	0.45	14.00	2.80 x 2.10	C	6HX	E302M2.6	2.8	2.60	50.0	8.0	3	DIN 2174
		.551					*.110*	*.102*	*1.969*	*.315*		
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E302M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					*.138*	*.118*	*2.205*	*.354*		
M 3.5	0.60	20.00	4.00 x 3.00	C	6HX	E302M3.5	4.0	3.50	56.0	11.0	4	DIN 2174
		.787					*.157*	*.138*	*2.205*	*.433*		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E302M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E302M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E302M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E302M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E302M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E302M12	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	E302M16	12.0	16.00	110.0	25.0	6	DIN 2174
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 20	2.50	70.00	16.00 x 12.00	C	6HX	E302M20	16.0	20.00	140.0	30.0	7	DIN 2174
		2.756					*.630*	*.787*	*5.512*	*1.181*		
M 24	3.00	80.00	18.00 x 14.50	C	6HX	E302M24	18.0	24.00	160.0	36.0	8	DIN 2174
		3.150					*.709*	*.945*	*6.299*	*1.417*		

C170 C157 E9 C154

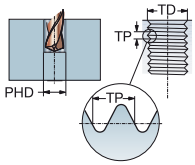
SANDVIK Coromant

CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD TIN



P M N S

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 3	0.50	18.00	3.50 x 2.70	E	6HX	E305M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					*.138*	*.118*	*2.205*	*.354*		
M 4	0.70	21.00	4.50 x 3.40	E	6HX	E305M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	E	6HX	E305M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	E	6HX	E305M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	E	6HX	E305M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	E	6HX	E305M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 3	0.50	18.00	3.50 x 2.70	C	6GX	E309M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					*.138*	*.118*	*2.205*	*.354*		
M 3.5	0.60	20.00	4.00 x 3.00	C	6GX	E309M3.5	4.0	3.50	56.0	11.0	4	DIN 2174
		.787					*.157*	*.138*	*2.205*	*.433*		
M 4	0.70	21.00	4.50 x 3.40	C	6GX	E309M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	C	6GX	E309M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	C	6GX	E309M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6GX	E309M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6GX	E309M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6GX	E309M12	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 3	0.50	18.00	3.50 x 2.70	E	6GX	E310M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					*.138*	*.118*	*2.205*	*.354*		
M 4	0.70	21.00	4.50 x 3.40	E	6GX	E310M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	E	6GX	E310M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	E	6GX	E310M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	E	6GX	E310M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	E	6GX	E310M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.787*		

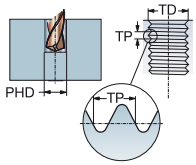
C170 C157 E9 C154

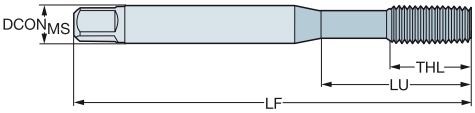
CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD CRN





P M N S

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E306M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					*.138*	*.118*	*2.205*	*.354*		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E306M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E306M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E306M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E306M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E306M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E306M12	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268					*.354*	*.472*	*4.331*	*.906*		

C170 C157 E9 C154

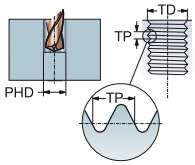
SANDVIK Coromant

CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.5
SUBSTRATE HSS-E
COATING PVD TIN



P M N S

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 3	0.50	18.00	3.50 x 2.70	C	6HX	E308M3	3.5	3.00	56.0	9.0	4	DIN 2174
		.709					*.138*	*.118*	*2.205*	*.354*		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	E308M4	4.5	4.00	63.0	12.0	5	DIN 2174
		.827					*.177*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	E308M5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	E308M6	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
M 7	1.00	30.00	7.00 x 5.50	C	6HX	E308M7	7.0	7.00	80.0	15.0	5	DIN 2174
		1.181					*.276*	*.276*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	E308M8	8.0	8.00	90.0	18.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	E308M10	10.0	10.00	100.0	20.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	E308M12	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	E308M14	11.0	14.00	110.0	25.0	6	DIN 2174
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	E308M16	12.0	16.00	110.0	25.0	6	DIN 2174
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	E308M20	16.0	20.00	140.0	30.0	7	DIN 2174
		3.740					*.630*	*.787*	*5.512*	*1.181*		
M 24	3.00	113.00	18.00 x 14.50	C	6HX	E308M24	18.0	24.00	160.0	36.0	8	DIN 2174
		4.449					*.709*	*.945*	*6.299*	*1.417*		

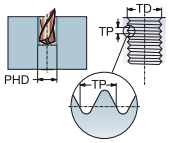
C170 C157 E9 C154

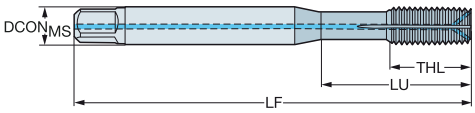
CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.5
SUBSTRATE HSS-E
COATING PVD TIN





P M N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
									Dimensions, mm, inch					
M 5	0.80	21.00	6.00 x 4.90	C	6HX	1	2	**E315M5**	6.0	5.00	70.0	13.0	5	DIN 2174
		.827							*.236*	*.197*	*2.756*	*.512*		
M 6	1.00	26.00	6.00 x 4.90	C	6HX	1	2	**E315M6**	6.0	6.00	80.0	15.0	5	DIN 2174
		1.024							*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	30.00	8.00 x 6.20	C	6HX	1	2	**E315M8**	8.0	8.00	90.0	18.0	5	DIN 2174
		1.181							*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	33.00	10.00 x 8.00	C	6HX	1	2	**E315M10**	10.0	10.00	100.0	20.0	5	DIN 2174
		1.299							*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	2	**E315M12**	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268							*.354*	*.472*	*4.331*	*.906*		

CXSC 2 = Radial coolant exit

C170 C157 E9 E28 C154

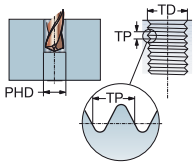
SANDVIK Coromant

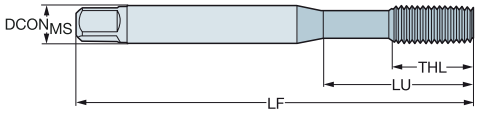
CoroTap™ 400 forming tap

Thread form: Metric

C-DIN 2174, DIN 2174

ULDR 3.0
SUBSTRATE HM
COATING PVD TICN





P M N S

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	10.00	3.50 x 2.70	C	6HX	T115M3	3.5	3.00	56.0	10.0	4	C-DIN 2174
		.394					*.138*	*.118*	*2.205*	*.394*		
M 4	0.70	13.00	4.50 x 3.40	C	6HX	T115M4	4.5	4.00	63.0	13.0	5	C-DIN 2174
		.512					*.177*	*.157*	*2.480*	*.512*		
M 5	0.80	16.00	6.00 x 4.90	C	6HX	T115M5	6.0	5.00	70.0	16.0	5	C-DIN 2174
		.630					*.236*	*.197*	*2.756*	*.630*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T115M6	6.0	6.00	80.0	19.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.748*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T115M8	8.0	8.00	90.0	22.0	5	DIN 2174
		1.378					*.315*	*.315*	*3.543*	*.866*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	T115M10	10.0	10.00	100.0	24.0	5	DIN 2174
		1.535					*.394*	*.394*	*3.937*	*.945*		

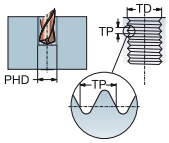
C170 C157 E9 C154

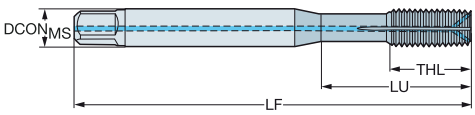
CoroTap™ 400 forming tap

Thread form: Metric

C-DIN 2174, DIN 2174

ULDR 3.0
SUBSTRATE HM
COATING PVD TICN





P M N S

									Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 5	0.80	16.00	6.00 x 4.90	C	6HX	1	1	**T116M5**	6.0	5.00	70.0	16.0	5	C-DIN 2174
		.630							*.236*	*.197*	*2.756*	*.630*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	**T116M6**	6.0	6.00	80.0	19.0	5	DIN 2174
		1.181							*.236*	*.236*	*3.150*	*.748*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	**T116M8**	8.0	8.00	90.0	22.0	5	DIN 2174
		1.378							*.315*	*.315*	*3.543*	*.866*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	**T116M10**	10.0	10.00	100.0	24.0	5	DIN 2174
		1.535							*.394*	*.394*	*3.937*	*.945*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	**T116M12**	9.0	12.00	110.0	23.0	5	DIN 2174
		3.268							*.354*	*.472*	*4.331*	*.906*		

CXSC 1 = Axial concentric coolant exit

C170 C157 E9 E28 C154

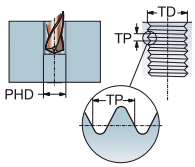
SANDVIK Coromant

CoroTap™ 400 forming tap

Thread form: Metric

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-PM
COATING PVD TIN



P M N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 3	0.50	18.81	.141 x .110	C	6H	E890M3	3.6	3.00	56.0	18.8	4	DIN/ANSI
		.740					*.141*	*.118*	*2.205*	*.740*		
M 4	0.70	16.58	.168 x .131	C	6H	E890M4	4.3	4.00	63.0	16.5	4	DIN/ANSI
		.653					*.168*	*.157*	*2.480*	*.650*		
M 5	0.80	21.42	.194 x .152	C	6H	E890M5	4.9	5.00	70.0	19.3	4	DIN/ANSI
		.843					*.194*	*.197*	*2.756*	*.760*		
M 6	1.00	25.59	.255 x .191	C	6H	E890M6	6.5	6.00	80.0	15.0	4	DIN/ANSI
		1.007					*.255*	*.236*	*3.150*	*.591*		
M 8	1.25	30.20	.318 x .238	C	6H	E890M8	8.1	8.00	90.0	18.0	5	DIN/ANSI
		1.189					*.318*	*.315*	*3.543*	*.709*		
M 10	1.50	32.80	.381 x .286	C	6H	E890M10	9.7	10.00	100.0	20.0	6	DIN/ANSI
		1.292					*.381*	*.394*	*3.937*	*.787*		
M 12	1.75	87.00	.367 x .275	C	6H	E890M12	9.3	12.00	110.0	23.0	6	DIN/ANSI
		3.425					*.367*	*.472*	*4.331*	*.906*		
M 16	2.00	72.00	.480 x .360	C	6H	E890M16	12.2	16.00	110.0	23.0	8	DIN/ANSI
		2.835					*.480*	*.630*	*4.331*	*.906*		
M 18	2.50	87.00	.542 x .406	C	6H	E890M18	13.8	18.00	125.0	30.0	8	DIN/ANSI
		3.425					*.542*	*.709*	*4.921*	*1.181*		
M 20	2.50	102.00	.652 x .489	C	6H	E890M20	16.6	20.00	140.0	36.0	8	DIN/ANSI
		4.016					*.652*	*.787*	*5.512*	*1.417*		

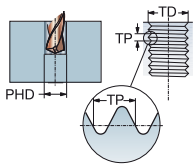
C170 C157 E9 C154

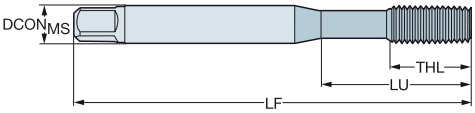
CoroTap™ 400 forming tap

Thread form: Metric fine

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD TIN





P M N S

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
MF 5x0.5	0.50	25.00	6.00 x 4.90	C	6HX	E317M5X0.5	6.0	5.00	70.0	13.0	5	DIN 2174
		.984					*.236*	*.197*	*2.756*	*.512*		
MF 6x0.75	0.75	30.00	6.00 x 4.90	C	6HX	E317M6X0.75	6.0	6.00	80.0	15.0	5	DIN 2174
		1.181					*.236*	*.236*	*3.150*	*.591*		
MF 7x0.75	0.75	30.00	7.00 x 5.50	C	6HX	E317M7X0.75	7.0	7.00	80.0	15.0	5	DIN 2174
		1.181					*.276*	*.276*	*3.150*	*.591*		
MF 8x0.75	0.75	57.00	6.00 x 4.90	C	6HX	E317M8X.75	6.0	8.00	80.0	18.0	5	DIN 2174
		2.244					*.236*	*.315*	*3.150*	*.709*		
MF 8x1	1.00	67.00	6.00 x 4.90	C	6HX	E317M8X1	6.0	8.00	90.0	18.0	5	DIN 2174
		2.638					*.236*	*.315*	*3.543*	*.709*		
MF 10x1	1.00	75.00	7.00 x 5.50	C	6HX	E317M10X1	7.0	10.00	100.0	20.0	5	DIN 2174
		2.953					*.276*	*.394*	*3.937*	*.787*		
MF 10x1.25	1.25	75.00	7.00 x 5.50	C	6HX	E317M10X1.25	7.0	10.00	100.0	20.0	5	DIN 2174
		2.953					*.276*	*.394*	*3.937*	*.787*		
MF 12x1	1.00	73.00	9.00 x 7.00	C	6HX	E317M12X1	9.0	12.00	100.0	23.0	5	DIN 2174
		2.874					*.354*	*.472*	*3.937*	*.906*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	E317M12X1.25	9.0	12.00	100.0	23.0	5	DIN 2174
		2.874					*.354*	*.472*	*3.937*	*.906*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	E317M12X1.5	9.0	12.00	100.0	23.0	5	DIN 2174
		2.874					*.354*	*.472*	*3.937*	*.906*		
MF 14x1	1.00	71.00	11.00 x 9.00	C	6HX	E317M14X1	11.0	14.00	100.0	21.0	6	DIN 2174
		2.795					*.433*	*.551*	*3.937*	*.827*		
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6HX	E317M14X1.25	11.0	14.00	100.0	21.0	6	DIN 2174
		2.795					*.433*	*.551*	*3.937*	*.827*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	E317M14X1.5	11.0	14.00	100.0	21.0	6	DIN 2174
		2.795					*.433*	*.551*	*3.937*	*.827*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	E317M16X1.5	12.0	16.00	100.0	21.0	6	DIN 2174
		2.283					*.472*	*.630*	*3.937*	*.827*		

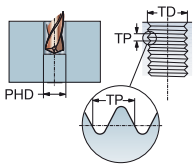
C170 C157 E9 C154

CoroTap™ 400 forming tap

Thread form: Metric fine

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-PM
COATING PVD TIN



P M N S

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
MF 10x1.25	1.25	36.61	.381 x .286	C	6H	**E891M10X1.25**	9.7	10.00	100.0	20.0	6	DIN/ANSI
		1.442					*.381*	*.394*	*3.937*	*.787*		
MF 12x1.5	1.50	87.00	.367 x .275	C	6H	**E891M12X1.5**	9.3	12.00	110.0	23.0	6	DIN/ANSI
		3.425					*.367*	*.472*	*4.331*	*.906*		

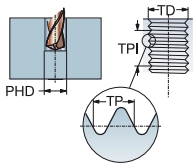
C170 C157 E9 C154

CoroTap™ 400 forming tap

Thread form: UNC

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-PM
COATING PVD TIN



P M N S

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
UNC #4-40	40.00	15.47	.141 x .110	C	2B	E8924-40	3.6	2.84	56.0	11.0	3	DIN/ANSI
		.609					*.141*	*.112*	*2.205*	*.433*		
UNC #6-32	32.00	15.08	.141 x .110	C	2B	E8926-32	3.6	3.51	56.0	13.0	3	DIN/ANSI
		.594					*.141*	*.138*	*2.205*	*.510*		
UNC #8-32	32.00	16.58	.168 x .131	C	2B	E8928-32	4.3	4.17	63.0	16.5	4	DIN/ANSI
		.653					*.168*	*.164*	*2.480*	*.650*		
UNC #10-24	24.00	21.42	.194 x .152	C	2B	E89210-24	4.9	4.83	70.0	19.3	4	DIN/ANSI
		.843					*.194*	*.190*	*2.756*	*.760*		
UNC #12-24	24.00	25.55	.220 x .165	C	2B	E89212-24	5.6	5.49	80.0	15.0	4	DIN/ANSI
		1.006					*.220*	*.216*	*3.150*	*.591*		
UNC 1/4-20	20.00	25.59	.255 x .191	C	2B	E8921/4	6.5	6.35	80.0	15.0	4	DIN/ANSI
		1.007					*.255*	*.250*	*3.150*	*.591*		
UNC 5/16-18	18.00	30.20	.318 x .238	C	2B	E8925/16	8.1	7.94	90.0	18.0	5	DIN/ANSI
		1.189					*.318*	*.313*	*3.543*	*.709*		
UNC 3/8-16	16.00	32.80	.381 x .286	C	2B	E8923/8	9.7	9.53	100.0	20.0	6	DIN/ANSI
		1.292					*.381*	*.375*	*3.937*	*.787*		
UNC 7/16-14	14.00	72.60	.323 x .242	C	2B	E8927/16	8.2	11.11	100.0	20.0	6	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.787*		
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	E8921/2	9.3	12.70	110.0	23.0	6	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.906*		
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	E8925/8	12.2	15.88	110.0	23.0	8	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.906*		
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	E8923/4	15.0	19.05	125.0	30.0	8	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*1.181*		
UNC 7/8-9	9.00	90.90	.697 x .523	C	2B	E8927/8-9	17.7	22.23	140.0	34.0	8	DIN/ANSI
		3.579					*.697*	*.875*	*5.512*	*1.339*		
UNC 1"-8	8.00	95.40	.800 x .600	C	2B	E8921	20.3	25.40	160.0	38.0	8	DIN/ANSI
		3.756					*.800*	*1.000*	*6.299*	*1.496*		

C170 C157 E9 C154

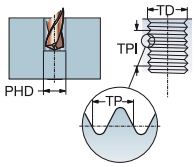
SANDVIK Coromant

CoroTap™ 400 forming tap

Thread form: UNF

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-PM
COATING PVD TIN



P M N S

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
UNF #10-32	32.00	21.42	.194 x .152	C	2B	E89310-32	4.9	4.83	70.0	19.3	4	DIN/ANSI
		.843					*.194*	*.190*	*2.756*	*.760*		
UNF 1/4-28	28.00	25.59	.255 x .191	C	2B	E8931/4	6.5	6.35	80.0	15.0	4	DIN/ANSI
		1.007					*.255*	*.250*	*3.150*	*.591*		
UNF 5/16-24	24.00	30.20	.318 x .238	C	2B	E8935/16	8.1	7.94	90.0	18.0	5	DIN/ANSI
		1.189					*.318*	*.313*	*3.543*	*.709*		
UNF 3/8-24	24.00	32.80	.381 x .286	C	2B	E8933/8	9.7	9.53	100.0	20.0	6	DIN/ANSI
		1.292					*.381*	*.375*	*3.937*	*.787*		
UNF 7/16-20	20.00	72.60	.323 x .242	C	2B	E8937/16	8.2	11.11	100.0	20.0	6	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.787*		
UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	E8931/2	9.3	12.70	110.0	23.0	6	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.906*		
UNF 5/8-18	18.00	65.80	.480 x .360	C	2B	E8935/8	12.2	15.88	110.0	23.0	8	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.906*		
UNF 3/4-16	16.00	77.50	.590 x .442	C	2B	E8933/4	15.0	19.05	125.0	30.0	8	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*1.181*		
UNF 1"-12	12.00	95.40	.800 x .600	C	2B	E8931	20.3	25.40	160.0	36.0	8	DIN/ANSI
		3.756					*.800*	*1.000*	*6.299*	*1.417*		

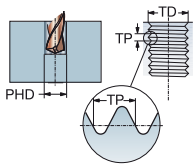
C170 C157 E9 C154

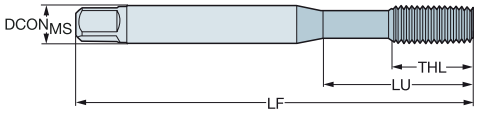
CoroTap™ 400 forming tap

Thread form: EGM

DIN 40435

ULDR 3.0
SUBSTRATE HSS-E
COATING PVD TIN





P M N S

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	**Ordering code**	$DCON_{MS}$	TD	LF	THL	NOF	BSG
EGM 3	0.50	21.00	4.50 x 3.40	C	6HMOD	**E323M3**	4.5	3.65	63.0	12.0	4	DIN 40435
		.827					*.177*	*.144*	*2.480*	*.472*		
EGM 4	0.70	25.00	6.00 x 4.90	C	6HMOD	**E323M4**	6.0	4.91	70.0	13.0	4	DIN 40435
		.984					*.236*	*.193*	*2.756*	*.512*		
EGM 5	0.80	30.00	6.00 x 4.90	C	6HMOD	**E323M5**	6.0	6.04	80.0	15.0	4	DIN 40435
		1.181					*.236*	*.238*	*3.150*	*.591*		
EGM 6	1.00	35.00	8.00 x 6.20	C	6HMOD	**E323M6**	8.0	7.30	90.0	18.0	5	DIN 40435
		1.378					*.315*	*.287*	*3.543*	*.709*		
EGM 8	1.25	39.00	10.00 x 8.00	C	6HMOD	**E323M8**	10.0	9.62	100.0	20.0	5	DIN 40435
		1.535					*.394*	*.379*	*3.937*	*.787*		
EGM 10	1.50	73.00	9.00 x 7.00	C	6HMOD	**E323M10**	9.0	11.95	100.0	21.0	5	DIN 40435
		2.874					*.354*	*.470*	*3.937*	*.827*		
EGM 12	1.75	81.00	11.00 x 9.00	C	6HMOD	**E323M12**	11.0	14.27	110.0	25.0	6	DIN 40435
		3.189					*.433*	*.562*	*4.331*	*.984*		

C170 C157 E9 C154

CoroTap™ 100

Applications

- Taps optimized for specific materials
- For both through- and blind holes
- Depths up to 2.5 × diameter
- Tolerances ISO K: 6H, 6HX, 2B, 2BX, 3B
- Tolerances ISO N: 6H
- Tolerances ISO H: 6H, 6HX

O C

Benefits and features

- Three coolant holes for optimized strength
- Five flutes to reduce load on cutting edges and to reduce wear
- Unique grade with higher hardness to reduce wear on coating and substrate
- For ISO N materials: taps with interrupted threads for reduced torque

- Taps with straight flutes
- Mainly used for short chipping materials like cast iron
- Suitable for both through and blind holes
- Flute mainly used for cutting fluid but with internal coolant, chip evacuation is also possible

www.sandvik.coromant.com/corotap100

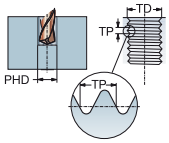
CoroChuck™ 970, see our Rotating Tools catalog.

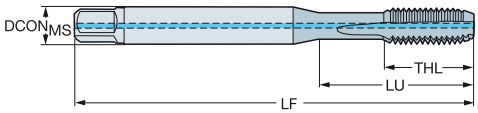
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

C-DIN 371, DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HM
COATING PVD TIALN





K

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	CNSC	CXSC	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
									Dimensions, mm, inch					
M 5	0.80	47.00	6.00 x 4.90	C	6HX	1	1	T101M5	6.0	5.00	70.0	16.0	4	C-DIN 371
		1.850							*.236*	*.197*	*2.756*	*.630*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	T101M6	6.0	6.00	80.0	19.0	4	DIN 371
		1.181							*.236*	*.236*	*3.150*	*.748*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	T101M8	8.0	8.00	90.0	22.0	4	DIN 371
		1.378							*.315*	*.315*	*3.543*	*.866*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	T101M10	10.0	10.00	100.0	24.0	4	DIN 371
		1.535							*.394*	*.394*	*3.937*	*.945*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	T101M12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	1	T101M16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.984*		

CXSC 1 = Axial concentric coolant exit

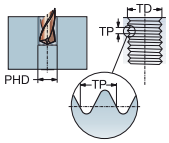
C172 C157 E9 E28 C154

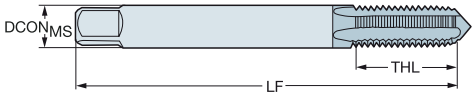
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

C-DIN 371

ULDR 2.0
SUBSTRATE HM
COATING PVD TIALN





H

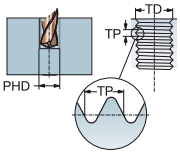
									Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	10.00	3.50 x 2.70	C	6H	0	0	T100M3	3.5	3.00	56.0	10.0	3	C-DIN 371
		.394							*.138*	*.118*	*2.205*	*.394*		
M 4	0.70	13.00	4.50 x 3.40	C	6H	0	0	T100M4	4.5	4.00	63.0	13.0	3	C-DIN 371
		.512							*.177*	*.157*	*2.480*	*.512*		
M 5	0.80	16.00	6.00 x 4.90	C	6H	0	0	T100M5	6.0	5.00	70.0	16.0	3	C-DIN 371
		.630							*.236*	*.197*	*2.756*	*.630*		
M 6	1.00	20.00	6.00 x 4.90	C	6H	0	0	T100M6	6.0	6.00	80.0	20.0	3	C-DIN 371
		.787							*.236*	*.236*	*3.150*	*.787*		
M 8	1.25	25.00	8.00 x 6.20	C	6H	0	0	T100M8	8.0	8.00	90.0	25.0	3	C-DIN 371
		.984							*.315*	*.315*	*3.543*	*.984*		
M 10	1.50	30.00	10.00 x 8.00	C	6H	0	0	T100M10	10.0	10.00	100.0	30.0	3	C-DIN 371
		1.181							*.394*	*.394*	*3.937*	*1.181*		
M 12	1.75	36.00	12.00 x 9.00	C	6H	0	0	T100M12	12.0	12.00	110.0	36.0	3	C-DIN 371
		1.417							*.472*	*.472*	*4.331*	*1.417*		
M 3	0.50	8.00	3.50 x 2.70	C	6HX	0	0	T110M3	3.5	3.00	56.0	8.0	4	C-DIN 371
		.315							*.138*	*.118*	*2.205*	*.315*		
M 4	0.70	11.00	4.50 x 3.40	C	6HX	0	0	T110M4	4.5	4.00	63.0	11.0	5	C-DIN 371
		.433							*.177*	*.157*	*2.480*	*.433*		
M 5	0.80	13.50	6.00 x 4.90	C	6HX	0	0	T110M5	6.0	5.00	70.0	13.5	5	C-DIN 371
		.531							*.236*	*.197*	*2.756*	*.531*		
M 6	1.00	16.50	6.00 x 4.90	C	6HX	0	0	T110M6	6.0	6.00	80.0	16.5	5	C-DIN 371
		.650							*.236*	*.236*	*3.150*	*.650*		
M 8	1.25	21.50	8.00 x 6.20	C	6HX	0	0	T110M8	8.0	8.00	90.0	21.5	5	C-DIN 371
		.846							*.315*	*.315*	*3.543*	*.846*		
M 10	1.50	27.00	10.00 x 8.00	C	6HX	0	0	T110M10	10.0	10.00	100.0	27.0	5	C-DIN 371
		1.063							*.394*	*.394*	*3.937*	*1.063*		
M 12	1.75	32.00	12.00 x 9.00	C	6HX	0	0	T110M12	12.0	12.00	110.0	32.0	6	C-DIN 371
		1.260							*.472*	*.472*	*4.331*	*1.260*		

C172 C157 E9 E28 C154

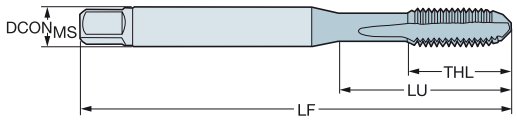
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

DIN 371, DIN 376



ULDR	2.5
SUBSTRATE	HSS-E-PM
COATING	PVD TIALN



TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	K D210	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
M 3	0.50	18.00	3.50 x 2.70	C	6HX	T100-KM100DA-M3	★	3.5	3.00	56.0	9.0	4	2.5	DIN 371
		.709						*.138*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	21.00	4.50 x 3.40	C	6HX	T100-KM100DA-M4	★	4.5	4.00	63.0	12.0	4	3.3	DIN 371
		.827						*.177*	*.157*	*2.480*	*.472*		*.130*	
M 5	0.80	25.00	6.00 x 4.90	C	6HX	T100-KM100DA-M5	★	6.0	5.00	70.0	13.0	5	4.2	DIN 371
		.984						*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T100-KM100DA-M6	★	6.0	6.00	80.0	15.0	5	5.0	DIN 371
		1.181						*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T100-KM100DA-M8	★	8.0	8.00	90.0	18.0	5	6.8	DIN 371
		1.378						*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	C	6HX	T100-KM100DA-M10	★	10.0	10.00	100.0	20.0	5	8.5	DIN 371
		1.535						*.394*	*.394*	*3.937*	*.787*		*.335*	
M 8	1.25	67.00	6.00 x 4.90	C	6HX	T100-KM101DA-M8	★	6.0	8.00	90.0	20.0	5	6.8	DIN 376
		2.638						*.236*	*.315*	*3.543*	*.787*		*.268*	
M 10	1.50	77.00	7.00 x 5.50	C	6HX	T100-KM101DA-M10	★	7.0	10.00	100.0	23.5	5	8.5	DIN 376
		3.032						*.276*	*.394*	*3.937*	*.925*		*.335*	
M 12	1.75	83.00	9.00 x 7.00	C	6HX	T100-KM101DA-M12	★	9.0	12.00	110.0	23.0	5	10.2	DIN 376
		3.268						*.354*	*.472*	*4.331*	*.906*		*.402*	
M 14	2.00	81.00	11.00 x 9.00	C	6HX	T100-KM101DA-M14	★	11.0	14.00	110.0	25.0	5	12.0	DIN 376
		3.189						*.433*	*.551*	*4.331*	*.984*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	C	6HX	T100-KM101DA-M16	★	12.0	16.00	110.0	25.0	5	14.0	DIN 376
		2.677						*.472*	*.630*	*4.331*	*.984*		*.551*	
M 18	2.50	81.00	14.00 x 11.00	C	6HX	T100-KM101DA-M18	★	14.0	18.00	125.0	30.0	5	15.5	DIN 376
		3.189						*.551*	*.709*	*4.921*	*1.181*		*.610*	
M 20	2.50	95.00	16.00 x 12.00	C	6HX	T100-KM101DA-M20	★	16.0	20.00	140.0	30.0	5	17.5	DIN 376
		3.740						*.630*	*.787*	*5.512*	*1.181*		*.689*	
M 22	2.50	93.00	18.00 x 14.50	C	6HX	T100-KM101DA-M22	★	18.0	22.00	140.0	34.0	5	19.5	DIN 376
		3.661						*.709*	*.866*	*5.512*	*1.339*		*.768*	
M 24	3.00	113.00	18.00 x 14.50	C	6HX	T100-KM101DA-M24	★	18.0	24.00	160.0	38.0	5	21.0	DIN 376
		4.449						*.709*	*.945*	*6.299*	*1.496*		*.827*	
M 5	0.80	25.00	6.00 x 4.90	E	6HX	T100-KM102DA-M5	★	6.0	5.00	70.0	13.0	5	4.2	DIN 371
		.984						*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	30.00	6.00 x 4.90	E	6HX	T100-KM102DA-M6	★	6.0	6.00	80.0	15.0	5	5.0	DIN 371
		1.181						*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	35.00	8.00 x 6.20	E	6HX	T100-KM102DA-M8	★	8.0	8.00	90.0	18.0	5	6.8	DIN 371
		1.378						*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	39.00	10.00 x 8.00	E	6HX	T100-KM102DA-M10	★	10.0	10.00	100.0	20.0	5	8.5	DIN 371
		1.535						*.394*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	83.00	9.00 x 7.00	E	6HX	T100-KM103DA-M12	★	9.0	12.00	110.0	23.0	5	10.2	DIN 376
		3.268						*.354*	*.472*	*4.331*	*.906*		*.402*	

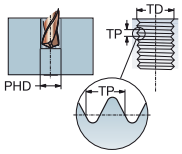
C172 C157 E9 E27 C154

SANDVIK Coromant

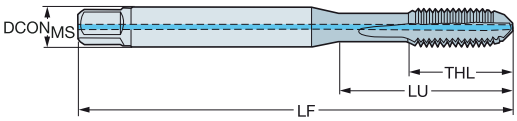
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

DIN 371, DIN 376



ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN



TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	K P210	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	BSG
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	T100-KM104DA-M6	★	6.0	6.00	80.0	15.0	5	DIN 371
		1.181								*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	T100-KM104DA-M8	★	8.0	8.00	90.0	18.0	5	DIN 371
		1.378								*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	T100-KM104DA-M10	★	10.0	10.00	100.0	20.0	5	DIN 371
		1.535								*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	T100-KM105DA-M12	★	9.0	12.00	110.0	23.0	5	DIN 376
		3.268								*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	1	1	T100-KM105DA-M14	★	11.0	14.00	110.0	25.0	5	DIN 376
		3.189								*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	1	T100-KM105DA-M16	★	12.0	16.00	110.0	25.0	5	DIN 376
		2.677								*.472*	*.630*	*4.331*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	1	1	T100-KM105DA-M20	★	16.0	20.00	140.0	30.0	5	DIN 376
		3.740								*.630*	*.787*	*5.512*	*1.181*		
M 22	2.50	93.00	18.00 x 14.50	C	6HX	1	1	T100-KM105DA-M22	★	18.0	22.00	140.0	34.0	5	DIN 376
		3.661								*.709*	*.866*	*5.512*	*1.339*		
M 24	3.00	113.00	18.00 x 14.50	C	6HX	1	1	T100-KM105DA-M24	★	18.0	24.00	160.0	38.0	5	DIN 376
		4.449								*.709*	*.945*	*6.299*	*1.496*		

CXSC 1 = Axial concentric coolant exit

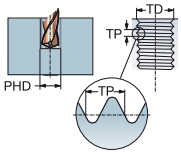
C172 C157 E9 E27 E28 C154

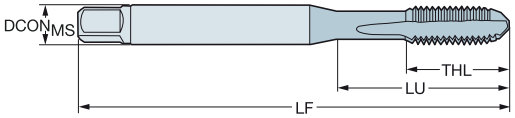
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

DIN 371/ANSI, DIN 376/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	K D210	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
M 6	1.00	25.00	.255 x .191	C	6HX	T100-KM100AA-M6	★	6.5	6.00	80.0	15.6	5	5.0	DIN 371/ANSI
		.984						*.255*	*.236*	*3.150*	*.614*		*.197*	
M 8	1.25	33.50	.318 x .238	C	6HX	T100-KM100AA-M8	★	8.1	8.00	90.0	18.7	5	6.8	DIN 371/ANSI
		1.319						*.318*	*.315*	*3.543*	*.736*		*.268*	
M 10	1.50	38.00	.381 x .286	C	6HX	T100-KM100AA-M10	★	9.7	10.00	100.0	20.6	5	8.5	DIN 371/ANSI
		1.496						*.381*	*.394*	*3.937*	*.811*		*.335*	
M 12	1.75	81.90	.367 x .275	C	6HX	T100-KM101AA-M12	★	9.3	12.00	110.0	23.0	5	10.2	DIN 376/ANSI
		3.224						*.367*	*.472*	*4.331*	*.906*		*.402*	
M 14	2.00	80.30	.429 x .322	C	6HX	T100-KM101AA-M14	★	10.9	14.00	110.0	23.0	5	12.0	DIN 376/ANSI
		3.161						*.429*	*.551*	*4.331*	*.906*		*.472*	
M 16	2.00	65.70	.480 x .360	C	6HX	T100-KM101AA-M16	★	12.2	16.00	110.0	23.0	5	14.0	DIN 376/ANSI
		2.587						*.480*	*.630*	*4.331*	*.906*		*.551*	
M 18	2.50	79.10	.542 x .406	C	6HX	T100-KM101AA-M18	★	13.8	18.00	125.0	30.0	5	15.5	DIN 376/ANSI
		3.114						*.542*	*.709*	*4.921*	*1.181*		*.610*	
M 6	1.00	25.00	.255 x .191	E	6HX	T100-KM102AA-M6	★	6.5	6.00	80.0	15.6	5	5.0	DIN 371/ANSI
		.984						*.255*	*.236*	*3.150*	*.614*		*.197*	
M 8	1.25	33.50	.318 x .238	E	6HX	T100-KM102AA-M8	★	8.1	8.00	90.0	18.7	5	6.8	DIN 371/ANSI
		1.319						*.318*	*.315*	*3.543*	*.736*		*.268*	
M 10	1.50	38.00	.381 x .286	E	6HX	T100-KM102AA-M10	★	9.7	10.00	100.0	20.6	5	8.5	DIN 371/ANSI
		1.496						*.381*	*.394*	*3.937*	*.811*		*.335*	
M 12	1.75	81.90	.367 x .275	E	6HX	T100-KM103AA-M12	★	9.3	12.00	110.0	23.0	5	10.2	DIN 376/ANSI
		3.224						*.367*	*.472*	*4.331*	*.906*		*.402*	
M 14	2.00	80.30	.429 x .322	E	6HX	T100-KM103AA-M14	★	10.9	14.00	110.0	23.0	5	12.0	DIN 376/ANSI
		3.161						*.429*	*.551*	*4.331*	*.906*		*.472*	
M 16	2.00	65.70	.480 x .360	E	6HX	T100-KM103AA-M16	★	12.2	16.00	110.0	23.0	5	14.0	DIN 376/ANSI
		2.587						*.480*	*.630*	*4.331*	*.906*		*.551*	

C172 C157 E9 E27 C154

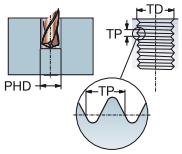
SANDVIK Coromant

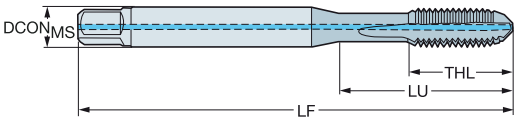
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

DIN 371/ANSI, DIN 376/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	K D210	$DCON_{MS}$	TD	LF	THL	NOF	BSG
										Dimensions, mm, inch					
M 6	1.00	25.00	.255 x .191	C	6HX	1	1	T100-KM104AA-M6	★	6.5	6.00	80.0	15.6	5	DIN 371/ANSI
		.984								*.255*	*.236*	*3.150*	*.614*		
M 8	1.25	33.50	.318 x .238	C	6HX	1	1	T100-KM104AA-M8	★	8.1	8.00	90.0	18.7	5	DIN 371/ANSI
		1.319								*.318*	*.315*	*3.543*	*.736*		
M 10	1.50	38.00	.381 x .286	C	6HX	1	1	T100-KM104AA-M10	★	9.7	10.00	100.0	20.6	5	DIN 371/ANSI
		1.496								*.381*	*.394*	*3.937*	*.811*		
M 12	1.75	81.90	.367 x .275	C	6HX	1	1	T100-KM105AA-M12	★	9.3	12.00	110.0	23.0	5	DIN 376/ANSI
		3.224								*.367*	*.472*	*4.331*	*.906*		
M 16	2.00	65.70	.480 x .360	C	6HX	1	1	T100-KM105AA-M16	★	12.2	16.00	110.0	23.0	5	DIN 376/ANSI
		2.587								*.480*	*.630*	*4.331*	*.906*		
M 20	2.50	92.50	.652 x .489	C	6HX	1	1	T100-KM105AA-M20	★	16.6	20.00	140.0	30.0	5	DIN 376/ANSI
		3.642								*.652*	*.787*	*5.512*	*1.181*		
M 6	1.00	25.00	.255 x .191	E	6HX	1	1	T100-KM106AA-M6	★	6.5	6.00	80.0	15.6	5	DIN 371/ANSI
		.984								*.255*	*.236*	*3.150*	*.614*		
M 8	1.25	33.50	.318 x .238	E	6HX	1	1	T100-KM106AA-M8	★	8.1	8.00	90.0	18.7	5	DIN 371/ANSI
		1.319								*.318*	*.315*	*3.543*	*.736*		
M 10	1.50	38.00	.381 x .286	E	6HX	1	1	T100-KM106AA-M10	★	9.7	10.00	100.0	20.6	5	DIN 371/ANSI
		1.496								*.381*	*.394*	*3.937*	*.811*		
M 12	1.75	81.90	.367 x .275	E	6HX	1	1	T100-KM107AA-M12	★	9.3	12.00	110.0	23.0	5	DIN 376/ANSI
		3.224								*.367*	*.472*	*4.331*	*.906*		
M 14	2.00	80.30	.429 x .322	E	6HX	1	1	T100-KM107AA-M14	★	10.9	14.00	110.0	23.0	5	DIN 376/ANSI
		3.161								*.429*	*.551*	*4.331*	*.906*		
M 16	2.00	65.70	.480 x .360	E	6HX	1	1	T100-KM107AA-M16	★	12.2	16.00	110.0	23.0	5	DIN 376/ANSI
		2.587								*.480*	*.630*	*4.331*	*.906*		
M 20	2.50	92.50	.652 x .489	E	6HX	1	1	T100-KM107AA-M20	★	16.6	20.00	140.0	30.0	5	DIN 376/ANSI
		3.642								*.652*	*.787*	*5.512*	*1.181*		
M 6	1.00	25.00	.255 x .191	C	6HX	1	2	T100-KM108AA-M6	★	6.5	6.00	80.0	15.6	5	DIN 371/ANSI
		.984								*.255*	*.236*	*3.150*	*.614*		
M 8	1.25	33.50	.318 x .238	C	6HX	1	2	T100-KM108AA-M8	★	8.1	8.00	90.0	18.7	5	DIN 371/ANSI
		1.319								*.318*	*.315*	*3.543*	*.736*		
M 10	1.50	38.00	.381 x .286	C	6HX	1	2	T100-KM108AA-M10	★	9.7	10.00	100.0	20.6	5	DIN 371/ANSI
		1.496								*.381*	*.394*	*3.937*	*.811*		
M 12	1.75	81.90	.367 x .275	C	6HX	1	2	T100-KM109AA-M12	★	9.3	12.00	110.0	23.0	5	DIN 376/ANSI
		3.224								*.367*	*.472*	*4.331*	*.906*		
M 14	2.00	80.30	.429 x .322	C	6HX	1	2	T100-KM109AA-M14	★	10.9	14.00	110.0	23.0	5	DIN 376/ANSI
		3.161								*.429*	*.551*	*4.331*	*.906*		
M 16	2.00	65.70	.480 x .360	C	6HX	1	2	T100-KM109AA-M16	★	12.2	16.00	110.0	23.0	5	DIN 376/ANSI
		2.587								*.480*	*.630*	*4.331*	*.906*		
M 20	2.50	92.50	.652 x .489	C	6HX	1	2	T100-KM109AA-M20	★	16.6	20.00	140.0	30.0	5	DIN 376/ANSI
		3.642								*.652*	*.787*	*5.512*	*1.181*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

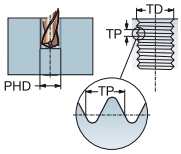
C172 C157 E9 E27 E28 C154

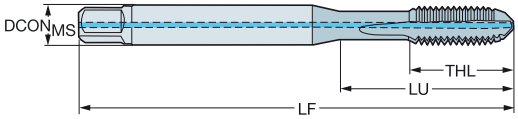
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	K D210	$DCON_{MS}$	TD	LF	THL	NOF	BSG
										Dimensions, mm, inch					
M 6	1.00	30.00	6.00 x 4.90	E	6HX	1	1	T100-KM106DA-M6	★	6.0	6.00	80.0	15.0	5	DIN 371
		1.181								*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	E	6HX	1	1	T100-KM106DA-M8	★	8.0	8.00	90.0	18.0	5	DIN 371
		1.378								*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	E	6HX	1	1	T100-KM106DA-M10	★	10.0	10.00	100.0	20.0	5	DIN 371
		1.535								*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	E	6HX	1	1	T100-KM107DA-M12	★	9.0	12.00	110.0	23.0	5	DIN 376
		3.268								*.354*	*.472*	*4.331*	*.906*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	2	T100-KM108DA-M6	★	6.0	6.00	80.0	15.0	5	DIN 371
		1.181								*.236*	*.236*	*3.150*	*.591*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	2	T100-KM108DA-M8	★	8.0	8.00	90.0	18.0	5	DIN 371
		1.378								*.315*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	2	T100-KM108DA-M10	★	10.0	10.00	100.0	20.0	5	DIN 371
		1.535								*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	2	T100-KM109DA-M12	★	9.0	12.00	110.0	23.0	5	DIN 376
		3.268								*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	1	2	T100-KM109DA-M14	★	11.0	14.00	110.0	25.0	5	DIN 376
		3.189								*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	2	T100-KM109DA-M16	★	12.0	16.00	110.0	25.0	5	DIN 376
		2.677								*.472*	*.630*	*4.331*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	1	2	T100-KM109DA-M20	★	16.0	20.00	140.0	30.0	5	DIN 376
		3.740								*.630*	*.787*	*5.512*	*1.181*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

C172 C157 E9 E27 E28 C154

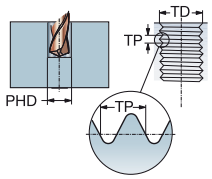
SANDVIK Coromant

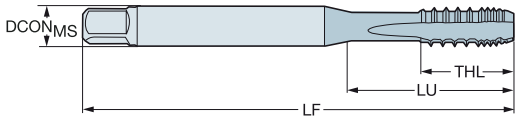
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric

DIN 371

ULDR 2.0
SUBSTRATE HSS-E-PM



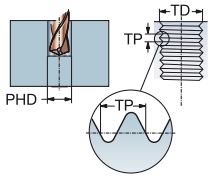


N

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

DIN 376

ULDR 2.0
SUBSTRATE HSS-E-PM



N

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

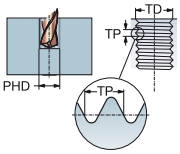
C172 C157 E9 E27 E28 C154

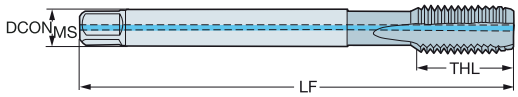
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric fine

DIN 374

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	K D210	$DCON_{MS}$	TD	LF	THL	NOF	BSG
										Dimensions, mm, inch					
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	1	1	T100-KM104DB-M10X100	★	7.0	10.00	90.0	18.0	5	DIN 374
		2.638								*.276*	*.394*	*3.543*	*.709*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	1	1	T100-KM104DB-M10X125	★	7.0	10.00	100.0	20.0	5	DIN 374
		3.032								*.276*	*.394*	*3.937*	*.787*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	1	1	T100-KM104DB-M12X125	★	9.0	12.00	100.0	21.0	5	DIN 374
		2.874								*.354*	*.472*	*3.937*	*.827*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	1	1	T100-KM104DB-M12X150	★	9.0	12.00	100.0	21.0	5	DIN 374
		2.874								*.354*	*.472*	*3.937*	*.827*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	1	1	T100-KM104DB-M14X150	★	11.0	14.00	100.0	21.0	5	DIN 374
		2.795								*.433*	*.551*	*3.937*	*.827*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	1	1	T100-KM104DB-M16X150	★	12.0	16.00	100.0	21.0	5	DIN 374
		2.283								*.472*	*.630*	*3.937*	*.827*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	1	1	T100-KM104DB-M18X150	★	14.0	18.00	110.0	24.0	5	DIN 374
		2.598								*.551*	*.709*	*4.331*	*.945*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	1	1	T100-KM104DB-M20X150	★	16.0	20.00	125.0	24.0	5	DIN 374
		3.150								*.630*	*.787*	*4.921*	*.945*		
MF 10x1	1.00	67.00	7.00 x 5.50	E	6HX	1	1	T100-KM106DB-M10X100	★	7.0	10.00	90.0	18.0	5	DIN 374
		2.638								*.276*	*.394*	*3.543*	*.709*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	E	6HX	1	1	T100-KM106DB-M10X125	★	7.0	10.00	100.0	20.0	5	DIN 374
		3.032								*.276*	*.394*	*3.937*	*.787*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	E	6HX	1	1	T100-KM106DB-M12X125	★	9.0	12.00	100.0	21.0	5	DIN 374
		2.874								*.354*	*.472*	*3.937*	*.827*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	E	6HX	1	1	T100-KM106DB-M12X150	★	9.0	12.00	100.0	21.0	5	DIN 374
		2.874								*.354*	*.472*	*3.937*	*.827*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	E	6HX	1	1	T100-KM106DB-M14X150	★	11.0	14.00	100.0	21.0	5	DIN 374
		2.795								*.433*	*.551*	*3.937*	*.827*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	E	6HX	1	1	T100-KM106DB-M16X150	★	12.0	16.00	100.0	21.0	5	DIN 374
		2.283								*.472*	*.630*	*3.937*	*.827*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	E	6HX	1	1	T100-KM106DB-M18X150	★	14.0	18.00	110.0	24.0	5	DIN 374
		2.598								*.551*	*.709*	*4.331*	*.945*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	E	6HX	1	1	T100-KM106DB-M20X150	★	16.0	20.00	125.0	24.0	5	DIN 374
		3.150								*.630*	*.787*	*4.921*	*.945*		
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	1	2	T100-KM108DB-M10X100	★	7.0	10.00	90.0	18.0	5	DIN 374
		2.638								*.276*	*.394*	*3.543*	*.709*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	1	2	T100-KM108DB-M10X125	★	7.0	10.00	100.0	20.0	5	DIN 374
		3.032								*.276*	*.394*	*3.937*	*.787*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	1	2	T100-KM108DB-M12X125	★	9.0	12.00	100.0	21.0	5	DIN 374
		2.874								*.354*	*.472*	*3.937*	*.827*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	1	2	T100-KM108DB-M12X150	★	9.0	12.00	100.0	21.0	5	DIN 374
		2.874								*.354*	*.472*	*3.937*	*.827*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	1	2	T100-KM108DB-M14X150	★	11.0	14.00	100.0	21.0	5	DIN 374
		2.795								*.433*	*.551*	*3.937*	*.827*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	1	2	T100-KM108DB-M16X150	★	12.0	16.00	100.0	21.0	5	DIN 374
		2.283								*.472*	*.630*	*3.937*	*.827*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	1	2	T100-KM108DB-M18X150	★	14.0	18.00	110.0	24.0	5	DIN 374
		2.598								*.551*	*.709*	*4.331*	*.945*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	1	2	T100-KM108DB-M20X150	★	16.0	20.00	125.0	24.0	5	DIN 374
		3.150								*.630*	*.787*	*4.921*	*.945*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

C172 C157 E9 E27 E28 C154

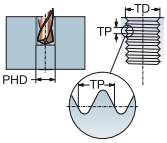
SANDVIK Coromant

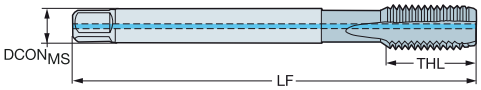
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric fine

DIN 374

ULDR 2.5
SUBSTRATE HM
COATING PVD TIALN





K

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	CNSC	CXSC	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
									Dimensions, mm, inch					
MF 8x1	1.00	67.00	6.00 x 4.90	C	6HX	1	1	T120M8X1.0	6.0	8.00	90.0	12.0	4	DIN 374
		2.638							*.236*	*.315*	*3.543*	*.472*		
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	1	1	T120M10X1.0	7.0	10.00	90.0	14.0	4	DIN 374
		2.638							*.276*	*.394*	*3.543*	*.551*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	1	1	T120M12X1.5	9.0	12.00	100.0	20.0	4	DIN 374
		2.874							*.354*	*.472*	*3.937*	*.787*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	1	1	T120M14X1.5	11.0	14.00	100.0	21.0	4	DIN 374
		2.795							*.433*	*.551*	*3.937*	*.827*		

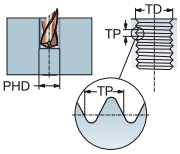
CXSC 1 = Axial concentric coolant exit

C172 C157 E9 E28 C154

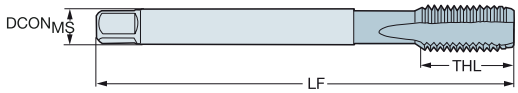
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric fine

DIN 374



ULDR	2.5
SUBSTRATE	HSS-E-PM
COATING	PVD TIALN



TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	K / D210	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	T100-KM100DB-M10X100	★	7.0	10.00	90.0	18.0	5	9.0	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.709*		*.354*	
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	T100-KM100DB-M10X125	★	7.0	10.00	100.0	20.0	5	8.8	DIN 374
		3.032						*.276*	*.394*	*3.937*	*.787*		*.346*	
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	T100-KM100DB-M12X125	★	9.0	12.00	100.0	21.0	5	10.8	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.423*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	T100-KM100DB-M12X150	★	9.0	12.00	100.0	21.0	5	10.5	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.413*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	T100-KM100DB-M14X150	★	11.0	14.00	100.0	21.0	5	12.5	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.492*	
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	T100-KM100DB-M16X150	★	12.0	16.00	100.0	21.0	5	14.5	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.827*		*.571*	
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	T100-KM100DB-M18X150	★	14.0	18.00	110.0	24.0	5	16.5	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.945*		*.650*	
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	T100-KM100DB-M20X150	★	16.0	20.00	125.0	24.0	5	18.5	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.945*		*.728*	
MF 10x1	1.00	67.00	7.00 x 5.50	E	6HX	T100-KM102DB-M10X100	★	7.0	10.00	90.0	18.0	5	9.0	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.709*		*.354*	
MF 10x1.25	1.25	77.00	7.00 x 5.50	E	6HX	T100-KM102DB-M10X125	★	7.0	10.00	100.0	20.0	5	8.8	DIN 374
		3.032						*.276*	*.394*	*3.937*	*.787*		*.346*	
MF 12x1.25	1.25	73.00	9.00 x 7.00	E	6HX	T100-KM102DB-M12X125	★	9.0	12.00	100.0	21.0	5	10.8	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.423*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	E	6HX	T100-KM102DB-M12X150	★	9.0	12.00	100.0	21.0	5	10.5	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.413*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	E	6HX	T100-KM102DB-M14X150	★	11.0	14.00	100.0	21.0	5	12.5	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.492*	
MF 16x1.5	1.50	58.00	12.00 x 9.00	E	6HX	T100-KM102DB-M16X150	★	12.0	16.00	100.0	21.0	5	14.5	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.827*		*.571*	
MF 18x1.5	1.50	66.00	14.00 x 11.00	E	6HX	T100-KM102DB-M18X150	★	14.0	18.00	110.0	24.0	5	16.5	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.945*		*.650*	
MF 20x1.5	1.50	80.00	16.00 x 12.00	E	6HX	T100-KM102DB-M20X150	★	16.0	20.00	125.0	24.0	5	18.5	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.945*		*.728*	

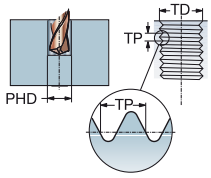
C172 C157 E9 E27 C154

SANDVIK Coromant

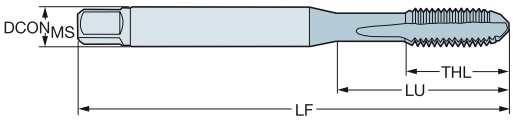
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric fine

DIN 374/ANSI



ULDR	2.5
SUBSTRATE	HSS-E-PM
COATING	PVD TIALN



Dimensions, mm, inch

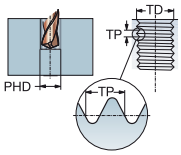
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	K	D210	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 10x1	1.00	38.00	.381 x .286	C	6HX	T100-KM100AB-M10X100	★		9.7	10.00	90.0	20.6	5	9.0	DIN 374/ANSI
		1.496							*.381*	*.394*	*3.543*	*.811*		*.354*	
MF 12x1.25	1.25	71.90	.367 x .275	C	6HX	T100-KM101AB-M12X125	★		9.3	12.00	100.0	23.0	5	10.8	DIN 374/ANSI
		2.831							*.367*	*.472*	*3.937*	*.906*		*.423*	
MF 12x1.5	1.50	71.90	.367 x .275	C	6HX	T100-KM101AB-M12X150	★		9.3	12.00	100.0	23.0	5	10.5	DIN 374/ANSI
		2.831							*.367*	*.472*	*3.937*	*.906*		*.413*	
MF 14x1.5	1.50	70.30	.429 x .322	C	6HX	T100-KM101AB-M14X150	★		10.9	14.00	100.0	23.0	5	12.5	DIN 374/ANSI
		2.768							*.429*	*.551*	*3.937*	*.906*		*.492*	

C172 C157 E9 E27 C154

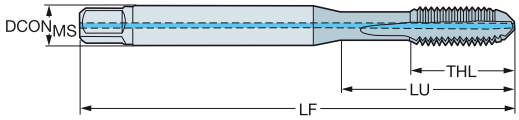
CoroTap™ 100 cutting tap with straight flutes

Thread form: Metric fine

DIN 374/ANSI



ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN



TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	K ISO 513 D210	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	BSG
MF 10x1.25	1.25	38.00	.381 x .286	C	6HX	1	1	T100-KM104AB-M10X125	★	9.7	10.00	100.0	20.6	5	DIN 374/ANSI
		1.496								*.381*	*.394*	*3.937*	*.811*		
MF 14x1.5	1.50	70.30	.429 x .322	C	6HX	1	1	T100-KM105AB-M14X150	★	10.9	14.00	100.0	23.0	5	DIN 374/ANSI
		2.768								*.429*	*.551*	*3.937*	*.906*		
MF 10x1.25	1.25	38.00	.381 x .286	C	6HX	1	2	T100-KM108AB-M10X125	★	9.7	10.00	100.0	20.6	5	DIN 374/ANSI
		1.496								*.381*	*.394*	*3.937*	*.811*		
MF 12x1.5	1.50	71.90	.367 x .275	C	6HX	1	2	T100-KM109AB-M12X150	★	9.3	12.00	100.0	23.0	5	DIN 374/ANSI
		2.831								*.367*	*.472*	*3.937*	*.906*		
MF 14x1.5	1.50	70.30	.429 x .322	C	6HX	1	2	T100-KM109AB-M14X150	★	10.9	14.00	100.0	23.0	5	DIN 374/ANSI
		2.768								*.429*	*.551*	*3.937*	*.906*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

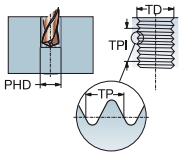
C172 C157 E9 E27 E28 C154

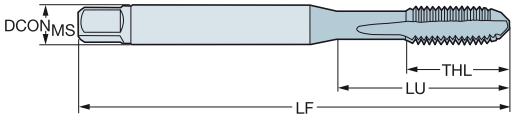
CoroTap™ 100 cutting tap with straight flutes

Thread form: UNC

DIN 2184-1/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	K D210	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC 1/4-20	20.00	25.00	.255 x .191	C	2BX	T100-KM100AE-1/4	★	6.5	6.35	80.0	15.6	5	5.1	DIN 2184-1/ANSI
		.984						*.255*	*.250*	*3.150*	*.614*		*.201*	
UNC 5/16-18	18.00	33.50	.318 x .238	C	2BX	T100-KM100AE-5/16	★	8.1	7.94	90.0	18.7	5	6.6	DIN 2184-1/ANSI
		1.319						*.318*	*.313*	*3.543*	*.736*		*.260*	
UNC 3/8-16	16.00	38.00	.381 x .286	C	2BX	T100-KM100AE-3/8	★	9.7	9.53	100.0	20.6	5	8.0	DIN 2184-1/ANSI
		1.496						*.381*	*.375*	*3.937*	*.811*		*.315*	
UNC 7/16-14	14.00	72.70	.323 x .242	C	2BX	T100-KM101AE-7/16	★	8.2	11.11	100.0	20.0	5	9.4	DIN 2184-1/ANSI
		2.862						*.323*	*.438*	*3.937*	*.787*		*.370*	
UNC 1/2-13	13.00	81.90	.367 x .275	C	2BX	T100-KM101AE-1/2	★	9.3	12.70	110.0	23.0	5	10.8	DIN 2184-1/ANSI
		3.224						*.367*	*.500*	*4.331*	*.906*		*.425*	
UNC 5/8-11	11.00	65.70	.480 x .360	C	2BX	T100-KM101AE-5/8	★	12.2	15.88	110.0	23.0	5	13.5	DIN 2184-1/ANSI
		2.587						*.480*	*.625*	*4.331*	*.906*		*.531*	
UNC 3/4-10	10.00	77.50	.590 x .442	C	2BX	T100-KM101AE-3/4	★	15.0	19.05	125.0	30.0	5	16.5	DIN 2184-1/ANSI
		3.051						*.590*	*.750*	*4.921*	*1.181*		*.650*	
UNC 7/8-9	9.00	90.95	.697 x .523	C	2BX	T100-KM101AE-7/8	★	17.7	22.23	140.0	34.0	5	19.5	DIN 2184-1/ANSI
		3.581						*.697*	*.875*	*5.512*	*1.339*		*.768*	
UNC 1/4-20	20.00	25.00	.255 x .191	E	2BX	T100-KM102AE-1/4	★	6.5	6.35	80.0	15.6	5	5.1	DIN 2184-1/ANSI
		.984						*.255*	*.250*	*3.150*	*.614*		*.201*	
UNC 5/16-18	18.00	33.50	.318 x .238	E	2BX	T100-KM102AE-5/16	★	8.1	7.94	90.0	18.7	5	6.6	DIN 2184-1/ANSI
		1.319						*.318*	*.313*	*3.543*	*.736*		*.260*	
UNC 3/8-16	16.00	38.00	.381 x .286	E	2BX	T100-KM102AE-3/8	★	9.7	9.53	100.0	20.6	5	8.0	DIN 2184-1/ANSI
		1.496						*.381*	*.375*	*3.937*	*.811*		*.315*	
UNC 1/2-13	13.00	81.90	.367 x .275	E	2BX	T100-KM103AE-1/2	★	9.3	12.70	110.0	23.0	5	10.8	DIN 2184-1/ANSI
		3.224						*.367*	*.500*	*4.331*	*.906*		*.425*	
UNC 5/8-11	11.00	65.70	.480 x .360	E	2BX	T100-KM103AE-5/8	★	12.2	15.88	110.0	23.0	5	13.5	DIN 2184-1/ANSI
		2.587						*.480*	*.625*	*4.331*	*.906*		*.531*	
UNC 3/4-10	10.00	77.50	.590 x .442	E	2BX	T100-KM103AE-3/4	★	15.0	19.05	125.0	30.0	5	16.5	DIN 2184-1/ANSI
		3.051						*.590*	*.750*	*4.921*	*1.181*		*.650*	
UNC 7/8-9	9.00	90.95	.697 x .523	E	2BX	T100-KM103AE-7/8	★	17.7	22.23	140.0	34.0	5	19.5	DIN 2184-1/ANSI
		3.581						*.697*	*.875*	*5.512*	*1.339*		*.768*	

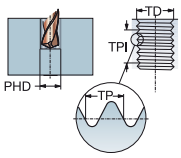
C172 C157 E9 E27 C154

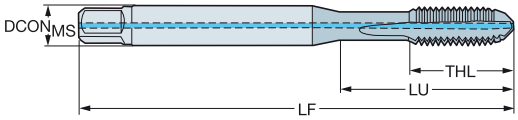
CoroTap™ 100 cutting tap with straight flutes

Thread form: UNC

DIN 2184-1/ANSI, DIN 376/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	K D210	$DCON_{MS}$	TD	LF	THL	NOF	BSG
										Dimensions, mm, inch					
UNC 1/4-20	20.00	25.00	.255 x .191	C	2BX	1	1	T100-KM104AE-1/4	★	6.5	6.35	80.0	15.6	5	DIN 2184-1/ANSI
		.984								*.255*	*.250*	*3.150*	*.614*		
UNC 5/16-18	18.00	33.50	.318 x .238	C	2BX	1	1	T100-KM104AE-5/16	★	8.1	7.94	90.0	18.7	5	DIN 2184-1/ANSI
		1.319								*.318*	*.313*	*3.543*	*.736*		
UNC 3/8-16	16.00	38.00	.381 x .286	C	2BX	1	1	T100-KM104AE-3/8	★	9.7	9.53	100.0	20.6	5	DIN 2184-1/ANSI
		1.496								*.381*	*.375*	*3.937*	*.811*		
UNC 7/16-14	14.00	72.70	.323 x .242	C	2BX	1	1	T100-KM105AE-7/16	★	8.2	11.11	100.0	20.0	5	DIN 376/ANSI
		2.862								*.323*	*.438*	*3.937*	*.787*		
UNC 1/2-13	13.00	81.90	.367 x .275	C	2BX	1	1	T100-KM105AE-1/2	★	9.3	12.70	110.0	23.0	5	DIN 2184-1/ANSI
		3.224								*.367*	*.500*	*4.331*	*.906*		
UNC 1/4-20	20.00	25.00	.255 x .191	E	2BX	1	1	T100-KM106AE-1/4	★	6.5	6.35	80.0	15.6	5	DIN 2184-1/ANSI
		.984								*.255*	*.250*	*3.150*	*.614*		
UNC 5/16-18	18.00	33.50	.318 x .238	E	2BX	1	1	T100-KM106AE-5/16	★	8.1	7.94	90.0	18.7	5	DIN 2184-1/ANSI
		1.319								*.318*	*.313*	*3.543*	*.736*		
UNC 3/8-16	16.00	38.00	.381 x .286	E	2BX	1	1	T100-KM106AE-3/8	★	9.7	9.53	100.0	20.6	5	DIN 2184-1/ANSI
		1.496								*.381*	*.375*	*3.937*	*.811*		
UNC 1/2-13	13.00	81.90	.367 x .275	E	2BX	1	1	T100-KM107AE-1/2	★	9.3	12.70	110.0	23.0	5	DIN 2184-1/ANSI
		3.224								*.367*	*.500*	*4.331*	*.906*		
UNC 1/4-20	20.00	25.00	.255 x .191	C	2BX	1	2	T100-KM108AE-1/4	★	6.5	6.35	80.0	15.6	5	DIN 2184-1/ANSI
		.984								*.255*	*.250*	*3.150*	*.614*		
UNC 5/16-18	18.00	33.50	.318 x .238	C	2BX	1	2	T100-KM108AE-5/16	★	8.1	7.94	90.0	18.7	5	DIN 2184-1/ANSI
		1.319								*.318*	*.313*	*3.543*	*.736*		
UNC 3/8-16	16.00	38.00	.381 x .286	C	2BX	1	2	T100-KM108AE-3/8	★	9.7	9.53	100.0	20.6	5	DIN 2184-1/ANSI
		1.496								*.381*	*.375*	*3.937*	*.811*		
UNC 7/16-14	14.00	72.70	.323 x .242	C	2BX	1	2	T100-KM109AE-7/16	★	8.2	11.11	100.0	20.0	5	DIN 2184-1/ANSI
		2.862								*.323*	*.438*	*3.937*	*.787*		
UNC 1/2-13	13.00	81.90	.367 x .275	C	2BX	1	2	T100-KM109AE-1/2	★	9.3	12.70	110.0	23.0	5	DIN 2184-1/ANSI
		3.224								*.367*	*.500*	*4.331*	*.906*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

C172 C157 E9 E27 E28 C154

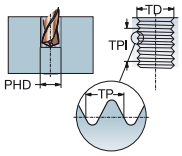
SANDVIK Coromant

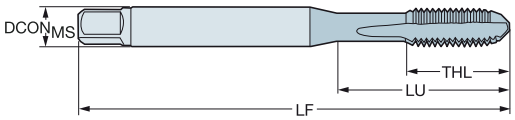
CoroTap™ 100 cutting tap with straight flutes

Thread form: UNF

DIN 2184-1/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	K D210	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF 1/4-28	28.00	25.00	.255 x .191	C	2BX	T100-KM100AF-1/4	★	6.5	6.35	80.0	15.6	5	5.5	DIN 2184-1/ANSI
		.984						*.255*	*.250*	*3.150*	*.614*		*.217*	
UNF 5/16-24	24.00	33.50	.318 x .238	C	2BX	T100-KM100AF-5/16	★	8.1	7.94	90.0	18.7	5	6.9	DIN 2184-1/ANSI
		1.319						*.318*	*.313*	*3.543*	*.736*		*.272*	
UNF 3/8-24	24.00	38.00	.381 x .286	C	2BX	T100-KM100AF-3/8	★	9.7	9.53	90.0	20.6	5	8.5	DIN 2184-1/ANSI
		1.496						*.381*	*.375*	*3.543*	*.811*		*.335*	
UNF 7/16-20	20.00	72.70	.323 x .242	C	2BX	T100-KM101AF-7/16	★	8.2	11.11	100.0	20.0	5	9.9	DIN 2184-1/ANSI
		2.862						*.323*	*.438*	*3.937*	*.787*		*.390*	
UNF 1/2-20	20.00	71.90	.367 x .275	C	2BX	T100-KM101AF-1/2	★	9.3	12.70	100.0	23.0	5	11.5	DIN 2184-1/ANSI
		2.831						*.367*	*.500*	*3.937*	*.906*		*.453*	
UNF 3/4-16	16.00	62.50	.590 x .442	C	2BX	T100-KM101AF-3/4	★	15.0	19.05	110.0	25.0	5	17.5	DIN 2184-1/ANSI
		2.461						*.590*	*.750*	*4.331*	*.984*		*.689*	
UNF 1/4-28	28.00	25.00	.255 x .191	E	2BX	T100-KM102AF-1/4	★	6.5	6.35	80.0	15.6	5	5.5	DIN 2184-1/ANSI
		.984						*.255*	*.250*	*3.150*	*.614*		*.217*	
UNF 3/8-24	24.00	38.00	.381 x .286	E	2BX	T100-KM102AF-3/8	★	9.7	9.53	90.0	20.6	5	8.5	DIN 2184-1/ANSI
		1.496						*.381*	*.375*	*3.543*	*.811*		*.335*	
UNF 7/16-20	20.00	72.70	.323 x .242	E	2BX	T100-KM103AF-7/16	★	8.2	11.11	100.0	20.0	5	9.9	DIN 2184-1/ANSI
		2.862						*.323*	*.438*	*3.937*	*.787*		*.390*	
UNF 1/2-20	20.00	71.90	.367 x .275	E	2BX	T100-KM103AF-1/2	★	9.3	12.70	100.0	23.0	5	11.5	DIN 2184-1/ANSI
		2.831						*.367*	*.500*	*3.937*	*.906*		*.453*	
UNF 5/8-18	18.00	55.70	.480 x .360	E	2BX	T100-KM103AF-5/8	★	12.2	15.88	100.0	23.0	5	14.5	DIN 2184-1/ANSI
		2.193						*.480*	*.625*	*3.937*	*.906*		*.571*	
UNF 3/4-16	16.00	62.50	.590 x .442	E	2BX	T100-KM103AF-3/4	★	15.0	19.05	110.0	25.0	5	17.5	DIN 2184-1/ANSI
		2.461						*.590*	*.750*	*4.331*	*.984*		*.689*	
UNF 7/8-14	14.00	75.95	.697 x .523	E	2BX	T100-KM103AF-7/8	★	17.7	22.23	125.0	25.0	5	20.4	DIN 2184-1/ANSI
		2.990						*.697*	*.875*	*4.921*	*.984*		*.803*	

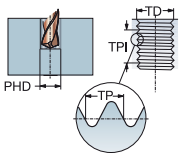
C172 C157 E9 E27 C154

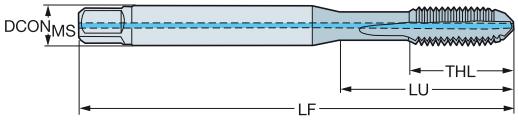
CoroTap™ 100 cutting tap with straight flutes

Thread form: UNF

DIN 2184-1/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	K C210	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	BSG
UNF 1/4-28	28.00	25.00	.255 x .191	C	2BX	1	1	T100-KM104AF-1/4	★	6.5	6.35	80.0	15.6	5	DIN 2184-1/ANSI
		.984								*.255*	*.250*	*3.150*	*.614*		
UNF 5/16-24	24.00	33.50	.318 x .238	C	2BX	1	1	T100-KM104AF-5/16	★	8.1	7.94	90.0	18.7	5	DIN 2184-1/ANSI
		1.319								*.318*	*.313*	*3.543*	*.736*		
UNF 3/8-24	24.00	38.00	.381 x .286	C	2BX	1	1	T100-KM104AF-3/8	★	9.7	9.53	90.0	20.6	5	DIN 2184-1/ANSI
		1.496								*.381*	*.375*	*3.543*	*.811*		
UNF 7/16-20	20.00	72.70	.323 x .242	C	2BX	1	1	T100-KM105AF-7/16	★	8.2	11.11	100.0	20.0	5	DIN 2184-1/ANSI
		2.862								*.323*	*.438*	*3.937*	*.787*		
UNF 1/2-20	20.00	71.90	.367 x .275	C	2BX	1	1	T100-KM105AF-1/2	★	9.3	12.70	100.0	23.0	5	DIN 2184-1/ANSI
		2.831								*.367*	*.500*	*3.937*	*.906*		
UNF 1/4-28	28.00	25.00	.255 x .191	E	2BX	1	1	T100-KM106AF-1/4	★	6.5	6.35	80.0	15.6	5	DIN 2184-1/ANSI
		.984								*.255*	*.250*	*3.150*	*.614*		
UNF 5/16-24	24.00	33.50	.318 x .238	E	2BX	1	1	T100-KM106AF-5/16	★	8.1	7.94	90.0	18.7	5	DIN 2184-1/ANSI
		1.319								*.318*	*.313*	*3.543*	*.736*		
UNF 3/8-24	24.00	38.00	.381 x .286	E	2BX	1	1	T100-KM106AF-3/8	★	9.7	9.53	90.0	20.6	5	DIN 2184-1/ANSI
		1.496								*.381*	*.375*	*3.543*	*.811*		
UNF 7/16-20	20.00	72.70	.323 x .242	E	2BX	1	1	T100-KM107AF-7/16	★	8.2	11.11	100.0	20.0	5	DIN 2184-1/ANSI
		2.862								*.323*	*.438*	*3.937*	*.787*		
UNF 1/2-20	20.00	71.90	.367 x .275	E	2BX	1	1	T100-KM107AF-1/2	★	9.3	12.70	100.0	23.0	5	DIN 2184-1/ANSI
		2.831								*.367*	*.500*	*3.937*	*.906*		
UNF 1/4-28	28.00	25.00	.255 x .191	C	2BX	1	2	T100-KM108AF-1/4	★	6.5	6.35	80.0	15.6	5	DIN 2184-1/ANSI
		.984								*.255*	*.250*	*3.150*	*.614*		
UNF 5/16-24	24.00	33.50	.318 x .238	C	2BX	1	2	T100-KM108AF-5/16	★	8.1	7.94	90.0	18.7	5	DIN 2184-1/ANSI
		1.319								*.318*	*.313*	*3.543*	*.736*		
UNF 3/8-24	24.00	38.00	.381 x .286	C	2BX	1	2	T100-KM108AF-3/8	★	9.7	9.53	90.0	20.6	5	DIN 2184-1/ANSI
		1.496								*.381*	*.375*	*3.543*	*.811*		
UNF 7/16-20	20.00	72.70	.323 x .242	C	2BX	1	2	T100-KM109AF-7/16	★	8.2	11.11	100.0	20.0	5	DIN 2184-1/ANSI
		2.862								*.323*	*.438*	*3.937*	*.787*		
UNF 1/2-20	20.00	71.90	.367 x .275	C	2BX	1	2	T100-KM109AF-1/2	★	9.3	12.70	100.0	23.0	5	DIN 2184-1/ANSI
		2.831								*.367*	*.500*	*3.937*	*.906*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

C172 C157 E9 E27 E28 C154

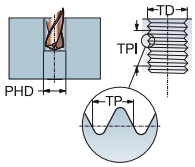
SANDVIK Coromant

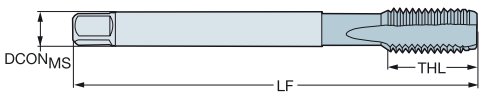
CoroTap™ 100 cutting tap with straight flutes

Thread form: G

DIN 5156

ULDR 2.0
SUBSTRATE HSS-E
COATING PVD FEN





K

							Dimensions, mm, inch					
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
G 1/8-28	28.00	67.00	7.00 x 5.50	C	NORMAL	E4161/8	7.0	9.73	90.0	20.0	4	DIN 5156
		2.638					*.276*	*.383*	*3.543*	*.787*		
G 1/4-19	19.00	71.00	11.00 x 9.00	C	NORMAL	E4161/4	11.0	13.16	100.0	21.0	4	DIN 5156
		2.795					*.433*	*.518*	*3.937*	*.827*		
G 3/8-19	19.00	58.00	12.00 x 9.00	C	NORMAL	E4163/8	12.0	16.66	100.0	21.0	5	DIN 5156
		2.283					*.472*	*.656*	*3.937*	*.827*		
G 1/2-14	14.00	80.00	16.00 x 12.00	C	NORMAL	E4161/2	16.0	20.96	125.0	24.0	5	DIN 5156
		3.150					*.630*	*.825*	*4.921*	*.945*		
G 3/4-14	14.00	77.00	20.00 x 16.00	C	NORMAL	E4163/4	20.0	26.44	140.0	28.0	6	DIN 5156
		3.032					*.787*	*1.041*	*5.512*	*1.102*		
G 1"-11	11.00	93.00	25.00 x 20.00	C	NORMAL	E4161	25.0	33.25	160.0	30.0	6	DIN 5156
		3.661					*.984*	*1.309*	*6.299*	*1.181*		

C172 C157 E9 C154

CoroTap™ 200

Applications

- Only for through holes
- Available in many thread forms and standards
- Up to 3 × D depending on materials

O C

Benefits and features

- Chamfer B (3.5–5 threads) for high process security
- Edge treatment for reduced axial force and torque makes the tool run more smoothly, reduces risk of cutting-edge chipping, and improves surface quality, tool life, and chip formation
- High speed powder steel taps for improved strength, wear resistance, and tool life
- Different coatings and grades are available

- Taps with spiral point grinding
- Pushes the chips forward
- Used for through holes

www.sandvik.coromant.com/corotap200

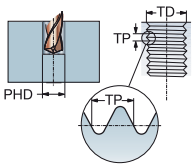
CoroChuck™ 970, see our Rotating Tools catalog.

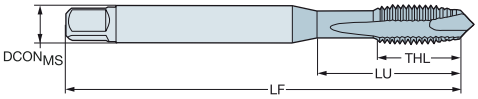
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

C-DIN371, DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
30–48 HRC

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 3	0.50	12.00	4.50 x 3.40	B	6H	E324M3	4.5	3.00	63.0	12.0	3	C-DIN 371
		.472					*.177*	*.118*	*2.480*	*.472*		
M 4	0.70	13.00	6.00 x 4.90	B	6H	E324M4	6.0	4.00	70.0	13.0	3	C-DIN 371
		.512					*.236*	*.157*	*2.756*	*.512*		
M 5	0.80	15.00	6.00 x 4.90	B	6H	E324M5	6.0	5.00	80.0	15.0	3	C-DIN 371
		.591					*.236*	*.197*	*3.150*	*.591*		
M 6	1.00	18.00	8.00 x 6.20	B	6H	E324M6	8.0	6.00	90.0	18.0	3	C-DIN 371
		.709					*.315*	*.236*	*3.543*	*.709*		
M 8	1.25	20.00	10.00 x 8.00	B	6H	E324M8	10.0	8.00	100.0	20.0	3	C-DIN 371
		.787					*.394*	*.315*	*3.937*	*.787*		
M 10	1.50	39.00	10.00 x 8.00	B	6H	E324M10	10.0	10.00	100.0	20.0	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	B	6H	E326M12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	B	6H	E326M14	11.0	14.00	110.0	25.0	4	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	B	6H	E326M16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 18	2.50	81.00	14.00 x 11.00	B	6H	E326M18	14.0	18.00	125.0	30.0	4	DIN 376
		3.189					*.551*	*.709*	*4.921*	*1.181*		
M 20	2.50	95.00	16.00 x 12.00	B	6H	E326M20	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*1.181*		

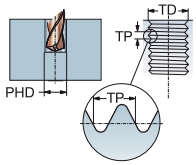
C174 C157 E9 C154

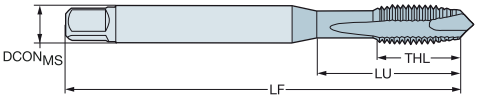
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

C-DIN/ANSI, DIN/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
30–48 HRC

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	13.00	.168 x .131	B	6H	E854M3	4.3	3.00	63.0	14.7	3	C-DIN/ANSI
		.512					*.168*	*.118*	*2.480*	*.579*		
M 4	0.70	15.10	.194 x .152	B	6H	E854M4	4.9	4.00	70.0	15.1	3	C-DIN/ANSI
		.594					*.194*	*.157*	*2.756*	*.594*		
M 5	0.80	17.00	.255 x .191	B	6H	E854M5	6.5	5.00	80.0	17.0	3	C-DIN/ANSI
		.669					*.255*	*.197*	*3.150*	*.669*		
M 6	1.00	20.20	.318 x .238	B	6H	E854M6	8.1	6.00	90.0	20.2	3	C-DIN/ANSI
		.795					*.318*	*.236*	*3.543*	*.795*		
M 8	1.25	20.00	.381 x .286	B	6H	E854M8	9.7	8.00	100.0	22.8	3	C-DIN/ANSI
		.787					*.381*	*.315*	*3.937*	*.898*		
M 10	1.50	37.80	.381 x .286	B	6H	E854M10	9.7	10.00	100.0	20.0	3	C-DIN/ANSI
		1.488					*.381*	*.394*	*3.937*	*.787*		
M 12	1.75	86.02	.367 x .275	B	6H	E854M12	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					*.367*	*.472*	*4.331*	*.906*		
M 14	2.00	84.82	.429 x .322	B	6H	E854M14	10.9	14.00	110.0	23.0	4	DIN/ANSI
		3.339					*.429*	*.551*	*4.331*	*.906*		
M 16	2.00	70.86	.480 x .360	B	6H	E854M16	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					*.480*	*.630*	*4.331*	*.906*		
M 18	2.50	84.69	.542 x .406	B	6H	E854M18	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					*.542*	*.709*	*4.921*	*1.181*		
M 20	2.50	97.58	.652 x .489	B	6H	E854M20	16.6	20.00	140.0	30.0	4	DIN/ANSI
		3.842					*.652*	*.787*	*5.512*	*1.181*		

C174 C157 E9 C154

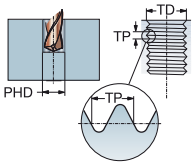
SANDVIK Coromant

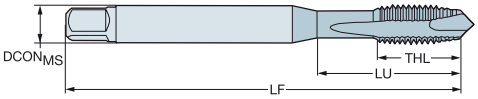
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TiAlN





P
≤350HB

							Dimensions, mm, inch					
TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
M 1	0.25	20.00	2.50 x 2.10	B	5HX	EP03PM1	2.5	1.00	40.0	5.0	2	DIN 371
		.787					*.098*	*.039*	*1.575*	*.197*		
M 1.2	0.25	20.00	2.50 x 2.10	B	5HX	EP03PM1.2	2.5	1.20	40.0	5.0	2	DIN 371
		.787					*.098*	*.047*	*1.575*	*.197*		
M 1.4	0.30	20.00	2.50 x 2.10	B	5HX	EP03PM1.4	2.5	1.40	40.0	6.5	2	DIN 371
		.787					*.098*	*.055*	*1.575*	*.256*		
M 1.6	0.35	20.00	2.50 x 2.10	B	6HX	EP03PM1.6	2.5	1.60	40.0	7.0	2	DIN 371
		.787					*.098*	*.063*	*1.575*	*.276*		
M 1.8	0.35	20.00	2.50 x 2.10	B	6HX	EP03PM1.8	2.5	1.80	40.0	7.0	2	DIN 371
		.787					*.098*	*.071*	*1.575*	*.276*		
M 2	0.40	9.00	2.80 x 2.10	B	6HX	EP03PM2	2.8	2.00	45.0	6.0	2	DIN 371
		.354					*.110*	*.079*	*1.772*	*.236*		
M 2.2	0.45	12.00	2.80 x 2.10	B	6HX	EP03PM2.2	2.8	2.20	45.0	7.0	2	DIN 371
		.472					*.110*	*.087*	*1.772*	*.276*		
M 2.3	0.40	12.00	2.80 x 2.10	B	6HX	EP03PM2.3	2.8	2.30	45.0	7.0	2	DIN 371
		.472					*.110*	*.091*	*1.772*	*.276*		
M 2.5	0.45	12.50	2.80 x 2.10	B	6HX	EP03PM2.5	2.8	2.50	50.0	8.0	2	DIN 371
		.492					*.110*	*.098*	*1.969*	*.315*		
M 3	0.50	18.00	3.50 x 2.70	B	6HX	EP03PM3	3.5	3.00	56.0	8.9	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.350*		
M 3.5	0.60	20.00	4.00 x 3.00	B	6HX	EP03PM3.5	4.0	3.50	56.0	10.8	3	DIN 371
		.787					*.157*	*.138*	*2.205*	*.425*		
M 4	0.70	21.00	4.50 x 3.40	B	6HX	EP03PM4	4.5	4.00	63.0	11.7	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.461*		
M 4	0.70	43.00	2.80 x 2.10	B	6HX	EP03PM4DIN376	2.8	4.00	63.0	12.0	3	DIN 376
		1.693					*.110*	*.157*	*2.480*	*.472*		
M 5	0.80	25.00	6.00 x 4.90	B	6HX	EP03PM5	6.0	5.00	70.0	12.6	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.496*		
M 5	0.80	49.00	3.50 x 2.70	B	6HX	EP03PM5DIN376	3.5	5.00	70.0	13.2	3	DIN 376
		1.929					*.138*	*.197*	*2.756*	*.520*		
M 6	1.00	30.00	6.00 x 4.90	B	6HX	EP03PM6	6.0	6.00	80.0	14.5	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.571*		
M 6	1.00	59.00	4.50 x 3.40	B	6HX	EP03PM6DIN376	4.5	6.00	80.0	15.1	3	DIN 376
		2.323					*.177*	*.236*	*3.150*	*.594*		
M 7	1.00	30.00	7.00 x 5.50	B	6HX	EP03PM7	7.0	7.00	80.0	14.5	3	DIN 371
		1.181					*.276*	*.276*	*3.150*	*.571*		
M 8	1.25	35.00	8.00 x 6.20	B	6HX	EP03PM8	8.0	8.00	90.0	17.4	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.685*		
M 8	1.25	67.00	6.00 x 4.90	B	6HX	EP03PM8DIN376	6.0	8.00	90.0	18.0	3	DIN 376
		2.638					*.236*	*.315*	*3.543*	*.709*		
M 10	1.50	39.00	10.00 x 8.00	B	6HX	EP03PM10	10.0	10.00	100.0	19.2	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.756*		
M 10	1.50	77.00	7.00 x 5.50	B	6HX	EP03PM10DIN376	7.0	10.00	100.0	19.8	3	DIN 376
		3.032					*.276*	*.394*	*3.937*	*.780*		
M 12	1.75	83.00	9.00 x 7.00	B	6HX	EP03PM12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	B	6HX	EP03PM14	11.0	14.00	110.0	25.0	4	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	B	6HX	EP03PM16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 18	2.50	81.00	14.00 x 11.00	B	6HX	EP03PM18	14.0	18.00	125.0	30.0	4	DIN 376
		3.189					*.551*	*.709*	*4.921*	*1.181*		
M 20	2.50	95.00	16.00 x 12.00	B	6HX	EP03PM20	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*1.181*		

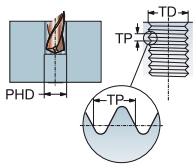
C174 C157 E9 C154

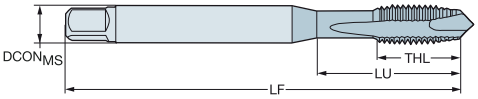
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 22	2.50	93.00	18.00 x 14.50	B	6HX	EP03PM22	18.0	22.00	140.0	34.0	4	DIN 376
		3.661					*.709*	*.866*	*5.512*	*1.339*		
M 24	3.00	113.00	18.00 x 14.50	B	6HX	EP03PM24	18.0	24.00	160.0	38.0	4	DIN 376
		4.449					*.709*	*.945*	*6.299*	*1.496*		
M 27	3.00	97.00	20.00 x 16.00	B	6HX	EP03PM27	20.0	27.00	160.0	38.0	4	DIN 376
		3.819					*.787*	*1.063*	*6.299*	*1.496*		
M 30	3.50	115.00	22.00 x 18.00	B	6HX	EP03PM30	22.0	30.00	180.0	45.0	4	DIN 376
		4.528					*.866*	*1.181*	*7.087*	*1.772*		

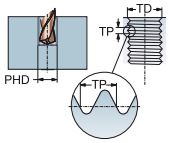
C174 C157 E9 C154

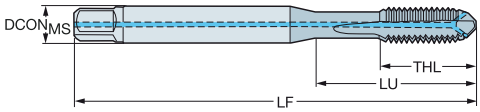
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

									Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 4	0.70	21.00	4.50 x 3.40	B	6HX	1	2	EP09PM4	4.5	4.00	63.0	11.7	3	DIN 371
		.827							*.177*	*.157*	*2.480*	*.461*		
M 5	0.80	25.00	6.00 x 4.90	B	6HX	1	2	EP09PM5	6.0	5.00	70.0	12.6	3	DIN 371
		.984							*.236*	*.197*	*2.756*	*.496*		
M 6	1.00	30.00	6.00 x 4.90	B	6HX	1	2	EP09PM6	6.0	6.00	80.0	14.5	3	DIN 371
		1.181							*.236*	*.236*	*3.150*	*.571*		
M 8	1.25	35.00	8.00 x 6.20	B	6HX	1	2	EP09PM8	8.0	8.00	90.0	17.4	3	DIN 371
		1.378							*.315*	*.315*	*3.543*	*.685*		
M 10	1.50	39.00	10.00 x 8.00	B	6HX	1	2	EP09PM10	10.0	10.00	100.0	19.2	3	DIN 371
		1.535							*.394*	*.394*	*3.937*	*.756*		
M 12	1.75	83.00	9.00 x 7.00	B	6HX	1	2	EP09PM12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	B	6HX	1	2	EP09PM14	11.0	14.00	110.0	25.0	4	DIN 376
		3.189							*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	B	6HX	1	2	EP09PM16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.984*		
M 18	2.50	81.00	14.00 x 11.00	B	6HX	1	2	EP09PM18	14.0	18.00	125.0	30.0	4	DIN 376
		3.189							*.551*	*.709*	*4.921*	*1.181*		
M 20	2.50	95.00	16.00 x 12.00	B	6HX	1	2	EP09PM20	16.0	20.00	140.0	30.0	4	DIN 376
		3.740							*.630*	*.787*	*5.512*	*1.181*		
M 22	2.50	93.00	18.00 x 14.50	B	6HX	1	2	EP09PM22	18.0	22.00	140.0	34.0	4	DIN 376
		3.661							*.709*	*.866*	*5.512*	*1.339*		
M 24	3.00	113.00	18.00 x 14.50	B	6HX	1	2	EP09PM24	18.0	24.00	160.0	38.0	4	DIN 376
		4.449							*.709*	*.945*	*6.299*	*1.496*		
M 30	3.50	115.00	22.00 x 18.00	B	6HX	1	2	EP09PM30	22.0	30.00	180.0	45.0	4	DIN 376
		4.528							*.866*	*1.181*	*7.087*	*1.772*		

CXSC 2 = Radial coolant exit

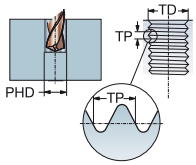
C174 C157 E9 E28 C154

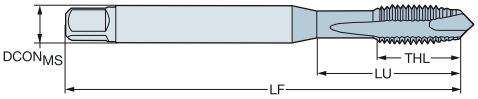
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	17.74	.141 x .110	B	6HX	EP03PAM3	3.6	3.00	56.0	9.0	3	DIN/ANSI
		.698					*.141*	*.118*	*2.205*	*.354*		
M 4	0.70	16.58	.168 x .131	B	6HX	EP03PAM4	4.3	4.00	63.0	13.0	3	DIN/ANSI
		.653					*.168*	*.157*	*2.480*	*.512*		
M 5	0.80	21.42	.194 x .152	B	6HX	EP03PAM5	4.9	5.00	70.0	14.0	3	DIN/ANSI
		.843					*.194*	*.197*	*2.756*	*.551*		
M 6	1.00	25.59	.255 x .191	B	6HX	EP03PAM6	6.5	6.00	80.0	15.0	3	DIN/ANSI
		1.007					*.255*	*.236*	*3.150*	*.591*		
M 8	1.25	30.20	.318 x .238	B	6HX	EP03PAM8	8.1	8.00	90.0	18.0	3	DIN/ANSI
		1.189					*.318*	*.315*	*3.543*	*.709*		
M 10	1.50	32.80	.381 x .286	B	6HX	EP03PAM10	9.7	10.00	100.0	20.0	3	DIN/ANSI
		1.292					*.381*	*.394*	*3.937*	*.787*		
M 12	1.75	86.02	.367 x .275	B	6HX	EP03PAM12	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					*.367*	*.472*	*4.331*	*.906*		
M 14	2.00	84.82	.429 x .322	B	6HX	EP03PAM14	10.9	14.00	110.0	23.0	4	DIN/ANSI
		3.339					*.429*	*.551*	*4.331*	*.906*		
M 16	2.00	70.86	.480 x .360	B	6HX	EP03PAM16	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					*.480*	*.630*	*4.331*	*.906*		
M 18	2.50	84.69	.542 x .406	B	6HX	EP03PAM18	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					*.542*	*.709*	*4.921*	*1.181*		
M 20	2.50	97.58	.652 x .489	B	6HX	EP03PAM20	16.6	20.00	140.0	30.0	4	DIN/ANSI
		3.842					*.652*	*.787*	*5.512*	*1.181*		
M 24	3.00	101.60	.760 x .570	B	6HX	EP03PAM24	19.3	24.00	160.0	36.0	4	DIN/ANSI
		4.000					*.760*	*.945*	*6.299*	*1.417*		

C174 C157 E9 C154

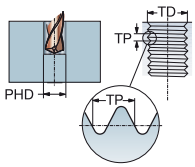
SANDVIK Coromant

CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HSS-E
COATING PVD FEN



M

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 3	0.50	18.00	3.50 x 2.70	B	6H	E344M3	3.5	3.00	56.0	8.9	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.350*		
M 4	0.70	21.00	4.50 x 3.40	B	6H	E344M4	4.5	4.00	63.0	11.7	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.461*		
M 5	0.80	25.00	6.00 x 4.90	B	6H	E344M5	6.0	5.00	70.0	12.6	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.496*		
M 6	1.00	30.00	6.00 x 4.90	B	6H	E344M6	6.0	6.00	80.0	14.5	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.571*		
M 8	1.25	35.00	8.00 x 6.20	B	6H	E344M8	8.0	8.00	90.0	17.4	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.685*		
M 10	1.50	39.00	10.00 x 8.00	B	6H	E344M10	10.0	10.00	100.0	19.2	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.756*		
M 12	1.75	83.00	9.00 x 7.00	B	6H	E345M12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	B	6H	E345M14	11.0	14.00	110.0	25.0	4	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	B	6H	E345M16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 18	2.50	81.00	14.00 x 11.00	B	6H	E345M18	14.0	18.00	125.0	30.0	4	DIN 376
		3.189					*.551*	*.709*	*4.921*	*1.181*		
M 20	2.50	95.00	16.00 x 12.00	B	6H	E345M20	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*1.181*		
M 24	3.00	113.00	18.00 x 14.50	B	6H	E345M24	18.0	24.00	160.0	38.0	4	DIN 376
		4.449					*.709*	*.945*	*6.299*	*1.496*		
M 30	3.50	115.00	22.00 x 18.00	B	6H	E345M30	22.0	30.00	180.0	45.0	4	DIN 376
		4.528					*.866*	*1.181*	*7.087*	*1.772*		

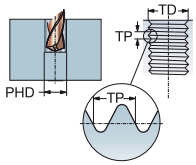
C174 C157 E9 C154

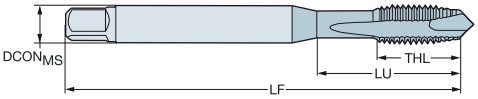
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 2.5
SUBSTRATE HSS-E
COATING PVD TICN





M

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 1	0.25	20.00	2.50 x 2.10	B	5HX	E454M1	2.5	1.00	40.0	5.0	2	DIN 371
		.787					*.098*	*.039*	*1.575*	*.197*		
M 1.2	0.25	20.00	2.50 x 2.10	B	5HX	E454M1.2	2.5	1.20	40.0	5.0	2	DIN 371
		.787					*.098*	*.047*	*1.575*	*.197*		
M 1.4	0.30	20.00	2.50 x 2.10	B	5HX	E454M1.4	2.5	1.40	40.0	6.5	2	DIN 371
		.787					*.098*	*.055*	*1.575*	*.256*		
M 1.6	0.35	20.00	2.50 x 2.10	B	6H	E454M1.6	2.5	1.60	40.0	7.0	2	DIN 371
		.787					*.098*	*.063*	*1.575*	*.276*		
M 1.8	0.35	20.00	2.50 x 2.10	B	6H	E454M1.8	2.5	1.80	40.0	7.0	2	DIN 371
		.787					*.098*	*.071*	*1.575*	*.276*		
M 2	0.40	9.00	2.80 x 2.10	B	6H	E454M2	2.8	2.00	45.0	6.0	2	DIN 371
		.354					*.110*	*.079*	*1.772*	*.236*		
M 2.2	0.45	12.00	2.80 x 2.10	B	6H	E454M2.2	2.8	2.20	45.0	7.0	2	DIN 371
		.472					*.110*	*.087*	*1.772*	*.276*		
M 2.3	0.40	12.00	2.80 x 2.10	B	6H	E454M2.3	2.8	2.30	45.0	7.0	2	DIN 371
		.472					*.110*	*.091*	*1.772*	*.276*		
M 2.5	0.45	12.50	2.80 x 2.10	B	6H	E454M2.5	2.8	2.50	50.0	8.0	2	DIN 371
		.492					*.110*	*.098*	*1.969*	*.315*		
M 2.6	0.45	12.50	2.80 x 2.10	B	6H	E454M2.6	2.8	2.60	50.0	8.0	2	DIN 371
		.492					*.110*	*.102*	*1.969*	*.315*		
M 3	0.50	18.00	3.50 x 2.70	B	6H	E454M3	3.5	3.00	56.0	8.9	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.350*		
M 4	0.70	21.00	4.50 x 3.40	B	6H	E454M4	4.5	4.00	63.0	11.7	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.461*		
M 5	0.80	25.00	6.00 x 4.90	B	6H	E454M5	6.0	5.00	70.0	12.6	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.496*		
M 6	1.00	30.00	6.00 x 4.90	B	6H	E454M6	6.0	6.00	80.0	14.5	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.571*		
M 8	1.25	35.00	8.00 x 6.20	B	6H	E454M8	8.0	8.00	90.0	17.4	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.685*		
M 10	1.50	39.00	10.00 x 8.00	B	6H	E454M10	10.0	10.00	100.0	19.2	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.756*		
M 12	1.75	83.00	9.00 x 7.00	B	6H	E455M12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	B	6H	E455M14	11.0	14.00	110.0	25.0	4	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	B	6H	E455M16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 18	2.50	81.00	14.00 x 11.00	B	6H	E455M18	14.0	18.00	125.0	30.0	4	DIN 376
		3.189					*.551*	*.709*	*4.921*	*1.181*		
M 20	2.50	95.00	16.00 x 12.00	B	6H	E455M20	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*1.181*		

C174 C157 E9 C154

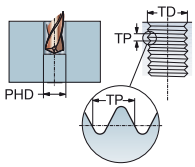
SANDVIK Coromant

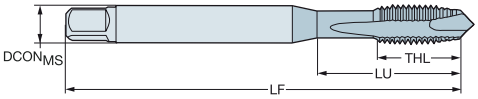
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN+WCC





M

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 4	0.70	16.58	.168 x .131	B	6H	E852M4	4.3	4.00	63.0	13.0	3	DIN/ANSI
		.653					*.168*	*.157*	*2.480*	*.512*		
M 5	0.80	21.42	.194 x .152	B	6H	E852M5	4.9	5.00	70.0	14.0	3	DIN/ANSI
		.843					*.194*	*.197*	*2.756*	*.551*		
M 6	1.00	25.59	.255 x .191	B	6H	E852M6	6.5	6.00	80.0	15.0	3	DIN/ANSI
		1.007					*.255*	*.236*	*3.150*	*.591*		
M 8	1.25	30.20	.318 x .238	B	6H	E852M8	8.1	8.00	90.0	18.0	3	DIN/ANSI
		1.189					*.318*	*.315*	*3.543*	*.709*		
M 10	1.50	32.80	.381 x .286	B	6H	E852M10	9.7	10.00	100.0	20.0	3	DIN/ANSI
		1.292					*.381*	*.394*	*3.937*	*.787*		
M 12	1.75	86.02	.367 x .275	B	6H	E852M12	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					*.367*	*.472*	*4.331*	*.906*		
M 16	2.00	70.86	.480 x .360	B	6H	E852M16	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					*.480*	*.630*	*4.331*	*.906*		
M 18	2.50	84.69	.542 x .406	B	6H	E852M18	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					*.542*	*.709*	*4.921*	*1.181*		

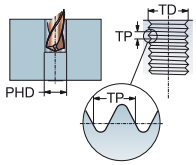
C174 C157 E9 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD TICN



For nickel-based alloys

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S	Dimensions, mm, inch						
							D115	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	15.00	3.50 x 2.70	B	6H	T200-SD100DA-M3	★	3.5	3.00	55.6	15.0	3	2.5	DIN 371
		.591						*.138*	*.118*	*2.191*	*.591*		*.098*	
M 4	0.70	20.00	4.50 x 3.40	B	6H	T200-SD100DA-M4	★	4.5	4.00	62.5	20.0	3	3.3	DIN 371
		.787						*.177*	*.157*	*2.461*	*.787*		*.130*	
M 5	0.80	25.00	6.00 x 4.90	B	6H	T200-SD100DA-M5	★	6.0	5.00	69.4	25.0	3	4.2	DIN 371
		.984						*.236*	*.197*	*2.733*	*.984*		*.165*	
M 6	1.00	30.00	6.00 x 4.90	B	6H	T200-SD100DA-M6	★	6.0	6.00	79.3	30.0	3	5.0	DIN 371
		1.181						*.236*	*.236*	*3.122*	*1.181*		*.197*	
M 8	1.25	40.00	8.00 x 6.20	B	6H	T200-SD100DA-M8	★	8.0	8.00	89.2	40.0	3	6.8	DIN 371
		1.575						*.315*	*.315*	*3.511*	*1.575*		*.268*	
M 10	1.50	50.00	10.00 x 8.00	B	6H	T200-SD100DA-M10	★	10.0	10.00	99.0	50.0	3	8.5	DIN 371
		1.969						*.394*	*.394*	*3.896*	*1.969*		*.335*	
M 12	1.75	67.85	9.00 x 7.00	B	6H	T200-SD100DA-M12	★	9.0	12.00	109.7	23.0	4	10.2	DIN 376
		2.671						*.354*	*.472*	*4.317*	*.906*		*.402*	
M 14	2.00	66.20	11.00 x 9.00	B	6H	T200-SD100DA-M14	★	11.0	14.00	110.0	25.0	4	12.0	DIN 376
		2.606						*.433*	*.551*	*4.331*	*.984*		*.472*	
M 16	2.00	66.20	12.00 x 9.00	B	6H	T200-SD100DA-M16	★	12.0	16.00	110.0	25.0	4	14.0	DIN 376
		2.606						*.472*	*.630*	*4.331*	*.984*		*.551*	
M 18	2.50	79.20	14.00 x 11.00	B	6H	T200-SD100DA-M18	★	14.0	18.00	125.0	30.0	4	15.5	DIN 376
		3.118						*.551*	*.709*	*4.921*	*1.181*		*.610*	
M 20	2.50	93.20	16.00 x 12.00	B	6H	T200-SD100DA-M20	★	16.0	20.00	140.0	30.0	4	17.5	DIN 376
		3.669						*.630*	*.787*	*5.512*	*1.181*		*.689*	

C174 C157 E9 E27 C154

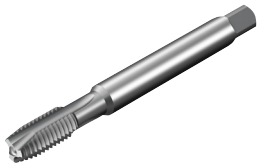
SANDVIK Coromant

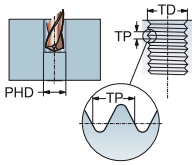
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371, DIN 376

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD ALCRN





For titanium alloys

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	S	D115	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
									Dimensions, mm, inch						
M 2	0.40	8.00	2.80 x 2.10	B	6HX	T200-SM100DA-M2	★		2.8	2.00	45.0	8.0	2	1.6	DIN 371
		.315							*.110*	*.079*	*1.772*	*.315*		*.063*	
M 2.5	0.45	9.00	2.80 x 2.10	B	6HX	T200-SM100DA-M2.5	★		2.8	2.50	50.0	9.0	2	2.1	DIN 371
		.354							*.110*	*.098*	*1.969*	*.354*		*.081*	
M 3	0.50	10.00	3.50 x 2.70	B	6HX	T200-SM100DA-M3	★		3.5	3.00	56.0	10.0	2	2.5	DIN 371
		.394							*.138*	*.118*	*2.205*	*.394*		*.098*	
M 3.5	0.60	12.00	4.00 x 3.00	B	6HX	T200-SM100DA-M3.5	★		4.0	3.50	56.0	12.0	3	2.9	DIN 371
		.472							*.157*	*.138*	*2.205*	*.472*		*.114*	
M 4	0.70	13.00	4.50 x 3.40	B	6HX	T200-SM100DA-M4	★		4.5	4.00	63.0	13.0	3	3.3	DIN 371
		.512							*.177*	*.157*	*2.480*	*.512*		*.130*	
M 5	0.80	16.00	6.00 x 4.90	B	6HX	T200-SM100DA-M5	★		6.0	5.00	70.0	16.0	3	4.2	DIN 371
		.630							*.236*	*.197*	*2.756*	*.630*		*.165*	
M 6	1.00	23.00	6.00 x 4.90	B	6HX	T200-SM100DA-M6	★		6.0	6.00	80.0	15.0	3	5.0	DIN 371
		.906							*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	29.50	8.00 x 6.20	B	6HX	T200-SM100DA-M8	★		8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.161							*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	33.50	10.00 x 8.00	B	6HX	T200-SM101DA-M10	★		10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.319							*.394*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	83.00	9.00 x 7.00	B	6HX	T200-SM101DA-M12	★		9.0	12.00	110.0	23.0	4	10.2	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		*.402*	
M 16	2.00	68.00	12.00 x 9.00	B	6HX	T200-SM101DA-M16	★		12.0	16.00	110.0	25.0	4	14.0	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.984*		*.551*	
M 20	2.50	95.00	16.00 x 12.00	B	6HX	T200-SM101DA-M20	★		16.0	20.00	140.0	30.0	4	17.5	DIN 376
		3.740							*.630*	*.787*	*5.512*	*1.181*		*.689*	

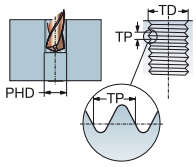
C174 C157 E9 E27 C154

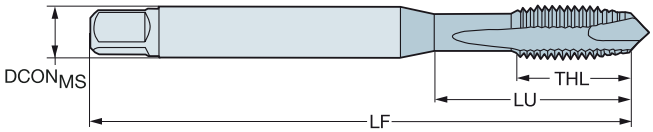
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN 371

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





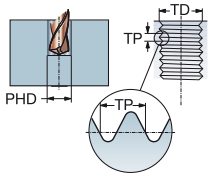
N

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

Dimensions, mm, inch

DIN 376

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



N

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

Dimensions, mm, inch

C174 C157 E9 E27 C154

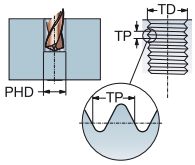
SANDVIK Coromant

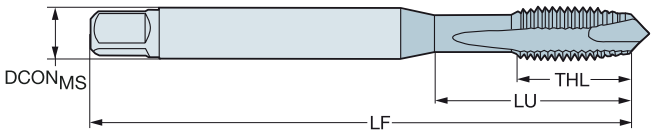
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM





N

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	15.88	.141 x .110	B	6H	T200-NM100AA-M3	★	3.6	3.00	56.0	9.0	2	2.5	DIN/ANSI
		.625						*.141*	*.118*	*2.205*	*.354*		*.098*	
M 4	0.70	16.58	.168 x .131	B	6H	T200-NM100AA-M4	★	4.3	4.00	63.0	13.0	2	3.3	DIN/ANSI
		.653						*.168*	*.157*	*2.480*	*.512*		*.130*	
M 5	0.80	21.42	.194 x .152	B	6H	T200-NM100AA-M5	★	4.9	5.00	70.0	14.0	2	4.2	DIN/ANSI
		.843						*.194*	*.197*	*2.756*	*.551*		*.165*	
M 6	1.00	25.59	.255 x .191	B	6H	T200-NM100AA-M6	★	6.5	6.00	80.0	15.0	3	5.0	DIN/ANSI
		1.007						*.255*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	30.20	.318 x .238	B	6H	T200-NM100AA-M8	★	8.1	8.00	90.0	18.0	3	6.8	DIN/ANSI
		1.189						*.318*	*.315*	*3.543*	*.709*		*.268*	

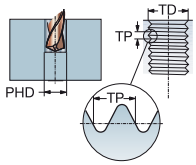
C174 C157 E9 E27 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: Metric fine

DIN 374

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIALN



P
≤350HB

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
MF 4x0.5	0.50	43.00	2.80 x 2.10	B	6HX	EP13PM4X.5	2.8	4.00	63.0	12.0	3	DIN 374
		1.693					*.110*	*.157*	*2.480*	*.472*		
MF 5x0.5	0.50	49.00	3.50 x 2.70	B	6HX	EP13PM5X.5	3.5	5.00	70.0	13.0	3	DIN 374
		1.929					*.138*	*.197*	*2.756*	*.512*		
MF 6x0.75	0.75	59.00	4.50 x 3.40	B	6HX	EP13PM6X.75	4.5	6.00	80.0	15.0	3	DIN 374
		2.323					*.177*	*.236*	*3.150*	*.591*		
MF 8x0.75	0.75	57.00	6.00 x 4.90	B	6HX	EP13PM8X.75	6.0	8.00	80.0	15.0	3	DIN 374
		2.244					*.236*	*.315*	*3.150*	*.591*		
MF 8x1	1.00	67.00	6.00 x 4.90	B	6HX	EP13PM8X1.0	6.0	8.00	90.0	18.0	3	DIN 374
		2.638					*.236*	*.315*	*3.543*	*.709*		
MF 10x1	1.00	67.00	7.00 x 5.50	B	6HX	EP13PM10X1.0	7.0	10.00	90.0	17.6	3	DIN 374
		2.638					*.276*	*.394*	*3.543*	*.693*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	B	6HX	EP13PM10X1.25	7.0	10.00	100.0	19.8	3	DIN 374
		3.032					*.276*	*.394*	*3.937*	*.780*		
MF 12x1	1.00	73.00	9.00 x 7.00	B	6HX	EP13PM12X1.0	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.827*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	B	6HX	EP13PM12X1.25	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.827*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6HX	EP13PM12X1.5	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.827*		
MF 14x1	1.00	71.00	11.00 x 9.00	B	6HX	EP13PM14X1.0	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.827*		
MF 14x1.25	1.25	71.00	11.00 x 9.00	B	6HX	EP13PM14X1.25	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.827*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6HX	EP13PM14X1.5	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.827*		
MF 16x1	1.00	58.00	12.00 x 9.00	B	6HX	EP13PM16X1.0	12.0	16.00	100.0	21.0	4	DIN 374
		2.283					*.472*	*.630*	*3.937*	*.827*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	B	6HX	EP13PM16X1.5	12.0	16.00	100.0	21.0	4	DIN 374
		2.283					*.472*	*.630*	*3.937*	*.827*		
MF 18x1	1.00	66.00	14.00 x 11.00	B	6HX	EP13PM18X1.0	14.0	18.00	110.0	24.0	4	DIN 374
		2.598					*.551*	*.709*	*4.331*	*.945*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	B	6HX	EP13PM18X1.5	14.0	18.00	110.0	24.0	4	DIN 374
		2.598					*.551*	*.709*	*4.331*	*.945*		
MF 20x1	1.00	80.00	16.00 x 12.00	B	6HX	EP13PM20X1.0	16.0	20.00	125.0	24.0	4	DIN 374
		3.150					*.630*	*.787*	*4.921*	*.945*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	B	6HX	EP13PM20X1.5	16.0	20.00	125.0	24.0	4	DIN 374
		3.150					*.630*	*.787*	*4.921*	*.945*		
MF 22x1.5	1.50	78.00	18.00 x 14.50	B	6HX	EP13PM22X1.5	18.0	22.00	125.0	25.0	4	DIN 374
		3.071					*.709*	*.866*	*4.921*	*.984*		
MF 24x1.5	1.50	93.00	18.00 x 14.50	B	6HX	EP13PM24X1.5	18.0	24.00	140.0	28.0	4	DIN 374
		3.661					*.709*	*.945*	*5.512*	*1.102*		
MF 24x2	2.00	93.00	18.00 x 14.50	B	6HX	EP13PM24X2.0	18.0	24.00	140.0	28.0	4	DIN 374
		3.661					*.709*	*.945*	*5.512*	*1.102*		
MF 26x1.5	1.50	93.00	18.00 x 14.50	B	6HX	EP13PM26X1.5	18.0	26.00	140.0	28.0	4	DIN 374
		3.661					*.709*	*1.024*	*5.512*	*1.102*		
MF 27x2	2.00	77.00	20.00 x 16.00	B	6HX	EP13PM27X2.0	20.0	27.00	140.0	28.0	4	DIN 374
		3.032					*.787*	*1.063*	*5.512*	*1.102*		
MF 28x1.5	1.50	77.00	20.00 x 16.00	B	6HX	EP13PM28X1.5	20.0	28.00	140.0	28.0	4	DIN 374
		3.032					*.787*	*1.102*	*5.512*	*1.102*		
MF 30x1.5	1.50	85.00	22.00 x 18.00	B	6HX	EP13PM30X1.5	22.0	30.00	150.0	28.0	4	DIN 374
		3.346					*.866*	*1.181*	*5.906*	*1.102*		
MF 30x2	2.00	85.00	22.00 x 18.00	B	6HX	EP13PM30X2.0	22.0	30.00	150.0	28.0	4	DIN 374
		3.346					*.866*	*1.181*	*5.906*	*1.102*		

C174 C157 E9 C154

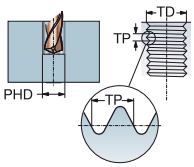
SANDVIK Coromant

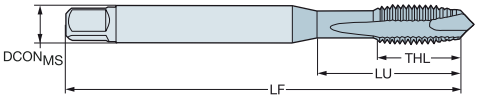
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric fine

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
MF 8x1	1.00	30.20	.318 x .238	B	6HX	EP13PAM8X1.0	8.1	8.00	90.0	18.0	3	DIN/ANSI
		1.189					*.318*	*.315*	*3.543*	*.709*		
MF 10x1.25	1.25	32.80	.381 x .286	B	6HX	EP13PAM10X1.25	9.7	10.00	100.0	20.0	3	DIN/ANSI
		1.292					*.381*	*.394*	*3.937*	*.787*		
MF 12x1.25	1.25	86.02	.367 x .275	B	6HX	EP13PAM12X1.25	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					*.367*	*.472*	*4.331*	*.906*		
MF 12x1.5	1.50	86.02	.367 x .275	B	6HX	EP13PAM12X1.5	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					*.367*	*.472*	*4.331*	*.906*		
MF 14x1.5	1.50	84.82	.429 x .322	B	6HX	EP13PAM14X1.5	10.9	14.00	110.0	23.0	4	DIN/ANSI
		3.339					*.429*	*.551*	*4.331*	*.906*		
MF 16x1.5	1.50	70.86	.480 x .360	B	6HX	EP13PAM16X1.5	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					*.480*	*.630*	*4.331*	*.906*		
MF 18x1.5	1.50	84.69	.542 x .406	B	6HX	EP13PAM18X1.5	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					*.542*	*.709*	*4.921*	*1.181*		

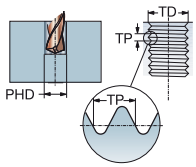
C174 C157 E9 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: Metric fine

DIN 374

ULDR 2.5
SUBSTRATE HSS-E
COATING PVD FEN



M

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
MF 8x1	1.00	67.00	6.00 x 4.90	B	6H	E364M8X1.0	6.0	8.00	90.0	18.0	3	DIN 374
		2.638					*.236*	*.315*	*3.543*	*.709*		
MF 10x1	1.00	67.00	7.00 x 5.50	B	6H	E364M10X1.0	7.0	10.00	90.0	20.0	3	DIN 374
		2.638					*.276*	*.394*	*3.543*	*.787*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	B	6H	E364M10X1.25	7.0	10.00	100.0	20.0	3	DIN 374
		3.032					*.276*	*.394*	*3.937*	*.787*		
MF 12x1	1.00	73.00	9.00 x 7.00	B	6H	E364M12X1.0	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.827*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	B	6H	E364M12X1.25	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.827*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6H	E364M12X1.5	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.827*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6H	E364M14X1.5	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.827*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	B	6H	E364M16X1.5	12.0	16.00	100.0	21.0	5	DIN 374
		2.283					*.472*	*.630*	*3.937*	*.827*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	B	6H	E364M18X1.5	14.0	18.00	110.0	24.0	5	DIN 374
		2.598					*.551*	*.709*	*4.331*	*.945*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	B	6H	E364M20X1.5	16.0	20.00	125.0	24.0	5	DIN 374
		3.150					*.630*	*.787*	*4.921*	*.945*		

C174 C157 E9 C154

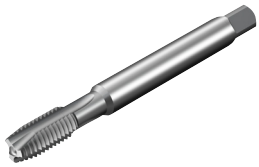
SANDVIK Coromant

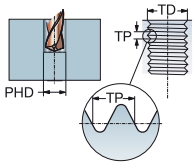
CoroTap™ 200 cutting tap with spiral point

Thread form: Metric fine

DIN 371, DIN 374

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD ALCRN





For titanium alloys

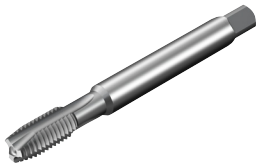
TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S D115	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
MF 6x0.75	0.75	23.00	6.00 x 4.90	B	6HX	T200-SM100DB-M6X075	★	6.0	6.00	80.0	15.0	3	5.3	DIN 371
		.906						*.236*	*.236*	*3.150*	*.591*		*.207*	
MF 8x0.75	0.75	29.50	8.00 x 6.20	B	6HX	T200-SM100DB-M8X075	★	8.0	8.00	90.0	18.0	3	7.3	DIN 371
		1.161						*.315*	*.315*	*3.543*	*.709*		*.285*	
MF 8x1	1.00	29.50	8.00 x 6.20	B	6HX	T200-SM100DB-M8X100	★	8.0	8.00	90.0	18.0	3	7.0	DIN 371
		1.161						*.315*	*.315*	*3.543*	*.709*		*.276*	
MF 10x1	1.00	33.50	10.00 x 8.00	B	6HX	T200-SM100DB-M10X100	★	10.0	10.00	100.0	20.0	3	9.0	DIN 371
		1.319						*.394*	*.394*	*3.937*	*.787*		*.354*	
MF 12x1	1.00	73.00	9.00 x 7.00	B	6HX	T200-SM100DB-M12X100	★	9.0	12.00	100.0	21.0	4	11.0	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.433*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	B	6HX	T200-SM100DB-M12X150	★	9.0	12.00	100.0	21.0	4	10.5	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.413*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	B	6HX	T200-SM100DB-M14X150	★	11.0	14.00	100.0	21.0	4	12.5	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.492*	

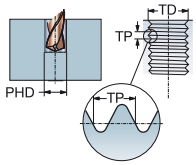
C174 C157 E9 E27 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: MJ

DIN 371





ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD ALCRN

For titanium alloys

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S / D115	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
MJ 4	0.70	13.00	4.50 x 3.40	B	4H	T200-SM100DC-MJ4	★	4.5	4.00	63.0	13.0	3	3.3	DIN 371
		.512						*.177*	*.157*	*2.480*	*.512*		*.130*	
MJ 5	0.80	16.00	6.00 x 4.90	B	4H	T200-SM100DC-MJ5	★	6.0	5.00	70.0	16.0	3	4.2	DIN 371
		.630						*.236*	*.197*	*2.756*	*.630*		*.165*	
MJ 6	1.00	23.00	6.00 x 4.90	B	4H	T200-SM100DC-MJ6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		.906						*.236*	*.236*	*3.150*	*.591*		*.197*	
MJ 8	1.25	29.50	8.00 x 6.20	B	4H	T200-SM100DC-MJ8	★	8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.161						*.315*	*.315*	*3.543*	*.709*		*.268*	

C174 C157 E9 E27 C154

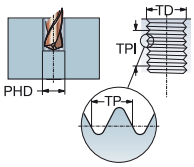
SANDVIK Coromant

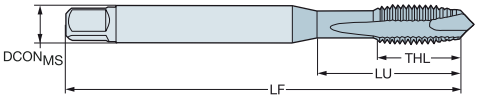
CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

C-DIN/ANSI, DIN/ANSI

ULDR 2.5
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
30–48 HRC

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
UNC #4-40	40.00	11.90	.141 x .110	B	2B	**E8744-40**	3.6	2.84	56.0	11.9	3	C-DIN/ANSI
		.469					*.141*	*.112*	*2.205*	*.469*		
UNC #5-40	40.00	11.00	.141 x .110	B	2B	**E8745-40**	3.6	3.18	56.0	11.0	3	C-DIN/ANSI
		.433					*.141*	*.125*	*2.205*	*.433*		
UNC #6-32	32.00	13.90	.168 x .131	B	2B	**E8746-32**	4.3	3.51	63.0	13.9	3	C-DIN/ANSI
		.547					*.168*	*.138*	*2.480*	*.547*		
UNC #8-32	32.00	15.10	.194 x .152	B	2B	**E8748-32**	4.9	4.17	70.0	15.1	3	C-DIN/ANSI
		.594					*.194*	*.164*	*2.756*	*.594*		
UNC #10-24	24.00	17.00	.255 x .191	B	2B	**E87410-24**	6.5	4.83	80.0	17.0	3	C-DIN/ANSI
		.669					*.255*	*.190*	*3.150*	*.669*		
UNC 1/4-20	20.00	20.20	.318 x .238	B	2B	**E8741/4**	8.1	6.35	90.0	20.2	3	C-DIN/ANSI
		.795					*.318*	*.250*	*3.543*	*.795*		
UNC 5/16-18	18.00	20.00	.381 x .286	B	2B	**E8745/16**	9.7	7.94	100.0	22.8	3	C-DIN/ANSI
		.787					*.381*	*.313*	*3.937*	*.898*		
UNC 3/8-16	16.00	29.16	.381 x .286	B	2B	**E8743/8**	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.148					*.381*	*.375*	*3.937*	*.787*		
UNC 1/2-13	13.00	81.80	.367 x .275	B	2B	**E8741/2**	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.906*		
UNC 5/8-11	11.00	65.80	.480 x .360	B	2B	**E8745/8**	12.2	15.88	110.0	23.0	4	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.906*		
UNC 3/4-10	10.00	77.50	.590 x .442	B	2B	**E8743/4**	15.0	19.05	125.0	30.0	4	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*1.181*		

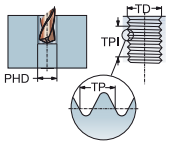
C174 C157 E9 C154

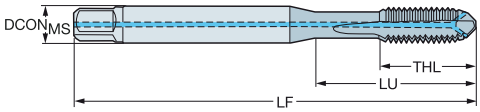
CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

									Dimensions, mm, inch					
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
UNC 1/4-20	20.00	24.59	.255 x .191	B	2BX	1	2	EP29PA1/4	6.5	6.35	80.0	15.0	3	DIN/ANSI
		.968							*.255*	*.250*	*3.150*	*.591*		
UNC 5/16-18	18.00	33.17	.318 x .238	B	2BX	1	2	EP29PA5/16	8.1	7.94	90.0	18.0	3	DIN/ANSI
		1.306							*.318*	*.313*	*3.543*	*.709*		
UNC 3/8-16	16.00	37.77	.381 x .286	B	2BX	1	2	EP29PA3/8	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.487							*.381*	*.375*	*3.937*	*.787*		
UNC 7/16-14	14.00	72.60	.323 x .242	B	2BX	1	2	EP29PA7/16	8.2	11.11	100.0	20.0	4	DIN/ANSI
		2.858							*.323*	*.438*	*3.937*	*.787*		
UNC 1/2-13	13.00	81.80	.367 x .275	B	2BX	1	2	EP29PA1/2	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220							*.367*	*.500*	*4.331*	*.906*		
UNC 5/8-11	11.00	65.80	.480 x .360	B	2BX	1	2	EP29PA5/8	12.2	15.88	110.0	23.0	4	DIN/ANSI
		2.591							*.480*	*.625*	*4.331*	*.906*		
UNC 3/4-10	10.00	77.50	.590 x .442	B	2BX	1	2	EP29PA3/4	15.0	19.05	125.0	30.0	4	DIN/ANSI
		3.051							*.590*	*.750*	*4.921*	*1.181*		
UNC 7/8-9	9.00	90.90	.697 x .523	B	2BX	1	2	EP29PA7/8	17.7	22.23	140.0	34.0	4	DIN/ANSI
		3.579							*.697*	*.875*	*5.512*	*1.339*		
UNC 1"-8	8.00	95.40	.800 x .600	B	2BX	1	2	EP29PA1	20.3	25.40	160.0	36.0	4	DIN/ANSI
		3.756							*.800*	*1.000*	*6.299*	*1.417*		

CXSC 2 = Radial coolant exit

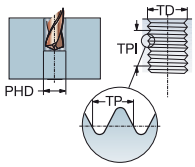
C174 C157 E9 E28 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TiAlN



P ≤350HB

TCT	TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
H1	UNC #2-56	56.00	11.99	.141 x .110	B	2B	EP23PA2-56	3.6	2.18	45.0	7.0	2	DIN/ANSI
			.472					*.141*	*.086*	*1.772*	*.276*		
H2	UNC #4-40	40.00	16.97	.141 x .110	B	2B	EP23PA4-40	3.6	2.84	56.0	9.0	3	DIN/ANSI
			.668					*.141*	*.112*	*2.205*	*.354*		
H3	UNC #6-32	32.00	20.20	.141 x .110	B	2B	EP23PA6-32	3.6	3.51	56.0	11.0	3	DIN/ANSI
			.795					*.141*	*.138*	*2.205*	*.433*		
H3	UNC #8-32	32.00	21.18	.168 x .131	B	2B	EP23PA8-32	4.3	4.17	63.0	13.0	3	DIN/ANSI
			.834					*.168*	*.164*	*2.480*	*.512*		
H5	UNC #8-32	32.00	21.18	.168 x .131	B	2BX	EP23PA8-32H5	4.3	4.17	63.0	13.0	3	DIN/ANSI
			.834					*.168*	*.164*	*2.480*	*.512*		
H3	UNC #10-24	24.00	27.54	.194 x .152	B	2B	EP23PA10-24	4.9	4.83	70.0	14.0	3	DIN/ANSI
			1.084					*.194*	*.190*	*2.756*	*.551*		
H3	UNC 1/4-20	20.00	24.59	.255 x .191	B	3B	EP23PA1/4	6.5	6.35	80.0	15.0	3	DIN/ANSI
			.968					*.255*	*.250*	*3.150*	*.591*		
H5	UNC 1/4-20	20.00	24.59	.255 x .191	B	2B	EP23PA1/4H5	6.5	6.35	80.0	15.0	3	DIN/ANSI
			.968					*.255*	*.250*	*3.150*	*.591*		
H3	UNC 5/16-18	18.00	33.17	.318 x .238	B	3B	EP23PA5/16	8.1	7.94	90.0	18.0	3	DIN/ANSI
			1.306					*.318*	*.313*	*3.543*	*.709*		
H5	UNC 5/16-18	18.00	33.17	.318 x .238	B	2B	EP23PA5/16H5	8.1	7.94	90.0	18.0	3	DIN/ANSI
			1.306					*.318*	*.313*	*3.543*	*.709*		
H3	UNC 3/8-16	16.00	37.77	.381 x .286	B	3B	EP23PA3/8	9.7	9.53	100.0	20.0	3	DIN/ANSI
			1.487					*.381*	*.375*	*3.937*	*.787*		
H5	UNC 3/8-16	16.00	37.77	.381 x .286	B	2B	EP23PA3/8H5	9.7	9.53	100.0	20.0	3	DIN/ANSI
			1.487					*.381*	*.375*	*3.937*	*.787*		
H3	UNC 7/16-14	14.00	72.60	.323 x .242	B	3B	EP23PA7/16	8.2	11.11	100.0	20.0	4	DIN/ANSI
			2.858					*.323*	*.438*	*3.937*	*.787*		
H3	UNC 1/2-13	13.00	81.80	.367 x .275	B	3B	EP23PA1/2	9.3	12.70	110.0	23.0	4	DIN/ANSI
			3.220					*.367*	*.500*	*4.331*	*.906*		
H5	UNC 1/2-13	13.00	81.80	.367 x .275	B	2B	EP23PA1/2H5	9.3	12.70	110.0	23.0	4	DIN/ANSI
			3.220					*.367*	*.500*	*4.331*	*.906*		
H3	UNC 5/8-11	11.00	65.80	.480 x .360	B	3B	EP23PA5/8	12.2	15.88	110.0	23.0	4	DIN/ANSI
			2.591					*.480*	*.625*	*4.331*	*.906*		
H5	UNC 5/8-11	11.00	65.80	.480 x .360	B	2B	EP23PA5/8H5	12.2	15.88	110.0	23.0	4	DIN/ANSI
			2.591					*.480*	*.625*	*4.331*	*.906*		
H3	UNC 3/4-10	10.00	77.50	.590 x .442	B	3B	EP23PA3/4	15.0	19.05	125.0	30.0	4	DIN/ANSI
			3.051					*.590*	*.750*	*4.921*	*1.181*		
H5	UNC 3/4-10	10.00	77.50	.590 x .442	B	2B	EP23PA3/4H5	15.0	19.05	125.0	30.0	4	DIN/ANSI
			3.051					*.590*	*.750*	*4.921*	*1.181*		
H4	UNC 7/8-9	9.00	92.50	.697 x .523	B	3B	EP23PA7/8	17.7	22.23	140.0	34.0	4	DIN/ANSI
			3.642					*.697*	*.875*	*5.512*	*1.339*		
H4	UNC 1"-8	8.00	95.40	.800 x .600	B	3B	EP23PA1	20.3	25.40	160.0	36.0	4	DIN/ANSI
			3.756					*.800*	*1.000*	*6.299*	*1.417*		

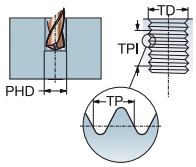
C174 C157 E9 C154

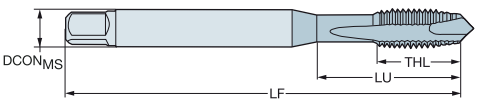
CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN/ANSI

ULDR 2.5
SUBSTRATE HSS-PM
COATING PVD TIALN+WCC





M

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
UNC #4-40	40.00	15.47	.141 x .110	B	2B	E8724-40	3.6	2.84	56.0	9.0	3	DIN/ANSI
		.609					*.141*	*.112*	*2.205*	*.354*		
UNC #6-32	32.00	15.08	.141 x .110	B	2B	E8726-32	3.6	3.51	56.0	11.0	3	DIN/ANSI
		.594					*.141*	*.138*	*2.205*	*.433*		
UNC #8-32	32.00	16.58	.168 x .131	B	2B	E8728-32	4.3	4.17	63.0	13.0	3	DIN/ANSI
		.653					*.168*	*.164*	*2.480*	*.512*		
UNC #10-24	24.00	21.42	.194 x .152	B	2B	E87210-24	4.9	4.83	70.0	14.0	3	DIN/ANSI
		.843					*.194*	*.190*	*2.756*	*.551*		
UNC 1/4-20	20.00	25.59	.255 x .191	B	2B	E8721/4	6.5	6.35	80.0	15.0	3	DIN/ANSI
		1.007					*.255*	*.250*	*3.150*	*.591*		
UNC 5/16-18	18.00	30.20	.318 x .238	B	2B	E8725/16	8.1	7.94	90.0	18.0	3	DIN/ANSI
		1.189					*.318*	*.313*	*3.543*	*.709*		
UNC 3/8-16	16.00	32.80	.381 x .286	B	2B	E8723/8	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.292					*.381*	*.375*	*3.937*	*.787*		
UNC 7/16-14	14.00	72.60	.323 x .242	B	2B	E8727/16	8.2	11.11	100.0	20.0	4	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.787*		
UNC 1/2-13	13.00	81.80	.367 x .275	B	2B	E8721/2	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.906*		
UNC 3/4-10	10.00	77.50	.590 x .442	B	2B	E8723/4	15.0	19.05	125.0	30.0	4	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*1.181*		

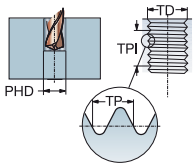
C174 C157 E9 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN/ANSI

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD TICN



For nickel-based alloys

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S D115	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	14.20	.141 x .110	B	3BX	T200-SD100AE-4-40	★	3.6	2.84	55.9	14.2	3	2.4	DIN/ANSI
		.559						*.141*	*.112*	*2.202*	*.559*		*.093*	
UNC #6-32	32.00	17.50	.141 x .110	B	3BX	T200-SD100AE-6-32	★	3.6	3.51	55.3	17.5	3	2.9	DIN/ANSI
		.689						*.141*	*.138*	*2.176*	*.689*		*.112*	
UNC #8-32	32.00	20.80	.168 x .131	B	3BX	T200-SD100AE-8-32	★	4.3	4.17	62.6	20.8	3	3.5	DIN/ANSI
		.819						*.168*	*.164*	*2.466*	*.819*		*.138*	
UNC #10-24	24.00	24.10	.194 x .152	B	3BX	T200-SD100AE-10-24	★	4.9	4.83	69.7	24.1	3	3.9	DIN/ANSI
		.949						*.194*	*.190*	*2.744*	*.949*		*.154*	
UNC 1/4-20	20.00	31.80	.255 x .191	B	3BX	T200-SD100AE-1/4	★	6.5	6.35	79.0	31.8	3	5.1	DIN/ANSI
		1.252						*.255*	*.250*	*3.111*	*1.252*		*.201*	
UNC 5/16-18	18.00	39.70	.323 x .242	B	3BX	T200-SD100AE-5/16	★	8.2	7.94	89.1	39.7	3	6.6	DIN/ANSI
		1.563						*.323*	*.313*	*3.509*	*1.563*		*.260*	
UNC 3/8-16	16.00	47.60	.381 x .286	B	3BX	T200-SD100AE-3/8	★	9.7	9.53	99.2	47.6	3	8.0	DIN/ANSI
		1.874						*.381*	*.375*	*3.906*	*1.874*		*.315*	
UNC 7/16-14	14.00	72.60	.323 x .242	B	3BX	T200-SD100AE-7/16	★	8.2	11.11	100.0	20.0	4	9.4	DIN/ANSI
		2.858						*.323*	*.438*	*3.937*	*.787*		*.370*	
UNC 1/2-13	13.00	81.80	.367 x .275	B	3BX	T200-SD100AE-1/2	★	9.3	12.70	110.0	23.0	4	10.8	DIN/ANSI
		3.220						*.367*	*.500*	*4.331*	*.906*		*.425*	
UNC 5/8-11	11.00	65.80	.480 x .360	B	3BX	T200-SD100AE-5/8	★	12.2	15.88	110.0	23.0	4	13.5	DIN/ANSI
		2.591						*.480*	*.625*	*4.331*	*.906*		*.531*	
UNC 3/4-10	10.00	77.50	.590 x .442	B	3BX	T200-SD100AE-3/4	★	15.0	19.05	125.0	30.0	4	16.5	DIN/ANSI
		3.051						*.590*	*.750*	*4.921*	*1.181*		*.650*	

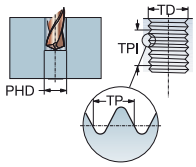
C174 C157 E9 E27 C154

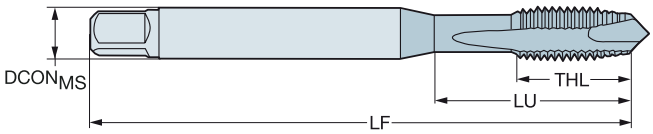
CoroTap™ 200 cutting tap with spiral point

Thread form: UNC

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM





N

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

Thread form: UNF

DIN/ANSI

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

C174 C157 E9 E27 C154

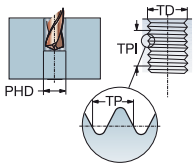
SANDVIK Coromant

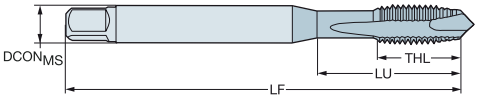
CoroTap™ 200 cutting tap with spiral point

Thread form: UNF

DIN/ANSI

ULDR 2.5
SUBSTRATE HSS-PM
COATING PVD TIALN+WCC





M

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	BSG
UNF #10-32	32.00	21.42	.194 x .152	B	2B	E87310-32	4.9	4.83	70.0	14.0	3	DIN/ANSI
		.843					*.194*	*.190*	*2.756*	*.551*		
UNF 1/4-28	28.00	25.59	.255 x .191	B	2B	E8731/4	6.5	6.35	80.0	15.0	3	DIN/ANSI
		1.007					*.255*	*.250*	*3.150*	*.591*		
UNF 5/16-24	24.00	30.20	.318 x .238	B	2B	E8735/16	8.1	7.94	90.0	18.0	3	DIN/ANSI
		1.189					*.318*	*.313*	*3.543*	*.709*		
UNF 3/8-24	24.00	32.80	.381 x .286	B	2B	E8733/8	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.292					*.381*	*.375*	*3.937*	*.787*		
UNF 7/16-20	20.00	72.60	.323 x .242	B	2B	E8737/16	8.2	11.11	100.0	20.0	4	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.787*		
UNF 1/2-20	20.00	81.80	.367 x .275	B	2B	E8731/2	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.906*		
UNF 5/8-18	18.00	65.80	.480 x .360	B	2B	E8735/8	12.2	15.88	110.0	23.0	4	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.906*		
UNF 7/8-14	14.00	90.90	.697 x .523	B	2B	E8737/8	17.7	22.23	140.0	34.0	4	DIN/ANSI
		3.579					*.697*	*.875*	*5.512*	*1.339*		

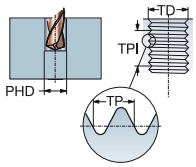
C174 C157 E9 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: UNF

DIN/ANSI

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD TICN



For nickel-based alloys

							S	Dimensions, mm, inch						
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	D115	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF #4-48	48.00	14.20	.141 x .110	B	3BX	T200-SD100AF-4-48	★	3.6	2.84	55.9	14.2	3	2.4	DIN/ANSI
		.559						*.141*	*.112*	*2.202*	*.559*		*.094*	
UNF #6-40	40.00	17.50	.141 x .110	B	3BX	T200-SD100AF-6-40	★	3.6	3.51	55.3	17.5	3	3.0	DIN/ANSI
		.689						*.141*	*.138*	*2.176*	*.689*		*.116*	
UNF #8-36	36.00	20.80	.168 x .131	B	3BX	T200-SD100AF-8-36	★	4.3	4.17	62.6	20.8	3	3.5	DIN/ANSI
		.819						*.168*	*.164*	*2.466*	*.819*		*.138*	
UNF #10-32	32.00	24.10	.194 x .152	B	3BX	T200-SD100AF-10-32	★	4.9	4.83	69.7	24.1	3	4.1	DIN/ANSI
		.949						*.194*	*.190*	*2.744*	*.949*		*.161*	
UNF 1/4-28	28.00	31.80	.255 x .191	B	3BX	T200-SD100AF-1/4	★	6.5	6.35	79.0	31.8	3	5.5	DIN/ANSI
		1.252						*.255*	*.250*	*3.111*	*1.252*		*.217*	
UNF 5/16-24	24.00	39.70	.318 x .238	B	3BX	T200-SD100AF-5/16	★	8.1	7.94	89.1	39.7	3	6.9	DIN/ANSI
		1.563						*.318*	*.313*	*3.509*	*1.563*		*.272*	
UNF 3/8-24	24.00	47.60	.381 x .286	B	3BX	T200-SD100AF-3/8	★	9.7	9.53	99.2	47.6	3	8.5	DIN/ANSI
		1.874						*.381*	*.375*	*3.906*	*1.874*		*.335*	
UNF 7/16-20	20.00	72.60	.323 x .242	B	3BX	T200-SD100AF-7/16	★	8.2	11.11	100.0	20.0	4	9.9	DIN/ANSI
		2.858						*.323*	*.438*	*3.937*	*.787*		*.390*	
UNF 1/2-20	20.00	81.80	.367 x .275	B	3BX	T200-SD100AF-1/2	★	9.3	12.70	110.0	23.0	4	11.5	DIN/ANSI
		3.220						*.367*	*.500*	*4.331*	*.906*		*.453*	
UNF 5/8-18	18.00	65.80	.480 x .360	B	3BX	T200-SD100AF-5/8	★	12.2	15.88	110.0	23.0	4	14.5	DIN/ANSI
		2.591						*.480*	*.625*	*4.331*	*.906*		*.571*	
UNF 3/4-16	16.00	77.50	.590 x .442	B	3BX	T200-SD100AF-3/4	★	15.0	19.05	125.0	30.0	4	17.5	DIN/ANSI
		3.051						*.590*	*.750*	*4.921*	*1.181*		*.689*	

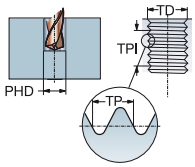
C174 C157 E9 E27 C154

CoroTap™ 200 cutting tap with spiral point

Thread form: UNJC

DIN/ANSI

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD TICN



For nickel-based alloys

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S D115	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNJC #4-40	40.00	14.20	.141 x .110	B	3BX	T200-SD100AH-4-40	★	3.6	2.84	55.9	14.2	3	2.4	DIN/ANSI
		.559						*.141*	*.112*	*2.202*	*.559*		*.093*	
UNJC #6-32	32.00	17.50	.141 x .110	B	3BX	T200-SD100AH-6-32	★	3.6	3.51	55.3	17.5	3	2.9	DIN/ANSI
		.689						*.141*	*.138*	*2.176*	*.689*		*.112*	
UNJC #8-32	32.00	20.80	.168 x .131	B	3BX	T200-SD100AH-8-32	★	4.3	4.17	62.6	20.8	3	3.5	DIN/ANSI
		.819						*.168*	*.164*	*2.466*	*.819*		*.138*	

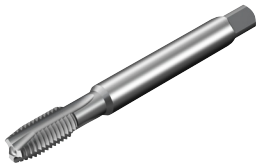
C174 C157 E9 E27 C154

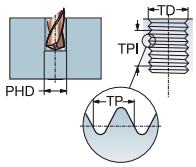
CoroTap™ 200 cutting tap with spiral point

Thread form: UNJF

DIN 2184-1, DIN/ANSI

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD ALCRN

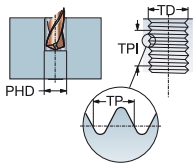




For titanium alloys

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S / D115	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
UNJF #10-32	32.00	16.00	6.00 x 4.90	B	3B	T200-SM100DI-10-32	★	6.0	4.83	70.0	16.0	3	4.1	DIN 2184-1
		.630						*.236*	*.190*	*2.756*	*.630*		*.161*	
UNJF 1/4-28	28.00	25.00	7.00 x 5.50	B	3B	T200-SM100DI-1/4	★	7.0	6.35	80.0	15.0	3	5.5	DIN 2184-1
		.984						*.276*	*.250*	*3.150*	*.591*		*.217*	
UNJF 5/16-24	24.00	29.50	8.00 x 6.20	B	3B	T200-SM100DI-5/16	★	8.0	7.94	90.0	18.0	3	6.9	DIN 2184-1
		1.161						*.315*	*.313*	*3.543*	*.709*		*.272*	
UNJF 3/8-24	24.00	33.50	10.00 x 8.00	B	3B	T200-SM100DI-3/8	★	10.0	9.53	100.0	20.0	3	8.5	DIN 2184-1
		1.319						*.394*	*.375*	*3.937*	*.787*		*.335*	

ULDR 2.0
SUBSTRATE HSS-E-PM
COATING PVD TICN



For nickel-based alloys

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S / D115	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
UNJF #10-32	32.00	24.10	.194 x .152	B	3BX	T200-SD100AI-10-32	★	4.9	4.83	69.7	24.1	3	4.1	DIN/ANSI
		.949						*.194*	*.190*	*2.744*	*.949*		*.161*	
UNJF 1/4-28	28.00	31.80	.255 x .191	B	3BX	T200-SD100AI-1/4	★	6.5	6.35	79.0	31.8	3	5.5	DIN/ANSI
		1.252						*.255*	*.250*	*3.111*	*1.252*		*.217*	
UNJF 5/16-24	24.00	39.70	.323 x .242	B	3BX	T200-SD100AI-5/16	★	8.2	7.94	89.1	39.7	3	6.9	DIN/ANSI
		1.563						*.323*	*.313*	*3.509*	*1.563*		*.272*	
UNJF 3/8-24	24.00	47.60	.381 x .286	B	3BX	T200-SD100AI-3/8	★	9.7	9.53	99.2	47.6	3	8.5	DIN/ANSI
		1.874						*.381*	*.375*	*3.906*	*1.874*		*.335*	
UNJF 7/16-20	20.00	72.60	.323 x .242	B	3BX	T200-SD100AI-7/16	★	8.2	11.11	100.0	20.0	4	9.9	DIN/ANSI
		2.858						*.323*	*.438*	*3.937*	*.787*		*.390*	
UNJF 1/2-20	20.00	81.80	.367 x .275	B	3BX	T200-SD100AI-1/2	★	9.3	12.70	110.0	23.0	4	11.5	DIN/ANSI
		3.220						*.367*	*.500*	*4.331*	*.906*		*.453*	

C174 C157 E9 E27 C154

CoroTap™ 300

Applications

- Suitable for blind holes
- Available in many thread forms and standards
- Depths up to 3 × diameter

O C

Benefits and features

- The design of the spiral flute secures a constant rake angle and gives a constant cutting process
- Back chamfer, used on taps with a high helix angle, reduces torque and chipping
- Taps with a high spiral angle give excellent chip evacuation and possibilities to thread up to 3 × diameter in blind holes
- Taps with a low spiral angle give strong edges and are suitable for tapping tough materials, generating short chips in blind holes
- High speed powder steel taps for improved strength, wear resistance, and tool life
- Solid carbide taps for long tool life and high productivity

- Taps with spiral flute grinding
- The spiral flute transports the chips out of the hole
- Best option for blind holes
- Different helix angle for different applications
- Flute used for both cutting fluid and chip evacuation
- Different threading depths due to application and geometry

www.sandvik.coromant.com/corotap300

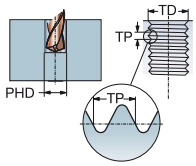
CoroChuck™ 970, see our Rotating Tools catalog.

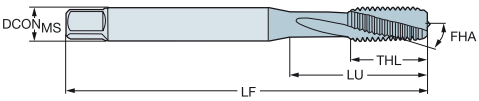
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

C-DIN 371, DIN 371, DIN 376

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
30-48 HRC

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	12.00	4.50 x 3.40	C	6H	E314M3	4.5	3.00	63.0	12.0	3	C-DIN 371
		.472					*.177*	*.118*	*2.480*	*.472*		
M 4	0.70	13.00	6.00 x 4.90	C	6H	E314M4	6.0	4.00	70.0	13.0	3	C-DIN 371
		.512					*.236*	*.157*	*2.756*	*.512*		
M 5	0.80	15.00	6.00 x 4.90	C	6H	E314M5	6.0	5.00	80.0	15.0	3	C-DIN 371
		.591					*.236*	*.197*	*3.150*	*.591*		
M 6	1.00	18.00	8.00 x 6.20	C	6H	E314M6	8.0	6.00	90.0	18.0	3	C-DIN 371
		.709					*.315*	*.236*	*3.543*	*.709*		
M 8	1.25	20.00	10.00 x 8.00	C	6H	E314M8	10.0	8.00	100.0	20.0	3	C-DIN 371
		.787					*.394*	*.315*	*3.937*	*.787*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E314M10	10.0	10.00	100.0	20.0	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.787*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E316M12	9.0	12.00	110.0	23.0	4	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E316M14	11.0	14.00	110.0	25.0	4	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.984*		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E316M16	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E316M20	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*1.181*		

C177 C157 E9 C154

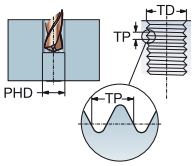
SANDVIK Coromant

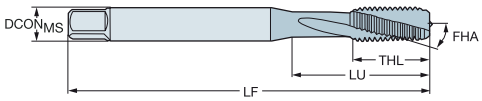
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN/ANSI

ULDR	1.5
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD TiAlN





P
30-48 HRC

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	13.00	.168 x .131	C	6H	E864M3	4.3	3.00	63.0	14.7	3	DIN/ANSI
		.512					*.168*	*.118*	*2.480*	*.579*		
M 4	0.70	15.10	.194 x .152	C	6H	E864M4	4.9	4.00	70.0	15.1	3	DIN/ANSI
		.594					*.194*	*.157*	*2.756*	*.594*		
M 5	0.80	17.00	.255 x .191	C	6H	E864M5	6.5	5.00	80.0	17.0	3	DIN/ANSI
		.669					*.255*	*.197*	*3.150*	*.669*		
M 6	1.00	20.20	.318 x .238	C	6H	E864M6	8.1	6.00	90.0	20.2	3	DIN/ANSI
		.795					*.318*	*.236*	*3.543*	*.795*		
M 8	1.25	20.00	.381 x .286	C	6H	E864M8	9.7	8.00	100.0	22.8	3	DIN/ANSI
		.787					*.381*	*.315*	*3.937*	*.898*		
M 10	1.50	37.80	.381 x .286	C	6H	E864M10	9.7	10.00	100.0	20.0	3	DIN/ANSI
		1.488					*.381*	*.394*	*3.937*	*.787*		
M 12	1.75	86.02	.367 x .275	C	6H	E864M12	9.3	12.00	110.0	23.0	4	DIN/ANSI
		3.386					*.367*	*.472*	*4.331*	*.906*		
M 14	2.00	84.82	.429 x .322	C	6H	E864M14	10.9	14.00	110.0	23.0	4	DIN/ANSI
		3.339					*.429*	*.551*	*4.331*	*.906*		
M 16	2.00	70.86	.480 x .360	C	6H	E864M16	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					*.480*	*.630*	*4.331*	*.906*		
M 18	2.50	84.69	.542 x .406	C	6H	E864M18	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					*.542*	*.709*	*4.921*	*1.181*		
M 20	2.50	97.58	.652 x .489	C	6H	E864M20	16.6	20.00	140.0	30.0	4	DIN/ANSI
		3.842					*.652*	*.787*	*5.512*	*1.181*		

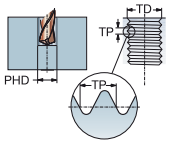
C177 C157 E9 C154

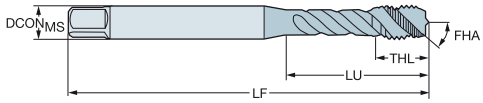
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR 3.0
FHA 48°
SUBSTRATE HSS-E-PM
COATING PVD TiAlN





P
≤350HB

							Dimensions, mm, inch					
TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
M 1.6	0.35	20.00	2.50 x 2.10	C	6HX	EX03PM1.6	2.5	1.60	40.0	6.0	2	DIN 371
		.787					*.098*	*.063*	*1.575*	*.236*		
M 2	0.40	9.00	2.80 x 2.10	C	6HX	EX03PM2	2.8	2.00	45.0	4.0	3	DIN 371
		.354					*.110*	*.079*	*1.772*	*.157*		
M 2.3	0.40	12.00	2.80 x 2.10	C	6HX	EX03PM2.3	2.8	2.30	45.0	4.0	3	DIN 371
		.472					*.110*	*.091*	*1.772*	*.157*		
M 2.5	0.45	12.50	2.80 x 2.10	C	6HX	EX03PM2.5	2.8	2.50	50.0	4.0	3	DIN 371
		.492					*.110*	*.098*	*1.969*	*.157*		
M 2.6	0.45	12.50	2.80 x 2.10	C	6HX	EX03PM2.6	2.8	2.60	50.0	4.0	3	DIN 371
		.492					*.110*	*.102*	*1.969*	*.157*		
M 3	0.50	18.00	3.50 x 2.70	C	6HX	EX03PM3	3.5	3.00	56.0	5.9	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.232*		
M 3.5	0.60	20.00	4.00 x 3.00	C	6HX	EX03PM3.5	4.0	3.50	56.0	7.0	3	DIN 371
		.787					*.157*	*.138*	*2.205*	*.276*		
M 4	0.70	21.00	4.50 x 3.40	C	6HX	EX03PM4	4.5	4.00	63.0	6.7	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.264*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	EX03PM5	6.0	5.00	70.0	7.7	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.303*		
M 5	0.80	49.00	3.50 x 2.70	C	6HX	EX03PM5DIN376	3.5	5.00	70.0	8.0	3	DIN 376
		1.929					*.138*	*.197*	*2.756*	*.315*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	EX03PM6	6.0	6.00	80.0	10.0	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.394*		
M 6	1.00	59.00	4.50 x 3.40	C	6HX	EX03PM6DIN376	4.5	6.00	80.0	10.0	3	DIN 376
		2.323					*.177*	*.236*	*3.150*	*.394*		
M 7	1.00	31.00	7.00 x 5.50	C	6HX	EX03PM7	7.0	7.00	80.0	10.0	3	DIN 371
		1.220					*.276*	*.276*	*3.150*	*.394*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	EX03PM8	8.0	8.00	90.0	11.6	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.457*		
M 8	1.25	67.00	6.00 x 4.90	C	6HX	EX03PM8DIN376	6.0	8.00	90.0	13.0	3	DIN 376
		2.638					*.236*	*.315*	*3.543*	*.512*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	EX03PM10	10.0	10.00	100.0	15.1	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.594*		
M 10	1.50	77.00	7.00 x 5.50	C	6HX	EX03PM10DIN376	7.0	10.00	100.0	15.0	3	DIN 376
		3.032					*.276*	*.394*	*3.937*	*.591*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	EX03PM12	9.0	12.00	110.0	16.0	3	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	EX03PM14	11.0	14.00	110.0	20.0	3	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	EX03PM16	12.0	16.00	110.0	20.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.787*		
M 18	2.50	81.00	14.00 x 11.00	C	6HX	EX03PM18	14.0	18.00	125.0	25.0	4	DIN 376
		3.189					*.551*	*.709*	*4.921*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	EX03PM20	16.0	20.00	140.0	25.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*.984*		
M 22	2.50	93.00	18.00 x 14.50	C	6HX	EX03PM22	18.0	22.00	140.0	25.0	4	DIN 376
		3.661					*.709*	*.866*	*5.512*	*.984*		
M 24	3.00	113.00	18.00 x 14.50	C	6HX	EX03PM24	18.0	24.00	160.0	30.0	4	DIN 376
		4.449					*.709*	*.945*	*6.299*	*1.181*		
M 27	3.00	97.00	20.00 x 16.00	C	6HX	EX03PM27	20.0	27.00	160.0	30.0	4	DIN 376
		3.819					*.787*	*1.063*	*6.299*	*1.181*		
M 30	3.50	115.00	22.00 x 18.00	C	6HX	EX03PM30	22.0	30.00	180.0	36.0	4	DIN 376
		4.528					*.866*	*1.181*	*7.087*	*1.417*		

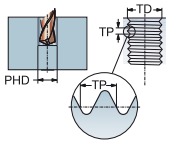
C177 C157 E9 C154

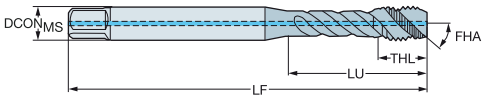
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR	3.0
FHA	48°
SUBSTRATE	HSS-E-PM
COATING	PVD TIALN





P
≤350HB

									Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 4	0.70	21.00	4.50 x 3.40	C	6HX	1	1	EX09PM4	4.5	4.00	63.0	6.7	3	DIN 371
		.827							*.177*	*.157*	*2.480*	*.264*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	1	1	EX09PM5	6.0	5.00	70.0	7.7	3	DIN 371
		.984							*.236*	*.197*	*2.756*	*.303*		
M 6	1.00	31.00	6.00 x 4.90	C	6HX	1	1	EX09PM6	6.0	6.00	80.0	10.0	3	DIN 371
		1.220							*.236*	*.236*	*3.150*	*.394*		
M 7	1.00	31.00	7.00 x 5.50	C	6HX	1	1	EX09PM7	7.0	7.00	80.0	10.0	3	DIN 371
		1.220							*.276*	*.276*	*3.150*	*.394*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	EX09PM8	8.0	8.00	90.0	11.6	3	DIN 371
		1.378							*.315*	*.315*	*3.543*	*.457*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	EX09PM10	10.0	10.00	100.0	15.1	3	DIN 371
		1.535							*.394*	*.394*	*3.937*	*.594*		
M 12	1.75	83.00	9.00 x 7.00	C	6HX	1	1	EX09PM12	9.0	12.00	110.0	16.0	3	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	81.00	11.00 x 9.00	C	6HX	1	1	EX09PM14	11.0	14.00	110.0	20.0	3	DIN 376
		3.189							*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	68.00	12.00 x 9.00	C	6HX	1	1	EX09PM16	12.0	16.00	110.0	20.0	4	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.787*		
M 18	2.50	81.00	14.00 x 11.00	C	6HX	1	1	EX09PM18	14.0	18.00	125.0	25.0	4	DIN 376
		3.189							*.551*	*.709*	*4.921*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6HX	1	1	EX09PM20	16.0	20.00	140.0	25.0	4	DIN 376
		3.740							*.630*	*.787*	*5.512*	*.984*		
M 22	2.50	93.00	18.00 x 14.50	C	6HX	1	1	EX09PM22	18.0	22.00	140.0	25.0	4	DIN 376
		3.661							*.709*	*.866*	*5.512*	*.984*		
M 24	3.00	113.00	18.00 x 14.50	C	6HX	1	1	EX09PM24	18.0	24.00	160.0	30.0	4	DIN 376
		4.449							*.709*	*.945*	*6.299*	*1.181*		
M 27	3.00	97.00	20.00 x 16.00	C	6HX	1	1	EX09PM27	20.0	27.00	160.0	30.0	4	DIN 376
		3.819							*.787*	*1.063*	*6.299*	*1.181*		
M 30	3.50	115.00	22.00 x 18.00	C	6HX	1	1	EX09PM30	22.0	30.00	180.0	36.0	4	DIN 376
		4.528							*.866*	*1.181*	*7.087*	*1.417*		

CXSC 1 = Axial concentric coolant exit

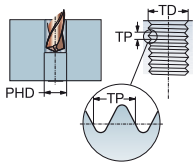
C177 C157 E9 E28 C154

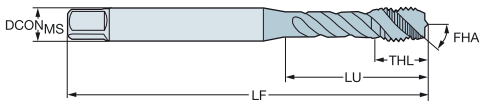
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN/ANSI

ULDR	3.0
FHA	48°
SUBSTRATE	HSS-E-PM
COATING	PVD TIALN





P
≤350HB

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	15.88	.141 x .110	C	6HX	EX03PAM3	3.6	3.00	56.0	6.0	3	DIN/ANSI
		.625					.141	.118	2.205	.236		
M 4	0.70	16.58	.168 x .131	C	6HX	EX03PAM4	4.3	4.00	63.0	7.0	3	DIN/ANSI
		.653					.168	.157	2.480	.276		
M 5	0.80	21.42	.194 x .152	C	6HX	EX03PAM5	4.9	5.00	70.0	8.0	3	DIN/ANSI
		.843					.194	.197	2.756	.315		
M 6	1.00	25.59	.255 x .191	C	6HX	EX03PAM6	6.5	6.00	80.0	10.0	3	DIN/ANSI
		1.007					.255	.236	3.150	.394		
M 8	1.25	30.20	.318 x .238	C	6HX	EX03PAM8	8.1	8.00	90.0	12.0	3	DIN/ANSI
		1.189					.318	.315	3.543	.472		
M 10	1.50	37.77	.381 x .286	C	6HX	EX03PAM10	9.7	10.00	100.0	15.0	3	DIN/ANSI
		1.487					.381	.394	3.937	.591		
M 12	1.75	86.02	.367 x .275	C	6HX	EX03PAM12	9.3	12.00	110.0	18.0	3	DIN/ANSI
		3.386					.367	.472	4.331	.709		
M 14	2.00	84.82	.429 x .322	C	6HX	EX03PAM14	10.9	14.00	110.0	20.0	3	DIN/ANSI
		3.339					.429	.551	4.331	.787		
M 16	2.00	70.86	.480 x .360	C	6HX	EX03PAM16	12.2	16.00	110.0	23.0	4	DIN/ANSI
		2.790					.480	.630	4.331	.906		
M 18	2.50	84.69	.542 x .406	C	6HX	EX03PAM18	13.8	18.00	125.0	30.0	4	DIN/ANSI
		3.334					.542	.709	4.921	1.181		
M 20	2.50	97.58	.652 x .489	C	6HX	EX03PAM20	16.6	20.00	140.0	30.0	4	DIN/ANSI
		3.842					.652	.787	5.512	1.181		
M 24	3.00	101.60	.760 x .570	C	6HX	EX03PAM24	19.3	24.00	160.0	30.0	4	DIN/ANSI
		4.000					.760	.945	6.299	1.181		

C177 C157 E9 C154

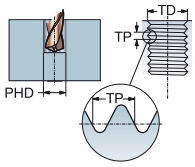
SANDVIK Coromant

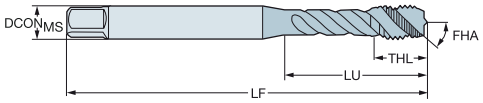
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR	2.0
FHA	40°
SUBSTRATE	HSS-E
COATING	PVD FEN





M

							Dimensions, mm, inch					
TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	18.00	3.50 x 2.70	C	6H	E346M3	3.5	3.00	56.0	5.9	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.232*		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E346M4	4.5	4.00	63.0	6.7	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.264*		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E346M5	6.0	5.00	70.0	7.7	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.303*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E346M6	6.0	6.00	80.0	10.0	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.394*		
M 8	1.25	33.00	8.00 x 6.20	C	6H	E346M8	8.0	8.00	90.0	11.6	3	DIN 371
		1.299					*.315*	*.315*	*3.543*	*.457*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E346M10	10.0	10.00	100.0	15.1	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.594*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E347M12	9.0	12.00	110.0	16.0	4	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E347M14	11.0	14.00	110.0	20.0	4	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E347M16	12.0	16.00	110.0	20.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.787*		
M 18	2.50	81.00	14.00 x 11.00	C	6H	E347M18	14.0	18.00	125.0	25.0	4	DIN 376
		3.189					*.551*	*.709*	*4.921*	*.984*		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E347M20	16.0	20.00	140.0	25.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*.984*		
M 24	3.00	113.00	18.00 x 14.50	C	6H	E347M24	18.0	24.00	160.0	30.0	4	DIN 376
		4.449					*.709*	*.945*	*6.299*	*1.181*		
M 27	3.00	97.00	20.00 x 16.00	C	6H	E347M27	20.0	27.00	160.0	30.0	4	DIN 376
		3.819					*.787*	*1.063*	*6.299*	*1.181*		
M 30	3.50	115.00	22.00 x 18.00	C	6H	E347M30	22.0	30.00	180.0	36.0	4	DIN 376
		4.528					*.866*	*1.181*	*7.087*	*1.417*		

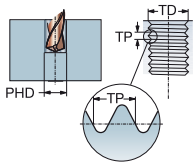
C177 C157 E9 C154

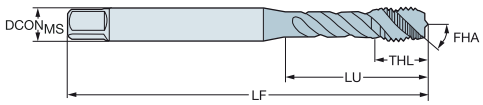
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR	2.5
FHA	48°
SUBSTRATE	HSS-E
COATING	PVD TIALN+WCC





M

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 1.6	0.35	8.00	2.50 x 2.10	C	6H	E404M1.6	2.5	1.60	40.0	6.0	2	DIN 371
		.315					*.098*	*.063*	*1.575*	*.236*		
M 2	0.40	9.00	2.80 x 2.10	C	6H	E404M2	2.8	2.00	45.0	4.0	3	DIN 371
		.354					*.110*	*.079*	*1.772*	*.157*		
M 2.2	0.45	12.00	2.80 x 2.10	C	6H	E404M2.2	2.8	2.20	45.0	4.0	3	DIN 371
		.472					*.110*	*.087*	*1.772*	*.157*		
M 2.3	0.40	12.00	2.80 x 2.10	C	6H	E404M2.3	2.8	2.30	45.0	4.0	3	DIN 371
		.472					*.110*	*.091*	*1.772*	*.157*		
M 2.5	0.45	12.50	2.80 x 2.10	C	6H	E404M2.5	2.8	2.50	50.0	4.0	3	DIN 371
		.492					*.110*	*.098*	*1.969*	*.157*		
M 3	0.50	18.00	3.50 x 2.70	C	6H	E404M3	3.5	3.00	56.0	5.9	3	DIN 371
		.709					*.138*	*.118*	*2.205*	*.232*		
M 4	0.70	21.00	4.50 x 3.40	C	6H	E404M4	4.5	4.00	63.0	6.7	3	DIN 371
		.827					*.177*	*.157*	*2.480*	*.264*		
M 5	0.80	25.00	6.00 x 4.90	C	6H	E404M5	6.0	5.00	70.0	7.7	3	DIN 371
		.984					*.236*	*.197*	*2.756*	*.303*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	E404M6	6.0	6.00	80.0	10.0	3	DIN 371
		1.181					*.236*	*.236*	*3.150*	*.394*		
M 8	1.25	35.00	8.00 x 6.20	C	6H	E404M8	8.0	8.00	90.0	11.6	3	DIN 371
		1.378					*.315*	*.315*	*3.543*	*.457*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	E404M10	10.0	10.00	100.0	15.1	3	DIN 371
		1.535					*.394*	*.394*	*3.937*	*.594*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	E404M12	9.0	12.00	110.0	23.0	3	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		
M 14	2.00	81.00	11.00 x 9.00	C	6H	E404M14	11.0	14.00	110.0	20.0	3	DIN 376
		3.189					*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	68.00	12.00 x 9.00	C	6H	E404M16	12.0	16.00	110.0	20.0	4	DIN 376
		2.677					*.472*	*.630*	*4.331*	*.787*		
M 20	2.50	95.00	16.00 x 12.00	C	6H	E404M20	16.0	20.00	140.0	25.0	4	DIN 376
		3.740					*.630*	*.787*	*5.512*	*.984*		

C177 C157 E9 C154

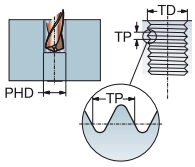
SANDVIK Coromant

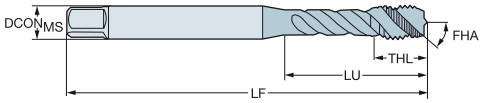
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN/ANSI

ULDR	2.5
FHA	48°
SUBSTRATE	HSS-PM
COATING	PVD TIALN+WCC





M

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
M 4	0.70	16.58	.168 x .131	C	6H	**E862M4**	4.3	4.00	63.0	7.9	3	DIN/ANSI
		.653					*.168*	*.157*	*2.480*	*.311*		
M 5	0.80	21.42	.194 x .152	C	6H	**E862M5**	4.9	5.00	70.0	8.0	3	DIN/ANSI
		.843					*.194*	*.197*	*2.756*	*.315*		
M 6	1.00	25.59	.255 x .191	C	6H	**E862M6**	6.5	6.00	80.0	10.7	3	DIN/ANSI
		1.007					*.255*	*.236*	*3.150*	*.421*		
M 8	1.25	30.20	.318 x .238	C	6H	**E862M8**	8.1	8.00	90.0	12.1	3	DIN/ANSI
		1.189					*.318*	*.315*	*3.543*	*.476*		
M 10	1.50	32.80	.381 x .286	C	6H	**E862M10**	9.7	10.00	100.0	15.1	3	DIN/ANSI
		1.292					*.381*	*.394*	*3.937*	*.594*		
M 12	1.75	86.02	.367 x .275	C	6H	**E862M12**	9.3	12.00	110.0	18.0	3	DIN/ANSI
		3.386					*.367*	*.472*	*4.331*	*.709*		
M 16	2.00	70.86	.480 x .360	C	6H	**E862M16**	12.2	16.00	110.0	20.0	4	DIN/ANSI
		2.790					*.480*	*.630*	*4.331*	*.787*		

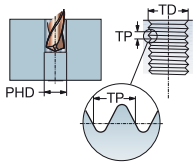
C177 C157 E9 C154

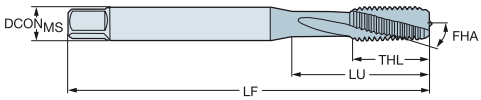
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

C-DIN 371, DIN 376

ULDR 2.0
FHA 15°
SUBSTRATE HM

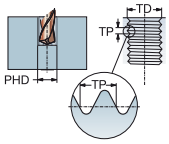


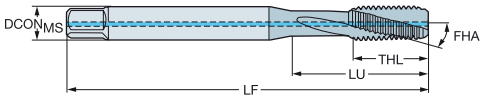


K

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 3	0.50	10.00	3.50 x 2.70	C	6H	T105M3	3.5	3.00	56.0	10.0	3	C-DIN 371
		.394					*.138*	*.118*	*2.205*	*.394*		
M 4	0.70	13.00	4.50 x 3.40	C	6H	T105M4	4.5	4.00	63.0	13.0	3	C-DIN 371
		.512					*.177*	*.157*	*2.480*	*.512*		
M 5	0.80	16.00	6.00 x 4.90	C	6H	T105M5	6.0	5.00	70.0	16.0	3	C-DIN 371
		.630					*.236*	*.197*	*2.756*	*.630*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	T105M6	6.0	6.00	80.0	19.0	3	C-DIN 371
		1.181					*.236*	*.236*	*3.150*	*.748*		
M 8	1.25	35.00	8.00 x 6.20	C	6H	T105M8	8.0	8.00	90.0	22.0	3	C-DIN 371
		1.378					*.315*	*.315*	*3.543*	*.866*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	T105M10	10.0	10.00	100.0	24.0	3	C-DIN 371
		1.535					*.394*	*.394*	*3.937*	*.945*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	T105M12	9.0	12.00	110.0	23.0	3	DIN 376
		3.268					*.354*	*.472*	*4.331*	*.906*		

ULDR 3.0
FHA 15°
SUBSTRATE HM





K

									Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
M 5	0.80	47.00	6.00 x 4.90	C	6H	1	1	T106M5	6.0	5.00	70.0	16.0	3	C-DIN 371
		1.850							*.236*	*.197*	*2.756*	*.630*		
M 6	1.00	30.00	6.00 x 4.90	C	6H	1	1	T106M6	6.0	6.00	80.0	19.0	3	C-DIN 371
		1.181							*.236*	*.236*	*3.150*	*.748*		
M 8	1.25	35.00	8.00 x 6.20	C	6H	1	1	T106M8	8.0	8.00	90.0	22.0	3	C-DIN 371
		1.378							*.315*	*.315*	*3.543*	*.866*		
M 10	1.50	39.00	10.00 x 8.00	C	6H	1	1	T106M10	10.0	10.00	100.0	24.0	3	C-DIN 371
		1.535							*.394*	*.394*	*3.937*	*.945*		
M 12	1.75	83.00	9.00 x 7.00	C	6H	1	1	T106M12	9.0	12.00	110.0	23.0	3	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		

CXSC 1 = Axial concentric coolant exit

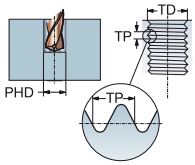
C177 C157 E9 E28 C154

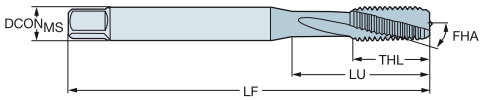
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371

ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM





For nickel-based alloys

							S	Dimensions, mm, inch						
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	D150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	8.00	3.50 x 2.70	C	6HX	T300-SD100DA-M3	★	3.5	3.00	56.0	8.0	3	2.5	DIN 371
		.315						*.138*	*.118*	*2.205*	*.315*		*.098*	
M 4	0.70	10.50	4.50 x 3.40	C	6HX	T300-SD100DA-M4	★	4.5	4.00	63.0	10.5	3	3.3	DIN 371
		.413						*.177*	*.157*	*2.480*	*.413*		*.130*	
M 5	0.80	13.00	6.00 x 4.90	C	6HX	T300-SD100DA-M5	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.512						*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	16.00	6.00 x 4.90	C	6HX	T300-SD100DA-M6	★	6.0	6.00	80.0	16.0	3	5.0	DIN 371
		.630						*.236*	*.236*	*3.150*	*.630*		*.197*	
M 8	1.25	20.50	8.00 x 6.20	C	6HX	T300-SD100DA-M8	★	8.0	8.00	90.0	20.5	3	6.8	DIN 371
		.807						*.315*	*.315*	*3.543*	*.807*		*.268*	
M 10	1.50	25.50	10.00 x 8.00	C	6HX	T300-SD100DA-M10	★	10.0	10.00	100.0	25.5	3	8.5	DIN 371
		1.004						*.394*	*.394*	*3.937*	*1.004*		*.335*	
M 12	1.75	30.50	12.00 x 9.00	C	6HX	T300-SD100DA-M12	★	12.0	12.00	110.0	30.5	4	10.2	DIN 371
		1.201						*.472*	*.472*	*4.331*	*1.201*		*.402*	
M 16	2.00	39.50	16.00 x 12.00	C	6HX	T300-SD100DA-M16	★	16.0	16.00	110.0	39.5	4	14.0	DIN 371
		1.555						*.630*	*.630*	*4.331*	*1.555*		*.551*	

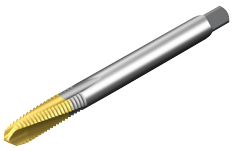
C177 C157 E9 E27 C154

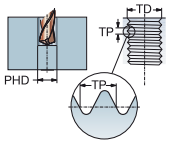
CoroTap™ 300 cutting tap with spiral flutes

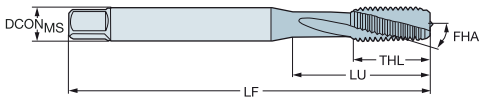
Thread form: Metric

DIN 371

ULDR	1.5
FHA	10°
SUBSTRATE	HSS-E-PM
COATING	PVD TIN







For nickel-based alloys

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	P D125	M D125	K D125	N D125	S D125	H D125	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	8.00	3.50 x 2.70	C	6HX	T300-SD101DA-M3	☆	☆	☆	☆	★	☆	3.5	3.00	56.0	8.0	3	2.5	DIN 371
		.315											*.138*	*.118*	*2.205*	*.315*		*.098*	
M 4	0.70	10.50	4.50 x 3.40	C	6HX	T300-SD101DA-M4	☆	☆	☆	☆	★	☆	4.5	4.00	63.0	10.5	3	3.3	DIN 371
		.413											*.177*	*.157*	*2.480*	*.413*		*.130*	
M 5	0.80	13.00	6.00 x 4.90	C	6HX	T300-SD101DA-M5	☆	☆	☆	☆	★	☆	6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.512											*.236*	*.197*	*2.756*	*.512*		*.165*	
M 6	1.00	16.00	6.00 x 4.90	C	6HX	T300-SD101DA-M6	☆	☆	☆	☆	★	☆	6.0	6.00	80.0	16.0	3	5.0	DIN 371
		.630											*.236*	*.236*	*3.150*	*.630*		*.197*	
M 8	1.25	20.50	8.00 x 6.20	C	6HX	T300-SD101DA-M8	☆	☆	☆	☆	★	☆	8.0	8.00	90.0	20.5	3	6.8	DIN 371
		.807											*.315*	*.315*	*3.543*	*.807*		*.268*	
M 10	1.50	25.50	10.00 x 8.00	C	6HX	T300-SD101DA-M10	☆	☆	☆	☆	★	☆	10.0	10.00	100.0	25.5	3	8.5	DIN 371
		1.004											*.394*	*.394*	*3.937*	*1.004*		*.335*	
M 12	1.75	30.50	12.00 x 9.00	C	6HX	T300-SD101DA-M12	☆	☆	☆	☆	★	☆	12.0	12.00	110.0	30.5	4	10.2	DIN 371
		1.201											*.472*	*.472*	*4.331*	*1.201*		*.402*	
M 16	2.00	39.50	16.00 x 12.00	C	6HX	T300-SD101DA-M16	☆	☆	☆	☆	★	☆	16.0	16.00	110.0	39.5	4	14.0	DIN 371
		1.555											*.630*	*.630*	*4.331*	*1.555*		*.551*	

C177 C157 E9 E27 C154

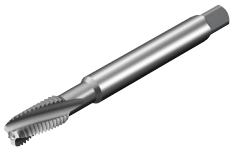
SANDVIK Coromant

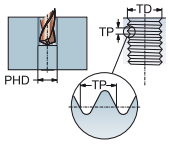
CoroTap™ 300 cutting tap with spiral flutes

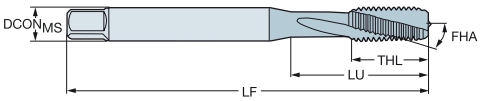
Thread form: Metric

DIN 371, DIN 376

ULDR	2.0
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD ALCRN







For titanium alloys

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S	D115	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 2	0.40	8.00	2.80 x 2.10	C	6HX	T300-SM100DA-M2	★		2.8	2.00	45.0	8.0	3	1.6	DIN 371
		.315							*.110*	*.079*	*1.772*	*.315*		*.063*	
M 2.5	0.45	30.00	2.80 x 2.10	C	6HX	T300-SM100DA-M2.5	★		2.8	2.50	50.0	9.0	3	2.1	DIN 371
		1.181							*.110*	*.098*	*1.969*	*.354*		*.081*	
M 3	0.50	10.00	3.50 x 2.70	C	6HX	T300-SM100DA-M3	★		3.5	3.00	56.0	10.0	3	2.5	DIN 371
		.394							*.138*	*.118*	*2.205*	*.394*		*.098*	
M 3.5	0.60	12.00	4.00 x 3.00	C	6HX	T300-SM100DA-M3.5	★		4.0	3.50	56.0	12.0	3	2.9	DIN 371
		.472							*.157*	*.138*	*2.205*	*.472*		*.114*	
M 4	0.70	13.00	4.50 x 3.40	C	6HX	T300-SM100DA-M4	★		4.5	4.00	63.0	13.0	3	3.3	DIN 371
		.512							*.177*	*.157*	*2.480*	*.512*		*.130*	
M 5	0.80	16.00	6.00 x 4.90	C	6HX	T300-SM100DA-M5	★		6.0	5.00	70.0	16.0	3	4.2	DIN 371
		.630							*.236*	*.197*	*2.756*	*.630*		*.165*	
M 6	1.00	23.00	6.00 x 4.90	C	6HX	T300-SM100DA-M6	★		6.0	6.00	80.0	15.0	3	5.0	DIN 371
		.906							*.236*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	29.50	8.00 x 6.20	C	6HX	T300-SM100DA-M8	★		8.0	8.00	90.0	18.0	3	6.8	DIN 371
		1.161							*.315*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	33.50	10.00 x 8.00	C	6HX	T300-SM101DA-M10	★		10.0	10.00	100.0	20.0	3	8.5	DIN 371
		1.319							*.394*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	83.00	9.00 x 7.10	C	6HX	T300-SM101DA-M12	★		9.0	12.00	110.0	23.0	4	10.2	DIN 376
		3.268							*.354*	*.472*	*4.331*	*.906*		*.402*	
M 16	2.00	68.00	12.00 x 9.00	C	6HX	T300-SM101DA-M16	★		12.0	16.00	110.0	25.0	4	14.0	DIN 376
		2.677							*.472*	*.630*	*4.331*	*.984*		*.551*	
M 20	2.50	95.00	16.00 x 12.00	C	6HX	T300-SM101DA-M20	★		16.0	20.00	140.0	30.0	4	17.5	DIN 376
		3.740							*.630*	*.787*	*5.512*	*1.181*		*.689*	

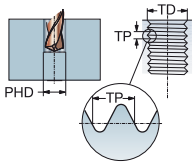
C177 C157 E9 E27 C154

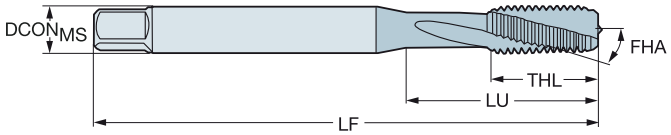
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371

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





N

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

C177 C157 E9 E27 C154

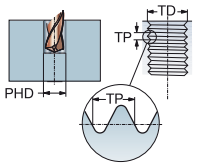
SANDVIK Coromant

CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 376

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



N

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N / D150	Dimensions, mm, inch: $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 14	2.00	81.00	11.00 x 9.00	C	6H	T300-NM101DA-M14	★	11.0	14.00	110.0	25.0	3	12.0	DIN 376
		3.189						*.433*	*.551*	*4.331*	*.984*		*.472*	
M 16	2.00	68.00	12.00 x 9.00	C	6H	T300-NM101DA-M16	★	12.0	16.00	110.0	25.0	3	14.0	DIN 376
		2.677						*.472*	*.630*	*4.331*	*.984*		*.551*	

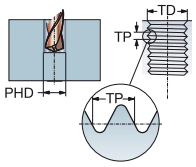
C177 C157 E9 E27 C154

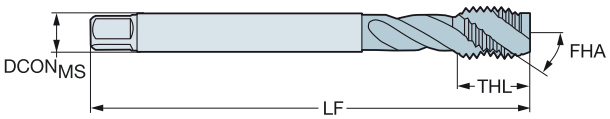
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN 371, DIN 376

ULDR	2.5
FHA	35°
SUBSTRATE	HSS-E, HSS-E-PM
COATING	UNCOAT - B150





N

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

C177 C157 E9 E27 C154

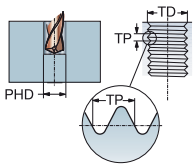
SANDVIK Coromant

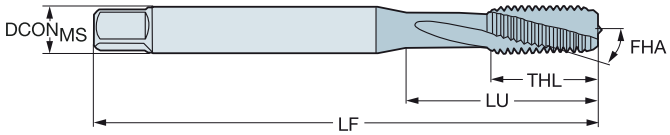
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric

DIN/ANSI

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E-PM





N

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	N / D150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
M 5	0.80	21.42	.194 x .152	C	6H	T300-NM100AA-M5	★	4.9	5.00	70.0	14.0	3	4.2	DIN/ANSI
		.843						*.194*	*.197*	*2.756*	*.551*		*.165*	
M 6	1.00	25.59	.255 x .191	C	6H	T300-NM100AA-M6	★	6.5	6.00	80.0	15.0	3	5.0	DIN/ANSI
		1.007						*.255*	*.236*	*3.150*	*.591*		*.197*	
M 8	1.25	30.20	.318 x .238	C	6H	T300-NM100AA-M8	★	8.1	8.00	90.0	18.0	3	6.8	DIN/ANSI
		1.189						*.318*	*.315*	*3.543*	*.709*		*.268*	
M 10	1.50	32.80	.381 x .286	C	6H	T300-NM100AA-M10	★	9.7	10.00	100.0	20.0	3	8.5	DIN/ANSI
		1.292						*.381*	*.394*	*3.937*	*.787*		*.335*	
M 12	1.75	86.02	.367 x .275	C	6H	T300-NM101AA-M12	★	9.3	12.00	110.0	23.0	3	10.2	DIN/ANSI
		3.386						*.367*	*.472*	*4.331*	*.906*		*.402*	

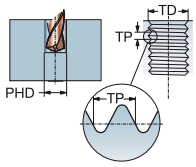
C177 C157 E9 E27 C154

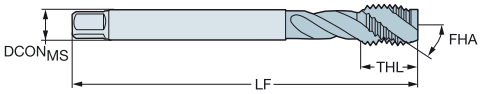
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374

ULDR 3.0
FHA 48°
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
MF 4x0.5	0.50	43.00	2.80 x 2.10	C	6HX	EX13PM4X.50	2.8	4.00	63.0	7.0	3	DIN 374
		1.693					*.110*	*.157*	*2.480*	*.276*		
MF 5x0.5	0.50	49.00	3.50 x 2.70	C	6HX	EX13PM5X.50	3.5	5.00	70.0	8.0	3	DIN 374
		1.929					*.138*	*.197*	*2.756*	*.315*		
MF 6x0.75	0.75	59.00	4.50 x 3.40	C	6HX	EX13PM6X.75	4.5	6.00	80.0	10.0	3	DIN 374
		2.323					*.177*	*.236*	*3.150*	*.394*		
MF 8x0.75	0.75	57.00	6.00 x 4.90	C	6HX	EX13PM8X.75	6.0	8.00	80.0	13.0	3	DIN 374
		2.244					*.236*	*.315*	*3.150*	*.512*		
MF 8x1	1.00	67.00	6.00 x 4.90	C	6HX	EX13PM8X1.0	6.0	8.00	90.0	13.0	3	DIN 374
		2.638					*.236*	*.315*	*3.543*	*.512*		
MF 10x1	1.00	67.00	7.00 x 5.50	C	6HX	EX13PM10X1.0	7.0	10.00	90.0	13.0	3	DIN 374
		2.638					*.276*	*.394*	*3.543*	*.512*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6HX	EX13PM10X1.25	7.0	10.00	100.0	15.0	3	DIN 374
		3.032					*.276*	*.394*	*3.937*	*.591*		
MF 12x1	1.00	73.00	9.00 x 7.00	C	6HX	EX13PM12X1.0	9.0	12.00	100.0	15.0	3	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.591*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6HX	EX13PM12X1.25	9.0	12.00	100.0	15.0	3	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.591*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	EX13PM12X1.5	9.0	12.00	100.0	15.0	3	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.591*		
MF 14x1	1.00	71.00	11.00 x 9.00	C	6HX	EX13PM14X1.0	11.0	14.00	100.0	15.0	3	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.591*		
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6HX	EX13PM14X1.25	11.0	14.00	100.0	15.0	3	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.591*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	EX13PM14X1.5	11.0	14.00	100.0	15.0	3	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.591*		
MF 16x1	1.00	58.00	12.00 x 9.00	C	6HX	EX13PM16X1.0	12.0	16.00	100.0	15.0	4	DIN 374
		2.283					*.472*	*.630*	*3.937*	*.591*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6HX	EX13PM16X1.5	12.0	16.00	100.0	15.0	4	DIN 374
		2.283					*.472*	*.630*	*3.937*	*.591*		
MF 18x1	1.00	66.00	14.00 x 11.00	C	6HX	EX13PM18X1.0	14.0	18.00	110.0	17.0	4	DIN 374
		2.598					*.551*	*.709*	*4.331*	*.669*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6HX	EX13PM18X1.5	14.0	18.00	110.0	17.0	4	DIN 374
		2.598					*.551*	*.709*	*4.331*	*.669*		
MF 20x1	1.00	80.00	16.00 x 12.00	C	6HX	EX13PM20X1.0	16.0	20.00	125.0	17.0	4	DIN 374
		3.150					*.630*	*.787*	*4.921*	*.669*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6HX	EX13PM20X1.5	16.0	20.00	125.0	17.0	4	DIN 374
		3.150					*.630*	*.787*	*4.921*	*.669*		
MF 22x1.5	1.50	78.00	18.00 x 14.50	C	6HX	EX13PM22X1.5	18.0	22.00	125.0	17.0	4	DIN 374
		3.071					*.709*	*.866*	*4.921*	*.669*		
MF 24x1.5	1.50	93.00	18.00 x 14.50	C	6HX	EX13PM24X1.5	18.0	24.00	140.0	20.0	4	DIN 374
		3.661					*.709*	*.945*	*5.512*	*.787*		
MF 24x2	2.00	93.00	18.00 x 14.50	C	6HX	EX13PM24X2.0	18.0	24.00	140.0	20.0	4	DIN 374
		3.661					*.709*	*.945*	*5.512*	*.787*		
MF 25x1.5	1.50	93.00	18.00 x 14.50	C	6HX	EX13PM25X1.5	18.0	25.00	140.0	20.0	4	DIN 374
		3.661					*.709*	*.984*	*5.512*	*.787*		
MF 26x1.5	1.50	93.00	18.00 x 14.50	C	6HX	EX13PM26X1.5	18.0	26.00	140.0	20.0	4	DIN 374
		3.661					*.709*	*1.024*	*5.512*	*.787*		
MF 27x1.5	1.50	77.00	20.00 x 16.00	C	6HX	EX13PM27X1.5	20.0	27.00	140.0	20.0	4	DIN 374
		3.032					*.787*	*1.063*	*5.512*	*.787*		
MF 27x2	2.00	77.00	20.00 x 16.00	C	6HX	EX13PM27X2.0	20.0	27.00	140.0	20.0	4	DIN 374
		3.032					*.787*	*1.063*	*5.512*	*.787*		

C177 C157 E9 C154

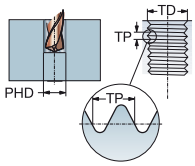
SANDVIK Coromant

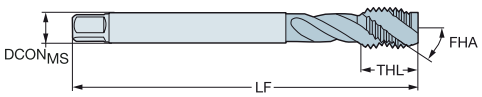
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374

ULDR 3.0
FHA 48°
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
MF 30x1.5	1.50	85.00	22.00 x 18.00	C	6HX	EX13PM30X1.5	22.0	30.00	150.0	20.0	4	DIN 374
		3.346					*.866*	*1.181*	*5.906*	*.787*		
MF 30x2	2.00	85.00	22.00 x 18.00	C	6HX	EX13PM30X2.0	22.0	30.00	150.0	20.0	4	DIN 374
		3.346					*.866*	*1.181*	*5.906*	*.787*		

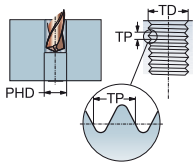
C177 C157 E9 C154

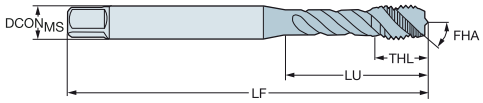
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN/ANSI

ULDR	3.0
FHA	48°
SUBSTRATE	HSS-E-PM
COATING	PVD TiAlN





P
≤350HB

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
MF 8x1	1.00	33.17	.318 x .238	C	6HX	EX13PAM8X1.0	8.1	8.00	90.0	12.1	3	DIN/ANSI
		1.306					*.318*	*.315*	*3.543*	*.476*		
MF 12x1.25	1.25	81.80	.367 x .275	C	6HX	EX13PAM12X1.25	9.3	12.00	110.0	18.0	3	DIN/ANSI
		3.220					*.367*	*.472*	*4.331*	*.709*		
MF 12x1.5	1.50	81.80	.367 x .275	C	6HX	EX13PAM12X1.5	9.3	12.00	110.0	18.0	3	DIN/ANSI
		3.220					*.367*	*.472*	*4.331*	*.709*		
MF 16x1.5	1.50	65.80	.480 x .360	C	6HX	EX13PAM16X1.5	12.2	16.00	110.0	20.0	4	DIN/ANSI
		2.591					*.480*	*.630*	*4.331*	*.787*		
MF 18x1.5	1.50	79.00	.542 x .406	C	6HX	EX13PAM18X1.5	13.8	18.00	125.0	25.0	4	DIN/ANSI
		3.110					*.542*	*.709*	*4.921*	*.984*		

C177 C157 E9 C154

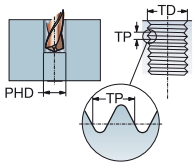
SANDVIK Coromant

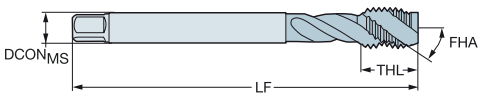
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374

ULDR	2.0
FHA	40°
SUBSTRATE	HSS-E
COATING	PVD FEN





M

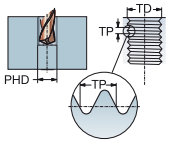
							Dimensions, mm, inch					
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
MF 6x0.75	0.75	59.00	4.50 x 3.40	C	6H	E363M6X.75	4.5	6.00	80.0	10.0	3	DIN 374
		2.323					*.177*	*.236*	*3.150*	*.394*		
MF 8x1	1.00	67.00	6.00 x 4.90	C	6H	E363M8X1.0	6.0	8.00	90.0	12.0	3	DIN 374
		2.638					*.236*	*.315*	*3.543*	*.472*		
MF 10x1	1.00	67.00	7.00 x 5.50	C	6H	E363M10X1.0	7.0	10.00	90.0	12.0	3	DIN 374
		2.638					*.276*	*.394*	*3.543*	*.472*		
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6H	E363M10X1.25	7.0	10.00	100.0	15.0	3	DIN 374
		3.032					*.276*	*.394*	*3.937*	*.591*		
MF 12x1	1.00	73.00	9.00 x 7.00	C	6H	E363M12X1.0	9.0	12.00	100.0	13.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.512*		
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6H	E363M12X1.25	9.0	12.00	100.0	13.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.512*		
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6H	E363M12X1.5	9.0	12.00	100.0	13.0	4	DIN 374
		2.874					*.354*	*.472*	*3.937*	*.512*		
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6H	E363M14X1.5	11.0	14.00	100.0	15.0	4	DIN 374
		2.795					*.433*	*.551*	*3.937*	*.591*		
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6H	E363M16X1.5	12.0	16.00	100.0	15.0	5	DIN 374
		2.283					*.472*	*.630*	*3.937*	*.591*		
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6H	E363M18X1.5	14.0	18.00	110.0	17.0	5	DIN 374
		2.598					*.551*	*.709*	*4.331*	*.669*		
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6H	E363M20X1.5	16.0	20.00	125.0	17.0	5	DIN 374
		3.150					*.630*	*.787*	*4.921*	*.669*		

C177 C157 E9 C154

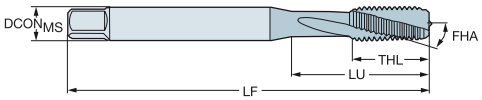
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374



ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM



For nickel-based alloys

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	S / D150	Dimensions, mm, inch: $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 8x1	1.00	20.00	8.00 x 6.20	C	6HX	T300-SD100DB-M8X100	★	8.0	8.00	90.0	20.0	3	7.0	DIN 374
		.787						*.315*	*.315*	*3.543*	*.787*		*.276*	
MF 10x1	1.00	24.00	10.00 x 8.00	C	6HX	T300-SD100DB-M10X100	★	10.0	10.00	90.0	24.0	3	9.0	DIN 374
		.945						*.394*	*.394*	*3.543*	*.945*		*.354*	
MF 10x1.25	1.25	24.50	10.00 x 8.00	C	6HX	T300-SD100DB-M10X125	★	10.0	10.00	100.0	24.5	3	8.8	DIN 374
		.965						*.394*	*.394*	*3.937*	*.965*		*.344*	
MF 12x1	1.00	28.00	12.00 x 9.00	C	6HX	T300-SD100DB-M12X100	★	12.0	12.00	100.0	28.0	4	11.0	DIN 374
		1.102						*.472*	*.472*	*3.937*	*1.102*		*.433*	
MF 12x1.25	1.25	28.50	12.00 x 9.00	C	6HX	T300-SD100DB-M12X125	★	12.0	12.00	100.0	28.5	4	10.8	DIN 374
		1.122						*.472*	*.472*	*3.937*	*1.122*		*.423*	
MF 12x1.5	1.50	29.50	12.00 x 9.00	C	6HX	T300-SD100DB-M12X150	★	12.0	12.00	100.0	29.5	4	10.5	DIN 374
		1.161						*.472*	*.472*	*3.937*	*1.161*		*.413*	

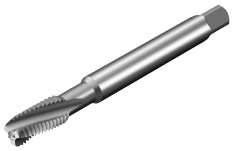
C177 C157 E9 E27 C154

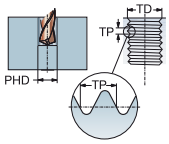
CoroTap™ 300 cutting tap with spiral flutes

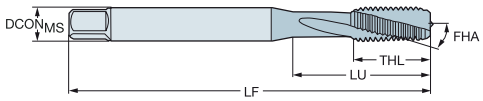
Thread form: Metric fine

DIN 371, DIN 374

ULDR	2.0
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD ALCRN







For titanium alloys

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	S / D115	Dimensions, mm, inch: $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 6x0.75	0.75	23.00	6.00 x 4.90	C	6HX	T300-SM100DB-M6X075	★	6.0	6.00	80.0	15.0	3	5.3	DIN 371
		.906						*.236*	*.236*	*3.150*	*.591*		*.207*	
MF 8x0.75	0.75	29.50	8.00 x 6.20	C	6HX	T300-SM100DB-M8X075	★	8.0	8.00	90.0	18.0	3	7.3	DIN 371
		1.161						*.315*	*.315*	*3.543*	*.709*		*.285*	
MF 8x1	1.00	29.50	8.00 x 6.20	C	6HX	T300-SM100DB-M8X100	★	8.0	8.00	90.0	18.0	3	7.0	DIN 371
		1.161						*.315*	*.315*	*3.543*	*.709*		*.276*	
MF 10x1	1.00	33.50	10.00 x 8.00	C	6HX	T300-SM100DB-M10X100	★	10.0	10.00	100.0	20.0	3	9.0	DIN 371
		1.319						*.394*	*.394*	*3.937*	*.787*		*.354*	
MF 12x1	1.00	73.00	9.00 x 7.00	C	6HX	T300-SM100DB-M12X100	★	9.0	12.00	100.0	21.0	4	11.0	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.433*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6HX	T300-SM100DB-M12X150	★	9.0	12.00	100.0	21.0	4	10.5	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.413*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6HX	T300-SM100DB-M14X150	★	11.0	14.00	100.0	21.0	4	12.5	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.492*	

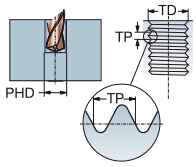
C177 C157 E9 E27 C154

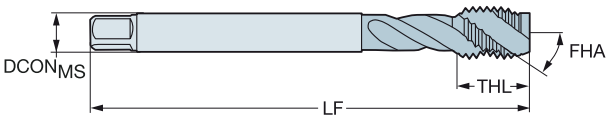
CoroTap™ 300 cutting tap with spiral flutes

Thread form: Metric fine

DIN 374

ULDR 2.5
FHA 35°
SUBSTRATE HSS-E
COATING UNCOAT





N

TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N	Dimensions, mm, inch						
							R1:50	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
MF 5x0.5	0.50	49.00	3.50 x 2.70	C	6H	T300-NM100DB-M5X050	★	3.5	5.00	70.0	13.0	2	4.5	DIN 374
		1.929						*.138*	*.197*	*2.756*	*.512*		*.177*	
MF 8x1	1.00	67.00	6.00 x 4.90	C	6H	T300-NM100DB-M8X100	★	6.0	8.00	90.0	18.0	2	7.0	DIN 374
		2.638						*.236*	*.315*	*3.543*	*.709*		*.276*	
MF 10x1	1.00	67.00	7.00 x 5.50	C	6H	T300-NM100DB-M10X100	★	7.0	10.00	90.0	20.0	3	9.0	DIN 374
		2.638						*.276*	*.394*	*3.543*	*.787*		*.354*	
MF 10x1.25	1.25	77.00	7.00 x 5.50	C	6H	T300-NM100DB-M10X125	★	7.0	10.00	100.0	20.0	3	8.8	DIN 374
		3.032						*.276*	*.394*	*3.937*	*.787*		*.346*	
MF 12x1.25	1.25	73.00	9.00 x 7.00	C	6H	T300-NM100DB-M12X125	★	9.0	12.00	100.0	21.0	3	10.8	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.425*	
MF 12x1.5	1.50	73.00	9.00 x 7.00	C	6H	T300-NM100DB-M12X150	★	9.0	12.00	100.0	21.0	3	10.5	DIN 374
		2.874						*.354*	*.472*	*3.937*	*.827*		*.413*	
MF 14x1.25	1.25	71.00	11.00 x 9.00	C	6H	T300-NM100DB-M14X125	★	11.0	14.00	100.0	21.0	3	12.8	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.504*	
MF 14x1.5	1.50	71.00	11.00 x 9.00	C	6H	T300-NM100DB-M14X150	★	11.0	14.00	100.0	21.0	3	12.5	DIN 374
		2.795						*.433*	*.551*	*3.937*	*.827*		*.492*	
MF 16x1.5	1.50	58.00	12.00 x 9.00	C	6H	T300-NM100DB-M16X150	★	12.0	16.00	100.0	21.0	3	14.5	DIN 374
		2.283						*.472*	*.630*	*3.937*	*.827*		*.571*	
MF 18x1.5	1.50	66.00	14.00 x 11.00	C	6H	T300-NM100DB-M18X150	★	14.0	18.00	110.0	24.0	3	16.5	DIN 374
		2.598						*.551*	*.709*	*4.331*	*.945*		*.650*	
MF 20x1.5	1.50	80.00	16.00 x 12.00	C	6H	T300-NM100DB-M20X150	★	16.0	20.00	125.0	24.0	3	18.5	DIN 374
		3.150						*.630*	*.787*	*4.921*	*.945*		*.728*	

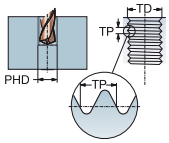
C177 C157 E9 E27 C154

SANDVIK Coromant

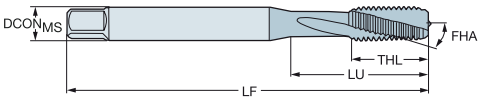
CoroTap™ 300 cutting tap with spiral flutes

Thread form: MJ

DIN 371



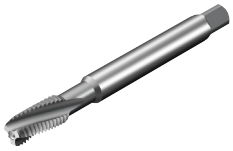
ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM

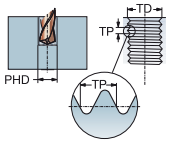


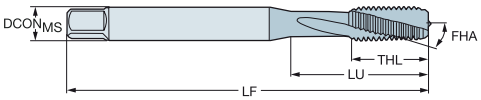
For nickel-based alloys

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	S D150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
MJ 3	0.50	8.00	3.50 x 2.70	C	4H	T300-SD100DC-MJ3	★	3.5	3.00	56.0	8.0	3	2.5	DIN 371
		.315						*.138*	*.118*	*2.205*	*.315*		*.098*	
MJ 4	0.70	10.50	4.50 x 3.40	C	4H	T300-SD100DC-MJ4	★	4.5	4.00	63.0	10.5	3	3.3	DIN 371
		.413						*.177*	*.157*	*2.480*	*.413*		*.130*	
MJ 5	0.80	13.00	6.00 x 4.90	C	4H	T300-SD100DC-MJ5	★	6.0	5.00	70.0	13.0	3	4.2	DIN 371
		.512						*.236*	*.197*	*2.756*	*.512*		*.165*	
MJ 6	1.00	15.50	6.00 x 4.90	C	4H	T300-SD100DC-MJ6	★	6.0	6.00	80.0	15.5	3	5.0	DIN 371
		.610						*.236*	*.236*	*3.150*	*.610*		*.197*	

ULDR 2.0
FHA 15°
SUBSTRATE HSS-E-PM
COATING PVD ALCRN







For titanium alloys

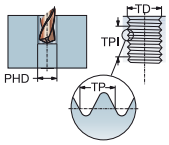
TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	S D115	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
MJ 4	0.70	13.00	4.50 x 3.40	C	6HX	T300-SM100DC-MJ4	★	4.5	4.00	63.0	13.0	3	3.3	DIN 371
		.512						*.177*	*.157*	*2.480*	*.512*		*.130*	
MJ 5	0.80	16.00	6.00 x 4.90	C	6HX	T300-SM100DC-MJ5	★	6.0	5.00	70.0	16.0	3	4.2	DIN 371
		.630						*.236*	*.197*	*2.756*	*.630*		*.165*	
MJ 6	1.00	23.00	6.00 x 4.90	C	6HX	T300-SM100DC-MJ6	★	6.0	6.00	80.0	15.0	3	5.0	DIN 371
		.906						*.236*	*.236*	*3.150*	*.591*		*.197*	
MJ 8	1.25	29.50	8.00 x 6.20	C	6HX	T300-SM100DC-MJ8	★	8.0	8.00	100.0	18.0	3	6.8	DIN 371
		1.161						*.315*	*.315*	*3.937*	*.709*		*.268*	

C177 C157 E9 E27 C154

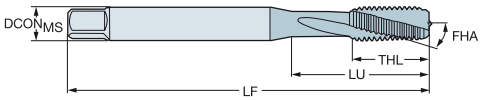
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN 2184-1



ULDR 1.5
FHA 25°
SUBSTRATE HSS-E-PM



For nickel-based alloys

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S / D150	Dimensions, mm, inch: DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC #3-48	48.00	9.00	2.80 x 2.10	C	2B	T300-SD100DE-3-48	★	2.8	2.51	50.0	9.0	3	2.1	DIN 2184-1
		.354						*.110*	*.099*	*1.969*	*.354*		*.083*	
UNC #2-56	56.00	9.00	2.80 x 2.10	C	2B	T300-SD100DE-2-56	★	2.8	2.18	45.0	9.0	3	1.9	DIN 2184-1
		.354						*.110*	*.086*	*1.772*	*.354*		*.073*	
UNC #4-40	40.00	10.00	3.50 x 2.70	C	2B	T300-SD100DE-4-40	★	3.5	2.84	56.0	10.0	3	2.4	DIN 2184-1
		.394						*.138*	*.112*	*2.205*	*.394*		*.093*	
UNC #6-32	32.00	12.00	4.00 x 3.00	C	2B	T300-SD100DE-6-32	★	4.0	3.51	56.0	12.0	3	2.9	DIN 2184-1
		.472						*.157*	*.138*	*2.205*	*.472*		*.112*	
UNC #8-32	32.00	13.00	4.50 x 3.40	C	2B	T300-SD100DE-8-32	★	4.5	4.17	63.0	13.0	3	3.5	DIN 2184-1
		.512						*.177*	*.164*	*2.480*	*.512*		*.138*	
UNC #10-24	24.00	16.00	6.00 x 4.90	C	2B	T300-SD100DE-10-24	★	6.0	4.83	70.0	16.0	3	3.9	DIN 2184-1
		.630						*.236*	*.190*	*2.756*	*.630*		*.154*	
UNC 1/4-20	20.00	25.00	7.00 x 5.50	C	2B	T300-SD100DE-1/4	★	7.0	6.35	80.0	15.0	3	5.1	DIN 2184-1
		.984						*.276*	*.250*	*3.150*	*.591*		*.201*	
UNC 5/16-18	18.00	29.50	8.00 x 6.20	C	2B	T300-SD100DE-5/16	★	8.0	7.94	90.0	18.0	3	6.6	DIN 2184-1
		1.161						*.315*	*.313*	*3.543*	*.709*		*.260*	
UNC 3/8-16	16.00	33.50	10.00 x 8.00	C	2B	T300-SD100DE-3/8	★	10.0	9.53	100.0	20.0	4	8.0	DIN 2184-1
		1.319						*.394*	*.375*	*3.937*	*.787*		*.315*	

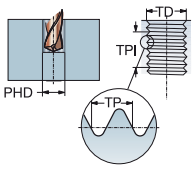
C177 C157 E9 E27 C154

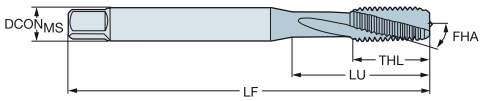
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

C-DIN/ANSI, DIN/ANSI

ULDR	1.5
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD TIALN





P
30-48 HRC

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
UNC #4-40	40.00	11.90	.141 x .110	C	2B	E8844-40	3.6	2.84	56.0	11.9	3	C-DIN/ANSI
		.469					*.141*	*.112*	*2.205*	*.469*		
UNC #6-32	32.00	13.90	.168 x .131	C	2B	E8846-32	4.3	3.51	63.0	13.9	3	C-DIN/ANSI
		.547					*.168*	*.138*	*2.480*	*.547*		
UNC #8-32	32.00	15.10	.194 x .152	C	2B	E8848-32	4.9	4.17	70.0	15.1	3	C-DIN/ANSI
		.594					*.194*	*.164*	*2.756*	*.594*		
UNC #10-24	24.00	17.00	.255 x .191	C	2B	E88410-24	6.5	4.83	80.0	17.0	3	C-DIN/ANSI
		.669					*.255*	*.190*	*3.150*	*.669*		
UNC 1/4-20	20.00	20.20	.318 x .238	C	2B	E8841/4	8.1	6.35	90.0	20.2	3	C-DIN/ANSI
		.795					*.318*	*.250*	*3.543*	*.795*		
UNC 5/16-18	18.00	20.00	.381 x .286	C	2B	E8845/16	9.7	7.94	100.0	22.8	3	C-DIN/ANSI
		.787					*.381*	*.313*	*3.937*	*.898*		
UNC 3/8-16	16.00	37.00	.381 x .286	C	2B	E8843/8	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.457					*.381*	*.375*	*3.937*	*.787*		
UNC 7/16-14	14.00	72.60	.323 x .242	C	2B	E8847/16	8.2	11.11	100.0	20.0	4	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.787*		
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	E8841/2	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.906*		
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	E8845/8	12.2	15.88	110.0	23.0	4	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.906*		
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	E8843/4	15.0	19.05	125.0	30.0	4	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*1.181*		

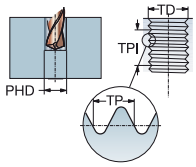
C177 C157 E9 C154

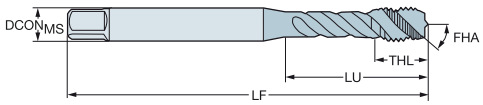
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN/ANSI

ULDR 3.0
FHA 48°
SUBSTRATE HSS-E-PM
COATING PVD TiAlN





P
≤350HB

TCT	TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
H1	UNC #2-56	56.00	11.99	.141 x .110	C	3B	EX23PA2-56	3.6	2.18	45.0	4.0	3	DIN/ANSI
			.472					*.141*	*.086*	*1.772*	*.157*		
H2	UNC #4-40	40.00	16.97	.141 x .110	C	2B	EX23PA4-40	3.6	2.84	56.0	6.5	3	DIN/ANSI
			.668					*.141*	*.112*	*2.205*	*.256*		
H2	UNC #5-40	40.00	17.74	.141 x .110	C	2B	EX23PA5-40	3.6	3.18	56.0	6.5	3	DIN/ANSI
			.698					*.141*	*.125*	*2.205*	*.256*		
H3	UNC #6-32	32.00	20.20	.141 x .110	C	2B	EX23PA6-32	3.6	3.51	56.0	6.5	3	DIN/ANSI
			.795					*.141*	*.138*	*2.205*	*.256*		
H3	UNC #8-32	32.00	21.18	.168 x .131	C	2B	EX23PA8-32	4.3	4.17	63.0	7.0	3	DIN/ANSI
			.834					*.168*	*.164*	*2.480*	*.276*		
H5	UNC #8-32	32.00	21.18	.168 x .131	C	2B	EX23PA8-32H5	4.3	4.17	63.0	7.0	3	DIN/ANSI
			.834					*.168*	*.164*	*2.480*	*.276*		
H3	UNC #10-24	24.00	27.54	.194 x .152	C	2B	EX23PA10-24	4.9	4.83	70.0	8.4	3	DIN/ANSI
			1.084					*.194*	*.190*	*2.756*	*.331*		
H3	UNC 1/4-20	20.00	24.69	.255 x .191	C	3B	EX23PA1/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					*.255*	*.250*	*3.150*	*.402*		
H5	UNC 1/4-20	20.00	24.69	.255 x .191	C	2B	EX23PA1/4H5	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					*.255*	*.250*	*3.150*	*.402*		
H3	UNC 5/16-18	18.00	33.17	.318 x .238	C	3B	EX23PA5/16	8.1	7.94	90.0	12.2	3	DIN/ANSI
			1.306					*.318*	*.313*	*3.543*	*.480*		
H5	UNC 5/16-18	18.00	33.17	.318 x .238	C	2B	EX23PA5/16H5	8.1	7.94	90.0	12.2	3	DIN/ANSI
			1.306					*.318*	*.313*	*3.543*	*.480*		
H3	UNC 3/8-16	16.00	38.07	.381 x .286	C	3B	EX23PA3/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					*.381*	*.375*	*3.937*	*.622*		
H5	UNC 3/8-16	16.00	38.07	.381 x .286	C	2B	EX23PA3/8H5	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					*.381*	*.375*	*3.937*	*.622*		
H3	UNC 7/16-14	14.00	72.60	.323 x .242	C	3B	EX23PA7/16	8.2	11.11	100.0	15.0	3	DIN/ANSI
			2.858					*.323*	*.438*	*3.937*	*.591*		
H3	UNC 1/2-13	13.00	81.80	.367 x .275	C	3B	EX23PA1/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					*.367*	*.500*	*4.331*	*.709*		
H5	UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	EX23PA1/2H5	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					*.367*	*.500*	*4.331*	*.709*		
H3	UNC 5/8-11	11.00	65.80	.480 x .360	C	3B	EX23PA5/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					*.480*	*.625*	*4.331*	*.787*		
H5	UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	EX23PA5/8H5	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					*.480*	*.625*	*4.331*	*.787*		
H3	UNC 3/4-10	10.00	77.50	.590 x .442	C	3B	EX23PA3/4	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					*.590*	*.750*	*4.921*	*.984*		
H5	UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	EX23PA3/4H5	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					*.590*	*.750*	*4.921*	*.984*		
H4	UNC 7/8-9	9.00	90.90	.697 x .523	C	3B	EX23PA7/8	17.7	22.23	140.0	25.0	4	DIN/ANSI
			3.579					*.697*	*.875*	*5.512*	*.984*		
H4	UNC 1"-8	8.00	95.40	.800 x .600	C	3B	EX23PA1	20.3	25.40	160.0	30.0	4	DIN/ANSI
			3.756					*.800*	*1.000*	*6.299*	*1.181*		

C177 C157 E9 C154

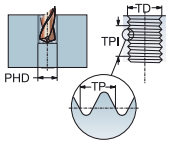
SANDVIK Coromant

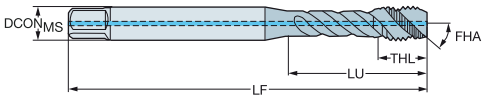
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN/ANSI

ULDR 3.0
FHA 48°
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
									Dimensions, mm, inch					
UNC 1/4-20	20.00	24.69	.255 x .191	C	2BX	1	1	**EX29PA1/4**	6.5	6.35	80.0	10.2	3	DIN/ANSI
		.972							*.255*	*.250*	*3.150*	*.402*		
UNC 5/16-18	18.00	33.17	.318 x .238	C	2BX	1	1	**EX29PA5/16**	8.1	7.94	90.0	12.2	3	DIN/ANSI
		1.306							*.318*	*.313*	*3.543*	*.480*		
UNC 3/8-16	16.00	38.07	.381 x .286	C	2BX	1	1	**EX29PA3/8**	9.7	9.53	100.0	15.8	3	DIN/ANSI
		1.499							*.381*	*.375*	*3.937*	*.622*		
UNC 1/2-13	13.00	81.90	.367 x .275	C	2BX	1	1	**EX29PA1/2**	9.3	12.70	110.0	18.0	3	DIN/ANSI
		3.224							*.367*	*.500*	*4.331*	*.709*		
UNC 5/8-11	11.00	65.80	.480 x .360	C	2BX	1	1	**EX29PA5/8**	12.2	15.88	110.0	20.0	4	DIN/ANSI
		2.591							*.480*	*.625*	*4.331*	*.787*		
UNC 3/4-10	10.00	77.50	.590 x .442	C	2BX	1	1	**EX29PA3/4**	15.0	19.05	125.0	25.0	4	DIN/ANSI
		3.051							*.590*	*.750*	*4.921*	*.984*		
UNC 7/8-9	9.00	90.90	.697 x .523	C	2BX	1	1	**EX29PA7/8**	17.7	22.23	140.0	25.0	4	DIN/ANSI
		3.579							*.697*	*.875*	*5.512*	*.984*		
UNC 1"-8	8.00	95.40	.800 x .600	C	2BX	1	1	**EX29PA1**	20.3	25.40	160.0	30.0	4	DIN/ANSI
		3.756							*.800*	*1.000*	*6.299*	*1.181*		

CXSC 1 = Axial concentric coolant exit

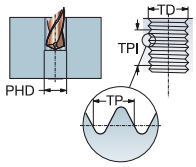
C177 C157 E9 E28 C154

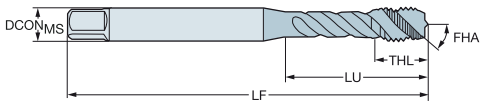
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN/ANSI

ULDR 2.5
FHA 48°
SUBSTRATE HSS-PM
COATING PVD TIALN+WCC





M

							Dimensions, mm, inch					
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
UNC #4-40	40.00	15.47	.141 x .110	C	2B	E8824-40	3.6	2.84	56.0	6.5	3	DIN/ANSI
		.609					*.141*	*.112*	*2.205*	*.256*		
UNC #6-32	32.00	15.08	.141 x .110	C	2B	E8826-32	3.6	3.51	56.0	6.5	3	DIN/ANSI
		.594					*.141*	*.138*	*2.205*	*.256*		
UNC #8-32	32.00	16.58	.168 x .131	C	2B	E8828-32	4.3	4.17	63.0	7.0	3	DIN/ANSI
		.653					*.168*	*.164*	*2.480*	*.276*		
UNC #10-24	24.00	21.00	.194 x .152	C	2B	E88210-24	4.9	4.83	70.0	8.4	3	DIN/ANSI
		.827					*.194*	*.190*	*2.756*	*.331*		
UNC 1/4-20	20.00	25.59	.255 x .191	C	2B	E8821/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
		1.007					*.255*	*.250*	*3.150*	*.402*		
UNC 5/16-18	18.00	30.20	.318 x .238	C	2B	E8825/16	8.1	7.94	90.0	12.2	3	DIN/ANSI
		1.189					*.318*	*.313*	*3.543*	*.480*		
UNC 3/8-16	16.00	32.80	.381 x .286	C	2B	E8823/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
		1.292					*.381*	*.375*	*3.937*	*.622*		
UNC 7/16-14	14.00	72.60	.323 x .242	C	2B	E8827/16	8.2	11.11	100.0	15.0	3	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.591*		
UNC 1/2-13	13.00	81.80	.367 x .275	C	2B	E8821/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.709*		
UNC 5/8-11	11.00	65.80	.480 x .360	C	2B	E8825/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.787*		
UNC 3/4-10	10.00	77.50	.590 x .442	C	2B	E8823/4	15.0	19.05	125.0	25.0	4	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*.984*		
UNC 7/8-9	9.00	90.90	.697 x .523	C	2B	E8827/8	17.7	22.23	140.0	25.0	4	DIN/ANSI
		3.579					*.697*	*.875*	*5.512*	*.984*		

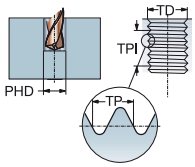
C177 C157 E9 C154

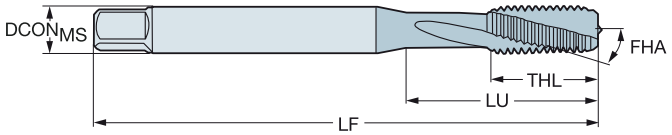
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNC

DIN/ANSI

ULDR 1.5
FHA 15°
SUBSTRATE HSS-E-PM





N

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

Thread form: UNF

DIN/ANSI

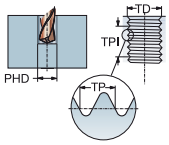
TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N D150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
UNF #10-32	32.00	21.42	.194 x .152	C	2B	T300-NM100AF-10-32	★	4.9	4.83	70.0	14.0	3	4.1	DIN/ANSI
		.843						*.194*	*.190*	*2.756*	*.551*		*.161*	
UNF 1/4-28	28.00	25.59	.255 x .191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

C177 C157 E9 E27 C154

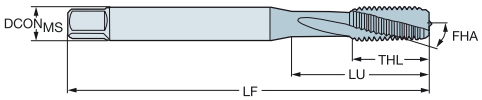
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

DIN 2184-1



ULDR 1.5
FHA 25°
SUBSTRATE HSS-E-PM



For nickel-based alloys

							S	Dimensions, mm, inch						
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	D150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNF #6-40	40.00	12.00	4.00 x 3.00	C	3B	T300-SD100DF-6-40	★	4.0	3.51	56.0	12.0	3	3.0	DIN 2184-1
		.472						*.157*	*.138*	*2.205*	*.472*		*.116*	
UNF #8-36	36.00	42.00	4.50 x 3.40	C	3B	T300-SD100DF-8-36	★	4.5	4.17	63.0	13.0	3	3.5	DIN 2184-1
		1.654						*.177*	*.164*	*2.480*	*.512*		*.138*	
UNF #10-32	32.00	16.00	6.00 x 4.90	C	3B	T300-SD100DF-10-32	★	6.0	4.83	70.0	16.0	3	4.1	DIN 2184-1
		.630						*.236*	*.190*	*2.756*	*.630*		*.161*	
UNF #12-28	28.00	23.00	6.00 x 4.90	C	3B	T300-SD100DF-12-28	★	6.0	5.49	80.0	15.0	3	4.6	DIN 2184-1
		.906						*.236*	*.216*	*3.150*	*.591*		*.181*	
UNF 1/4-28	28.00	25.00	7.00 x 5.50	C	3B	T300-SD100DF-1/4	★	7.0	6.35	80.0	15.0	3	5.5	DIN 2184-1
		.984						*.276*	*.250*	*3.150*	*.591*		*.217*	
UNF 5/16-24	24.00	29.50	8.00 x 6.20	C	3B	T300-SD100DF-5/16	★	8.0	7.94	90.0	18.0	3	6.9	DIN 2184-1
		1.161						*.315*	*.313*	*3.543*	*.709*		*.272*	
UNF 3/8-24	24.00	33.50	10.00 x 8.00	C	3B	T300-SD100DF-3/8	★	10.0	9.53	100.0	20.0	4	8.5	DIN 2184-1
		1.319						*.394*	*.375*	*3.937*	*.787*		*.335*	

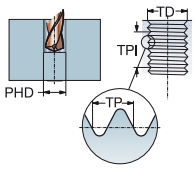
C177 C157 E9 E27 C154

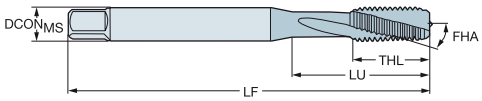
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

C-DIN/ANSI, DIN/ANSI

ULDR	1.5
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD TIALN





P
30-48 HRC

Dimensions, mm, inch

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
UNF #10-32	32.00	17.00	.255 x .191	C	2B	E88510-32	6.5	4.83	80.0	17.0	3	C-DIN/ANSI
		.669					*.255*	*.190*	*3.150*	*.669*		
UNF 1/4-28	28.00	20.20	.318 x .238	C	2B	E8851/4	8.1	6.35	90.0	20.2	3	C-DIN/ANSI
		.795					*.318*	*.250*	*3.543*	*.795*		
UNF 5/16-24	24.00	20.00	.381 x .286	C	2B	E8855/16	9.7	7.94	100.0	22.8	3	C-DIN/ANSI
		.787					*.381*	*.313*	*3.937*	*.898*		
UNF 3/8-24	24.00	33.00	.381 x .286	C	2B	E8853/8	9.7	9.53	100.0	20.0	3	DIN/ANSI
		1.299					*.381*	*.375*	*3.937*	*.787*		
UNF 7/16-20	20.00	72.60	.323 x .242	C	2B	E8857/16	8.2	11.11	100.0	20.0	4	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.787*		
UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	E8851/2	9.3	12.70	110.0	23.0	4	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.906*		
UNF 5/8-18	18.00	65.80	.480 x .360	C	2B	E8855/8	12.2	15.88	110.0	23.0	4	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.906*		
UNF 3/4-16	16.00	77.50	.590 x .442	C	2B	E8853/4	15.0	19.05	125.0	30.0	4	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*1.181*		

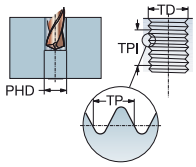
C177 C157 E9 C154

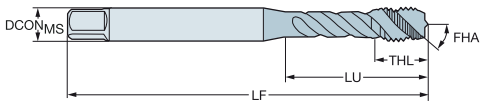
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

DIN/ANSI

ULDR 3.0
FHA 48°
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

TCT	TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
								Dimensions, mm, inch					
H2	UNF #8-36	36.00	21.18	.168 x .131	C	2B	EX33PA8-36	4.3	4.17	63.0	7.0	3	DIN/ANSI
			.834					*.168*	*.164*	*2.480*	*.276*		
H3	UNF #10-32	32.00	27.54	.194 x .152	C	2B	EX33PA10-32	4.9	4.83	70.0	8.0	3	DIN/ANSI
			1.084					*.194*	*.190*	*2.756*	*.315*		
H3	UNF 1/4-28	28.00	24.69	.255 x .191	C	3B	EX33PA1/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					*.255*	*.250*	*3.150*	*.402*		
H4	UNF 1/4-28	28.00	24.69	.255 x .191	C	2B	EX33PA1/4H4	6.5	6.35	80.0	10.2	3	DIN/ANSI
			.972					*.255*	*.250*	*3.150*	*.402*		
H3	UNF 5/16-24	24.00	33.17	.318 x .238	C	3B	EX33PA5/16	8.1	7.94	90.0	12.0	3	DIN/ANSI
			1.306					*.318*	*.313*	*3.543*	*.472*		
H4	UNF 5/16-24	24.00	33.17	.318 x .238	C	2B	EX33PA5/16H4	8.1	7.94	90.0	12.0	3	DIN/ANSI
			1.306					*.318*	*.313*	*3.543*	*.472*		
H3	UNF 3/8-24	24.00	38.07	.381 x .286	C	3B	EX33PA3/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					*.381*	*.375*	*3.937*	*.622*		
H4	UNF 3/8-24	24.00	38.07	.381 x .286	C	2B	EX33PA3/8H4	9.7	9.53	100.0	15.8	3	DIN/ANSI
			1.499					*.381*	*.375*	*3.937*	*.622*		
H3	UNF 7/16-20	20.00	72.60	.323 x .242	C	3B	EX33PA7/16	8.2	11.11	100.0	15.0	3	DIN/ANSI
			2.858					*.323*	*.438*	*3.937*	*.591*		
H3	UNF 1/2-20	20.00	81.80	.367 x .275	C	3B	EX33PA1/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					*.367*	*.500*	*4.331*	*.709*		
H5	UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	EX33PA1/2H5	9.3	12.70	110.0	18.0	3	DIN/ANSI
			3.220					*.367*	*.500*	*4.331*	*.709*		
H3	UNF 5/8-18	18.00	65.80	.480 x .360	C	3B	EX33PA5/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					*.480*	*.625*	*4.331*	*.787*		
H5	UNF 5/8-18	18.00	65.80	.480 x .360	C	2B	EX33PA5/8H5	12.2	15.88	110.0	20.0	4	DIN/ANSI
			2.591					*.480*	*.625*	*4.331*	*.787*		
H3	UNF 3/4-16	16.00	77.50	.590 x .442	C	3B	EX33PA3/4	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					*.590*	*.750*	*4.921*	*.984*		
H5	UNF 3/4-16	16.00	77.50	.590 x .442	C	2B	EX33PA3/4H5	15.0	19.05	125.0	25.0	4	DIN/ANSI
			3.051					*.590*	*.750*	*4.921*	*.984*		
H4	UNF 7/8-14	14.00	90.90	.697 x .523	C	3B	EX33PA7/8	17.7	22.23	140.0	25.0	4	DIN/ANSI
			3.579					*.697*	*.875*	*5.512*	*.984*		
H4	UNF 1"-12	12.00	95.40	.800 x .600	C	3B	EX33PA1-12	20.3	25.40	160.0	30.0	4	DIN/ANSI
			3.756					*.800*	*1.000*	*6.299*	*1.181*		

C177 C157 E9 C154

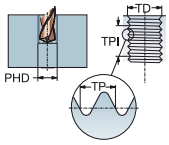
SANDVIK Coromant

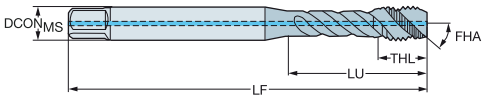
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

DIN/ANSI

ULDR 3.0
FHA 48°
SUBSTRATE HSS-E-PM
COATING PVD TIALN





P
≤350HB

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	CNSC	CXSC	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
									Dimensions, mm, inch					
UNF #10-32	32.00	27.54	.194 x .152	C	2BX	1	1	EX39PA10-32	4.9	4.83	70.0	8.0	3	DIN/ANSI
		1.084							*.194*	*.190*	*2.756*	*.315*		
UNF 1/4-28	28.00	24.69	.255 x .191	C	2BX	1	1	EX39PA1/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
		.972							*.255*	*.250*	*3.150*	*.402*		
UNF 5/16-24	24.00	33.17	.318 x .238	C	2BX	1	1	EX39PA5/16	8.1	7.94	90.0	12.0	3	DIN/ANSI
		1.306							*.318*	*.313*	*3.543*	*.472*		
UNF 3/8-24	24.00	38.07	.381 x .286	C	2BX	1	1	EX39PA3/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
		1.499							*.381*	*.375*	*3.937*	*.622*		
UNF 1/2-20	20.00	81.80	.367 x .275	C	2BX	1	1	EX39PA1/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
		3.220							*.367*	*.500*	*4.331*	*.709*		
UNF 5/8-18	18.00	65.80	.480 x .360	C	2BX	1	1	EX39PA5/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
		2.591							*.480*	*.625*	*4.331*	*.787*		

CXSC 1 = Axial concentric coolant exit

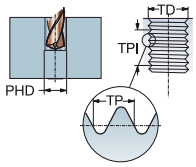
C177 C157 E9 E28 C154

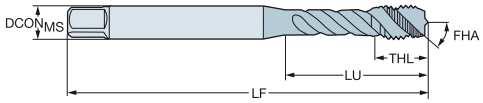
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNF

DIN/ANSI

ULDR	2.5
FHA	48°
SUBSTRATE	HSS-PM
COATING	PVD TIALN+WCC





M

							Dimensions, mm, inch					
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	$DCON_{MS}$	TD	LF	THL	NOF	BSG
UNF #10-32	32.00	21.42	.194 x .152	C	2B	E88310-32	4.9	4.83	70.0	8.4	3	DIN/ANSI
		.843					*.194*	*.190*	*2.756*	*.331*		
UNF 1/4-28	28.00	25.59	.255 x .191	C	2B	E8831/4	6.5	6.35	80.0	10.2	3	DIN/ANSI
		1.007					*.255*	*.250*	*3.150*	*.402*		
UNF 5/16-24	24.00	30.20	.318 x .238	C	2B	E8835/16	8.1	7.94	90.0	12.2	3	DIN/ANSI
		1.189					*.318*	*.313*	*3.543*	*.480*		
UNF 3/8-24	24.00	32.80	.381 x .286	C	2B	E8833/8	9.7	9.53	100.0	15.8	3	DIN/ANSI
		1.292					*.381*	*.375*	*3.937*	*.622*		
UNF 7/16-20	20.00	72.60	.323 x .242	C	2B	E8837/16	8.2	11.11	100.0	15.0	3	DIN/ANSI
		2.858					*.323*	*.438*	*3.937*	*.591*		
UNF 1/2-20	20.00	81.80	.367 x .275	C	2B	E8831/2	9.3	12.70	110.0	18.0	3	DIN/ANSI
		3.220					*.367*	*.500*	*4.331*	*.709*		
UNF 5/8-18	18.00	65.80	.480 x .360	C	2B	E8835/8	12.2	15.88	110.0	20.0	4	DIN/ANSI
		2.591					*.480*	*.625*	*4.331*	*.787*		
UNF 3/4-16	16.00	77.50	.590 x .442	C	2B	E8833/4	15.0	19.05	125.0	25.0	4	DIN/ANSI
		3.051					*.590*	*.750*	*4.921*	*.984*		
UNF 7/8-14	14.00	90.90	.697 x .523	C	2B	E8837/8	17.7	22.23	140.0	25.0	4	DIN/ANSI
		3.579					*.697*	*.875*	*5.512*	*.984*		

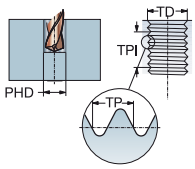
C177 C157 E9 C154

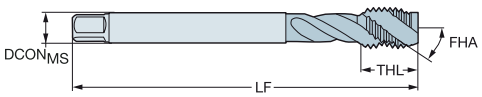
CoroTap™ 300 cutting tap with spiral flutes

Thread form: G

DIN 5156

ULDR 2.0
FHA 40°
SUBSTRATE HSS-E
COATING PVD FEN





M

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	Dimensions, mm, inch DCON$_{MS}$	TD	LF	THL	NOF	BSG
G 1/8-28	28.00	67.00	7.00 x 5.50	C	NORMAL	E3621/8	7.0	9.73	90.0	12.0	3	DIN 5156
		2.638					*.276*	*.383*	*3.543*	*.472*		
G 1/4-19	19.00	71.00	11.00 x 9.00	C	NORMAL	E3621/4	11.0	13.16	100.0	15.0	4	DIN 5156
		2.795					*.433*	*.518*	*3.937*	*.591*		
G 3/8-19	19.00	58.00	12.00 x 9.00	C	NORMAL	E3623/8	12.0	16.66	100.0	15.0	4	DIN 5156
		2.283					*.472*	*.656*	*3.937*	*.591*		
G 1/2-14	14.00	80.00	16.00 x 12.00	C	NORMAL	E3621/2	16.0	20.96	125.0	24.0	4	DIN 5156
		3.150					*.630*	*.825*	*4.921*	*.945*		
G 3/4-14	14.00	77.00	20.00 x 16.00	C	NORMAL	E3623/4	20.0	26.44	140.0	20.0	4	DIN 5156
		3.032					*.787*	*1.041*	*5.512*	*.787*		
G 1"-11	11.00	93.00	25.00 x 20.00	C	NORMAL	E3621	25.0	33.25	160.0	24.0	4	DIN 5156
		3.661					*.984*	*1.309*	*6.299*	*.945*		

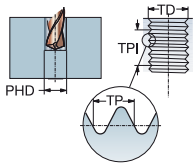
C177 C157 E9 C154

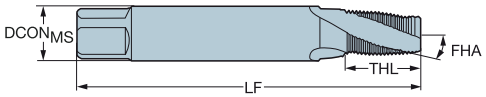
CoroTap™ 300 cutting tap with spiral flutes

Thread form: NPT

DIN/ANSI

ULDR 1.5
FHA 30°
SUBSTRATE HSS-E
COATING PVD FEN



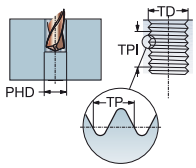


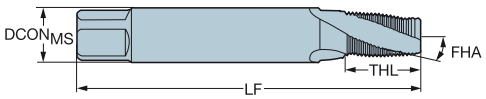
M

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
NPT 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	E7361/16	8.0	7.72	80.0	14.0	3	DIN/ANSI
		2.205					*.313*	*.304*	*3.150*	*.551*		
NPT 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	E7361/8	11.1	10.07	90.0	14.0	4	DIN/ANSI
		2.520					*.437*	*.396*	*3.543*	*.551*		
NPT 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	E7361/4	14.3	13.37	100.0	20.0	4	DIN/ANSI
		2.323					*.562*	*.526*	*3.937*	*.787*		
NPT 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	E7363/8	17.8	16.81	110.0	20.0	5	DIN/ANSI
		2.638					*.700*	*.662*	*4.331*	*.787*		
NPT 1/2-14	14.00	79.00	.687 x .515	C	NORMAL	E7361/2	17.4	20.95	125.0	26.0	5	DIN/ANSI
		3.110					*.687*	*.825*	*4.921*	*1.024*		
NPT 3/4-14	14.00	78.00	.906 x .679	C	NORMAL	E7363/4	23.0	26.29	140.0	26.0	5	DIN/ANSI
		3.071					*.906*	*1.035*	*5.512*	*1.024*		
NPT 1-11.5	11.50	58.00	1.125 x .843	C	NORMAL	E7361	28.6	32.91	150.0	31.0	5	DIN/ANSI
		2.283					*1.125*	*1.296*	*5.906*	*1.220*		

Thread form: NPTF

ULDR 1.5
FHA 30°
SUBSTRATE HSS-E
COATING PVD FEN





M

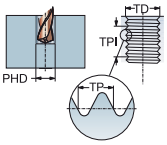
TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	DCON$_{MS}$	TD	LF	THL	NOF	BSG
							Dimensions, mm, inch					
NPTF 1/16-27	27.00	56.00	.313 x .234	C	NORMAL	E7381/16	8.0	7.64	80.0	14.0	3	DIN/ANSI
		2.205					*.313*	*.301*	*3.150*	*.551*		
NPTF 1/8-27	27.00	64.00	.437 x .328	C	NORMAL	E7381/8	11.1	9.98	90.0	20.0	4	DIN/ANSI
		2.520					*.437*	*.393*	*3.543*	*.787*		
NPTF 1/4-18	18.00	59.00	.562 x .421	C	NORMAL	E7381/4	14.3	13.31	100.0	20.0	4	DIN/ANSI
		2.323					*.562*	*.524*	*3.937*	*.787*		
NPTF 3/8-18	18.00	67.00	.700 x .531	C	NORMAL	E7383/8	17.8	16.75	110.0	26.0	5	DIN/ANSI
		2.638					*.700*	*.660*	*4.331*	*1.024*		
NPTF 1/2-14	14.00	79.00	.437 x .328	C	NORMAL	E7381/2	11.1	20.92	125.0	14.0	5	DIN/ANSI
		3.110					*.437*	*.824*	*4.921*	*.551*		
NPTF 3/4-14	14.00	78.00	.687 x .515	C	NORMAL	E7383/4	17.4	26.27	140.0	26.0	5	DIN/ANSI
		3.071					*.687*	*1.034*	*5.512*	*1.024*		

C177 C157 E9 C154

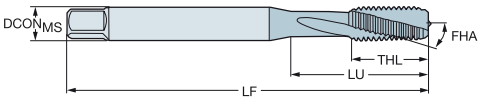
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNJC

DIN 2184-1



ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM



For nickel-based alloys

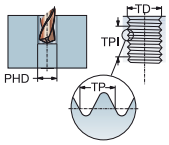
							S	Dimensions, mm, inch						
TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	D150	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNJC #10-24	24.00	13.50	6.00 x 4.90	C	3B	T300-SD100DH-10-24	★	6.0	4.83	70.0	13.5	3	3.9	DIN 2184-1
		.531						*.236*	*.190*	*2.756*	*.531*		*.154*	
UNJC 1/4-20	20.00	17.50	7.00 x 5.50	C	3B	T300-SD100DH-1/4	★	7.0	6.35	80.0	17.5	3	5.1	DIN 2184-1
		.689						*.276*	*.250*	*3.150*	*.689*		*.201*	
UNJC 3/8-16	16.00	25.00	10.00 x 8.00	C	3B	T300-SD100DH-3/8	★	10.0	9.53	100.0	25.0	3	8.0	DIN 2184-1
		.984						*.394*	*.375*	*3.937*	*.984*		*.315*	
UNJC 5/16-18	18.00	21.00	8.00 x 6.20	C	3B	T300-SD100DH-5/16	★	8.0	7.94	90.0	21.0	3	6.6	DIN 2184-1
		.827						*.315*	*.313*	*3.543*	*.827*		*.260*	
UNJC #4-40	40.00	8.00	3.50 x 2.70	C	3B	T300-SD100DH-4-40	★	3.5	2.84	56.0	8.0	3	2.4	DIN 2184-1
		.315						*.138*	*.112*	*2.205*	*.315*		*.093*	
UNJC #6-32	32.00	10.00	4.00 x 3.00	C	3B	T300-SD100DH-6-32	★	4.0	3.51	56.0	10.0	3	2.9	DIN 2184-1
		.394						*.157*	*.138*	*2.205*	*.394*		*.112*	
UNJC #8-32	32.00	11.00	4.50 x 3.40	C	3B	T300-SD100DH-8-32	★	4.5	4.17	63.0	11.0	3	3.5	DIN 2184-1
		.433						*.177*	*.164*	*2.480*	*.433*		*.138*	

C177 C157 E9 E27 C154

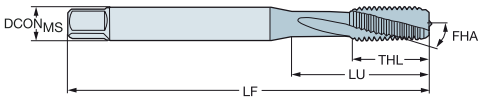
CoroTap™ 300 cutting tap with spiral flutes

Thread form: UNJF

DIN 2184-1



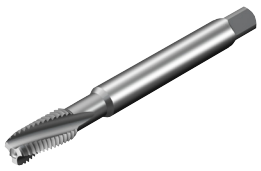
ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM

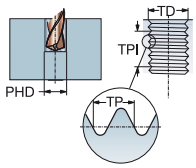


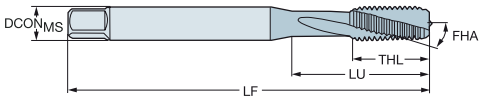
For nickel-based alloys

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S D150	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
UNJF #6-40	40.00	9.50	4.00 x 3.00	C	3B	T300-SD100DI-6-40	★	4.0	3.51	56.0	9.5	3	3.0	DIN 2184-1
		.374						*.157*	*.138*	*2.205*	*.374*		*.116*	
UNJF #8-36	36.00	11.00	4.50 x 3.40	C	3B	T300-SD100DI-8-36	★	4.5	4.17	63.0	11.0	3	3.5	DIN 2184-1
		.433						*.177*	*.164*	*2.480*	*.433*		*.138*	
UNJF #10-32	32.00	12.50	6.00 x 4.90	C	3B	T300-SD100DI-10-32	★	6.0	4.83	70.0	12.5	3	4.1	DIN 2184-1
		.492						*.236*	*.190*	*2.756*	*.492*		*.161*	
UNJF 1/4-28	28.00	16.00	7.00 x 5.50	C	3B	T300-SD100DI-1/4	★	7.0	6.35	80.0	16.0	3	5.5	DIN 2184-1
		.630						*.276*	*.250*	*3.150*	*.630*		*.217*	
UNJF 5/16-24	24.00	20.00	8.00 x 6.20	C	3B	T300-SD100DI-5/16	★	8.0	7.94	90.0	20.0	3	6.9	DIN 2184-1
		.787						*.315*	*.313*	*3.543*	*.787*		*.272*	
UNJF 3/8-24	24.00	23.00	10.00 x 8.00	C	3B	T300-SD100DI-3/8	★	10.0	9.53	100.0	23.0	3	8.5	DIN 2184-1
		.906						*.394*	*.375*	*3.937*	*.906*		*.335*	

ULDR 2.0
FHA 15°
SUBSTRATE HSS-E-PM
COATING PVD ALCRN







For titanium alloys

TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S D115	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
UNJF #10-32	32.00	16.00	6.00 x 4.90	C	3B	T300-SM100DI-10-32	★	6.0	4.83	70.0	16.0	3	4.1	DIN 2184-1
		.630						*.236*	*.190*	*2.756*	*.630*		*.161*	
UNJF 1/4-28	28.00	25.00	7.00 x 5.50	C	3B	T300-SM100DI-1/4	★	7.0	6.35	80.0	15.0	3	5.5	DIN 2184-1
		.984						*.276*	*.250*	*3.150*	*.591*		*.217*	
UNJF 5/16-24	24.00	29.50	8.00 x 6.20	C	3B	T300-SM100DI-5/16	★	8.0	7.94	90.0	18.0	3	6.9	DIN 2184-1
		1.161						*.315*	*.313*	*3.543*	*.709*		*.272*	
UNJF 3/8-24	24.00	33.50	10.00 x 8.00	C	3B	T300-SM100DI-3/8	★	10.0	9.53	100.0	20.0	3	8.5	DIN 2184-1
		1.319						*.394*	*.375*	*3.937*	*.787*		*.335*	

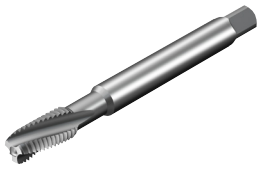
C177 C157 E9 E27 C154

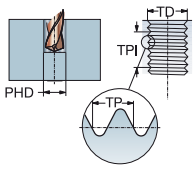
CoroTap™ 300 cutting tap with spiral flutes

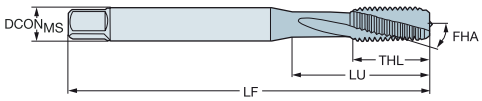
Thread form: -EGUNF

DIN 2184-1

ULDR	2.0
FHA	15°
SUBSTRATE	HSS-E-PM
COATING	PVD ALCRN







Insert taps

For titanium alloys

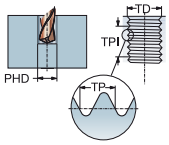
TDZ	TPI	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	S	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
							D115	Dimensions, mm, inch						
EGUNF #10-32	32.00	16.00	6.00 x 4.90	C	3B	T300-SM100DS-10-32	★	6.0	5.94	70.0	16.0	3	5.1	DIN 2184-1
		.630						*.236*	*.234*	*2.756*	*.630*		*.201*	
EGUNF 1/4-28	28.00	25.00	8.00 x 6.20	C	3B	T300-SM100DS-1/4	★	8.0	7.60	80.0	15.0	3	6.6	DIN 2184-1
		.984						*.315*	*.299*	*3.150*	*.591*		*.260*	

C177 C157 E9 E27 C154

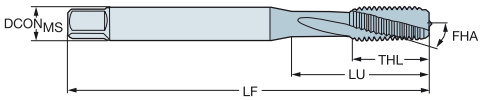
CoroTap™ 300 cutting tap with spiral flutes

Thread form: -EGUNJF

DIN 2184-1



ULDR 1.5
FHA 10°
SUBSTRATE HSS-E-PM



Insert taps

For nickel-based alloys

TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	S / D150	Dimensions, mm, inch: $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
EGUNJF #10-32	32.00	12.50	6.00 x 4.90	C	3B	T300-SD100DZ-10-32	★	6.0	5.94	70.0	15.0	3	5.1	DIN 2184-1
		.492						*.236*	*.234*	*2.756*	*.591*		*.201*	
EGUNJF 1/4-28	28.00	16.00	8.00 x 6.20	C	3B	T300-SD100DZ-1/4	★	8.0	7.60	80.0	18.0	3	6.6	DIN 2184-1
		.630						*.315*	*.299*	*3.150*	*.709*		*.260*	
EGUNJF 3/8-24	24.00	23.00	11.00 x 9.00	C	3B	T300-SD100DZ-3/8	★	11.0	10.99	100.0	20.0	3	9.8	DIN 2184-1
		.906						*.433*	*.433*	*3.937*	*.787*		*.386*	
EGUNJF 5/16-24	24.00	20.00	10.00 x 8.00	C	3B	T300-SD100DZ-5/16	★	10.0	9.40	90.0	20.0	3	8.2	DIN 2184-1
		.787						*.394*	*.370*	*3.543*	*.787*		*.323*	

C177 C157 E9 E27 C154

CoroTap™ 400

Applications

- Suitable for both through holes and blind holes
- Available in many thread forms and standards
- Depths up to 3.5 × diameter

Benefits and features

- Chamfer C (2–3 threads) and chamfer E (1.5–2 threads). Chamfer E mainly used in blind holes with low clearance
- High speed steel with cobalt taps for improved wear resistance
- High speed powder steel taps for improved strength, wear resistance, and tool life

- Taps that form the thread instead of cutting
- A chip-free solution
- All materials not suitable since there is need of certain ductility. Recommended tensile strength limit is 1200 N/mm^2
- For both through and blind holes
- Available with and without oil grooves

www.sandvik.coromant.com/corotap400

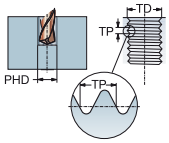
CoroChuck™ 970, see our Rotating Tools catalog.

CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN



TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P F125	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 9	1.25	35.00	9.00 x 7.00	C	6HX	T400-PM100DA-M9	★	9.0	9.00	90.0	13.0	6	8.3	DIN 2174
		1.378						*.354*	*.354*	*3.543*	*.512*		*.325*	
M 3	0.50	18.00	3.50 x 2.70	C	6HX	T400-PM100DA-M3	★	3.5	3.00	56.0	6.0	4	2.8	DIN 2174
		.709						*.138*	*.118*	*2.205*	*.236*		*.108*	
M 4	0.70	21.00	4.50 x 3.40	C	6HX	T400-PM100DA-M4	★	4.5	4.00	63.0	7.0	5	3.7	DIN 2174
		.827						*.177*	*.157*	*2.480*	*.276*		*.144*	
M 5	0.80	25.00	6.00 x 4.90	C	6HX	T400-PM100DA-M5	★	6.0	5.00	70.0	8.0	5	4.6	DIN 2174
		.984						*.236*	*.197*	*2.756*	*.315*		*.181*	
M 6	1.00	30.00	6.00 x 4.90	C	6HX	T400-PM100DA-M6	★	6.0	6.00	80.0	10.0	5	5.5	DIN 2174
		1.181						*.236*	*.236*	*3.150*	*.394*		*.217*	
M 7	1.00	30.00	7.00 x 5.50	C	6HX	T400-PM100DA-M7	★	7.0	7.00	80.0	7.0	6	6.5	DIN 2174
		1.181						*.276*	*.276*	*3.150*	*.276*		*.256*	
M 8	1.25	35.00	8.00 x 6.20	C	6HX	T400-PM100DA-M8	★	8.0	8.00	90.0	12.0	6	7.4	DIN 2174
		1.378						*.315*	*.315*	*3.543*	*.472*		*.291*	
M 10	1.50	39.00	10.00 x 8.00	C	6HX	T400-PM100DA-M10	★	10.0	10.00	100.0	15.0	7	9.3	DIN 2174
		1.535						*.394*	*.394*	*3.937*	*.591*		*.364*	
M 12	1.75	42.00	9.00 x 7.00	C	6HX	T400-PM100DA-M12	★	9.0	12.00	110.0	16.0	8	11.2	DIN 2174
		1.654						*.354*	*.472*	*4.331*	*.630*		*.441*	
M 14	2.00	49.00	11.00 x 9.00	C	6HX	T400-PM100DA-M14	★	11.0	14.00	110.0	20.0	8	13.0	DIN 2174
		1.929						*.433*	*.551*	*4.331*	*.787*		*.512*	
M 16	2.00	55.00	12.00 x 9.00	C	6HX	T400-PM100DA-M16	★	12.0	16.00	110.0	20.0	8	15.0	DIN 2174
		2.165						*.472*	*.630*	*4.331*	*.787*		*.591*	
M 3	0.50	18.00	3.50 x 2.70	C	6GX	T400-PM101DA-M3	★	3.5	3.00	56.0	6.0	4	2.8	DIN 2174
		.709						*.138*	*.118*	*2.205*	*.236*		*.108*	
M 4	0.70	21.00	4.50 x 3.40	C	6GX	T400-PM101DA-M4	★	4.5	4.00	63.0	7.0	5	3.7	DIN 2174
		.827						*.177*	*.157*	*2.480*	*.276*		*.144*	
M 5	0.80	25.00	6.00 x 4.90	C	6GX	T400-PM101DA-M5	★	6.0	5.00	70.0	8.0	5	4.6	DIN 2174
		.984						*.236*	*.197*	*2.756*	*.315*		*.181*	
M 6	1.00	30.00	6.00 x 4.90	C	6GX	T400-PM101DA-M6	★	6.0	6.00	80.0	10.0	5	5.5	DIN 2174
		1.181						*.236*	*.236*	*3.150*	*.394*		*.217*	
M 8	1.25	35.00	8.00 x 6.20	C	6GX	T400-PM101DA-M8	★	8.0	8.00	90.0	12.0	6	7.4	DIN 2174
		1.378						*.315*	*.315*	*3.543*	*.472*		*.291*	
M 10	1.50	39.00	10.00 x 8.00	C	6GX	T400-PM101DA-M10	★	10.0	10.00	100.0	15.0	7	9.3	DIN 2174
		1.535						*.394*	*.394*	*3.937*	*.591*		*.364*	
M 12	1.75	42.00	9.00 x 7.00	C	6GX	T400-PM101DA-M12	★	9.0	12.00	110.0	16.0	8	11.2	DIN 2174
		1.654						*.354*	*.472*	*4.331*	*.630*		*.441*	
M 14	2.00	49.00	11.00 x 9.00	C	6GX	T400-PM101DA-M14	★	11.0	14.00	110.0	20.0	8	13.0	DIN 2174
		1.929						*.433*	*.551*	*4.331*	*.787*		*.512*	
M 16	2.00	55.00	12.00 x 9.00	C	6GX	T400-PM101DA-M16	★	12.0	16.00	110.0	20.0	8	15.0	DIN 2174
		2.165						*.472*	*.630*	*4.331*	*.787*		*.591*	
M 3	0.50	18.00	3.50 x 2.70	E	6HX	T400-PM102DA-M3	★	3.5	3.00	56.0	6.0	4	2.8	DIN 2174
		.709						*.138*	*.118*	*2.205*	*.236*		*.108*	
M 4	0.70	21.00	4.50 x 3.40	E	6HX	T400-PM102DA-M4	★	4.5	4.00	63.0	7.0	5	3.7	DIN 2174
		.827						*.177*	*.157*	*2.480*	*.276*		*.144*	
M 5	0.80	25.00	6.00 x 4.90	E	6HX	T400-PM102DA-M5	★	6.0	5.00	70.0	8.0	5	4.6	DIN 2174
		.984						*.236*	*.197*	*2.756*	*.315*		*.181*	
M 6	1.00	30.00	6.00 x 4.90	E	6HX	T400-PM102DA-M6	★	6.0	6.00	80.0	10.0	5	5.5	DIN 2174
		1.181						*.236*	*.236*	*3.150*	*.394*		*.217*	
M 8	1.25	35.00	8.00 x 6.20	E	6HX	T400-PM102DA-M8	★	8.0	8.00	90.0	12.0	6	7.4	DIN 2174
		1.378						*.315*	*.315*	*3.543*	*.472*		*.291*	
M 10	1.50	39.00	10.00 x 8.00	E	6HX	T400-PM102DA-M10	★	10.0	10.00	100.0	15.0	7	9.3	DIN 2174
		1.535						*.394*	*.394*	*3.937*	*.591*		*.364*	
M 12	1.75	42.00	9.00 x 7.00	E	6HX	T400-PM102DA-M12	★	9.0	12.00	110.0	16.0	8	11.2	DIN 2174
		1.654						*.354*	*.472*	*4.331*	*.630*		*.441*	
M 14	2.00	49.00	11.00 x 9.00	E	6HX	T400-PM102DA-M14	★	11.0	14.00	110.0	20.0	8	13.0	DIN 2174
		1.929						*.433*	*.551*	*4.331*	*.787*		*.512*	
M 16	2.00	55.00	12.00 x 9.00	E	6HX	T400-PM102DA-M16	★	12.0	16.00	110.0	20.0	8	15.0	DIN 2174
		2.165						*.472*	*.630*	*4.331*	*.787*		*.591*	

C182 C157 E9 E27 C154

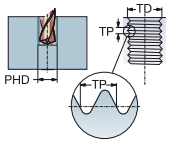
SANDVIK Coromant

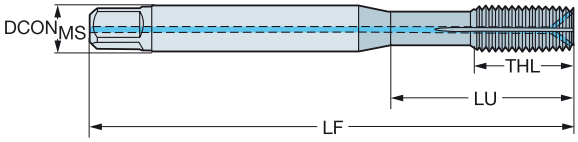
CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	CNSC	CXSC	Ordering code	P F125	DCON$_{MS}$	TD	LF	THL	NOF	BSG
										Dimensions, mm, inch					
M 9	1.25	35.00	9.00 x 7.00	C	6HX	1	2	T400-PM103DA-M9	★	9.0	9.00	90.0	13.0	6	DIN 2174
		1.378								*.354*	*.354*	*3.543*	*.512*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	1	2	T400-PM103DA-M5	★	6.0	5.00	70.0	8.0	5	DIN 2174
		.984								*.236*	*.197*	*2.756*	*.315*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	2	T400-PM103DA-M6	★	6.0	6.00	80.0	10.0	5	DIN 2174
		1.181								*.236*	*.236*	*3.150*	*.394*		
M 7	1.00	30.00	7.00 x 5.50	C	6HX	1	2	T400-PM103DA-M7	★	7.0	7.00	80.0	7.0	6	DIN 2174
		1.181								*.276*	*.276*	*3.150*	*.276*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	2	T400-PM103DA-M8	★	8.0	8.00	90.0	12.0	6	DIN 2174
		1.378								*.315*	*.315*	*3.543*	*.472*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	2	T400-PM103DA-M10	★	10.0	10.00	100.0	15.0	7	DIN 2174
		1.535								*.394*	*.394*	*3.937*	*.591*		
M 12	1.75	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM103DA-M12	★	9.0	12.00	110.0	16.0	8	DIN 2174
		1.654								*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	49.00	11.00 x 9.00	C	6HX	1	2	T400-PM103DA-M14	★	11.0	14.00	110.0	20.0	8	DIN 2174
		1.929								*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	55.00	12.00 x 9.00	C	6HX	1	2	T400-PM103DA-M16	★	12.0	16.00	110.0	20.0	8	DIN 2174
		2.165								*.472*	*.630*	*4.331*	*.787*		
M 5	0.80	25.00	6.00 x 4.90	C	6HX	1	1	T400-PM104DA-M5	★	6.0	5.00	70.0	8.0	5	DIN 2174
		.984								*.236*	*.197*	*2.756*	*.315*		
M 6	1.00	30.00	6.00 x 4.90	C	6HX	1	1	T400-PM104DA-M6	★	6.0	6.00	80.0	10.0	5	DIN 2174
		1.181								*.236*	*.236*	*3.150*	*.394*		
M 8	1.25	35.00	8.00 x 6.20	C	6HX	1	1	T400-PM104DA-M8	★	8.0	8.00	90.0	12.0	6	DIN 2174
		1.378								*.315*	*.315*	*3.543*	*.472*		
M 10	1.50	39.00	10.00 x 8.00	C	6HX	1	1	T400-PM104DA-M10	★	10.0	10.00	100.0	15.0	7	DIN 2174
		1.535								*.394*	*.394*	*3.937*	*.591*		
M 12	1.75	42.00	9.00 x 7.00	C	6HX	1	1	T400-PM104DA-M12	★	9.0	12.00	110.0	16.0	8	DIN 2174
		1.654								*.354*	*.472*	*4.331*	*.630*		
M 14	2.00	49.00	11.00 x 9.00	C	6HX	1	1	T400-PM104DA-M14	★	11.0	14.00	110.0	20.0	8	DIN 2174
		1.929								*.433*	*.551*	*4.331*	*.787*		
M 16	2.00	55.00	12.00 x 9.00	C	6HX	1	1	T400-PM104DA-M16	★	12.0	16.00	110.0	20.0	8	DIN 2174
		2.165								*.472*	*.630*	*4.331*	*.787*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

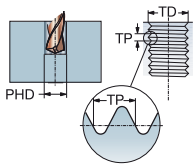
C182 C157 E9 E27 E28 C154

CoroTap™ 400 forming tap

Thread form: Metric

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN



TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P F125	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
M 3	0.50	18.00	.141 x .110	C	6HX	T400-PM100AA-M3	★	3.6	3.00	56.0	6.0	4	2.8	DIN/ANSI
		.709						*.141*	*.118*	*2.205*	*.236*		*.108*	
M 4	0.70	21.00	.168 x .131	C	6HX	T400-PM100AA-M4	★	4.3	4.00	63.0	7.0	5	3.7	DIN/ANSI
		.827						*.168*	*.157*	*2.480*	*.276*		*.144*	
M 5	0.80	25.00	.194 x .152	C	6HX	T400-PM100AA-M5	★	4.9	5.00	70.0	8.0	5	4.6	DIN/ANSI
		.984						*.194*	*.197*	*2.756*	*.315*		*.181*	
M 6	1.00	30.00	.255 x .191	C	6HX	T400-PM100AA-M6	★	6.5	6.00	80.0	10.0	5	5.5	DIN/ANSI
		1.181						*.255*	*.236*	*3.150*	*.394*		*.217*	
M 8	1.25	35.00	.318 x .238	C	6HX	T400-PM100AA-M8	★	8.1	8.00	90.0	12.0	6	7.4	DIN/ANSI
		1.378						*.318*	*.315*	*3.543*	*.472*		*.291*	
M 10	1.50	39.00	.381 x .286	C	6HX	T400-PM100AA-M10	★	9.7	10.00	100.0	15.0	7	9.3	DIN/ANSI
		1.535						*.381*	*.394*	*3.937*	*.591*		*.364*	
M 12	1.75	42.00	.367 x .275	C	6HX	T400-PM100AA-M12	★	9.3	12.00	110.0	16.0	8	11.2	DIN/ANSI
		1.654						*.367*	*.472*	*4.331*	*.630*		*.441*	
M 14	2.00	49.00	.429 x .322	C	6HX	T400-PM100AA-M14	★	10.9	14.00	110.0	20.0	8	13.0	DIN/ANSI
		1.929						*.429*	*.551*	*4.331*	*.787*		*.512*	
M 16	2.00	55.00	.480 x .360	C	6HX	T400-PM100AA-M16	★	12.2	16.00	110.0	20.0	8	15.0	DIN/ANSI
		2.165						*.480*	*.630*	*4.331*	*.787*		*.591*	

C182 C157 E9 E27 C154

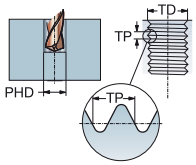
SANDVIK Coromant

CoroTap™ 400 forming tap

Thread form: Metric

DIN 2174

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



N

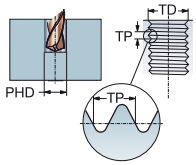
TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	Ordering code	N / B105	DCON$_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
M 3	0.50	18.00	3.50 x 2.70	C	6HX	T400-NM100DA-M3	★	3.5	3.00	56.0	9.0	4	2.8	DIN 2174
		.709						*.138*	*.118*	*2.205*	*.354*		*.110*	
M 4	0.70	21.00	4.50 x 3.40	C	6HX	T400-NM100DA-M4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

C182 C157 E9 E27 C154

CoroTap™ 400 forming tap

Thread form: Metric fine

DIN 2174



ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN

TDZ	TP	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P F125	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
MF 5x0.5	0.50	25.00	6.00 x 4.90	C	6HX	T400-PM100DB-M5X050	★	6.0	5.00	70.0	8.0	5	4.8	DIN 2174
		.984						*.236*	*.197*	*2.756*	*.315*		*.187*	
MF 6x0.75	0.75	30.00	6.00 x 4.90	C	6HX	T400-PM100DB-M6X075	★	6.0	6.00	80.0	10.0	5	5.6	DIN 2174
		1.181						*.236*	*.236*	*3.150*	*.394*		*.220*	
MF 8x1	1.00	35.00	6.00 x 4.90	C	6HX	T400-PM100DB-M8X100	★	6.0	8.00	90.0	12.0	6	7.5	DIN 2174
		1.378						*.236*	*.315*	*3.543*	*.472*		*.295*	
MF 10x1	1.00	39.00	7.00 x 5.50	C	6HX	T400-PM100DB-M10X100	★	7.0	10.00	90.0	12.0	7	9.5	DIN 2174
		1.535						*.276*	*.394*	*3.543*	*.472*		*.374*	
MF 10x1.25	1.25	39.00	7.00 x 5.50	C	6HX	T400-PM100DB-M10X125	★	7.0	10.00	100.0	15.0	7	9.4	DIN 2174
		1.535						*.276*	*.394*	*3.937*	*.591*		*.370*	
MF 12x1	1.00	42.00	9.00 x 7.00	C	6HX	T400-PM100DB-M12X100	★	9.0	12.00	100.0	13.0	8	11.5	DIN 2174
		1.654						*.354*	*.472*	*3.937*	*.512*		*.453*	
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	T400-PM100DB-M12X125	★	9.0	12.00	100.0	13.0	8	11.4	DIN 2174
		1.654						*.354*	*.472*	*3.937*	*.512*		*.449*	
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	T400-PM100DB-M12X150	★	9.0	12.00	100.0	13.0	8	11.3	DIN 2174
		1.654						*.354*	*.472*	*3.937*	*.512*		*.443*	
MF 14x1	1.00	49.00	11.00 x 9.00	C	6HX	T400-PM100DB-M14X100	★	11.0	14.00	100.0	15.0	8	13.5	DIN 2174
		1.929						*.433*	*.551*	*3.937*	*.591*		*.531*	
MF 14x1.25	1.25	49.00	11.00 x 9.00	C	6HX	T400-PM100DB-M14X125	★	11.0	14.00	100.0	15.0	8	13.4	DIN 2174
		1.929						*.433*	*.551*	*3.937*	*.591*		*.528*	
MF 14x1.5	1.50	49.00	11.00 x 9.00	C	6HX	T400-PM100DB-M14X150	★	11.0	14.00	100.0	15.0	8	13.3	DIN 2174
		1.929						*.433*	*.551*	*3.937*	*.591*		*.522*	
MF 16x1.5	1.50	50.00	12.00 x 9.00	C	6HX	T400-PM100DB-M16X150	★	12.0	16.00	100.0	15.0	8	15.3	DIN 2174
		1.969						*.472*	*.630*	*3.937*	*.591*		*.600*	

C182 C157 E9 E27 C154

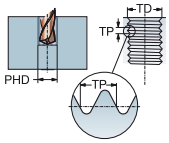
SANDVIK Coromant

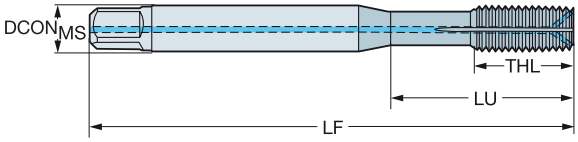
CoroTap™ 400 forming tap

Thread form: Metric fine

DIN 2174

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN





TDZ	TP	LU	CZC$_{MS}$	THCHT	TCTR	CNSC	CXSC	Ordering code	P F125	DCON$_{MS}$	TD	LF	THL	NOF	BSG
										Dimensions, mm, inch					
MF 8x1	1.00	35.00	6.00 x 4.90	C	6HX	1	2	T400-PM101DB-M8X100	★	6.0	8.00	90.0	12.0	6	DIN 2174
		1.378								*.236*	*.315*	*3.543*	*.472*		
MF 10x1	1.00	39.00	7.00 x 5.50	C	6HX	1	2	T400-PM101DB-M10X100	★	7.0	10.00	90.0	12.0	7	DIN 2174
		1.535								*.276*	*.394*	*3.543*	*.472*		
MF 10x1.25	1.25	39.00	7.00 x 5.50	C	6HX	1	2	T400-PM101DB-M10X125	★	7.0	10.00	100.0	15.0	7	DIN 2174
		1.535								*.276*	*.394*	*3.937*	*.591*		
MF 12x1	1.00	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM101DB-M12X100	★	9.0	12.00	100.0	13.0	8	DIN 2174
		1.654								*.354*	*.472*	*3.937*	*.512*		
MF 12x1.25	1.25	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM101DB-M12X125	★	9.0	12.00	100.0	13.0	8	DIN 2174
		1.654								*.354*	*.472*	*3.937*	*.512*		
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	1	2	T400-PM101DB-M12X150	★	9.0	12.00	100.0	13.0	8	DIN 2174
		1.654								*.354*	*.472*	*3.937*	*.512*		
MF 14x1.5	1.50	49.00	11.00 x 9.00	C	6HX	1	2	T400-PM101DB-M14X150	★	11.0	14.00	100.0	15.0	8	DIN 2174
		1.929								*.433*	*.551*	*3.937*	*.591*		
MF 16x1.5	1.50	50.00	12.00 x 9.00	C	6HX	1	2	T400-PM101DB-M16X150	★	12.0	16.00	100.0	15.0	8	DIN 2174
		1.969								*.472*	*.630*	*3.937*	*.591*		
MF 8x1	1.00	35.00	6.00 x 4.90	C	6HX	1	1	T400-PM102DB-M8X100	★	6.0	8.00	90.0	12.0	6	DIN 2174
		1.378								*.236*	*.315*	*3.543*	*.472*		
MF 10x1	1.00	39.00	7.00 x 5.50	C	6HX	1	1	T400-PM102DB-M10X100	★	7.0	10.00	90.0	10.0	7	DIN 2174
		1.535								*.276*	*.394*	*3.543*	*.394*		
MF 10x1.25	1.25	39.00	7.00 x 5.50	C	6HX	1	1	T400-PM102DB-M10X125	★	7.0	10.00	100.0	15.0	7	DIN 2174
		1.535								*.276*	*.394*	*3.937*	*.591*		
MF 12x1.25	1.25	42.00	9.00 x 7.00	C	6HX	1	1	T400-PM102DB-M12X125	★	9.0	12.00	100.0	12.0	8	DIN 2174
		1.654								*.354*	*.472*	*3.937*	*.472*		
MF 12x1.5	1.50	42.00	9.00 x 7.00	C	6HX	1	1	T400-PM102DB-M12X150	★	9.0	12.00	100.0	12.0	8	DIN 2174
		1.654								*.354*	*.472*	*3.937*	*.472*		
MF 14x1.5	1.50	49.00	11.00 x 9.00	C	6HX	1	1	T400-PM102DB-M14X150	★	11.0	14.00	100.0	15.0	8	DIN 2174
		1.929								*.433*	*.551*	*3.937*	*.591*		
MF 16x1.5	1.50	50.00	12.00 x 9.00	C	6HX	1	1	T400-PM102DB-M16X150	★	12.0	16.00	100.0	15.0	8	DIN 2174
		1.969								*.472*	*.630*	*3.937*	*.591*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

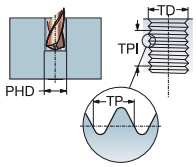
C182 C157 E9 E27 E28 C154

CoroTap™ 400 forming tap

Thread form: UNC

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN



TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P / F125	Dimensions, mm, inch: $DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
UNC #4-40	40.00	18.00	.141 x .110	C	2BX	T400-PM100AE-4-40	★	3.6	2.84	56.0	6.0	3	2.6	DIN/ANSI
		.709						*.141*	*.112*	*2.205*	*.236*		*.102*	
UNC #6-32	32.00	20.00	.141 x .110	C	2BX	T400-PM100AE-6-32	★	3.6	3.50	56.0	6.5	4	3.2	DIN/ANSI
		.787						*.141*	*.138*	*2.205*	*.256*		*.126*	
UNC #8-32	32.00	25.00	.168 x .131	C	2BX	T400-PM100AE-8-32	★	4.3	4.16	63.0	6.0	5	3.9	DIN/ANSI
		.984						*.168*	*.164*	*2.480*	*.236*		*.154*	
UNC #10-24	24.00	25.00	.194 x .152	C	2BX	T400-PM100AE-10-24	★	4.9	4.80	70.0	8.0	5	4.4	DIN/ANSI
		.984						*.194*	*.189*	*2.756*	*.315*		*.173*	
UNC #12-24	24.00	30.00	.220 x .165	C	2BX	T400-PM100AE-12-24	★	5.6	5.48	80.0	10.0	5	5.1	DIN/ANSI
		1.181						*.220*	*.216*	*3.150*	*.394*		*.201*	
UNC 1/4-20	20.00	30.00	.255 x .191	C	2BX	T400-PM100AE-1/4	★	6.5	6.35	80.0	10.0	5	5.9	DIN/ANSI
		1.181						*.255*	*.250*	*3.150*	*.394*		*.232*	
UNC 5/16-18	18.00	35.00	.318 x .238	C	2BX	T400-PM100AE-5/16	★	8.1	7.94	90.0	12.0	6	7.4	DIN/ANSI
		1.378						*.318*	*.313*	*3.543*	*.472*		*.291*	
UNC 3/8-16	16.00	39.00	.381 x .286	C	2BX	T400-PM100AE-3/8	★	9.7	9.52	100.0	15.0	6	8.9	DIN/ANSI
		1.535						*.381*	*.375*	*3.937*	*.591*		*.350*	
UNC 7/16-14	14.00	39.00	.323 x .242	C	2BX	T400-PM100AE-7/16	★	8.2	11.11	100.0	15.0	7	10.4	DIN/ANSI
		1.535						*.323*	*.437*	*3.937*	*.591*		*.409*	
UNC 1/2-13	13.00	44.50	.367 x .275	C	2BX	T400-PM100AE-1/2	★	9.3	12.70	110.0	18.0	8	12.0	DIN/ANSI
		1.752						*.367*	*.500*	*4.331*	*.709*		*.472*	
UNC 5/8-11	11.00	55.00	.480 x .360	C	2BX	T400-PM100AE-5/8	★	12.2	15.88	110.0	20.0	8	15.0	DIN/ANSI
		2.165						*.480*	*.625*	*4.331*	*.787*		*.591*	
UNC #4-40	40.00	18.00	.141 x .110	E	2BX	T400-PM101AE-4-40	★	3.6	2.84	56.0	6.0	3	2.6	DIN/ANSI
		.709						*.141*	*.112*	*2.205*	*.236*		*.102*	
UNC #6-32	32.00	20.00	.141 x .110	E	2BX	T400-PM101AE-6-32	★	3.6	3.50	56.0	6.5	4	3.2	DIN/ANSI
		.787						*.141*	*.138*	*2.205*	*.256*		*.126*	
UNC #8-32	32.00	25.00	.168 x .131	E	2BX	T400-PM101AE-8-32	★	4.3	4.16	63.0	6.0	5	3.9	DIN/ANSI
		.984						*.168*	*.164*	*2.480*	*.236*		*.154*	
UNC #10-24	24.00	25.00	.194 x .152	E	2BX	T400-PM101AE-10-24	★	4.9	4.80	70.0	8.0	5	4.4	DIN/ANSI
		.984						*.194*	*.189*	*2.756*	*.315*		*.173*	
UNC #12-24	24.00	30.00	.220 x .165	E	2BX	T400-PM101AE-12-24	★	5.6	5.48	80.0	10.0	5	5.1	DIN/ANSI
		1.181						*.220*	*.216*	*3.150*	*.394*		*.201*	
UNC 1/4-20	20.00	30.00	.255 x .191	E	2BX	T400-PM101AE-1/4	★	6.5	6.35	80.0	10.0	5	5.8	DIN/ANSI
		1.181						*.255*	*.250*	*3.150*	*.394*		*.228*	
UNC 5/16-18	18.00	35.00	.318 x .238	E	2BX	T400-PM101AE-5/16	★	8.1	7.94	90.0	12.0	6	7.4	DIN/ANSI
		1.378						*.318*	*.313*	*3.543*	*.472*		*.291*	
UNC 3/8-16	16.00	39.00	.381 x .286	E	2BX	T400-PM101AE-3/8	★	9.7	9.52	100.0	15.0	6	8.9	DIN/ANSI
		1.535						*.381*	*.375*	*3.937*	*.591*		*.350*	
UNC 7/16-14	14.00	39.00	.323 x .242	E	2BX	T400-PM101AE-7/16	★	8.2	11.11	100.0	15.0	7	10.4	DIN/ANSI
		1.535						*.323*	*.437*	*3.937*	*.591*		*.409*	
UNC 1/2-13	13.00	44.50	.367 x .275	E	2BX	T400-PM101AE-1/2	★	9.3	12.70	110.0	18.0	8	12.0	DIN/ANSI
		1.752						*.367*	*.500*	*4.331*	*.709*		*.472*	
UNC 5/8-11	11.00	55.00	.480 x .360	E	2BX	T400-PM101AE-5/8	★	12.2	15.88	110.0	20.0	8	15.0	DIN/ANSI
		2.165						*.480*	*.625*	*4.331*	*.787*		*.591*	

C182 C157 E9 E27 C154

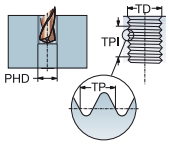
SANDVIK Coromant

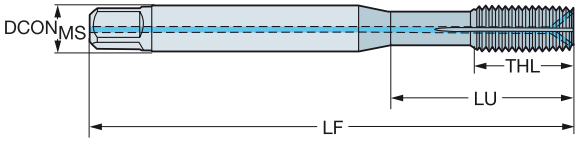
CoroTap™ 400 forming tap

Thread form: UNC

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	P F125	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	BSG
UNC #8-32	32.00	25.00	.168 x .131	C	2BX	1	2	T400-PM102AE-8-32	★	4.3	4.16	63.0	6.0	5	DIN/ANSI
		.984								*.168*	*.164*	*2.480*	*.236*		
UNC #10-24	24.00	25.00	.194 x .152	C	2BX	1	2	T400-PM102AE-10-24	★	4.9	4.80	70.0	8.0	5	DIN/ANSI
		.984								*.194*	*.189*	*2.756*	*.315*		
UNC #12-24	24.00	30.00	.220 x .165	C	2BX	1	2	T400-PM102AE-12-24	★	5.6	5.48	80.0	10.0	5	DIN/ANSI
		1.181								*.220*	*.216*	*3.150*	*.394*		
UNC 1/4-20	20.00	30.00	.255 x .191	C	2BX	1	2	T400-PM102AE-1/4	★	6.5	6.35	80.0	10.0	5	DIN/ANSI
		1.181								*.255*	*.250*	*3.150*	*.394*		
UNC 5/16-18	18.00	35.00	.318 x .238	C	2BX	1	2	T400-PM102AE-5/16	★	8.1	7.94	90.0	12.0	6	DIN/ANSI
		1.378								*.318*	*.313*	*3.543*	*.472*		
UNC 3/8-16	16.00	39.00	.381 x .286	C	2BX	1	2	T400-PM102AE-3/8	★	9.7	9.52	100.0	15.0	6	DIN/ANSI
		1.535								*.381*	*.375*	*3.937*	*.591*		
UNC 7/16-14	14.00	39.00	.323 x .242	C	2BX	1	2	T400-PM102AE-7/16	★	8.2	11.11	100.0	15.0	7	DIN/ANSI
		1.535								*.323*	*.437*	*3.937*	*.591*		
UNC 1/2-13	13.00	44.50	.367 x .275	C	2BX	1	2	T400-PM102AE-1/2	★	9.3	12.70	110.0	18.0	8	DIN/ANSI
		1.752								*.367*	*.500*	*4.331*	*.709*		
UNC 5/8-11	11.00	55.00	.480 x .360	C	2BX	1	2	T400-PM102AE-5/8	★	12.2	15.88	110.0	20.0	8	DIN/ANSI
		2.165								*.480*	*.625*	*4.331*	*.787*		
UNC #8-32	32.00	25.00	.168 x .131	C	2BX	1	1	T400-PM103AE-8-32	★	4.3	4.16	63.0	6.0	5	DIN/ANSI
		.984								*.168*	*.164*	*2.480*	*.236*		
UNC #10-24	24.00	25.00	.194 x .152	C	2BX	1	1	T400-PM103AE-10-24	★	4.9	4.80	70.0	8.0	5	DIN/ANSI
		.984								*.194*	*.189*	*2.756*	*.315*		
UNC #12-24	24.00	30.00	.220 x .165	C	2BX	1	1	T400-PM103AE-12-24	★	5.6	5.48	80.0	10.0	5	DIN/ANSI
		1.181								*.220*	*.216*	*3.150*	*.394*		
UNC 1/4-20	18.00	35.00	.318 x .238	C	2BX	1	1	T400-PM103AE-5/16	★	8.1	7.94	90.0	12.0	6	DIN/ANSI
		1.378								*.318*	*.313*	*3.543*	*.472*		
UNC 5/16-18	20.00	30.00	.255 x .191	C	2BX	1	1	T400-PM103AE-1/4	★	6.5	6.35	80.0	10.0	5	DIN/ANSI
		1.181								*.255*	*.250*	*3.150*	*.394*		
UNC 3/8-16	16.00	39.00	.381 x .286	C	2BX	1	1	T400-PM103AE-3/8	★	9.7	9.52	100.0	15.0	6	DIN/ANSI
		1.535								*.381*	*.375*	*3.937*	*.591*		
UNC 7/16-14	14.00	39.00	.323 x .242	C	2BX	1	1	T400-PM103AE-7/16	★	8.2	11.11	100.0	15.0	7	DIN/ANSI
		1.535								*.323*	*.437*	*3.937*	*.591*		
UNC 1/2-13	13.00	44.50	.367 x .275	C	2BX	1	1	T400-PM103AE-1/2	★	9.3	12.70	110.0	18.0	8	DIN/ANSI
		1.752								*.367*	*.500*	*4.331*	*.709*		
UNC 5/8-11	11.00	55.00	.480 x .360	C	2BX	1	1	T400-PM103AE-5/8	★	12.2	15.88	110.0	20.0	8	DIN/ANSI
		2.165								*.480*	*.625*	*4.331*	*.787*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

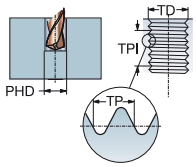
C182 C157 E9 E27 E28 C154

CoroTap™ 400 forming tap

Thread form: UNF

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN



TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	Ordering code	P / F125	$DCON_{MS}$	TD	LF	THL	NOF	PHD	BSG
								Dimensions, mm, inch						
UNF #10-32	32.00	25.00	.194 x .152	C	2BX	T400-PM100AF-10-32	★	4.9	4.82	70.0	8.0	5	4.5	DIN/ANSI
		.984						*.194*	*.190*	*2.756*	*.315*		*.177*	
UNF 1/4-28	28.00	30.00	.255 x .191	C	2BX	T400-PM100AF-1/4	★	6.5	6.35	80.0	10.0	5	6.0	DIN/ANSI
		1.181						*.255*	*.250*	*3.150*	*.394*		*.236*	
UNF 5/16-24	24.00	35.00	.318 x .238	C	2BX	T400-PM100AF-5/16	★	8.1	7.94	90.0	12.0	6	7.5	DIN/ANSI
		1.378						*.318*	*.313*	*3.543*	*.472*		*.295*	
UNF 3/8-24	24.00	39.00	.381 x .286	C	2BX	T400-PM100AF-3/8	★	9.7	9.50	100.0	12.0	6	9.1	DIN/ANSI
		1.535						*.381*	*.374*	*3.937*	*.472*		*.358*	
UNF 7/16-20	20.00	39.00	.323 x .242	C	2BX	T400-PM100AF-7/16	★	8.2	11.11	100.0	15.0	7	10.7	DIN/ANSI
		1.535						*.323*	*.437*	*3.937*	*.591*		*.421*	
UNF 1/2-20	20.00	44.50	.367 x .275	C	2BX	T400-PM100AF-1/2	★	9.3	12.70	100.0	13.0	8	12.2	DIN/ANSI
		1.752						*.367*	*.500*	*3.937*	*.512*		*.480*	
UNF 5/8-18	18.00	50.00	.480 x .360	C	2BX	T400-PM100AF-5/8	★	12.2	15.88	100.0	15.0	8	15.4	DIN/ANSI
		1.969						*.480*	*.625*	*3.937*	*.591*		*.606*	
UNF #10-32	32.00	25.00	.194 x .152	E	2BX	T400-PM101AF-10-32	★	4.9	4.82	70.0	8.0	5	4.5	DIN/ANSI
		.984						*.194*	*.190*	*2.756*	*.315*		*.177*	
UNF 1/4-28	28.00	30.00	.255 x .191	E	2BX	T400-PM101AF-1/4	★	6.5	6.35	80.0	10.0	5	6.0	DIN/ANSI
		1.181						*.255*	*.250*	*3.150*	*.394*		*.236*	
UNF 5/16-24	24.00	35.00	.318 x .238	E	2BX	T400-PM101AF-5/16	★	8.1	7.94	90.0	12.0	6	7.5	DIN/ANSI
		1.378						*.318*	*.313*	*3.543*	*.472*		*.295*	
UNF 3/8-24	24.00	39.00	.381 x .286	E	2BX	T400-PM101AF-3/8	★	9.7	9.50	100.0	12.0	6	9.1	DIN/ANSI
		1.535						*.381*	*.374*	*3.937*	*.472*		*.358*	
UNF 7/16-20	20.00	39.00	.323 x .242	E	2BX	T400-PM101AF-7/16	★	8.2	11.11	100.0	15.0	7	10.7	DIN/ANSI
		1.535						*.323*	*.437*	*3.937*	*.591*		*.421*	
UNF 1/2-20	20.00	44.50	.367 x .275	E	2BX	T400-PM101AF-1/2	★	9.3	12.70	100.0	13.0	8	12.2	DIN/ANSI
		1.752						*.367*	*.500*	*3.937*	*.512*		*.480*	
UNF 5/8-18	18.00	50.00	.480 x .360	E	2BX	T400-PM101AF-5/8	★	12.2	15.88	100.0	15.0	8	15.4	DIN/ANSI
		1.969						*.480*	*.625*	*3.937*	*.591*		*.606*	

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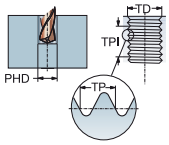
SANDVIK Coromant

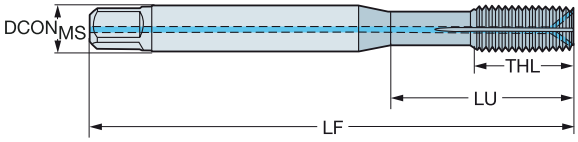
CoroTap™ 400 forming tap

Thread form: UNF

DIN/ANSI

ULDR 3.0
SUBSTRATE HSS-E-PM
COATING PVD TIN





TDZ	TPI	LU	CZC_{MS}	THCHT	TCTR	CNSC	CXSC	Ordering code	P F125	Dimensions, mm, inch $DCON_{MS}$	TD	LF	THL	NOF	BSG
UNF #10-32	32.00	25.00	.194 x .152	C	2BX	1	2	T400-PM102AF-10-32	★	4.9	4.82	70.0	8.0	5	DIN/ANSI
		.984								*.194*	*.190*	*2.756*	*.315*		
UNF 1/4-28	28.00	30.00	.255 x .191	C	2BX	1	2	T400-PM102AF-1/4	★	6.5	6.35	80.0	10.0	5	DIN/ANSI
		1.181								*.255*	*.250*	*3.150*	*.394*		
UNF 5/16-24	24.00	35.00	.318 x .238	C	2BX	1	2	T400-PM102AF-5/16	★	8.1	7.94	90.0	12.0	6	DIN/ANSI
		1.378								*.318*	*.313*	*3.543*	*.472*		
UNF 3/8-24	24.00	39.00	.381 x .286	C	2BX	1	2	T400-PM102AF-3/8	★	9.7	9.50	100.0	12.0	6	DIN/ANSI
		1.535								*.381*	*.374*	*3.937*	*.472*		
UNF 7/16-20	20.00	39.00	.323 x .242	C	2BX	1	2	T400-PM102AF-7/16	★	8.2	11.11	100.0	15.0	7	DIN/ANSI
		1.535								*.323*	*.437*	*3.937*	*.591*		
UNF 1/2-20	20.00	44.50	.367 x .275	C	2BX	1	2	T400-PM102AF-1/2	★	9.3	12.70	100.0	13.0	8	DIN/ANSI
		1.752								*.367*	*.500*	*3.937*	*.512*		
UNF 5/8-18	18.00	50.00	.480 x .360	C	2BX	1	2	T400-PM102AF-5/8	★	12.2	15.88	100.0	15.0	8	DIN/ANSI
		1.969								*.480*	*.625*	*3.937*	*.591*		
UNF #10-32	32.00	25.00	.194 x .152	C	2BX	1	1	T400-PM103AF-10-32	★	4.9	4.82	70.0	8.0	5	DIN/ANSI
		.984								*.194*	*.190*	*2.756*	*.315*		
UNF 1/4-28	28.00	30.00	.255 x .191	C	2BX	1	1	T400-PM103AF-1/4	★	6.5	6.35	80.0	10.0	5	DIN/ANSI
		1.181								*.255*	*.250*	*3.150*	*.394*		
UNF 5/16-24	24.00	35.00	.318 x .238	C	2BX	1	1	T400-PM103AF-5/16	★	8.1	7.94	90.0	12.0	6	DIN/ANSI
		1.378								*.318*	*.313*	*3.543*	*.472*		
UNF 3/8-24	24.00	39.00	.381 x .286	C	2BX	1	1	T400-PM103AF-3/8	★	9.7	9.50	100.0	12.0	6	DIN/ANSI
		1.535								*.381*	*.374*	*3.937*	*.472*		
UNF 7/16-20	20.00	39.00	.323 x .242	C	2BX	1	1	T400-PM103AF-7/16	★	8.2	11.11	100.0	15.0	7	DIN/ANSI
		1.535								*.323*	*.437*	*3.937*	*.591*		
UNF 1/2-20	20.00	44.50	.367 x .275	C	2BX	1	1	T400-PM103AF-1/2	★	9.3	12.70	100.0	13.0	8	DIN/ANSI
		1.752								*.367*	*.500*	*3.937*	*.512*		
UNF 5/8-18	18.00	50.00	.480 x .360	C	2BX	1	1	T400-PM103AF-5/8	★	12.2	15.88	100.0	15.0	8	DIN/ANSI
		1.969								*.480*	*.625*	*3.937*	*.591*		

CXSC 1 = Axial concentric coolant exit
CXSC 2 = Radial coolant exit

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Taps

Material

HM	HSS	HSS-E	HSS-PM	HSS-E-PM
Carbide	High Speed Steel	High Speed Cobalt	High Speed Powder Steel	HSS-E powder metallurgy steel

Grade/Coating

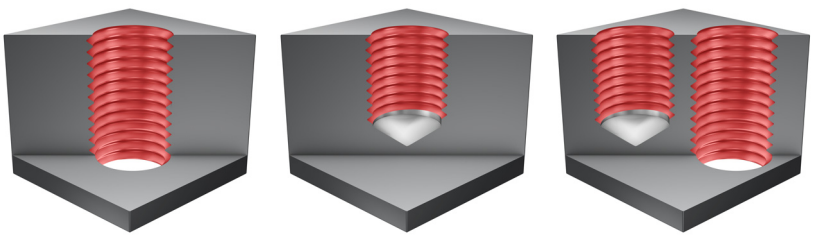
C110/B110	Cool Top	Smooth Top	ST/C145/B145	TiCN
Optimal combination of high hardness and abrasive wear	Optimal combination of high hardness and abrasive wear	Low friction coefficient minimizes material adhesion to the cutting edge	Steam tempered, for protection and prevention of the build-up edge	Titanium Carbon Nitride

CrN	TiN	N	Bright/C150/B150	D115
Chromium Nitride	Titanium Nitride	Nitrited	Uncoated, for reduced adherence in soft materials	Wear-resistant grade with low friction

D210	D125	F125		
Excellent wear resistance both in dry and wet machining	Wear-resistant grade with medium friction	Wear-resistant grade with low friction Optimized for steel		

Hole Type

Through hole **Blind hole** **Through or blind hole**

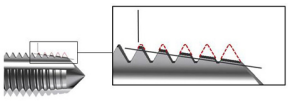


GENERAL HINTS ON TAPPING

The success of any tapping operation depends on a number of factors that affect the quality of the finished product. For the success of your operation, keep the following tips in mind:

1. Select the correct tap design for the component material and type of hole, i.e., through or blind, from the Materials Classification chart.
2. Ensure that the component is securely clamped—lateral movement may cause tap breakage or poor-quality threads.
3. Select the correct size of drill from the relevant catalog page. Remember that the drill sizes for forming taps are different. Wrong choice or bad drilling conditions can cause work hardening of the work piece material that reduces the performance of the tap.
4. Select the correct cutting speed as shown on the catalog product page and in the Guided product search.
5. Use the appropriate cutting fluid for the correct application.
6. Ensure smooth entry of the tap into the hole, as an uneven feed may cause 'bell mouthing.'

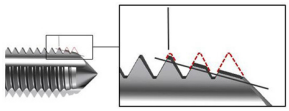
Threading chamfer type



Chamfer type B=3.5 – 5 × threads

Long chamfer:

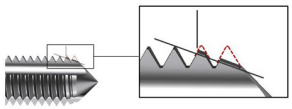
High torque
Best surface quality
Thin chips
Low pressure at the chamfer
Longer tool life
Most common for spiral point tap



Chamfer type C=2 – 3 × threads

Medium chamfer:

Low torque
Good surface quality
Normal thick chips
Normal pressure at the chamfer
Normal tool life
Most common design
Standard chamfer for blind holes
Most common for spiral-flute tap



Chamfer type E=1.5 – 2 × threads

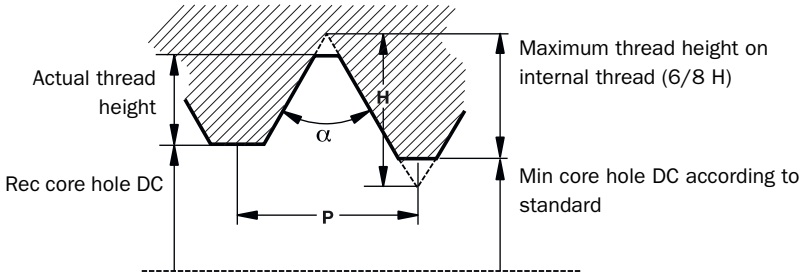
Short chamfer:

Low torque
Good surface quality
Thick chips
High pressure at the chamfer
Shorter tool life
Extreme design
To use when there is not much clearance in the bottom of the hole

What is thread height in %?

Example applies to ISO & UTS standard – 60° threads

Thread height in % is the ratio between actual height and maximum height of the internal thread



Example, M8×1.25

Maximum thread height according to standard is 6/8 H.
H = 0.866 × P
(H = Basic triangle height)
(P = thread pitch)

Maximum thread height is:
6/8 * (0.866 × 1.25) = 0.811 mm
Actual thread height at a core hole of DC 6.9 mm:
(8 - 6.9) / 2 = 0.55 mm
Thread height is then (0.55 / 0.81) × 100 = 68%

CUTTING TAPS CLASSES 2B & 3B: UNIFIED INCH SCREW THREADS

	TPI		Tap limits	
Size	UNC	UNF	Class 2B	Class 3B
0		80	H2	H1
1	64		H2	H1
1		72	H2	H1
2	56		H2	H1
2		64	H2	H1
3	48		H2	H1
3		56	H2	H1
4	40		H2	H2
4		48	H2	H1
5	40		H2	H2
5		44	H2	H1
6	32		H3	H2
6		40	H2	H2
8	32		H3	H2
8		36	H2	H2
10	24		H3	H3
10		32	H3	H2
12	24		H3	H3
12		28	H3	H3
1/4	20		H5	H3
1/4		28	H4	H3
5/16	18		H5	H3
5/16		24	H4	H3
3/8	16		H5	H3

	TPI		Tap limits	
Size	UNC	UNF	Class 2B	Class 3B
3/8		24	H4	H3
7/16	14		H5	H3
7/16		20	H5	H3
1/2	13		H5	H3
1/2		20	H5	H3
9/16	12		H5	H3
9/16		18	H5	H3
5/8	11		H5	H3
5/8		18	H5	H3
3/4	10		H5	H5
3/4		16	H5	H3
7/8	9		H6	H4
7/8		14	H6	H4
1"	8		H6	H4
1"		12	H6	H4
1.1/8	7		H8	H4
1.1/8		12	H6	H4
1.1/4	7		H8	H4
1.1/4		12	H6	H4
1.3/8	6		H8	H4
1.3/8		12	H6	H4
1.1/2	6		H8	H4
1.1/2		12	H6	H4

Hole size recommendations

Hole diameter guide

This guide gives recommendations for choosing the right diameter for holes to be tapped.

Type of drill and working material determine what hole diameter to choose.

Note that the hole diameter can differ from the drill size, depending on the tolerance of the drill. For best hole size accuracy, use a high-tech solid carbide drill with a tight tolerance level. This makes it possible to choose a drill that is closer to the maximum hole diameter value presented in this guide.

In exceptional cases, such as drilling in very tough material, a larger hole diameter can be selected for increased tool life. Thread strength can still be adequate, but the thread is outside the standard tolerance.

For more technical information, visit www.sandvik.coromant.com.

M

DIN 13			Metric		Inch	
TDZ		TP	PHD	PHDX	PHD	PHDX *5H/6H
M 1*	x	0.25	0.75	0.785	.0295	.0309
M 1.1*	x	0.25	0.85	0.885	.0335	.0348
M 1.2*	x	0.25	0.95	0.985	.0374	.0388
M 1.4*	x	0.30	1.10	1.142	.0433	.0450
M 1.6	x	0.35	1.25	1.321	.0492	.0520
M 1.8	x	0.35	1.45	1.521	.0571	.0599
M 2	x	0.40	1.60	1.679	.0630	.0661
M 2.2	x	0.45	1.75	1.838	.0689	.0724
M 2.3	x	0.40	1.85	1.938	.0728	.0763
M 2.5	x	0.45	2.05	2.138	.0807	.0842
M 2.6	x	0.45	2.15	2.238	.0846	.0881
M 3	x	0.50	2.50	2.599	.0984	.1023
M 3.5	x	0.60	2.90	3.010	.1142	.1185
M 4	x	0.70	3.30	3.422	.1299	.1347
M 4.5	x	0.75	3.70	3.878	.1457	.1527
M 5	x	0.80	4.20	4.334	.1654	.1706
M 6	x	1.00	5.00	5.153	.1969	.2029
M 7	x	1.00	6.00	6.153	.2362	.2422
M 8	x	1.25	6.80	6.912	.2677	.2721
M 9	x	1.25	7.80	7.912	.3071	.3115
M 10	x	1.50	8.50	8.676	.3346	.3416
M 11	x	1.50	9.50	9.676	.3740	.3809
M 12	x	1.75	10.20	10.441	.4016	.4111
M 14	x	2.00	12.00	12.210	.4724	.4807
M 16	x	2.00	14.00	14.210	.5512	.5594
M 18	x	2.50	15.50	15.744	.6102	.6198
M 20	x	2.50	17.50	17.744	.6890	.6986
M 22	x	2.50	19.50	19.744	.7677	.7773
M 24	x	3.00	21.00	21.252	.8268	.8367
M 27	x	3.00	24.00	24.252	.9449	.9548
M 30	x	3.50	26.50	26.771	1.0433	1.0540
M 33	x	3.50	29.50	29.771	1.1614	1.1721
M 36	x	4.00	32.00	32.270	1.2598	1.2705
M 39	x	4.00	35.00	35.270	1.3780	1.3886
M 42	x	4.50	37.50	37.799	1.4764	1.4881
M 45	x	4.50	40.50	40.799	1.5945	1.6063
M 48	x	5.00	43.00	43.297	1.6929	1.7046
M 52	x	5.00	47.00	47.297	1.8504	1.8621
M 56	x	5.50	50.50	50.796	1.9882	1.9998
M 64	x	6.00	58.00	58.305	2.2835	2.2955

Hole size recommendations

Cutting taps

MF

DIN 13		Metric		Inch	
TDZ	TP	PHD	PHDX 6H	PHD	PHDX 6H
MF 2.5	x 0.35	2.15	2.221	.0846	.0874
MF 3.0	x 0.35	2.65	2.721	.1043	.1071
MF 3.5	x 0.35	3.15	3.221	.1240	.1268
MF 4.0	x 0.50	3.50	3.599	.1378	.1417
MF 4.5	x 0.50	4.00	4.099	.1575	.1614
MF 5.0	x 0.50	4.50	4.599	.1772	.1811
MF 5.5	x 0.50	5.00	5.099	.1969	.2007
MF 6.0	x 0.75	5.25	5.378	.2047	.2117
MF 7.0	x 0.75	6.25	6.378	.2441	.2511
MF 8.0	x 0.50	7.50	7.599	.2953	.2992
MF 8.0	x 0.75	7.25	7.378	.2835	.2905
MF 8.0	x 1.00	7.00	7.153	.2756	.2816
MF 9.0	x 0.75	8.25	8.378	.3228	.3298
MF 9.0	x 1.00	8.00	8.153	.3150	.3210
MF 10	x 0.75	9.25	9.378	.3622	.3692
MF 10	x 1.00	9.00	9.153	.3543	.3604
MF 10	x 1.25	8.80	8.912	.3465	.3509
MF 11	x 0.75	10.25	10.378	.4016	.4086
MF 11	x 1.00	10.00	10.153	.3937	.3997
MF 12	x 1.00	11.00	11.153	.4331	.4391
MF 12	x 1.25	10.75	10.912	.4252	.4296
MF 12	x 1.50	10.50	10.676	.4134	.4203
MF 14	x 1.00	13.00	13.153	.5118	.5178
MF 14	x 1.25	12.75	12.912	.5039	.5083
MF 14	x 1.50	12.50	12.676	.4921	.4991
MF 15	x 1.00	14.00	14.153	.5512	.5572
MF 15	x 1.50	13.50	13.676	.5315	.5384
MF 16	x 1.00	15.00	15.153	.5906	.5966
MF 16	x 1.25	14.80	14.912	.5827	.5871
MF 16	x 1.50	14.50	14.676	.5709	.5778
MF 17	x 1.00	16.00	16.153	.6299	.6359
MF 17	x 1.50	15.50	15.676	.6102	.6172
MF 18	x 1.00	17.00	17.153	.6693	.6753
MF 18	x 1.50	16.50	16.676	.6496	.6565
MF 20	x 1.00	19.00	19.153	.7480	.7541
MF 20	x 1.50	18.50	18.676	.7283	.7353
MF 20	x 2.00	18.00	18.210	.7087	.7169
MF 22	x 1.00	21.00	21.153	.8268	.8328
MF 22	x 1.50	20.50	20.676	.8071	.8140
MF 22	x 2.00	20.00	20.210	.7874	.7957
MF 24	x 1.00	23.00	23.153	.9055	.9115
MF 24	x 1.50	22.50	22.676	.8858	.8928
MF 24	x 2.00	22.00	22.210	.8661	.8744
MF 25	x 1.00	24.00	24.153	.9449	.9509
MF 25	x 1.50	23.50	23.676	.9252	.9321
MF 25	x 2.00	23.00	23.210	.9055	.9138
MF 27	x 1.00	26.00	26.153	1.0236	1.0296
MF 27	x 1,50	25.50	25.676	1.0039	1.0109
MF 27	x 2.00	25.00	25.210	.9843	.9925
MF 28	x 1.00	27.00	27.153	1.0630	1.0690
MF 28	x 1.50	26.50	26.676	1.0433	1.0502
MF 28	x 2.00	26.00	26.210	1.0236	1.0319
MF 30	x 1.00	29.00	29.153	1.1417	1.1478
MF 30	x 1.50	28.50	28.676	1.1220	1.1290
MF 30	x 2.00	28.00	28.210	1.1024	1.1106
MF 30	x 3.00	27.00	27.252	1.0630	1.0729
MF 32	x 1.50	30.50	30.676	1.2008	1.2077
MF 32	x 2.00	30.00	30.210	1.1811	1.1894
MF 33	x 1.50	31.50	31.676	1.2402	1.2471
MF 33	x 2.00	31.00	31.210	1.2205	1.2287
MF 33	x 3.00	30.00	30.252	1.1811	1.1910
MF 35	x 1.50	33.50	33.676	1.3189	1.3258
MF 36	x 1.50	34.50	34.676	1.3583	1.3652

Hole size recommendations

Cutting taps

UNC

ASME B1.1			Metric			Inch		
TDZ		TPI	PHD	PHDX 2B	PHDX 3B	PHD	PHDX 2B	PHDX 3B
Nr. 1	-	64	1.55	1.582	1.582	.0610	.0623	.0623
Nr. 2	-	56	1.85	1.872	1.872	.0728	.0737	.0737
Nr. 3	-	48	2.10	2.146	2.146	.0827	.0845	.0845
Nr. 4	-	40	2.35	2.385	2.385	.0925	.0939	.0939
Nr. 5	-	40	2.65	2.697	2.697	.1043	.1062	.1062
Nr. 6	-	32	2.85	2.896	2.896	.1122	.1140	.1140
Nr. 8	-	32	3.50	3.531	3.528	.1378	.1390	.1389
Nr. 10	-	24	3.90	3.962	3.950	.1535	.1560	.1555
Nr. 12	-	24	4.50	4.597	4.590	.1772	.1810	.1807
1/4	-	20	5.10	5.268	5.250	.2008	.2074	.2067
5/16	-	18	6.60	6.734	6.680	.2598	.2651	.2630
3/8	-	16	8.00	8.164	8.082	.3150	.3214	.3182
7/16	-	14	9.40	9.550	9.441	.3701	.3760	.3717
1/2	-	13	10.80	11.013	10.881	.4252	.4336	.4284
9/16	-	12	12.20	12.456	12.301	.4803	.4904	.4843
5/8	-	11	13.50	13.868	13.693	.5315	.5460	.5391
3/4	-	10	16.50	16.833	16.324	.6496	.6627	.6427
7/8	-	9	19.50	19.748	19.520	.7677	.7775	.7685
1	-	8	22.25	22.598	22.344	.8760	.8897	.8797
1 1/8	-	7	25.00	25.349	25.082	.9843	.9980	.9875
1 1/4	-	7	28.00	28.524	28.258	1.1024	1.1230	1.1125
1 3/8	-	6	30.75	31.120	30.851	1.2106	1.2252	1.2146
1 1/2	-	6	34.00	34.295	34.026	1.3386	1.3502	1.3396
1 3/4	-	5	39.50	39.814	39.560	1.5551	1.5675	1.5575
2	-	4.5	45.00	45.598	45.367	1.7717	1.7952	1.7861

UNF

ASME B1.1			Metric			Inch		
TDZ		TPI	PHD	PHDX 2B	PHDX 3B	PHD	PHDX 2B	PHDX 3B
Nr.1	-	72	1.55	1.613	1.613	.0610	.0635	.0635
Nr.2	-	64	1.85	1.913	1.913	.0728	.0753	.0753
Nr.3	-	56	2.15	2.197	2.197	.0846	.0865	.0865
Nr.4	-	48	2.40	2.459	2.459	.0945	.0968	.0968
Nr.5	-	44	2.70	2.741	2.741	.1063	.1079	.1079
Nr.6	-	40	2.95	3.023	3.012	.1161	.1190	.1186
Nr.8	-	36	3.50	3.607	3.597	.1378	.1420	.1416
Nr. 10	-	32	4.10	4.166	4.168	.1614	.1640	.1641
Nr. 12	-	28	4.60	4.724	4.717	.1811	.1860	.1857
1/4	-	28	5.50	5.580	5.563	.2165	.2197	.2190
5/16	-	24	6.90	7.038	6.995	.2717	.2771	.2754
3/8	-	24	8.50	8.626	8.565	.3346	.3396	.3372
7/16	-	20	9.90	10.030	9.947	.3898	.3949	.3916
1/2	-	20	11.50	11.618	11.524	.4528	.4574	.4537
9/16	-	18	12.90	13.084	12.969	.5079	.5151	.5106
5/8	-	18	14.50	14.671	14.554	.5709	.5776	.5730
3/4	-	16	17.50	17.689	17.546	.6890	.6964	.6908
7/8	-	14	20.40	20.663	20.493	.8031	.8135	.8068
1	-	12	23.25	23.569	23.363	.9154	.9279	.9198
1 1/8	-	12	26.50	26.744	26.538	1.0433	1.0529	1.0448
1 1/4	-	12	29.50	29.919	29.713	1.1614	1.1779	1.1698
1 3/8	-	12	32.75	33.094	32.888	1.2894	1.3029	1.2948
1 1/2	-	12	36.00	36.269	36.063	1.4173	1.4279	1.4198

Hole size recommendations

Cutting taps

G

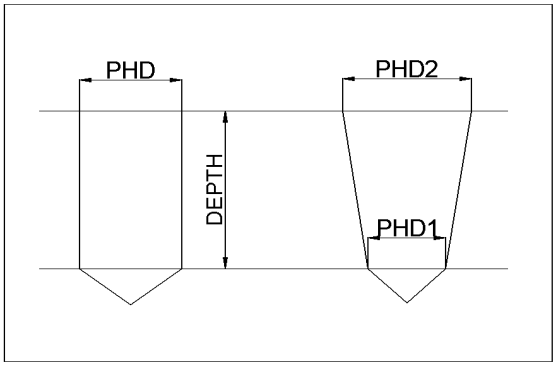
DIN-ISO 228			Metric		Inch	
TDZ		TPI	PHD	PHDX	PHD	PHDX
G 1/16	-	28	6.80	6.843	.2677	.2694
G 1/8	-	28	8.80	8.848	.3465	.3483
G 1/4	-	19	11.80	11.890	.4646	.4681
G 3/8	-	19	15.25	15.395	.6004	.6061
G 1/2	-	14	19.00	19.173	.7480	.7548
G 5/8	-	14	21.00	21.129	.8268	.8319
G 3/4	-	14	24.50	24.659	.9646	.9708
G 7/8	-	14	28.25	28.419	1.1122	1.1189
G 1	-	11	30.75	30.932	1.2106	1.2178
G 11/8	-	11	35.50	35.580	1.3976	1.4008
G 11/4	-	11	39.50	39.593	1.5551	1.5588
G 11/2	-	11	45.25	45.486	1.7815	1.7908

NPT

ASME B1.20.1 Cone 1:16			Metric				Inch			
TDZ		TPI	PHD	PHD1	PHD2	DEPTH	PHD	PHD1	PHD2	DEPTH
1/16	-	27	6.15	5.95	6.39	10.7	.2421	.2343	.2516	.4213
1/8	-	27	8.40	8.31	8.74	10.8	.3307	.3272	.3441	.4252
1/4	-	18	11.10	10.73	11.36	15.6	.4370	.4224	.4472	.6142
3/8	-	18	14.30	14.15	14.80	16.0	.5630	.5571	.5827	.6299
1/2	-	14	17.90	17.47	18.32	20.8	.7047	.6878	.7213	.8189
3/4	-	14	23.30	22.79	23.67	21.3	.9173	.8972	.9319	.8386
1	-	11.5	29,00	28.46	29.69	25.6	1.1417	1.0472	1.1689	1.0079

NPTF

ASME B1.20.3 Cone 1:16			Metric				Inch			
TDZ		TPI	PHD	PHD1	PHD2	DEPTH	PHD	PHD1	PHD2	DEPTH
1/16	-	27	6.10	5.97	6.41	10.30	.2402	.2350	.2524	.4055
1/8	-	27	8.40	8.33	8.77	10.30	.3307	.3280	.3453	.4055
1/4	-	18	11.00	10.77	11.40	15.00	.4331	.4240	.4488	.5906
3/8	-	18	14.50	14.19	14.84	15.30	.5709	.5587	.5843	.6024
1/2	-	14	17.00	17.48	18.33	19.00	.6693	.6882	.7217	.7480
3/4	-	14	23.00	22.84	23.72	9.00	.9055	.8992	.9339	.3543
1	-	11,5	29.00	28.68	29.76	20.40	1.1417	1.1291	1.1717	.8031



Hole size recommendations

Forming taps

M

DIN 13			Metric	Inch
TDZ		TP	PHD	PHD
M 1	x	0.25	0.90	.0354
M 1.2	x	0.25	1.10	.0433
M 1.4	x	0.30	1.26	.0496
M 1.6	x	0.35	1.45	.0571
M 1.7	x	0.35	1.55	.0610
M 1.8	x	0.35	1.65	.0650
M 2	x	0.40	1.82	.0728
M 2.2	x	0.45	2.00	.0787
M 2.5	x	0.45	2.30	.0906
M 3	x	0.50	2.80	.1102
M 3.5	x	0.60	3.25	.1280
M 4	x	0.70	3.70	.1457
M 5	x	0.80	4.65	.1831
M 6	x	1.00	5.55	.2185
M 7	x	1.00	6.55	.2579
M 8	x	1.25	7.40	.2913
M 9	x	1.25	8.40	.3307
M 10	x	1.50	9.30	.3661
M 11	x	1.50	10.30	.4055
M 12	x	1.75	11.20	.4409
M 14	x	2.00	13.10	.5157
M 16	x	2.00	15.10	.5945
M 18	x	2.50	16.90	.6654
M 20	x	2.50	18.90	.7441
M 22	x	2.50	20.90	.8228
M 24	x	3.00	22.70	.8937

MF

DIN 13			Metric	Inch
TDZ		TP	PHD	PHD
M 2.5	x	0.35	2.35	.0925
M 3	x	0.35	2.85	.1122
M 4	x	0.35	3.85	.1516
M 4	x	0.50	3.80	.1496
M 5	x	0.50	4.80	.1890
M 5.5	x	0.50	5.30	.2087
M 6	x	0.75	5.65	.2224
M 7	x	0.75	6.65	.2618
M 8	x	0.75	7.65	.3012
M 8	x	1.00	7.55	.2972
M 9	x	0.75	8.65	.3406
M 9	x	1.00	8.55	.3366
M 10	x	0.75	9.65	.3799
M 10	x	1.00	9.55	.3760
M 10	x	1.25	9.40	.3701
M 11	x	0.75	10.65	.4193
M 11	x	1.00	10.55	.4154
M 12	x	1.00	11.55	.4547
M 12	x	1.25	11.40	.4488
M 12	x	1.50	11.30	.4449
M 14	x	1.00	13.55	.5335
M 14	x	1.25	13.40	.5276
M 14	x	1.25	13.30	.5236
M 15	x	1.00	14.55	.5728
M 15	x	1.50	14.30	.5630
M 16	x	1.00	15.55	.6122
M 16	x	1.50	15.30	.6024
M 17	x	1.00	16.55	.6516
M 17	x	1.50	16.30	.6417
M 18	x	1.00	17.55	.6909
M 18	x	1.50	17.30	.6811
M 18	x	2.00	17.10	.6732
M 20	x	1.00	19.55	.7697
M 20	x	1.50	19.30	.7598
M 24	x	1.00	23.55	.9272
M 24	x	1.50	23.30	.9173
M 24	x	2.00	23.10	.9094

UNC

ASME B1.1			Metric	Inch
TDZ		TPI	PHD	PHD
Nr. 1	-	64	1.68	.0661
Nr. 2	-	56	1.98	.0780
Nr. 3	-	48	2.28	.0898
Nr. 4	-	40	2.55	.1004
Nr, 5	-	40	2.90	.1142
Nr. 6	-	32	3.15	.1240
Nr, 8	-	32	3.80	.1496
Nr.10	-	24	4.35	.1713
Nr.12	-	24	5.00	.1969
1/4	-	20	5.75	.2264
5/16	-	18	7.30	.2874
3/8	-	16	8.80	.3465
7/16	-	14	10.30	.4055
1/2	-	13	11.80	.4646
9/16	-	12	13.30	.5236
5/8	-	11	14.80	.5827
3/4	-	10	17.90	.7047
7/8	-	9	21.00	.8268
1	-	8	24.00	.9449

UNF

UNF: ASME B1.1			Metric	Inch
TDZ		TPI	PHD	PHD
Nr. 1	-	72	1.70	.0669
Nr. 2	-	64	2.00	.0787
Nr. 3	-	56	2.30	.0906
Nr. 4	-	48	2.60	.1024
Nr. 5	-	44	2.90	.1142
Nr. 6	-	40	3.20	.1260
Nr. 8	-	36	3.85	.1516
Nr.10	-	32	4.45	.1752
Nr.12	-	28	5.10	.2008
1/4	-	28	5.95	.2343
/16	-	24	7.45	.2933
3/8	-	24	9.05	.3563
7/16	-	20	10.55	.4154
1/2	-	20	12.10	.4764
9/16	-	18	13.65	.5374
5/8	-	18	15.25	.6004
3/4	-	16	18.35	.7224
7/8	-	14	21.40	.8425
1	-	12	24.45	.9626

EGM

DIN 8140			Metric
TDZ		TP	PHD
EG M 3	-	0.50	3.40
EG M 4	-	0.70	4.60
EG M 5	-	0.80	5.65
EG M 6	-	1.00	6.85
EG M 8	-	1.25	9.05
EG M 10	-	1.50	11.30
EG M 12	-	1.75	13.50

CoroTap - Versatile

CoroTap™ 200

Metric values

					E616		
					ULDR(xTD)	1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c m/min			
P	P1.1.Z.AN	Unalloyed steel	428	125	-	-	-
	P1.1.Z.HT		639	190	46	38	33
	P1.2.Z.AN		639	190	37	30	26
	P1.2.Z.HT		708	210	34	28	24
	P1.3.Z.AN		639	190	37	30	26
	P1.3.Z.HT		1013	300	18	15	13
	P2.1.Z.AN	Low-alloyed steel	591	175	37	30	26
	P2.2.Z.AN		811	240	34	28	24
	P2.3.Z.AN		867	260	18	15	13
	P2.5.Z.HT.1		961	285	18	15	13
	P3.0.Z.AN	High-alloyed steel	674	200	34	28	24
	P3.0.Z.HT.1		1282	380	12	10	9
	P3.1.Z.AN		839	250	34	28	24
	P1.5.C.UT	Steel castings	503	150	37	30	26
	P2.6.C.UT		674	200	34	28	24
	P5.0.Z.HT.1	Ferritic/martensitic stainless steel	1114	330	34	28	24
	P5.0.Z.PH		1114	330	6	5	4
M	M1.0.Z.AQ	Austenitic stainless steel	674	200	7	6	5
	M1.0.C.UT		674	200	7	6	5
	M2.0.Z.AQ	Super austenitic stainless steel	674	200	7	6	5
	M2.0.C.AQ		674	200	7	6	5
	M3.1.Z.AQ	Duplex (austenitic/ferritic) stainless steel	778	230	6	5	4
	M3.1.C.AQ		778	230	6	5	4
	M3.2.Z.AQ		867	260	6	5	4
K	K1.1.C.NS	Malleable cast iron	674	200	29	24	21
	K2.1.C.UT	Gray cast iron	602	180	24	20	17
	K2.2.C.UT		825	245	20	16	14
	K2.3.C.UT		591	175	29	24	21
	K3.1.C.UT	Nodular cast iron	518	155	29	24	21
	K3.2.C.UT		727	215	29	24	21
	K3.3.C.UT		885	265	29	24	21
	K3.5.C.UT		639	190	29	24	21
	K5.1.C.NS	Austempered ductile iron	1013	300	20	16	14
N	N1.2.Z.UT	Aluminum based alloys	-	60	-	-	-
	N1.2.Z.AG		-	100	-	-	-
	N1.3.C.UT		-	75	-	-	-
	N1.3.C.AG		-	90	-	-	-
	N1.4.C.NS		-	130	-	-	-
	N3.3.U.UT	Copper based alloys	-	110	55	45	38
	N3.1.U.UT		-	100	22	18	15

CoroTap - Versatile

CoroTap™ 200

Metric values

				T200-XM Grade B110/C110 ULDR			T200-XM Grade B145/C145 ULDR			T200-XM Grade B150/C150 ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	HB	v_c m/min			v_c m/min			v_c m/min		
P		**Unalloyed steel**										
	P1.1.Z.AN		125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT		190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT		210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT		300	21	17	15	12	10	9	12	10	9
		Low-alloyed steel										
	P2.1.Z.AN		175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN		240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN		260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1		285	21	17	15	12	10	9	12	10	9
		High-alloyed steel										
	P3.0.Z.AN		200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1		380	10	8	7	6	5	4	6	5	4
	P3.1.Z.AN		250	31	26	22	20	16	14	20	16	14
		Steel castings										
	P1.5.C.UT		150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT		200	31	26	22	20	16	14	20	16	14
		Ferritic/martensitic stainless steel										
	P5.0.Z.HT.1		330	32	26	22	20	16	14	20	16	14
	P5.0.Z.PH		330	12	10	9	5	4	3			
M		**Austenitic stainless steel**										
	M1.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M1.0.C.UT		230	10	8	7	7	6	5	-	-	-
		Super austenitic stainless steel										
	M2.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M2.0.C.AQ		260	10	8	7	7	6	5	-	-	-
		Duplex (austenitic/ferritic) stainless steel										
	M3.1.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.2.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.1.C.AQ		230	6	5	4	5	4	3	-	-	-
K		**Malleable cast iron**										
	K1.1.C.NS		200	24	20	17	18	15	13	18	15	13
		Gray cast iron										
	K2.1.C.UT		180	23	19	16	18	15	13	18	15	13
	K2.2.C.UT		245	16	13	11	10	8	7	10	8	7
	K2.3.C.UT		175	24	20	17	18	15	13	18	15	13
		Nodular cast iron										
	K3.1.C.UT		155	24	20	17	18	15	13	18	15	13
	K3.2.C.UT		215	24	20	17	18	15	13	18	15	13
	K3.3.C.UT		265	24	20	17	18	15	13	18	15	13
	K3.5.C.UT		190	24	20	17	18	15	13	18	15	13
	K5.1.C.NS	**Austempered ductile iron**	300	16	13	11	10	8	7	10	8	7
N		**Aluminum based alloys**										
	N1.2.Z.UT		60	49	40	34	-	-	-	43	35	30
	N1.2.Z.AG		100	49	40	34	-	-	-	43	35	30
	N1.3.C.UT		75	49	40	34	-	-	-	43	35	30
	N1.3.C.AG		90	31	25	21	-	-	-	24	20	17
	N1.4.C.NS		130	21	18	15	-	-	-	18	15	13
		Copper based alloys										
	N3.3.U.UT		110	46	38	32	-	-	-	37	30	26
	N3.1.U.UT		100	18	15	13	-	-	-	15	12	10
S		**Iron-based superalloys**										
	S1.0.U.AN		200	9	8	6	-	-	-	6	5	4
		Nickel-based superalloys										
	S2.0.Z.UT		275	9	8	6	-	-	-	6	5	4
	S2.0.Z.AN		250	9	8	6	-	-	-	6	5	4
	S2.1.Z.AN		125	23	19	16	-	-	-	15	12	10
		Titanium-based alloys										
	S4.1.Z.UT		200	21	18	15	-	-	-	18	15	13

CoroTap - Versatile

CoroTap™ 200

Inch values

					E616		
					ULDR(xTD)	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c ft/min			
P	P1.1.Z.AN	**Unalloyed steel**	428	125	-	-	-
	P1.1.Z.HT		639	190	152	125	107
	P1.2.Z.AN		639	190	120	98	84
	P1.2.Z.HT		708	210	112	92	79
	P1.3.Z.AN		639	190	120	98	84
	P1.3.Z.HT		1013	300	60	49	42
	P2.1.Z.AN	**Low-alloyed steel**	591	175	120	98	84
	P2.2.Z.AN		811	240	112	92	79
	P2.3.Z.AN		867	260	60	49	42
	P2.5.Z.HT.1		961	285	60	49	42
	P3.0.Z.AN	**High-alloyed steel**	674	200	112	92	79
	P3.0.Z.HT.1		1282	380	40	33	28
	P3.1.Z.AN		839	250	112	92	79
	P1.5.C.UT	**Steel castings**	503	150	120	98	84
	P2.6.C.UT		674	200	112	92	79
	P5.0.Z.HT.1	**Ferritic/martensitic stainless steel**	1114	330	112	92	79
	P5.0.Z.PH		1114	330	20	16	14
M	M1.0.Z.AQ	**Austenitic stainless steel**	674	200	24	20	17
	M1.0.C.UT		674	200	24	20	17
	M2.0.Z.AQ	**Super austenitic stainless steel**	674	200	24	20	17
	M2.0.C.AQ		674	200	24	20	17
	M3.1.Z.AQ	**Duplex (austenitic/ferritic) stainless steel**	778	230	20	16	14
	M3.1.C.AQ		778	230	20	16	14
	M3.2.Z.AQ		867	260	20	16	14
K	K1.1.C.NS	**Malleable cast iron**	674	200	96	79	67
	K2.1.C.UT	**Gray cast iron**	602	180	80	66	56
	K2.2.C.UT		825	245	64	52	45
	K2.3.C.UT		591	175	96	79	67
	K3.1.C.UT	**Nodular cast iron**	518	155	96	79	67
	K3.2.C.UT		727	215	96	79	67
	K3.3.C.UT		885	265	96	79	67
	K3.5.C.UT		639	190	96	79	67
	K5.1.C.NS	**Austempered ductile iron**	1013	300	64	52	45
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	-	-	-
	N1.2.Z.AG		-	100	-	-	-
	N1.3.C.UT		-	75	-	-	-
	N1.3.C.AG		-	90	-	-	-
	N1.4.C.NS		-	130	-	-	-
	N3.3.U.UT	**Copper based alloys**	-	110	181	148	126
	N3.1.U.UT		-	100	72	59	51

CoroTap - Versatile

CoroTap™ 200

Inch values

				T200-XM								
				Grade B110/C110			Grade B145/C145			Grade B150/C150		
				ULDR			ULDR			ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	HB	v_c ft/min			v_c ft/min			v_c ft/min		
P		**Unalloyed steel**										
	P1.1.Z.AN		125	140	115	98	100	82	70	100	82	70
	P1.1.Z.HT		190	134	110	94	88	72	62	88	72	62
	P1.2.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.2.Z.HT		210	102	84	72	64	52	45	64	52	45
	P1.3.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.3.Z.HT		300	70	57	49	40	33	28	40	33	28
		Low-alloyed steel										
	P2.1.Z.AN		175	126	103	88	72	59	51	72	59	51
	P2.2.Z.AN		240	102	84	72	64	52	45	64	52	45
	P2.3.Z.AN		260	70	57	49	40	33	28	40	33	28
	P2.5.Z.HT.1		285	70	57	49	40	33	28	40	33	28
		High-alloyed steel										
	P3.0.Z.AN		200	102	84	72	64	52	45	64	52	45
	P3.0.Z.HT.1		380	32	26	22	20	16	14	20	16	14
	P3.1.Z.AN		250	102	84	72	64	52	45	64	52	45
		Steel castings										
	P1.5.C.UT		150	126	103	88	72	59	51	72	59	51
	P2.6.C.UT		200	102	84	72	64	52	45	64	52	45
		Ferritic/martensitic stainless steel										
	P5.0.Z.HT.1		330	104	85	73	64	52	45	64	52	45
	P5.0.Z.PH		330	40	33	28	16	13	11	-	-	-
M		**Austenitic stainless steel**										
	M1.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M1.0.C.UT		230	32	26	22	24	20	17	-	-	-
		Super austenitic stainless steel										
	M2.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M2.0.C.AQ		260	32	26	22	24	20	17	-	-	-
		Duplex (austenitic/ferritic) stainless steel										
	M3.1.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.2.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.1.C.AQ		230	20	16	14	16	13	11	-	-	-
K		**Malleable cast iron**										
	K1.1.C.NS		200	80	66	56	60	49	42	60	49	42
		Gray cast iron										
	K2.1.C.UT		180	74	61	52	60	49	42	60	49	42
	K2.2.C.UT		245	52	43	36	32	26	22	32	26	22
	K2.3.C.UT		175	80	66	56	60	49	42	60	49	42
		Nodular cast iron										
	K3.1.C.UT		155	80	66	56	60	49	42	60	49	42
	K3.2.C.UT		215	80	66	56	60	49	42	60	49	42
	K3.3.C.UT		265	80	66	56	60	49	42	60	49	42
	K3.5.C.UT		190	80	66	56	60	49	42	60	49	42
	K5.1.C.NS	**Austempered ductile iron**	300	52	43	36	32	26	22	32	26	22
N		**Aluminum based alloys**										
	N1.2.Z.UT		60	161	131	112	-	-	-	140	115	98
	N1.2.Z.AG		100	161	131	112	-	-	-	140	115	98
	N1.3.C.UT		75	161	131	112	-	-	-	140	115	98
	N1.3.C.AG		90	100	82	70	-	-	-	80	66	56
	N1.4.C.NS		130	70	57	49	-	-	-	60	49	42
		Copper based alloys										
	N3.3.U.UT		110	150	123	105	-	-	-	120	98	84
	N3.1.U.UT		100	60	49	42	-	-	-	48	39	34
S		**Iron-based superalloys**										
	S1.0.U.AN		200	30	25	21	-	-	-	20	16	14
		Nickel-based superalloys										
	S2.0.Z.UT		275	30	25	21	-	-	-	20	16	14
	S2.0.Z.AN		250	30	25	21	-	-	-	20	16	14
	S2.1.Z.AN		125	74	61	52	-	-	-	48	39	34
		Titanium-based alloys										
	S4.1.Z.UT		200	70	57	49	-	-	-	60	49	42

CoroTap - Versatile

CoroTap™ 300

Metric values

					E003 E013 E023 E033			E195 E245			E615			E207 E258	E212 E263	T300-XM100AL T300-XM100AM
				ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3	1.5	1.5	1.5
ISO	MC No.	Material	N/mm²	HB	v_c m/min			v_c m/min			v_c m/min			v_c m/min	v_c m/min	v_c m/min
P	P1.1.Z.AN	Unalloyed steel	428	125	31	25	21	27	22	19	-	-	-	-	-	-
	P1.1.Z.HT		639	190	27	22	19	24	20	17	46	38	33	24	43	5
	P1.2.Z.AN		639	190	22	18	15	20	16	14	37	30	26	20	34	7
	P1.2.Z.HT		708	210	20	16	14	15	12	10	34	28	24	15	29	7
	P1.3.Z.AN		639	190	22	18	15	20	16	14	37	30	26	20	34	7
	P1.3.Z.HT		1013	300	12	10	9	9	7	6	18	15	13	9	12	5
	P2.1.Z.AN	Low-alloyed steel	591	175	22	18	15	20	16	14	37	30	26	20	34	7
	P2.2.Z.AN		811	240	20	16	14	15	12	10	34	28	24	15	29	7
	P2.3.Z.AN		867	260	12	10	9	9	7	6	18	15	13	9	12	5
	P2.5.Z.HT.1		961	285	12	10	9	9	7	6	18	15	13	9	12	5
	P3.0.Z.AN	High-alloyed steel	674	200	20	16	14	15	12	10	34	28	24	15	29	7
	P3.0.Z.HT.1		1282	380	-	-	-	-	-	-	12	10	9	-	-	4
	P3.1.Z.AN		839	250	20	16	14	15	12	10	34	28	24	15	29	7
	P1.5.C.UT	Steel castings	503	150	22	18	15	20	16	14	37	30	26	20	34	7
	P2.6.C.UT		674	200	20	16	14	15	12	10	34	28	24	15	29	7
	P5.0.Z.HT.1	Ferritic/martensitic stainless steel	1114	330	20	16	14	15	12	10	34	28	24	15	29	7
	P5.0.Z.PH		1114	330	5	4	3	-	-	-	6	5	4	-	-	-
M	M1.0.Z.AQ	Austenitic stainless steel	674	200	7	6	5	-	-	-	7	6	5	-	-	3
	M1.0.C.UT		674	200	7	6	5	-	-	-	7	6	5	-	-	3
	M2.0.Z.AQ	Super austenitic stainless steel	674	200	7	6	5	-	-	-	7	6	5	-	-	3
	M2.0.C.AQ		674	200	7	6	5	-	-	-	7	6	5	-	-	-
	M3.1.Z.AQ	Duplex (austenitic/ferritic) stainless steel	778	230	5	4	3	-	-	-	6	5	4	-	-	2
	M3.1.C.AQ		778	230	5	4	3	-	-	-	6	5	4	-	-	2
	M3.2.Z.AQ		867	260	5	4	3	-	-	-	6	5	4	-	-	2
K	K1.1.C.NS	Malleable cast iron	674	200	-	-	-	-	-	-	29	24	21	-	-	-
	K2.1.C.UT	Gray cast iron	602	180	-	-	-	-	-	-	24	20	17	-	-	11
	K2.2.C.UT		825	245	-	-	-	-	-	-	20	16	14	-	-	5
	K2.3.C.UT		591	175	-	-	-	-	-	-	29	24	21	-	-	-
	K3.1.C.UT	Nodular cast iron	518	155	-	-	-	-	-	-	29	24	21	-	-	-
	K3.2.C.UT		727	215	-	-	-	-	-	-	29	24	21	-	-	-
	K3.3.C.UT		885	265	-	-	-	-	-	-	29	24	21	-	-	-
	K3.5.C.UT		639	190	-	-	-	-	-	-	29	24	21	-	-	-
	K5.1.C.NS	Austempered ductile iron	1013	300	-	-	-	-	-	-	20	16	14	-	-	-
N	N1.2.Z.UT	Aluminum based alloys	-	60	-	-	-	43	35	30	-	-	-	37	43	-
	N1.2.Z.AG		-	100	-	-	-	43	35	30	-	-	-	37	43	-
	N1.3.C.UT		-	75	-	-	-	43	35	30	-	-	-	37	43	-
	N1.3.C.AG		-	90	-	-	-	24	20	17	-	-	-	18	24	20
	N1.4.C.NS		-	130	-	-	-	18	15	13	-	-	-	-	-	15
	N3.3.U.UT	Copper based alloys	-	110	-	-	-	-	-	-	55	45	38	-	-	60
	N3.1.U.UT		-	100	-	-	-	-	-	-	22	18	15	-	-	-

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CoroTap™ 300

Metric values

				T300-XM Grade B110/C110 ULDR			T300-XM Grade B145*/C145 ULDR			T300-XM Grade B150/C150 ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	HB	v_c m/min			v_c m/min			v_c m/min		
P		**Unalloyed steel**										
	P1.1.Z.AN		125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT		190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT		210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN		190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT		300	21	17	15	12	10	9	12	10	9
		Low-alloyed steel										
	P2.1.Z.AN		175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN		240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN		260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1		285	21	17	15	12	10	9	12	10	9
		High-alloyed steel										
	P3.0.Z.AN		200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1		380				6	5	4			
	P3.1.Z.AN		250	31	26	22	20	16	14	20	16	14
		Steel castings										
	P1.5.C.UT		150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT		200	31	26	22	20	16	14	20	16	14
		Ferritic/martensitic stainless steel										
	P5.0.Z.HT.1		330	32	26	22	20	16	14	20	16	14
	P5.0.Z.PH		330	12	10	9	5	4	3	-	-	-
M		**Austenitic stainless steel**										
	M1.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M1.0.C.UT		230	10	8	7	7	6	5	-	-	-
		Super austenitic stainless steel										
	M2.0.Z.AQ		200	10	8	7	7	6	5	-	-	-
	M2.0.C.AQ		260	10	8	7	7	6	5	-	-	-
		Duplex (austenitic/ferritic) stainless steel										
	M3.1.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.2.Z.AQ		200	6	5	4	5	4	3	-	-	-
	M3.1.C.AQ		230	6	5	4	5	4	3	-	-	-
K		**Malleable cast iron**										
	K1.1.C.NS		200	24	20	17	18	15	13	-	-	-
		Gray cast iron										
	K2.1.C.UT		180	23	19	16	18	15	13	-	-	-
	K2.2.C.UT		245	16	13	11	10	8	7	-	-	-
	K2.3.C.UT		175	24	20	17	18	15	13	-	-	-
		Nodular cast iron										
	K3.1.C.UT		155	24	20	17	18	15	13	-	-	-
	K3.2.C.UT		215	24	20	17	18	15	13	-	-	-
	K3.3.C.UT		265	24	20	17	18	15	13	-	-	-
	K3.5.C.UT		190	24	20	17	18	15	13	-	-	-
	K5.1.C.NS	**Austempered ductile iron**	300	16	13	11	10	8	7	-	-	-
N		**Aluminum based alloys**										
	N1.2.Z.UT		60	49	40	34	-	-	-	43	35	30
	N1.2.Z.AG		100	49	40	34	-	-	-	43	35	30
	N1.3.C.UT		75	49	40	34	-	-	-	43	35	30
	N1.3.C.AG		90	31	25	21	-	-	-	24	20	17
	N1.4.C.NS		130	21	18	15	-	-	-	18	15	13
		Copper based alloys										
	N3.3.U.UT		110	-	-	-	-	-	-	-	-	-
	N3.1.U.UT		100	-	-	-	-	-	-	-	-	-
S		**Iron-based superalloys**										
	S1.0.U.AN		200	9	8	6	-	-	-	6	5	4
		Nickel-based superalloys										
	S2.0.Z.UT		275	9	8	6	-	-	-	6	5	4
	S2.0.Z.AN		250	9	8	6	-	-	-	6	5	4
	S2.1.Z.AN		125	23	19	16	-	-	-	15	12	10
		Titanium-based alloys										
	S4.1.Z.UT		200	21	18	15	-	-	-	18	15	13

* Note: For cutting speed recommendations for T300-XM100AL and T300-XM100AM, see page C166

CoroTap - Versatile

CoroTap™ 300

Inch values

					E003 E013 E023 E033			E195 E245			E615			E207 E258	E212 E263	T300-XM100AL T300-XM100AM
				ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3	1.5	1.5	1.5
ISO	MC No.	Material	N/mm²	HB	v_c ft/min			v_c ft/min			v_c ft/min			v_c ft/min	v_c ft/min	v_c ft/min
P	P1.1.Z.AN	Unalloyed steel	428	125	100	82	70	88	72	62	-	-	-	-	-	-
	P1.1.Z.HT		639	190	88	72	62	80	66	56	152	125	107	80	140	16
	P1.2.Z.AN		639	190	72	59	51	64	52	45	120	98	84	64	112	24
	P1.2.Z.HT		708	210	64	52	45	48	39	34	112	92	79	48	96	24
	P1.3.Z.AN		639	190	72	59	51	64	52	45	120	98	84	64	112	24
	P1.3.Z.HT		1013	300	40	33	28	28	23	20	60	49	42	28	40	16
	P2.1.Z.AN	Low-alloyed steel	591	175	72	59	51	64	52	45	120	98	84	20	34	7
	P2.2.Z.AN		811	240	64	52	45	48	39	34	112	92	79	15	29	7
	P2.3.Z.AN		867	260	40	33	28	28	23	20	60	49	42	9	12	5
	P2.5.Z.HT.1		961	285	40	33	28	28	23	20	60	49	42	9	12	5
	P3.0.Z.AN	High-alloyed steel	674	200	64	52	45	48	39	34	112	92	79	15	29	7
	P3.0.Z.HT.1		1282	380	-	-	-	-	-	-	40	33	28	-	-	4
	P3.1.Z.AN		839	250	64	52	45	48	39	34	112	92	79	15	29	7
	P1.5.C.UT	Steel castings	503	150	72	59	51	64	52	45	120	98	84	20	34	7
	P2.6.C.UT		674	200	64	52	45	48	39	34	112	92	79	15	29	7
	P5.0.Z.HT.1	Ferritic/martensitic stainless steel	1114	330	64	52	45	48	39	34	112	92	79	15	29	7
	P5.0.Z.PH		1114	330	16	13	11	-	-	-	20	16	14	-	-	-
M	M1.0.Z.AQ	Austenitic stainless steel	674	200	24	20	17	-	-	-	24	20	17	-	-	10
	M1.0.C.UT		674	200	24	20	17	-	-	-	24	20	17	-	-	10
	M2.0.Z.AQ	Super austenitic stainless steel	674	200	24	20	17	-	-	-	24	20	17	-	-	10
	M2.0.C.AQ		674	200	24	20	17	-	-	-	24	20	17	-	-	-
	M3.1.Z.AQ	Duplex (austenitic/ferritic) stainless steel	778	230	16	13	11	-	-	-	20	16	14	-	-	6
	M3.1.C.AQ		778	230	16	13	11	-	-	-	20	16	14	-	-	6
	M3.2.Z.AQ		867	260	16	13	11	-	-	-	20	16	14	-	-	6
K	K1.1.C.NS	Malleable cast iron	674	200	-	-	-	-	-	-	96	79	67	-	-	-
	K2.1.C.UT	Gray cast iron	602	180	-	-	-	-	-	-	80	66	56	-	-	11
	K2.2.C.UT		825	245	-	-	-	-	-	-	64	52	45	-	-	5
	K2.3.C.UT		591	175	-	-	-	-	-	-	96	79	67	-	-	-
	K3.1.C.UT	Nodular cast iron	518	155	-	-	-	-	-	-	96	79	67	-	-	-
	K3.2.C.UT		727	215	-	-	-	-	-	-	96	79	67	-	-	-
	K3.3.C.UT		885	265	-	-	-	-	-	-	96	79	67	-	-	-
	K3.5.C.UT		639	190	-	-	-	-	-	-	96	79	67	-	-	-
	K5.1.C.NS	Austempered ductile iron	1013	300	-	-	-	-	-	-	64	52	45	-	-	-
N	N1.2.Z.UT	Aluminum based alloys	-	60	-	-	-	140	115	98	-	-	-	37	43	-
	N1.2.Z.AG		-	100	-	-	-	140	115	98	-	-	-	37	43	-
	N1.3.C.UT		-	75	-	-	-	140	115	98	-	-	-	37	43	-
	N1.3.C.AG		-	90	-	-	-	80	66	56	-	-	-	18	24	20
	N1.4.C.NS		-	130	-	-	-	60	49	42	-	-	-	-	-	15
	N3.3.U.UT	Copper based alloys	-	110	-	-	-	-	-	-	181	148	126	-	-	18
	N3.1.U.UT		-	100	-	-	-	-	-	-	72	59	51	-	-	-

CoroTap - Versatile

CoroTap™ 300

Inch values

				T300-XM Grade B110/C110 ULDR			T300-XM Grade B145*/C145 ULDR			T300-XM Grade B150/C150 ULDR		
			ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	HB	v_c ft/min			v_c ft/min			v_c ft/min		
P		**Unalloyed steel**										
	P1.1.Z.AN		125	140	115	98	100	82	70	100	82	70
	P1.1.Z.HT		190	134	110	94	88	72	62	88	72	62
	P1.2.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.2.Z.HT		210	102	84	72	64	52	45	64	52	45
	P1.3.Z.AN		190	126	103	88	72	59	51	72	59	51
	P1.3.Z.HT		300	70	57	49	40	33	28	40	33	28
		Low-alloyed steel										
	P2.1.Z.AN		175	126	103	88	72	59	51	72	59	51
	P2.2.Z.AN		240	102	84	72	64	52	45	64	52	45
	P2.3.Z.AN		260	70	57	49	40	33	28	40	33	28
	P2.5.Z.HT.1		285	70	57	49	40	33	28	40	33	28
		High-alloyed steel										
	P3.0.Z.AN		200	102	84	72	64	52	45	64	52	45
	P3.0.Z.HT.1		380				20	16	14			
	P3.1.Z.AN		250	102	84	72	64	52	45	64	52	45
		Steel castings										
	P1.5.C.UT		150	126	103	88	72	59	51	72	59	51
	P2.6.C.UT		200	102	84	72	64	52	45	64	52	45
		Ferritic/martensitic stainless steel										
	P5.0.Z.HT.1		330	104	85	73	64	52	45	64	52	45
	P5.0.Z.PH		330	40	33	28	16	13	11	-	-	-
M		**Austenitic stainless steel**										
	M1.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M1.0.C.UT		230	32	26	22	24	20	17	-	-	-
		Super austenitic stainless steel										
	M2.0.Z.AQ		200	32	26	22	24	20	17	-	-	-
	M2.0.C.AQ		260	32	26	22	24	20	17	-	-	-
		Duplex (austenitic/ferritic) stainless steel										
	M3.1.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.2.Z.AQ		200	20	16	14	16	13	11	-	-	-
	M3.1.C.AQ		230	20	16	14	16	13	11	-	-	-
K		**Malleable cast iron**										
	K1.1.C.NS		200	80	66	56	60	49	42	-	-	-
		Gray cast iron										
	K2.1.C.UT		180	74	61	52	60	49	42	-	-	-
	K2.2.C.UT		245	52	43	36	32	26	22	-	-	-
	K2.3.C.UT		175	80	66	56	60	49	42	-	-	-
		Nodular cast iron										
	K3.1.C.UT		155	80	66	56	60	49	42	-	-	-
	K3.2.C.UT		215	80	66	56	60	49	42	-	-	-
	K3.3.C.UT		265	80	66	56	60	49	42	-	-	-
	K3.5.C.UT		190	80	66	56	60	49	42	-	-	-
	K5.1.C.NS	**Austempered ductile iron**	300	52	43	36	32	26	22	-	-	-
N		**Aluminum based alloys**										
	N1.2.Z.UT		60	161	131	112	-	-	-	140	115	98
	N1.2.Z.AG		100	161	131	112	-	-	-	140	115	98
	N1.3.C.UT		75	161	131	112	-	-	-	140	115	98
	N1.3.C.AG		90	100	82	70	-	-	-	80	66	56
	N1.4.C.NS		130	70	57	49	-	-	-	60	49	42
		Copper based alloys										
	N3.3.U.UT		110	-	-	-	-	-	-	-	-	-
	N3.1.U.UT		100	-	-	-	-	-	-	-	-	-
S		**Iron-based superalloys**										
	S1.0.U.AN		200	30	25	21	-	-	-	20	16	14
		Nickel-based superalloys										
	S2.0.Z.UT		275	30	25	21	-	-	-	20	16	14
	S2.0.Z.AN		250	30	25	21	-	-	-	20	16	14
	S2.1.Z.AN		125	74	61	52	-	-	-	48	39	34
		Titanium-based alloys										
	S4.1.Z.UT		200	70	57	49	-	-	-	60	49	42

* Note: For cutting speed recommendations for T300-XM100AL and T300-XM100AM, see page C168

CoroTap - Versatile

CoroTap™ 400

Metric values

					E301			E890 E891 E892 E893 E091 E096 E097 E099			E302 E305 E306 E308 E309 E310 E315 E317 E323			T115 T116		
					ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**		v_c m/min			v_c m/min			v_c m/min			v_c m/min		
P	P1.1.Z.AN	**Unalloyed steel**	428	125	18	15	13	33	27	23	33	27	23	73	60	51
	P1.1.Z.HT		639	190	16	13	11	30	25	21	30	25	21	73	60	51
	P1.2.Z.AN		639	190	14	11	10	27	22	19	27	22	19	73	60	51
	P1.2.Z.HT		708	210	12	10	8	24	20	17	24	20	17	49	40	34
	P1.3.Z.AN		639	190	14	11	10	27	22	19	27	22	19	73	60	51
	P1.3.Z.HT		1013	300	-	-	-	12	10	8	12	10	8	37	30	26
	P2.1.Z.AN	**Low-alloyed steel**	591	175	14	11	10	27	22	19	27	22	19	73	60	51
	P2.2.Z.AN		811	240	12	10	8	24	20	17	24	20	17	49	40	34
	P2.3.Z.AN		867	260	-	-	-	12	10	8	12	10	8	37	30	26
	P2.5.Z.HT.1		961	285	-	-	-	12	10	8	12	10	8	37	30	26
	P3.0.Z.AN	**High-alloyed steel**	674	200	12	10	8	24	20	17	24	20	17	49	40	34
	P3.0.Z.HT.1		1282	380	-	-	-	-	-	-	-	-	-	-	-	-
	P3.1.Z.AN		839	250	12	10	8	24	20	17	24	20	17	49	40	34
	P1.5.C.UT	**Steel castings**	503	150	14	11	10	27	22	19	27	22	19	73	60	51
	P2.6.C.UT		674	200	12	10	8	24	20	17	24	20	17	49	40	34
	P5.0.Z.HT.1	**Ferritic/martensitic stainless steel**	1114	330	12	10	8	24	20	17	24	20	17	49	40	34
	P5.0.Z.PH		1114	330	-	-	-	6	5	4	12	5	4	31	25	21
M	M1.0.Z.AQ	**Austenitic stainless steel**	674	200	-	-	-	9	7	6	9	7	6	31	25	21
	M1.0.C.UT		674	200	-	-	-	9	7	6	9	7	6	31	25	21
	M2.0.Z.AQ	**Super austenitic stainless steel**	961	200	-	-	-	9	7	6	9	7	6	31	25	21
	M2.0.C.AQ		674	200	-	-	-	9	7	6	9	7	6	31	25	21
	M3.1.Z.AQ	**Duplex (austenitic/ferritic) stainless steel**	674	230	-	-	-	6	5	4	6	5	4	31	25	21
	M3.1.C.AQ		778	230	-	-	-	6	5	4	6	5	4	31	25	21
	M3.2.Z.AQ		867	260	-	-	-	6	5	4	6	5	4	31	25	21
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	46	38	33	67	55	47	67	55	47	98	80	68
	N1.2.Z.AG		-	100	46	38	33	67	55	47	67	55	47	98	80	68
	N1.3.C.UT		-	75	46	38	33	67	55	47	67	55	47	98	80	68
	N1.3.C.AG		-	90	27	22	19	49	40	34	49	40	34	98	80	68
	N1.4.C.NS		-	130	-	-	-	31	25	21	31	25	21	-	-	-
	N3.1.U.UT	**Copper based alloys**	-	100	-	-	-	31	25	21	31	25	21	49	40	34

CoroTap - Versatile

CoroTap™ 400

Inch values

					E301			E890 E891 E892 E893 E091 E096 E097 E099			E302 E305 E306 E308 E309 E310 E317 E323			T115 T116		
					ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	N/mm²	HB		v_c ft/min			v_c ft/min			v_c ft/min			v_c ft/min		
P	P1.1.Z.AN	Unalloyed steel	428	125		60	49	42	110	90	77	110	90	77	241	197	168
	P1.1.Z.HT		639	190		54	44	38	100	82	70	100	82	70	241	197	168
	P1.2.Z.AN		639	190		46	37	32	90	74	63	90	74	63	241	197	168
	P1.2.Z.HT		708	210		40	33	28	80	65	56	80	115	56	161	131	112
	P1.3.Z.AN		639	190		46	37	32	90	74	63	90	74	63	241	197	168
	P1.3.Z.HT		1013	300		-	-	-	40	33	28	40	33	28	120	98	84
	P2.1.Z.AN	Low-alloyed steel	591	175		46	37	32	90	74	63	90	74	63	241	197	168
	P2.2.Z.AN		811	240		40	33	28	80	65	56	80	115	56	161	131	112
	P2.3.Z.AN		867	260		-	-	-	40	33	28	40	33	28	120	98	84
	P2.5.Z.HT.1		961	285		-	-	-	40	33	28	40	33	28	120	98	84
	P3.0.Z.AN	High-alloyed steel	674	200		40	33	28	80	65	56	80	115	56	161	131	112
	P3.0.Z.HT.1		1282	380		-	-	-	-	-	-	-	-	-	-	-	-
	P3.1.Z.AN		839	250		40	33	28	80	65	56	80	115	56	161	131	112
	P1.5.C.UT	Steel castings	503	150		46	37	32	90	74	63	90	74	63	241	197	168
	P2.6.C.UT		674	200		40	33	28	80	65	56	80	115	56	161	131	112
	P5.0.Z.HT.1	Ferritic/martensitic stainless steel	1114	330		40	33	28	80	65	56	80	115	56	161	131	112
	P5.0.Z.PH		1114	330		-	-	-	20	16	14	20	16	14	100	82	70
M	M1.0.Z.AQ	Austenitic stainless steel	674	200		-	-	-	30	24	21	30	24	21	100	82	70
	M1.0.C.UT		674	200		-	-	-	30	24	21	30	24	21	100	82	70
	M2.0.Z.AQ	Super austenitic stainless steel	961	200		-	-	-	30	24	21	30	24	21	100	82	70
	M2.0.C.AQ		674	200		-	-	-	30	24	21	30	24	21	100	82	70
	M3.1.Z.AQ	Duplex (austenitic/ferritic) stainless steel	674	230		-	-	-	20	16	14	20	16	14	100	82	70
	M3.1.C.AQ		778	230		-	-	-	20	16	14	20	16	14	100	82	70
	M3.2.Z.AQ		867	260		-	-	-	20	16	14	20	16	14	100	82	70
N	N1.2.Z.UT	Aluminum based alloys	-	60		152	125	107	221	180	154	221	180	154	321	262	225
	N1.2.Z.AG		-	100		152	125	107	221	180	154	221	180	154	321	262	225
	N1.3.C.UT		-	75		152	125	107	221	180	154	221	180	154	321	262	225
	N1.3.C.AG		-	90		88	72	62	161	131	112	161	131	112	321	262	225
	N1.4.C.NS		-	130		-	-	-	100	82	70	100	82	70	321	262	225
	N3.1.U.UT	Copper based alloys	-	100		-	-	-	100	82	70	100	82	70	161	131	112

CoroTap - Optimized

CoroTap™ 100 KM

Metric values

					T100-KM		
				ULDR(xTD)	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c m/min		
P	P2.1.Z.AN	**Low-alloyed steel**	591	175	15	12	10
K	K1.1.C.NS	**Malleable cast iron**	674	200	73	60	51
	K1.2.C.NS		1076	260	73	60	51
	K2.1.C.UT	**Gray cast iron**	602	180	73	60	51
	K2.2.C.UT		825	245	61	50	43
	K2.3.C.UT		591	175	73	60	51
	K3.1.C.UT	**Nodular cast iron**	518	155	73	60	51
	K3.2.C.UT		727	215	73	60	51
	K3.3.C.UT		885	265	61	50	43
	K3.4.C.UT		1114	330	49	40	34
	K3.5.C.UT		639	190	61	50	43
	K4.1.C.UT	**Compacted graphite iron**	533	160	55	45	38
	K4.2.C.UT		778	230	55	45	38
	K5.1.C.NS	**Austempered ductile iron**	1013	300	12	10	9
N	N1.3.C.UT	**Aluminum based alloys**	-	75	55	45	38

Inch values

					T100-KM		
				ULDR(xTD)	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c ft/min		
P	P2.1.Z.AN	**Low-alloyed steel**	591	175	48	39	34
K	K1.1.C.NS	**Malleable cast iron**	674	200	241	197	168
	K1.2.C.NS		1076	260	241	197	168
	K2.1.C.UT	**Gray cast iron**	602	180	241	197	168
	K2.2.C.UT		825	245	201	164	140
	K2.3.C.UT		591	175	241	197	168
	K3.1.C.UT	**Nodular cast iron**	518	155	241	197	168
	K3.2.C.UT		727	215	241	197	168
	K3.3.C.UT		885	265	201	164	140
	K3.4.C.UT		1114	330	161	131	112
	K3.5.C.UT		639	190	201	164	140
	K4.1.C.UT	**Compacted graphite iron**	533	160	181	148	126
	K4.2.C.UT		778	230	181	148	126
	K5.1.C.NS	**Austempered ductile iron**	1013	300	40	33	28
N	N1.3.C.UT	**Aluminum based alloys**	-	75	181	148	126

CoroTap - Optimized

CoroTap™ 100

Metric values

					E416		T101 T120		
					ULDR(xTD)		1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c m/min		v_c m/min		
K	K1.1.C.NS	**Malleable cast iron**	674	200	18	15	79	65	55
	K2.1.C.UT	**Gray cast iron**	602	180	18	15	79	65	55
	K2.2.C.UT		825	245	10	8	63	52	44
	K2.3.C.UT		591	175	18	15	79	65	55
	K3.1.C.UT	**Nodular cast iron**	518	155	18	15	79	65	55
	K3.2.C.UT		727	215	18	15	79	65	55
	K3.3.C.UT		885	265	18	15	63	52	44
	K3.5.C.UT		639	190	18	15	63	52	44
	K5.1.C.NS	**Austempered ductile iron**	1013	300	10	8	16	13	11

					T100-NM					
					ULDR(xTD)			1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c m/min			v_c m/min		
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	43	35	30	43	35	30
	N1.2.Z.AG		-	100	43	35	30	43	35	30
	N1.3.C.UT		-	75	43	35	30	43	35	30
	N1.3.C.AG		-	90	24	20	17	24	20	17
	N1.4.C.NS		-	130	18	15	13	18	15	13

Inch values

					E416		T101 T120		
					ULDR(xTD)		1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c ft/min		v_c ft/min		
K	K1.1.C.NS	**Malleable cast iron**	674	200	60	49	260	215	180
	K2.1.C.UT	**Gray cast iron**	602	180	60	49	260	215	180
	K2.2.C.UT		825	245	32	26	205	170	145
	K2.3.C.UT		591	175	60	49	260	215	180
	K3.1.C.UT	**Nodular cast iron**	518	155	60	49	260	215	180
	K3.2.C.UT		727	215	60	49	260	215	180
	K3.3.C.UT		885	265	60	49	205	170	145
	K3.5.C.UT		639	190	60	49	205	170	145
	K5.1.C.NS	**Austempered ductile iron**	1013	300	32	26	52	43	36

					T100-NM					
					ULDR(xTD)			1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c ft/min			v_c ft/min		
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	140	115	98	140	115	98
	N1.2.Z.AG		-	100	140	115	98	140	115	98
	N1.3.C.UT		-	75	140	115	98	140	115	98
	N1.3.C.AG		-	90	80	66	56	80	66	56
	N1.4.C.NS		-	130	60	49	42	60	49	42

CoroTap - Optimized

CoroTap™ 200

Metric values

ISO	MC No.	Material	N/mm²	HB	E324 E326 E854 E855 E874 E875 ULDR(xTD) 1.5	2	3	EP03P EP03PA EP13P EP13PA EP23PA EP33PA 1.5	2	3	EP09P EP29PA EP39PA 1.5	2	3
					v_c m/min			v_c m/min			v_c m/min		
P	P1.1.Z.HT	**Unalloyed steel**	639	190	-	-	-	55	45	38	55	45	38
	P1.2.Z.AN		639	190	-	-	-	55	45	38	55	45	38
	P1.2.Z.HT		708	210	-	-	-	43	35	30	55	45	38
	P1.3.Z.AN		639	190	-	-	-	55	45	38	55	45	38
	P1.3.Z.HT		1013	300	21	17	15	31	25	21	43	35	30
	P1.5.C.UT		503	150	-	-	-	55	45	38	55	45	38
	P2.1.Z.AN	**Low-alloyed steel**	591	175	-	-	-	55	45	38	55	45	38
	P2.2.Z.AN		811	240	-	-	-	43	35	30	55	45	38
	P2.3.Z.AN		867	260	21	17	15	31	25	21	43	35	30
	P2.5.Z.HT.1		961	285	21	17	15	31	25	21	43	35	30
	P2.6.C.UT		674	200	-	-	-	43	35	30	55	45	38
	P3.0.Z.AN	**High-alloyed steel**	674	200	-	-	-	43	35	30	55	45	38
	P3.0.Z.HT.1		1282	380	13	11	9	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	43	35	30	55	45	38
	P5.0.Z.HT.1	**Ferritic/martensitic stainless steel**	1114	330	-	-	-	43	35	30	55	45	38

ISO	MC No.	Material	N/mm²	HB	E344 E345 E364 ULDR(xTD) 1.5	2	3	E454 E455 E852 E872 E873 1.5	2	3
					v_c m/min			v_c m/min		
P	P1.3.Z.HT	**Unalloyed steel**	1013	300	12	10	9	21	17	15
	P2.3.Z.AN	**Low-alloyed steel**	867	260	12	10	9	21	17	15
	P2.5.Z.HT.1		1114	285	12	10	9	21	17	15
	P3.0.Z.HT.1	**High-alloyed steel**	1282	380	6	5	4	13	11	9
	P5.0.Z.PH	**Ferritic/martensitic stainless steel**	1112	330	6	5	4	7	6	5
M	M1.0.C.UT	**Austenitic stainless steel**	674	200	9	7	6	12	10	9
	M1.0.Z.AQ		674	200	9	7	6	12	10	9
	M1.0.Z.PH		1013	300	6	5	4	7	6	5
	M2.0.C.AQ	**Super austenitic stainless steel**	674	200	9	7	6	12	10	9
	M2.0.Z.AQ		674	200	9	7	6	12	10	9
	M3.1.Z.AQ	**Duplex stainless steel**	778	230	6	5	4	7	6	5
	M3.2.Z.AQ		867	260	6	5	4	7	6	5
	M3.1.C.AQ		778	230	6	5	4	7	6	5
	M3.2.C.AQ		867	260	6	5	4	7	6	5

ISO	MC No.	Material	N/mm²	HB	T200-NM B150 ULDR(xTD) 1.5	2	3	T200-NM B125 1.5	2	3	T200-NM D150 1.5	2	3
					v_c m/min			v_c m/min			v_c m/min		
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	43	35	30	55	45	38	43	35	30
	N1.2.Z.AG		-	100	43	35	30	55	45	38	43	35	30
	N1.3.C.UT		-	75	43	35	30	55	45	38	43	35	30
	N1.3.C.AG		-	90	24	20	17	37	30	26	24	20	17
	N1.4.C.NS		-	130	18	15	13	24	20	17	18	15	13
	N3.3.U.UT	**Copper based alloys**	-	110	37	30	26	55	45	38	37	30	26
	N3.1.U.UT		-	100	15	12	10	22	18	15	15	12	10

CoroTap - Optimized

CoroTap™ 200

Inch values

					E324 E326 E854 E855 E874 E875			EP03P EP03PA EP13P EP13PA EP23PA EP33PA			EP09P EP29PA EP39PA		
				ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c ft/min			v_c ft/min			v_c ft/min		
P	P1.1.Z.HT	Unalloyed steel	639	190	-	-	-	181	148	126	181	148	126
	P1.2.Z.AN		639	190	-	-	-	181	148	126	181	148	126
	P1.2.Z.HT		708	210	-	-	-	140	115	98	181	148	126
	P1.3.Z.AN		639	190	-	-	-	181	148	126	181	148	126
	P1.3.Z.HT		1013	300	68	56	48	100	82	70	140	115	98
	P1.5.C.UT		503	150	-	-	-	181	148	126	181	148	126
	P2.1.Z.AN	Low-alloyed steel	591	175	-	-	-	181	148	126	181	148	126
	P2.2.Z.AN		811	240	-	-	-	140	115	98	181	148	126
	P2.3.Z.AN		867	260	68	56	48	100	82	70	140	115	98
	P2.5.Z.HT.1		961	285	68	56	48	100	82	70	140	115	98
	P2.6.C.UT		674	200	-	-	-	140	115	98	181	148	126
	P3.0.Z.AN	High-alloyed steel	674	200	-	-	-	140	115	98	181	148	126
	P3.0.Z.HT.1		1282	380	44	36	31	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	140	115	98	181	148	126
	P5.0.Z.HT.1	Ferritic/martensitic stainless steel	1114	330	-	-	-	140	115	98	181	148	126

					E344 E345 E364			E454 E455 E852 E872 E873		
				ULDR(xTD)	1.5	2	3	1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c ft/min			v_c ft/min		
P	P1.3.Z.HT	Unalloyed steel	1013	300	40	33	28	68	56	48
	P2.3.Z.AN	Low-alloyed steel	867	260	40	33	28	68	56	48
	P2.5.Z.HT.1		1114	285	40	33	28	68	56	48
	P3.0.Z.HT.1	High-alloyed steel	1282	380	20	16	14	44	36	31
	P5.0.Z.PH	Ferritic/martensitic stainless steel	1112	330	20	16	14	24	20	17
M	M1.0.C.UT	Austenitic stainless steel	674	200	28	23	20	40	33	28
	M1.0.Z.AQ		674	200	28	23	20	40	33	28
	M1.0.Z.PH		1013	300	20	16	14	24	20	17
	M2.0.Z.AQ	Super austenitic stainless steel	778	200	28	23	20	40	33	28
	M2.0.C.AQ		867	200	28	23	20	40	33	28
	M3.1.Z.AQ	Duplex stainless steel	674	200	20	16	14	24	20	17
	M3.2.Z.AQ		674	200	20	16	14	24	20	17
	M3.1.C.AQ		778	230	20	16	14	24	20	17
	M3.2.C.AQ		867	260	20	16	14	24	20	17

					T200-NM B150			T200-NM B125			T200-NM D150		
				ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c ft/min			v_c ft/min			v_c ft/min		
N	N1.2.Z.UT	Aluminum based alloys	-	60	140	115	98	181	148	126	140	115	98
	N1.2.Z.AG		-	100	140	115	98	181	148	126	140	115	98
	N1.3.C.UT		-	75	140	115	98	181	148	126	140	115	98
	N1.3.C.AG		-	90	80	66	56	120	98	84	80	66	56
	N1.4.C.NS		-	130	60	49	42	80	66	56	60	49	42
	N3.3.U.UT	Copper based alloys	-	110	120	98	84	181	148	126	120	98	84
	N3.1.U.UT		-	100	48	39	34	72	59	51	48	39	34

CoroTap - Optimized

CoroTap™ 200

Metric values

				T200-SD	
			ULDR	1.5	2
ISO	**MC-Code**	**Material**	**HB**	v_c m/min	
S	S1.0.U.AN	Heat resistant super alloys	200	7	6
	S1.0.U.AG		280	5	4
	S2.0.Z.AN	Nickel based alloys	250	7	6
	S2.0.Z.AG		350	2	2
	S2.0.Z.UT		275	5	4
	S2.0.C.NS		320	5	4
	S3.0.Z.AN	Cobolt based alloys	200	5	4
	S3.0.Z.AG		300	2	2
	S3.0.C.NS		320	5	4

Inch values

				T200-SD	
			ULDR	1.5	2
ISO	**MC-Code**	**Material**	**HB**	V_c feet/min	
S	S1.0.U.AN	Heat resistant super alloys	200	23	20
	S1.0.U.AG		280	17	14
	S2.0.Z.AN	Nickel based alloys	250	23	20
	S2.0.Z.AG		350	7	7
	S2.0.Z.UT		275	17	14
	S2.0.C.NS		320	17	14
	S3.0.Z.AN	Cobolt based alloys	200	17	14
	S3.0.Z.AG		300	7	7
	S3.0.C.NS		320	17	14

CoroTap - Optimized for specific materials

Metric values

				T200-SM	
			ULDR	1.5	2
ISO	**MC-Code**	**Material**	**HB**	v_c m/min	
S	S4.1.Z.UT	Titanium alloys	200	7	6
	S4.2.Z.AN		320	7	6
	S4.3.Z.AN		330	5	4
	S4.3.Z.AG		375	5	4
	S4.4.Z.AN		330	5	4
	S4.4.Z.AG		410	5	4

Inch version

				T200-SM	
			ULDR	1.5	2
ISO	**MC-Code**	**Material**	**HB**	ft m/min	
S	S4.1.Z.UT	Titanium alloys	200	23	20
	S4.2.Z.AN		320	23	20
	S4.3.Z.AN		330	17	14
	S4.3.Z.AG		375	17	14
	S4.4.Z.AN		330	17	14
	S4.4.Z.AG		410	17	14

CoroTap - Optimized

CoroTap™ 300

Metric values

					E314 E316 E864 E865 E884 E885			EX03P EX03PA EX13P EX13PA EX23PA EX33PA			EX09P EX29PA EX39PA		
					ULDR(xTD) 1.5	2	3	1.5	2	3	1.5	2	3
ISO	MC No.	Material	N/mm²	HB	v_c m/min			v_c m/min			v_c m/min		
P	P1.1.Z.HT	**Unalloyed steel**	639	190	-	-	-	49	40	34	55	45	38
	P1.2.Z.AN		639	190	-	-	-	49	40	34	55	45	38
	P1.2.Z.HT		708	210	-	-	-	37	30	26	49	40	34
	P1.3.Z.AN		639	190	-	-	-	49	40	34	55	45	38
	P1.3.Z.HT		1013	300	21	17	15	24	20	17	37	30	26
	P1.5.C.UT		503	150	-	-	-	49	40	34	55	45	38
	P2.1.Z.AN	**Low-alloyed steel**	591	175	-	-	-	49	40	34	55	45	38
	P2.2.Z.AN		811	240	-	-	-	37	30	26	49	40	34
	P2.3.Z.AN		867	260	21	17	15	24	20	17	37	30	26
	P2.5.Z.HT.1		961	285	21	17	15	24	20	17	37	30	26
	P2.6.C.UT		674	200	-	-	-	37	30	26	49	40	34
	P3.0.Z.AN	**High-alloyed steel**	674	200	-	-	-	37	30	26	49	40	34
	P3.0.Z.HT.1		1282	380	13	11	9	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	37	30	26	49	40	34
	P5.0.Z.HT.1	**Ferritic/martensitic stainless steel**	1114	330	-	-	-	37	30	26	49	40	34

					E047			E404 E862 E882 E883 E048			E346 E347 E362 E363 E095		E069 E079			E736 E738
					ULDR(xTD) 1.5	2	3	1.5	2	3	1.5	2	1.5	2	3	1.5
ISO	MC No.	Material	N/mm²	HB	v_c m/min			v_c m/min			v_c m/min		v_c m/min			v_c m/min
P	P1.3.Z.HT	**Unalloyed steel**	1013	300	12	10	9	16	13	11	12	10	12	10	9	-
	P2.3.Z.AN	**Low-alloyed steel**	867	260	12	10	9	16	13	11	12	10	12	10	9	-
	P2.5.Z.HT.1		1114	285	12	10	9	16	13	11	12	10	12	10	9	-
	P3.0.Z.HT.1	**High-alloyed steel**	1282	380	6	5	4	13	11	9	6	5	6	5	4	-
	P5.0.Z.PH	**Ferritic/martensitic stainless steel**	1114	330	6	5	4	7	6	5	6	5	5	4	3	4
M	M1.0.C.UT	**Austenitic stainless steel**	674	200	9	7	6	12	10	9	9	7	7	6	5	4
	M1.0.Z.AQ		674	200	9	7	6	12	10	9	9	7	7	6	5	4
	M1.0.Z.PH		1013	300	6	5	4	7	6	5	6	5	-	-	-	-
	M2.0.C.AQ	**Super austenitic stainless steel**	674	200	9	7	6	12	10	9	9	7	7	6	5	4
	M2.0.Z.AQ		674	200	9	7	6	12	10	9	9	7	7	6	5	4
	M3.1.Z.AQ	**Duplex stainless steel**	778	230	6	5	4	7	6	5	6	5	5	4	3	4
	M3.2.Z.AQ		867	260	6	5	4	7	6	5	6	5	5	4	3	4
	M3.1.C.AQ		778	230	6	5	4	7	6	5	6	5	5	4	3	4
	M3.2.C.AQ		867	260	6	5	4	7	6	5	6	5	5	4	3	4

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CoroTap™ 300

Inch values

					E314 E316 E864 E865 E884 E885			EX03P EX03PA EX13P EX13PA EX23PA EX33PA			EX09P EX29PA EX39PA		
				ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c ft/min			v_c ft/min			v_c ft/min		
P	P1.1.Z.AN	**Unalloyed steel**	428	125	-	-	-	-	-	-	-	-	-
	P1.1.Z.HT		639	190	-	-	-	161	131	112	181	148	126
	P1.2.Z.AN		639	190	-	-	-	161	131	112	181	148	126
	P1.2.Z.HT		708	210	-	-	-	120	98	84	161	131	112
	P1.3.Z.AN		639	190	-	-	-	161	131	112	181	148	126
	P1.3.Z.HT		1013	300	68	56	48	80	66	56	120	98	84
	P1.5.C.UT		503	150	-	-	-	161	131	112	181	148	126
	P2.1.Z.AN	**Low-alloyed steel**	591	175	-	-	-	161	131	112	181	148	126
	P2.2.Z.AN		811	240	-	-	-	120	98	84	161	131	112
	P2.3.Z.AN		867	260	68	56	48	80	66	56	120	98	84
	P2.5.Z.HT.1		961	285	68	56	48	80	66	56	120	98	84
	P2.6.C.UT		674	200	-	-	-	120	98	84	161	131	112
	P3.0.Z.AN	**High-alloyed steel**	674	200	-	-	-	120	98	84	161	131	112
	P3.0.Z.HT.1		1282	380	44	36	31	-	-	-	-	-	-
	P3.1.Z.AN		839	250	-	-	-	120	98	84	161	131	112
	P5.0.Z.AN	**Ferritic/martensitic stainless steel**	674	200	-	-	-	-	-	-	-	-	-
	P5.0.Z.PH		1114	330	-	-	-	-	-	-	-	-	-
	P5.0.Z.HT.1		1114	330	-	-	-	120	98	84	161	131	112
	P5.0.C.UT		839	200	-	-	-	-	-	-	-	-	-
	P5.0.C.HT		1114	330	-	-	-	-	-	-	-	-	-

					E047			E404 E862 E882 E883 E048			E346 E347 E362 E363 E095		E069 E079			E736 E738
				ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	1.5	2	3	1.5
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c ft/min			v_c ft/min			v_c ft/min		v_c ft/min			v_c ft/min
P	P1.3.Z.HT	**Unalloyed steel**	1013	300	40	33	28	52	43	36	40	33	40	33	28	-
	P2.3.Z.AN	**Low-alloyed steel**	867	260	40	33	28	52	43	36	40	33	40	33	28	-
	P2.5.Z.HT.1		1114	285	40	33	28	52	43	36	40	33	40	33	28	-
	P3.0.Z.HT.1	**High-alloyed steel**	1282	380	20	16	14	44	36	31	20	16	20	16	14	-
	P5.0.Z.PH	**Ferritic/martensitic stainless steel**	1114	330	20	16	14	24	20	17	20	16	16	13	11	12
M	M1.0.C.UT	**Austenitic stainless steel**	674	200	28	23	20	40	33	28	28	23	24	20	17	12
	M1.0.Z.AQ		674	200	28	23	20	40	33	28	28	23	24	20	17	12
	M1.0.Z.PH		1013	300	20	16	14	24	20	17	20	16	-	-	-	-
	M2.0.C.AQ	**Super austenitic stainless steel**	674	200	28	23	20	40	33	28	28	23	24	20	17	12
	M2.0.Z.AQ		674	200	28	23	20	40	33	28	28	23	24	20	17	12
	M3.1.Z.AQ	**Duplex stainless steel**	778	230	20	16	14	24	20	17	20	16	16	13	11	12
	M3.2.Z.AQ		867	260	20	16	14	24	20	17	20	16	16	13	11	12
	M3.1.C.AQ		778	230	20	16	14	24	20	17	20	16	16	13	11	12
	M3.2.C.AQ		867	260	20	16	14	24	20	17	20	16	16	13	11	12

CoroTap - Optimized

CoroTap™ 300

Metric values

					T105		T106		
					ULDR(xTD) 1.5	2	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c m/min		v_c m/min		
K	K1.1.C.NS	**Malleable cast iron**	674	200	31	25	31	25	21
	K2.1.C.UT	**Gray cast iron**	602	180	49	40	49	40	34
	K2.2.C.UT		825	245	18	15	18	15	13
	K2.3.C.UT		591	175	31	25	31	25	21
	K3.1.C.UT	**Nodular cast iron**	518	155	31	25	31	25	21
	K3.2.C.UT		727	215	31	25	31	25	21
	K3.3.C.UT		885	265	31	25	31	25	21
	K3.5.C.UT		639	190	31	25	31	25	21
	K5.1.C.NS	**Austempered ductile iron**	1013	300	18	15	18	15	13

					T300-NM D150			T300-NM D125			T300-NM B150		
					ULDR(xTD) 1.5	2	3	1.5	2	3	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c m/min			v_c m/min			v_c m/min		
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	43	35	30	55	45	38	43	35	30
	N1.2.Z.AG		-	100	43	35	30	55	45	38	43	35	30
	N1.3.C.UT		-	75	43	35	30	55	45	38	43	35	30
	N1.3.C.AG		-	90	24	20	17	37	30	26	24	20	17
	N1.4.C.NS		-	130	18	15	13	24	20	17	-	-	-
	N3.3.U.UT	**Copper based alloys**	-	110	37	30	26	55	45	38	-	-	-
	N3.1.U.UT		-	100	15	12	10	22	18	15	15	12	10

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Inch values

					T105		T106		
					ULDR(xTD)	1.5	2	1,5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c ft/min			v_c ft/min		
K	K1.1.C.NS	Malleable cast iron	674	200	100	82	100	82	70
	K2.1.C.UT	Gray cast iron	602	180	161	131	161	131	112
	K2.2.C.UT		825	245	60	49	60	49	42
	K2.3.C.UT		591	175	100	82	100	82	70
	K3.1.C.UT	Nodular cast iron	518	155	100	82	100	82	70
	K3.2.C.UT		727	215	100	82	100	82	70
	K3.3.C.UT		885	265	100	82	100	82	70
	K3.5.C.UT		639	190	100	82	100	82	70
	K5.1.C.NS	Austempered ductile iron	1013	300	60	49	60	49	42

					T300-NM D150			T300-NM D125			T300-NM B150		
					ULDR(xTD)	1.5	2	3	1.5	2	3	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c ft/min			v_c ft/min			v_c ft/min		
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	140	115	98	181	148	126	140	115	98
	N1.2.Z.AG		-	100	140	115	98	181	148	126	140	115	98
	N1.3.C.UT		-	75	140	115	98	181	148	126	140	115	98
	N1.3.C.AG		-	90	80	66	56	120	98	84	80	66	56
	N1.4.C.NS		-	130	60	49	42	80	66	56	-	-	-
	N3.3.U.UT	**Copper based alloys**	-	110	120	98	84	181	148	126	-	-	-
	N3.1.U.UT		-	100	48	39	34	72	59	51	48	39	34

CoroTap - Optimized

CoroTap™ 300

Metric values

				T300-SD	
			ULDR	1.5	
ISO	**MC No.**	**Material**	**HB**	v_c m/min	
S	S1.0.U.AN	Heat resistant super alloys	200	7	
	S1.0.U.AG		280	5	
	S2.0.Z.AN	Nickel based alloys	250	5	
	S2.0.Z.AG		350	3	
	S2.0.Z.UT		275	5	
	S2.0.C.NS		320	3	

Inch version

				T300-SD	
			ULDR	1.5	
ISO	**MC No.**	**Material**	**HB**	ft m/min	
S	S1.0.U.AN	Heat resistant super alloys	200	23	
	S1.0.U.AG		280	17	
	S2.0.Z.AN	Nickel based alloys	250	17	
	S2.0.Z.AG		350	10	
	S2.0.Z.UT		275	17	
	S2.0.C.NS		320	10	

Metric values

				T300-SM	
			ULDR	1.5	2
ISO	**MC No.**	**Material**	**HB**	v_c m/min	
S	S4.1.Z.UT	Titanium alloys	200	10	8
	S4.2.Z.AN		320	6	5
	S4.3.Z.AN		330	6	5
	S4.3.Z.AG		375	5	4
	S4.4.Z.AN		330	5	4
	S4.4.Z.AG		410	5	4

Inch version

				T300-SM	
			ULDR	1.5	2
ISO	**MC No.**	**Material**	**HB**	ft m/min	
S	S4.1.Z.UT	Titanium alloys	200	33	27
	S4.2.Z.AN		320	20	17
	S4.3.Z.AN		330	20	17
	S4.3.Z.AG		375	17	14
	S4.4.Z.AN		330	17	14
	S4.4.Z.AG		410	17	14

CoroTap - Optimized

CoroTap™ 400

Metric values

					T400-NM		
					ULDR(xTD)	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c m/min		
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	67	55	47
	N1.2.Z.AG		-	100	67	55	47
	N1.3.C.UT		-	75	67	55	47
	N1.3.C.AG		-	90	49	40	34
	N3.1.U.UT	**Copper based alloys**	-	100	31	25	21

Inch values

					T400-NM		
					ULDR(xTD)	1.5	2	3
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c ft/min		
N	N1.2.Z.UT	**Aluminum based alloys**	-	60	221	180	154
	N1.2.Z.AG		-	100	221	180	154
	N1.3.C.UT		-	75	221	180	154
	N1.3.C.AG		-	90	161	131	112
	N3.1.U.UT	**Copper based alloys**	-	100	100	82	70

Metric values

					T400-PM		
				ULDR (xTD)	1.5	2.0	3.0
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	v_c m/min		
P	P1.1.Z.AN	Unalloyed steel	428	125	40	33	28
	P1.1.Z.HT		639	190	36	30	26
	P1.2.Z.AN		639	190	33	27	23
	P1.2.Z.HT		708	210	29	24	21
	P1.3.Z.AN		639	190	33	27	23
	P1.3.Z.HT		1013	300	15	12	10
	P2.1.Z.AN	Low-alloyed steel	591	175	33	27	23
	P2.2.Z.AN		811	240	29	24	21
	P2.3.Z.AN		867	260	15	12	10
	P2.5.Z.HT.1		961	285	15	12	10
	P3.0.Z.AN	High-alloyed steel	674	200	29	24	21
	P3.1.Z.AN		839	250	29	24	21
	P1.5.C.UT	Steel castings	503	150	33	27	23
	P2.6.C.UT		674	200	29	24	21
	P1.5.C.UT	Ferritic/martensitic stainless steel	1114	330	29	24	21
	P2.6.C.UT		1114	330	8	6	5

Inch values

					T400-PM		
				ULDR (xTD)	1.5	2.0	3.0
ISO	**MC No.**	**Material**	**N/mm²**	**HB**	V_c feet/min		
P	P1.1.Z.AN	Unalloyed steel	428	125	132	108	93
	P1.1.Z.HT		639	190	120	99	84
	P1.2.Z.AN		639	190	108	89	76
	P1.2.Z.HT		708	210	96	78	68
	P1.3.Z.AN		639	190	108	89	76
	P1.3.Z.HT		1013	300	48	40	34
	P2.1.Z.AN	Low-alloyed steel	591	175	108	89	76
	P2.2.Z.AN		811	240	96	78	68
	P2.3.Z.AN		867	260	48	40	34
	P2.5.Z.HT.1		961	285	48	40	34
	P3.0.Z.AN	High-alloyed steel	674	200	96	78	68
	P3.1.Z.AN		839	250	96	78	68
	P1.5.C.UT	Steel castings	503	150	108	89	76
	P2.6.C.UT		674	200	96	78	68
	P1.5.C.UT	Ferritic/martensitic stainless steel	1114	330	96	78	68
	P2.6.C.UT		1114	330	24	20	17

Reaming

V

Versatile

CoroReamer™ 435 D2
For multi-materials D3-D4

O

Optimized

CoroReamer™ 835 D5
For steel D6-D7
For stainless steel D9-D10

CoroReamer™ 830 D11
Solid carbide head D12
Adapter D13

C

Customized

E8

CoroReamer™ 435

Flexible and high-performance reamer, suitable for a wide range of materials

Benefits and features

- High productivity thanks to high cutting parameters
- Consistency and productivity saving time and costs
- Excellent surface finish on the component
- Uniform concentricity for long tool life and dimensional accuracy
- High stability thanks to the solid carbide body
- Internal coolant for better chip evacuation and reduced wear

V C

ISO application area:

P K N

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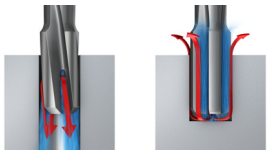
Versatile tools designed for high performance and secure machining in a variety of materials, applications, component sizes and shapes, allowing maximum machine utilization.

Flute geometry with extremely unequal flute spacing

Extremely unequal flute spacing means that the divide is not the same for each tooth. As there are no teeth diametrically opposite each other, the reamer produces a hole with improved hole roundness variance.

Through hole Blind hole



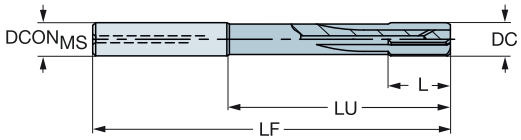
E14

CoroReamer™ 435 solid-carbide reamer

For multi-materials

For blind holes

CNSC 1
CXSC 1
SUBSTRATE HF



						P	K	N	Dimensions, mm, inch												
DC	DC"	LU	LU"	CZC_{MS}	Ordering code	H10F	H10F	H10F	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
4.00	.157	39.00	1.535	6	435.B-0400-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.01	.158	39.00	1.535	6	435.B-0401-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.50	.177	39.00	1.535	6	435.B-0450-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.32	2.926	0.3	.012	4.30	.169	COROMANT
5.00	.197	39.00	1.535	6	435.B-0500-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.01	.197	39.00	1.535	6	435.B-0501-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
6.00	.236	39.00	1.535	6	435.B-0600-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.01	.237	39.00	1.535	6	435.B-0601-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
7.00	.276	64.00	2.520	8	435.B-0700-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
8.00	.315	64.00	2.520	8	435.B-0800-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.01	.315	64.00	2.520	8	435.B-0801-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	435.B-0802-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
10.00	.394	80.00	3.150	10	435.B-1000-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	435.B-1001-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
12.00	.472	75.00	2.953	12	435.B-1200-A1-XF	★	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.03	.474	75.00	2.953	12	435.B-1203-A1-XF	★	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
13.00	.512	85.00	3.346	14	435.B-1300-A1-XF	★	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT
14.00	.551	85.00	3.346	14	435.B-1400-A1-XF	★	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	435.B-1500-A1-XF	★	★	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	435.B-1600-A1-XF	★	★	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT
17.00	.669	102.00	4.016	18	435.B-1700-A1-XF	★	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT
18.00	.709	102.00	4.016	18	435.B-1800-A1-XF	★	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT
20.00	.787	100.00	3.937	20	435.B-2000-A1-XF	★	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT

Full diameters H7 hole tolerance
Centesimal diameters produce a tighter hole tolerance due to manufacturing of +0.004mm

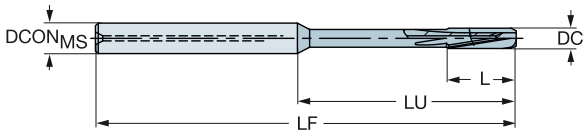
D14 E9 E28 E14

CoroReamer™ 435 solid-carbide reamer

For multi-materials

For through holes

FHA	10°
CNSC	1
CXSC	2
SUBSTRATE	HF



Dimensions, mm, inch

DC	DC"	LU	LU"	CZC$_{MS}$	Ordering code	P H10F	K H10F	N H10F	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
4.00	.157	39.00	1.535	6	435.T-0400-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
5.00	.197	39.00	1.535	6	435.T-0500-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.97	.235	39.00	1.535	6	435.T-0597-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.00	.236	39.00	1.535	6	435.T-0600-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	435.T-0602-A1-XF	★	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.50	.256	64.00	2.520	8	435.T-0650-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT
7.00	.276	64.00	2.520	8	435.T-0700-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
8.00	.315	64.00	2.520	8	435.T-0800-A1-XF	★	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
9.00	.354	60.00	2.362	10	435.T-0900-A1-XF	★	★	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
9.50	.374	80.00	3.150	10	435.T-0950-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT
9.98	.393	80.00	3.150	10	435.T-0998-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.00	.394	80.00	3.150	10	435.T-1000-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	435.T-1001-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.02	.394	80.00	3.150	10	435.T-1002-A1-XF	★	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
11.00	.433	75.00	2.953	12	435.T-1100-A1-XF	★	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT
11.97	.471	75.00	2.953	12	435.T-1197-A1-XF	★	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.00	.472	75.00	2.953	12	435.T-1200-A1-XF	★	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
13.00	.512	85.00	3.346	14	435.T-1300-A1-XF	★	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT
14.00	.551	85.00	3.346	14	435.T-1400-A1-XF	★	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	435.T-1500-A1-XF	★	★	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	435.T-1600-A1-XF	★	★	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT
17.00	.669	102.00	4.016	18	435.T-1700-A1-XF	★	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT
18.00	.709	102.00	4.016	18	435.T-1800-A1-XF	★	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT
19.00	.748	100.00	3.937	20	435.T-1900-A1-XF	★	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	147.14	5.793	0.3	.012	18.80	.740	COROMANT
20.00	.787	100.00	3.937	20	435.T-2000-A1-XF	★	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT

Full diameters H7 hole tolerance

Centesimal diameters produce a tighter hole tolerance due to manufacturing of +0.004mm

D14 E9 E28 E14

CoroReamer™ 835

High performance reamer for steel

Application

- For all industry segments, e.g., general machining, die and mold, automotive, energy and power generation
- Available in spiral flute for through holes and straight flute for blind holes
- Through holes, angled surface, and cross hole
- 20 bar coolant pressure

O C

ISO application area:

P K

Benefits and features

- High productivity thanks to high cutting parameters
- Consistency and productivity saving time and costs
- Excellent surface finish on the component
- Uniform concentricity for long tool life and dimensional accuracy
- High stability thanks to the solid carbide body
- Internal coolant for better chip evacuation and reduced wear
- Micro-grained carbide for high hardness and toughness
- Flute geometry with extremely unequal flute spacing

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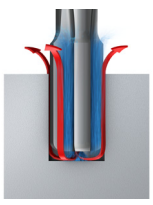
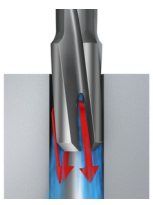
Flute geometry with extremely unequal flute spacing

Extremely unequal flute spacing means that the divide is not the same for each tooth. As there are no teeth diametrically opposite each other, the reamer produces a hole with improved hole roundness variance.

Blind hole



Through hole



E14

CoroReamer™ 835 solid-carbide reamer

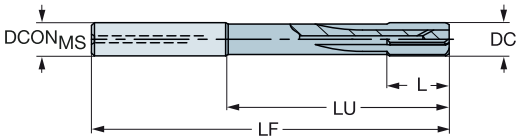
For steel

For blind holes

835.B..A1-PF

CNSC 1

CXSC 1



Dimensions, mm, inch

DC	DC"	LU	LU"	CZC$_{MS}$	Ordering code	P 1024	K 1024	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
4.00	.157	39.00	1.535	6	835.B-0400-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
5.00	.197	39.00	1.535	6	835.B-0500-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.99	.236	39.00	1.535	6	835.B-0599-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.00	.236	39.00	1.535	6	835.B-0600-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.01	.237	39.00	1.535	6	835.B-0601-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	835.B-0602-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.03	.237	39.00	1.535	6	835.B-0603-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.09	2.917	0.3	.012	5.80	.228	COROMANT
7.00	.276	64.00	2.520	8	835.B-0700-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
7.97	.314	64.00	2.520	8	835.B-0797-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
7.98	.314	64.00	2.520	8	835.B-0798-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
7.99	.315	64.00	2.520	8	835.B-0799-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.00	.315	64.00	2.520	8	835.B-0800-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	835.B-0802-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
9.00	.354	60.00	2.362	10	835.B-0900-A1-PF	★	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
9.50	.374	80.00	3.150	10	835.B-0950-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT
9.97	.393	80.00	3.150	10	835.B-0997-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.00	.394	80.00	3.150	10	835.B-1000-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	835.B-1001-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.02	.394	80.00	3.150	10	835.B-1002-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
10.03	.395	80.00	3.150	10	835.B-1003-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
10.50	.413	75.00	2.953	12	835.B-1050-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT
11.00	.433	75.00	2.953	12	835.B-1100-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT
11.50	.453	75.00	2.953	12	835.B-1150-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.27	4.656	0.3	.012	11.30	.445	COROMANT
11.97	.471	75.00	2.953	12	835.B-1197-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
11.99	.472	75.00	2.953	12	835.B-1199-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.00	.472	75.00	2.953	12	835.B-1200-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.01	.473	75.00	2.953	12	835.B-1201-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.02	.473	75.00	2.953	12	835.B-1202-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
13.00	.512	85.00	3.346	14	835.B-1300-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT
14.00	.551	85.00	3.346	14	835.B-1400-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	835.B-1500-A1-PF	★	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	835.B-1600-A1-PF	★	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT
18.00	.709	102.00	4.016	18	835.B-1800-A1-PF	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT
19.00	.748	100.00	3.937	20	835.B-1900-A1-PF	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	147.14	5.793	0.3	.012	18.80	.740	COROMANT
20.00	.787	100.00	3.937	20	835.B-2000-A1-PF	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT

Full diameters H7 hole tolerance

Centesimal diameters produce a tighter hole tolerance due to manufacturing of +0.004mm

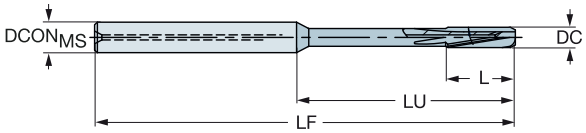
D19 E9 E28 E14

CoroReamer™ 835 solid-carbide reamer

For steel

For through holes

TCHA H7
CNSC 1



						P	K	Dimensions, mm, inch												
DC	DC"	LU	LU"	CZC_{MS}	Ordering code	1024	1024	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
3.98	.157	39.00	1.535	6	835.T-0398-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.00	.157	39.00	1.535	6	835.T-0400-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.01	.158	39.00	1.535	6	835.T-0401-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.02	.158	39.00	1.535	6	835.T-0402-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
5.00	.197	39.00	1.535	6	835.T-0500-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.01	.197	39.00	1.535	6	835.T-0501-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.98	.235	39.00	1.535	6	835.T-0598-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.00	.236	39.00	1.535	6	835.T-0600-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.01	.237	39.00	1.535	6	835.T-0601-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	835.T-0602-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.03	.237	39.00	1.535	6	835.T-0603-A1-PF	★	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.09	2.917	0.3	.012	5.80	.228	COROMANT
6.50	.256	64.00	2.520	8	835.T-0650-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT
7.00	.276	64.00	2.520	8	835.T-0700-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
7.50	.295	64.00	2.520	8	835.T-0750-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.87	3.893	0.3	.012	7.30	.287	COROMANT
7.97	.314	64.00	2.520	8	835.T-0797-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.00	.315	64.00	2.520	8	835.T-0800-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.01	.315	64.00	2.520	8	835.T-0801-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	835.T-0802-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
8.03	.316	64.00	2.520	8	835.T-0803-A1-PF	★	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
9.00	.354	60.00	2.362	10	835.T-0900-A1-PF	★	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
9.50	.374	80.00	3.150	10	835.T-0950-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT
9.97	.393	80.00	3.150	10	835.T-0997-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
9.99	.393	80.00	3.150	10	835.T-0999-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.00	.394	80.00	3.150	10	835.T-1000-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	835.T-1001-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.02	.394	80.00	3.150	10	835.T-1002-A1-PF	★	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.49	4.665	0.3	.012	9.80	.386	COROMANT
10.50	.413	75.00	2.953	12	835.T-1050-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT
11.00	.433	75.00	2.953	12	835.T-1100-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT
12.00	.472	75.00	2.953	12	835.T-1200-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.01	.473	75.00	2.953	12	835.T-1201-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
12.02	.473	75.00	2.953	12	835.T-1202-A1-PF	★	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.19	4.653	0.3	.012	11.80	.465	COROMANT
13.00	.512	85.00	3.346	14	835.T-1300-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	128.05	5.041	0.3	.012	12.80	.504	COROMANT
14.00	.551	85.00	3.346	14	835.T-1400-A1-PF	★	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	835.T-1500-A1-PF	★	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	835.T-1600-A1-PF	★	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT
17.00	.669	102.00	4.016	18	835.T-1700-A1-PF	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.45	5.805	0.3	.012	16.80	.661	COROMANT
18.00	.709	102.00	4.016	18	835.T-1800-A1-PF	★	★	18.00	.709	150.00	5.906	32.50	1.280	25.00	.984	147.30	5.799	0.3	.012	17.80	.701	COROMANT
20.00	.787	100.00	3.937	20	835.T-2000-A1-PF	★	★	20.00	.787	150.00	5.906	32.50	1.280	25.00	.984	146.99	5.787	0.3	.012	19.80	.780	COROMANT

Full diameters H7 hole tolerance

Centesimal diameters produce a tighter hole tolerance due to manufacturing of +0.004mm

D19 E9 E28 E14

CoroReamer™ 835

High performance reamer for stainless steel

Application

- For all industry segments, e.g., general machining, die and mold, automotive, energy and power generation
- Available in spiral flute for through holes and straight flute for blind holes
- Through holes, angled surface, and cross hole
- 20 bar coolant pressure

O C

ISO application area:

M

Benefits and features

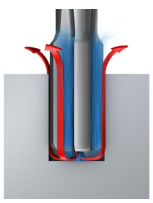
- High productivity thanks to high cutting parameters
- Consistency and productivity saving time and costs
- Excellent surface finish on the component
- Uniform concentricity for long tool life and dimensional accuracy
- High stability thanks to the solid carbide body
- Internal coolant for better chip evacuation and reduced wear
- Micro-grained carbide for high hardness and toughness
- Flute geometry with extremely unequal flute spacing

www.sandvik.coromant.com/cororeamer835

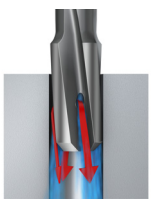
Flute geometry with extremely unequal flute spacing

Extremely unequal flute spacing means that the divide is not the same for each tooth. As there are no teeth diametrically opposite each other, the reamer produces a hole with improved hole roundness variance.

Blind hole



Through hole



E14

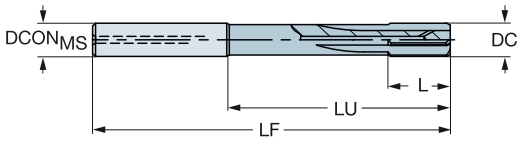
SANDVIK Coromant

CoroReamer™ 835 solid-carbide reamer

For stainless steel

For blind holes

TCHA H7
CNSC 1



DC	DC"	LU	LU"	CZC$_{MS}$	Ordering code	M 1024	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
							Dimensions, mm, inch														
3.97	.156	39.00	1.535	6	835.B-0397-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.00	.157	39.00	1.535	6	835.B-0400-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.02	.158	39.00	1.535	6	835.B-0402-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.97	.196	39.00	1.535	6	835.B-0497-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.00	.197	39.00	1.535	6	835.B-0500-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
6.00	.236	39.00	1.535	6	835.B-0600-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.01	.237	39.00	1.535	6	835.B-0601-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	835.B-0602-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
7.00	.276	64.00	2.520	8	835.B-0700-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
8.00	.315	64.00	2.520	8	835.B-0800-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.01	.315	64.00	2.520	8	835.B-0801-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.50	.335	60.00	2.362	10	835.B-0850-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.72	3.887	0.3	.012	8.30	.327	COROMANT
9.00	.354	60.00	2.362	10	835.B-0900-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
10.00	.394	80.00	3.150	10	835.B-1000-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
11.00	.433	75.00	2.953	12	835.B-1100-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.35	4.659	0.3	.012	10.80	.425	COROMANT
11.50	.453	75.00	2.953	12	835.B-1150-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.27	4.656	0.3	.012	11.30	.445	COROMANT
12.00	.472	75.00	2.953	12	835.B-1200-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
14.00	.551	85.00	3.346	14	835.B-1400-A1-MF	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
16.00	.630	102.00	4.016	16	835.B-1600-A1-MF	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT

Full diameters H7 hole tolerance

Centesimal diameters produce a tighter hole tolerance due to manufacturing of +0.004mm

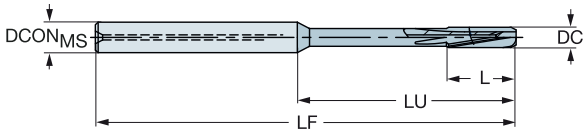
D22 E9 E28 E14

CoroReamer™ 835 solid-carbide reamer

For stainless steel

For through holes

TCHA H7
CNSC 1



DC	DC"	LU	LU"	CZC$_{MS}$	Ordering code	M 1024	DCON$_{MS}$	DCON$_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
							Dimensions, mm, inch														
3.97	.156	39.00	1.535	6	835.T-0397-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.00	.157	39.00	1.535	6	835.T-0400-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.01	.158	39.00	1.535	6	835.T-0401-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
4.02	.158	39.00	1.535	6	835.T-0402-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.40	2.929	0.3	.012	3.80	.150	COROMANT
5.00	.197	39.00	1.535	6	835.T-0500-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.25	2.923	0.3	.012	4.80	.189	COROMANT
5.03	.198	39.00	1.535	6	835.T-0503-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.24	2.923	0.3	.012	4.80	.189	COROMANT
5.99	.236	39.00	1.535	6	835.T-0599-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.00	.236	39.00	1.535	6	835.T-0600-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.02	.237	39.00	1.535	6	835.T-0602-A1-MF	★	6.00	.236	75.00	2.953	15.60	.614	12.00	.472	74.10	2.917	0.3	.012	5.80	.228	COROMANT
6.50	.256	64.00	2.520	8	835.T-0650-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	99.02	3.898	0.3	.012	6.30	.248	COROMANT
7.00	.276	64.00	2.520	8	835.T-0700-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.95	3.896	0.3	.012	6.80	.268	COROMANT
7.50	.295	64.00	2.520	8	835.T-0750-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.87	3.893	0.3	.012	7.30	.287	COROMANT
8.00	.315	64.00	2.520	8	835.T-0800-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.80	3.890	0.3	.012	7.80	.307	COROMANT
8.02	.316	64.00	2.520	8	835.T-0802-A1-MF	★	8.00	.315	100.00	3.937	20.80	.819	16.00	.630	98.79	3.889	0.3	.012	7.80	.307	COROMANT
8.50	.335	60.00	2.362	10	835.T-0850-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.72	3.887	0.3	.012	8.30	.327	COROMANT
9.00	.354	60.00	2.362	10	835.T-0900-A1-MF	★	10.00	.394	100.00	3.937	26.00	1.024	20.00	.787	98.65	3.884	0.3	.012	8.80	.346	COROMANT
9.50	.374	80.00	3.150	10	835.T-0950-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.57	4.668	0.3	.012	9.30	.366	COROMANT
10.00	.394	80.00	3.150	10	835.T-1000-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.01	.394	80.00	3.150	10	835.T-1001-A1-MF	★	10.00	.394	120.00	4.724	26.00	1.024	20.00	.787	118.50	4.665	0.3	.012	9.80	.386	COROMANT
10.50	.413	75.00	2.953	12	835.T-1050-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.42	4.662	0.3	.012	10.30	.406	COROMANT
12.00	.472	75.00	2.953	12	835.T-1200-A1-MF	★	12.00	.472	120.00	4.724	26.00	1.024	20.00	.787	118.20	4.654	0.3	.012	11.80	.465	COROMANT
14.00	.551	85.00	3.346	14	835.T-1400-A1-MF	★	14.00	.551	130.00	5.118	28.60	1.126	22.00	.866	127.90	5.035	0.3	.012	13.80	.543	COROMANT
15.00	.591	82.00	3.228	16	835.T-1500-A1-MF	★	16.00	.630	130.00	5.118	28.60	1.126	22.00	.866	127.75	5.030	0.3	.012	14.80	.583	COROMANT
16.00	.630	102.00	4.016	16	835.T-1600-A1-MF	★	16.00	.630	150.00	5.906	32.50	1.280	25.00	.984	147.60	5.811	0.3	.012	15.80	.622	COROMANT

Full diameters H7 hole tolerance

Centesimal diameters produce a tighter hole tolerance due to manufacturing of +0.004mm

D22 E9 E28 E14

CoroReamer™ 830

High-feed, exchangeable-head tool for through holes

Application

- For all industry segments, e.g., general machining, die and mold, automotive, energy and power generation
- Available in spiral flute for through holes and straight flute for blind holes
- Achievable hole tolerance: H7
- 20 bar coolant pressure

ISO application area:

P K

Benefits and features

- High surface finish and operation security
- High penetration rate
- Fast and easy head change with high accuracy < 3 µm (120 µinch)
- Effective chip evacuation by directing cutting fluid at each edge
- Achievable hole tolerance: H7
- Brazed cermet inserts in grade P10R
- Short and long shank options
- Head change

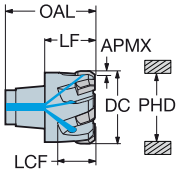
www.sandvik.coromant.com/cororeamer830

CoroReamer™ 830 solid-carbide head for reaming

For steel and cast iron

Internal coolant supply

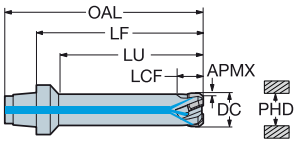
TCHA H7



P K

DC	DC"	CZC_{MS}	Ordering code	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
				Dimensions, mm, inch														
19.00	.748	S12	830A-E06D1900H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	18.80	.740	COROMANT
19.05	.750	S12	830A-E06D1905H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	18.83	.741	COROMANT
20.00	.787	S12	830A-E06D2000H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	19.80	.780	COROMANT
21.00	.827	S12	830A-E06D2100H7S12	12.00	.472	25.85	1.018	10.83	.426	6.00	.236	14.50	.571	0.3	.012	20.80	.819	COROMANT
22.00	.866	S14	830A-E06D2200H7S14	14.00	.551	27.85	1.096	13.05	.514	6.00	.236	15.50	.610	0.3	.012	21.80	.858	COROMANT
23.00	.906	S14	830A-E06D2300H7S14	14.00	.551	27.85	1.096	13.05	.514	6.00	.236	15.50	.610	0.3	.012	22.80	.898	COROMANT
24.00	.945	S16	830A-E06D2400H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	23.80	.937	COROMANT
25.00	.984	S16	830A-E06D2500H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	24.80	.976	COROMANT
25.40	1.000	S16	830A-E06D2540H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	25.20	.992	COROMANT
26.00	1.024	S16	830A-E06D2600H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	25.80	1.016	COROMANT
27.00	1.063	S16	830A-E06D2700H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	26.80	1.055	COROMANT
28.00	1.102	S16	830A-E06D2800H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	27.80	1.094	COROMANT
29.00	1.142	S16	830A-E06D2900H7S16	16.00	.630	29.85	1.175	13.05	.514	6.00	.236	16.00	.630	0.3	.012	28.80	1.134	COROMANT
30.00	1.181	S20	830A-E06D3000H7S20	20.00	.787	31.85	1.254	13.22	.520	6.00	.236	17.00	.669	0.3	.012	29.80	1.173	COROMANT
31.75	1.250	S20	830A-E06D3175H7S20	20.00	.787	31.85	1.254	13.22	.520	6.00	.236	17.00	.669	0.3	.012	31.60	1.244	COROMANT

TCHA H7



P K

DC	DC"	LU	LU"	CZC_{MS}	Ordering code	$DCON_{MS}$	$DCON_{MS}$"	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
						Dimensions, mm, inch														
10.00	.394	45.00	1.772	S12	830B-E06D1000H7S12	12.00	.472	71.35	2.809	9.99	.393	6.00	.236	60.00	2.362	0.3	.012	9.80	.386	COROMANT
11.00	.433	45.00	1.772	S12	830B-E06D1100H7S12	12.00	.472	71.35	2.809	10.00	.394	6.00	.236	60.00	2.362	0.3	.012	10.80	.425	COROMANT
12.00	.472	45.00	1.772	S12	830B-E06D1200H7S12	12.00	.472	71.35	2.809	9.99	.393	6.00	.236	60.00	2.362	0.3	.012	11.80	.465	COROMANT
13.00	.512	45.00	1.772	S12	830B-E06D1300H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	12.80	.504	COROMANT
14.00	.551	45.00	1.772	S12	830B-E06D1400H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	13.80	.543	COROMANT
15.00	.591	45.00	1.772	S12	830B-E06D1500H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	14.80	.583	COROMANT
16.00	.630	45.00	1.772	S12	830B-E06D1600H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	15.80	.622	COROMANT
17.00	.669	45.00	1.772	S12	830B-E06D1700H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	16.80	.661	COROMANT
18.00	.709	45.00	1.772	S12	830B-E06D1800H7S12	12.00	.472	71.35	2.809	10.01	.394	6.00	.236	60.00	2.362	0.3	.012	17.80	.701	COROMANT

Full diameters H7 hole tolerance

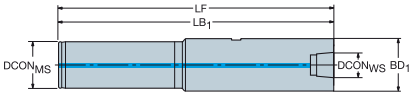
Centesimal diameters produce a tighter hole tolerance due to manufacturing of +0.004mm

D18 E9 E28

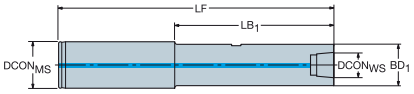
Cylindrical shank to CoroReamer™ 830 adapter

Internal coolant supply

DSGN 1



2



						Dimensions, mm, inch								BAR PSI	NM	KG	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2				RPMX
20.0	S12	1	1	2	**830-S12A20035F**	20.0	12.0	50	85.0	35.0	85.0	17.8	20.0	100	7.0	0.23	50000
						.787	.472	1.969	3.346	1.378	3.346	.701	.787	1450			
	S12	1	1	2	**830-S12A20069F**	20.0	12.0	50	118.5	68.5	118.5	17.8	20.0	100	7.0	0.29	50000
						.787	.472	1.969	4.665	2.697	4.665	.701	.787	1450			
	S12	1	1	2	**830-S12A20130F**	20.0	12.0	50	179.5	129.5	179.5	17.8	20.0	100	7.0	0.40	50000
						.787	.472	1.969	7.067	5.098	7.067	.701	.787	1450			
	S14	1	1	1	**830-S14A20070F**	20.0	14.0	50	119.5	119.5		20.5		100	7.0	0.31	50000
						.787	.551	1.969	4.705	4.705		.807		1450			
	S14	1	1	1	**830-S14A20131F**	20.0	14.0	50	180.5	180.5		20.5		100	7.0	0.44	50000
						.787	.551	1.969	7.106	7.106		.807		1450			
25.0	S16	1	1	2	**830-S16A25090F**	25.0	16.0	60	150.0	90.0	150.0	23.2	25.0	100	12.0	0.55	50000
						.984	.630	2.362	5.906	3.543	5.906	.913	.984	1450			
	S16	1	1	2	**830-S16A25151F**	25.0	16.0	60	211.0	151.0	211.0	23.2	25.0	100	12.0	0.70	50000
						.984	.630	2.362	8.307	5.945	8.307	.913	.984	1450			
	S20	1	1	1	**830-S20A25089F**	25.0	20.0	60	149.0	149.0		29.3		100	12.0	0.64	50000
						.984	.787	2.362	5.866	5.866		1.154		1450			
	S20	1	1	1	**830-S20A25150F**	25.0	20.0	60	210.0	210.0		29.3		100	12.0	1.03	50000
						.984	.787	2.362	8.268	8.268		1.154		1450			

Accessories

For reamer diameter				
mm	inch	Key for head (mm)	Retention knob with cutting fluid through	Retention knob without cutting fluid through
10-19.05	.750-709	3021 010-040 (4.0)	5519 107-01	5519 106-01
20-23	.787-906	3021 010-040 (4.0)	–	5519 106-01
24-31.75	.945-1.250	3021 010-050 (5.0)	–	5519 106-02

Accessories, must be ordered separately.

ISO 13399 E9

CNSC CXSC E28

Cutting data for CoroReamer™ 435

Metric values

CoroReamer™ 435 -XF					Ø mm					
ISO	MC No.	Material	N/mm²	Application data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P		**Unalloyed steel**								
				v_c m/min				30		
	P1.1.Z.AN	C=0.10-0.25%	428	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P1..Z.AN	Hardened and tempered	639	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P1.2.Z.AN	C=0.25-0.55%	639	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P1.2.Z.HT		708	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P1.3.Z.AN	C=0.55-0.80%	639	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P1.3.Z.HT		991	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
		Low alloy steel								
				v_c m/min				30		
	P2.1.Z.AN	Non-hardened	591	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P2.2.Z.AN	Annealed	811	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P2.3.Z.AN		867	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				15		
	P2.5.Z.HT	Hardened and tempered	961	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
		Steel castings								
				v_c m/min				30		
	P1.5.C.UT	Unalloyed	503	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P2.6.C.UT	Low alloyed (alloying elements ≤ 5%)	674	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
		High alloy steel								
				v_c m/min				20		
	P3.0.Z.AN	Annealed	674	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				15		
	P3.0.Z.HT		1282	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	P3.1.Z.AN	Annealed HSS	839	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				15		
	P5.0.Z.HT		1114	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	P5.0.Z.PH		503	f_n mm/rev	0.15	0.18	0.20	0.20	0.30	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30

Cutting data for CoroReamer™ 435

Inch values

CoroReamer™ 435 -XF					Ø inch					
ISO	MC No.	Material	N/mm²	Application data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
P		**Unalloyed steel**								
				v_c ft/min				98		
	P1.1.Z.AN	C=0.10-0.25%	428	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				98		
	P.1..Z.AN	Hardened and tempered	639	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				98		
	P1.2.Z.AN	C=0.25-0.55%	639	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				98		
	P1.2.Z.HT		708	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				98		
	P1.3.Z.AN	C=0.55-0.80%	639	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				66		
	P1.3.Z.HT		991	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
		Low alloy steel								
				v_c ft/min				98		
	P2.1.Z.AN	Non-hardened	591	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				66		
	P2.2.Z.AN	Annealed	811	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				66		
	P2.3.Z.AN		867	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				49		
	P2.5.Z.HT	Hardened and tempered	961	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
		Steel castings								
				v_c ft/min				98		
	P1.5.C.UT	Unalloyed	503	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				66		
	P2.6.C.UT	Low alloyed (alloying elements ≤ 5%)	674	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
		High alloy steel								
				v_c ft/min				66		
	P3.0.Z.AN	Annealed	674	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				49		
	P3.0.Z.HT		1282	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				66		
	P3.1.Z.AN	Annealed HSS	839	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				49		
	P5.0.Z.HT		1114	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min				98		
	P5.0.Z.PH		503	f_n inch/rev	.006	.007	.008	.008	.012	.012
				Stock	.004	.004	.008	.008	.008	.012

Cutting data for CoroReamer™ 435

Metric values

CoroReamer™ 435 -XF					Ø mm					
ISO	MC No.	Material	N/mm²	Application data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
K		**Malleable cast iron**								
				v_c m/min				30		
	K1.1.C.NS	Ferritic Pearlitic	428	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
		Gray cast iron								
				v_c m/min				30		
	K2.1.C.UT	Low tensile strength	639	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	K2.2.C.UT	High tensile strength	639	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				30		
	K2.3.C.UT		708	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
		Nodular cast iron								
				v_c m/min				20		
	K3.1.C.UT	Ferritic	639	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	K3.2.C.UT	Pearlitic	991	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	K3.3.C.UT	Pearlitic	503	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
				v_c m/min				20		
	K3.5.C.UT		591	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
N		**Aluminum alloys**								
				v_c m/min				50		
	N1.2.Z.UT	Wrought or wrought and coldworked, non-aging	400	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N1.2.Z.AG	Wrought or wrought and aged	650	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N1.3.C.UT	Cast, non aging	600	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N1.3.C.AG	Cast or cast and aged	700	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				30		
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	700	f_n mm/rev	0.15	0.15	0.15	0.20	0.20	0.30
				Stock	0.10	0.10	0.20	0.20	0.20	0.30
		Copper based alloys								
				v_c m/min				50		
	N3.3.U.UT	Free cutting copper based alloys (Pb>1%)	550	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				50		
	N3.1.U.UT	Non-leaded copper alloys (incl. electrolytic copper)	1350	f_n mm/rev	0.15	0.18	0.20	0.20	0.25	0.30
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
O		**Plastics**								
				v_c m/min				40		
				f_n mm/rev	0.15	0.15	0.15	0.35	0.35	0.40
				Stock	0.15	0.15	0.20	0.20	0.20	0.30

US

Cutting data for CoroReamer™ 435

Inch values

CoroReamer™ 435 -XF					Ø inch					
ISO	MC No.	Material	N/mm²	Application data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
K		**Malleable cast iron**								
				v_c ft/min	98					
	K1.1.C.NS	Ferritic Pearlitic	428	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.008	.008	.008	.012
		Gray cast iron								
				v_c ft/min	98					
	K2.1.C.UT	Low tensile strength	639	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004		.008	.008	.008	.012
				v_c ft/min	98					
	K2.2.C.UT	High tensile strength	639	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min	98					
	K2.3.C.UT		708	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.008	.008	.008	.012
		Nodular cast iron								
				v_c ft/min	66					
	K3.1.C.UT	Ferritic	639	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min	66					
	K3.2.C.UT	Pearlitic	991	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min	66					
	K3.3.C.UT	Pearlitic	503	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.008	.008	.008	.012
				v_c ft/min	66					
	K3.5.C.UT		591	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.008	.008	.008	.012
N		**Aluminum alloys**								
				v_c ft/min	164					
	N1.2.Z.UT	Wrought or wrought and coldworked, non-aging	400	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min	164					
	N1.2.Z.AG	Wrought or wrought and aged	650	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min	164					
	N1.3.C.UT	Cast, non aging	600	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min	164					
	N1.3.C.AG	Cast or cast and aged	700	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min	98					
	N1.4.C.NS	AlSi cast alloys, Si ≥ 13%	700	f_n inch/rev	.006	.006	.006	.008	.008	.012
				Stock	.004	.004	.008	.008	.008	.012
		Copper based alloys								
				v_c ft/min	164					
	N3.3.U.UT	Free cutting copper based alloys (Pb>1%)	550	f_n inch/rev	.006	.007	.008	.008	.010	.012
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min	164					
	N3.1.U.UT	Non-leaded copper alloys (incl. electrolytic copper)	1350	f_n inch/rev	.006	.007	.008	.008	.010	.012
					.004	.004	.006	.008	.008	.012
				Stock						
O		**Plastics**								
				v_c ft/min	131					
				f_n inch/rev	.006	.006	.006	.014	.014	.016
				Stock	.006	.006	.008	.008	.008	.012

Cutting data for Reamer 830

Metric values

ISO	CMC	Material	Hardness Brinell HB	Grade	Cutting speed V_c m/min	Feed f_z inch/rev	Radial depth of cut a_p mm
P		**Unalloyed steel**					
	01.1	Non-hardened 0.10-0.25% C	90-200	P10R	150-200	0.15-0.25	0.1-0.3
	01.2	Non-hardened 0.25-0.55% C	125-225		150-200	0.15-0.25	
	01.3	Non-hardened 0.55-0.80% C	150-225		140-180	0.15-0.25	
	01.4	High carbon and carbon tool steel	180-225		140-180	0.15-0.25	
		Low alloy steel					
	02.1	Non-hardened	150-260	P10R	110-180	0.15-0.25	0.1-0.3
	02.2	Hardened and tempered	220-400		70-130	0.10-0.20	
		Steel castings					
	06.1	Unalloyed	90-225	P10R	140-180	0.15-0.25	0.1-0.3
	06.2	Low alloyed	150-250		100-150	0.15-0.25	
K		**Malleable cast iron**					
	07.2	Pearlitic	150-270	P10R	150-200	0.15-0.25	0.1-0.3
		Nodular cast iron					
	09.2	Pearlitic	200-300	P10R	110-190	0.15-0.25	0.1-0.3

Inch values

ISO	CMC	Material	Hardness Brinell HB	Grade	Cutting speed V_c ft/min	Feed f_z inch/insert	Radial depth of cut a_p inch
P		**Unalloyed steel**					
	01.1	Non-hardened 0.10-0.25% C	90-200	P10R	490-650	.006-.010	.004-.012
	01.2	Non-hardened 0.25-0.55% C	125-225		490-650	.006-.010	
	01.3	Non-hardened 0.55-0.80% C	150-225		460-590	.006-.010	
	01.4	High carbon and carbon tool steel	180-225		460-590	.006-.010	
		Low alloy steel					
	02.1	Non-hardened	150-260	P10R	360-590	.006-.010	.004-.012
	02.2	Hardened and tempered	220-400		230-425	.004-.008	
		Steel castings					
	06.1	Unalloyed	90-225	P10R	460-590	.006-.010	.004-.012
	06.2	Low alloyed	150-250		330-490	.006-.010	
K		**Malleable cast iron**					
	07.2	Pearlitic	150-270	P10R	490-650	.006-.010	.004-.012
		Nodular cast iron					
	09.2	Pearlitic	200-300	P10R	360-620	.006-.010	.004-.012

Cutting data for CoroReamer™ 835

Metric values

CoroReamer™ 835 - PF					Ø mm					
ISO	MC No.	Material	N/mm²	Application data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P		**Unalloyed steel**								
				v_c m/min				180		
	P1.1.Z.AN	C=0.10-0.25%	428	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				180		
	P.1..Z.AN	Hardened and tempered	639	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				180		
	P1.2.Z.AN	C=0.25-0.55%	639	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				180		
	P1.2.Z.HT		708	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				180		
	P1.3.Z.AN	C=0.55-0.80%	639	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				140		
	P1.3.Z.HT		991	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
		Low alloy steel								
				v_c m/min				180		
	P2.1.Z.AN	Non-hardened	591	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				180		
	P2.2.Z.AN	Annealed	811	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				140		
	P2.3.Z.AN		867	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				140		
	P2.5.Z.HT	Hardened and tempered	961	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
		Steel castings								
				v_c m/min				180		
	P1.5.C.UT	Unalloyed	503	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				180		
	P2.6.C.UT	Low alloyed (alloying elements ≤ 5%)	674	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
		High alloy steel								
				v_c m/min				180		
	P3.0.Z.AN	Annealed	674	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				140		
	P3.0.Z.HT		1282	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				180		
	P3.1.Z.AN	Annealed HSS	839	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20
				v_c m/min				140		
	P5.0.Z.HT		1114	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20

Cutting data for CoroReamer™ 835

Inch values

CoroReamer™ 835 - PF					Ø inch					
ISO	MC No.	Material	N/mm²	Application data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
P		**Unalloyed steel**								
				v_c ft/min				591		
	P1.1.Z.AN	C=0.10-0.25%	428	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				591		
	P1..Z.AN	Hardened and tempered	639	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				591		
	P1.2.Z.AN	C=0.25-0.55%	639	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				591		
	P1.2.Z.HT		708	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				591		
	P1.3.Z.AN	C=0.55-0.80%	639	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				459		
	P1.3.Z.HT		991	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
		Low alloy steel								
				v_c ft/min				591		
	P2.1.Z.AN	Non-hardened	591	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				591		
	P2.2.Z.AN	Annealed	811	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				459		
	P2.3.Z.AN		867	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				459		
	P2.5.Z.HT	Hardened and tempered	961	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
		Steel castings								
				v_c ft/min				591		
	P1.5.C.UT	Unalloyed	503	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				591		
	P2.6.C.UT	Low alloyed (alloying elements ≤ 5%)	674	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
		High alloy steel								
				v_c ft/min				591		
	P3.0.Z.AN	Annealed	674	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				459		
	P3.0.Z.HT		1282	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				591		
	P3.1.Z.AN	Annealed HSS	839	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008
				v_c ft/min				459		
	P5.0.Z.HT		1114	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008

Cutting data for CoroReamer™ 835

Metric values

CoroReamer™ 835 - PF					Ø mm					
ISO	MC No.	Material	N/mm²	Application data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
K		**Malleable cast iron**								
				v_c m/min				90		
	K1.1.C.NS	Ferritic Pearlitic	428	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
		Gray cast iron								
				v_c m/min				110		
	K2.1.C.UT	Low tensile strength	639	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				150		
	K2.2.C.UT	High tensile strength	639	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				90		
	K2.3.C.UT		708	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
		Nodular cast iron								
				v_c m/min				90		
	K3.1.C.UT	Ferritic	639	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				90		
	K3.2.C.UT	Pearlitic	991	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				90		
	K3.3.C.UT	Pearlitic	503	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30
				v_c m/min				90		
	K3.5.C.UT		591	f_n mm/rev	0.30	0.40	0.60	1.00	1.30	1.80
				Stock	0.10	0.10	0.15	0.20	0.20	0.30

Inch values

CoroReamer™ 835 - PF					Ø inch					
ISO	MC No.	Material	N/mm²	Application data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
K		**Malleable cast iron**								
				v_c ft/min				295		
	K1.1.C.NS	Ferritic Pearlitic	428	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012
		Gray cast iron								
				v_c ft/min				361		
	K2.1.C.UT	Low tensile strength	639	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min				492		
	K2.2.C.UT	High tensile strength	639	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min				295		
	K2.3.C.UT		708	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012
		Nodular cast iron								
				v_c ft/min				295		
	K3.1.C.UT	Ferritic	639	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min				295		
	K3.2.C.UT	Pearlitic	991	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min				295		
	K3.3.C.UT	Pearlitic	503	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012
				v_c ft/min				295		
	K3.5.C.UT		591	f_n inch/rev	.012	.016	.024	.039	.051	.071
				Stock	.004	.004	.006	.008	.008	.012

Cutting data for CoroReamer™ 835

Metric values

CoroReamer™ 835 -MF					Ø mm					
ISO	MC No.	Material	N/mm²	Application data	< 5.00	5.00 - 6.20	6.20 - 8.00	8.00 - 12.00	12.00 - 16.00	16.00 - 20.00
P		**Unalloyed steel**								
				v_c m/min				30		
	P5.0.Z.PH		503	f_n mm/rev	0.10	0.15	0.30	0.40	0.50	0.60
				Stock	0.05	0.10	0.10	0.10	0.20	0.20
M		**Stainless steel**								
				v_c m/min				40		
	M1.0.Z.AQ	Austenitic	811	f_n mm/rev	0.10	0.15	0.30	0.40	0.50	0.60
				Stock	0.05	0.10	0.10	0.10	0.20	0.20
				v_c m/min				40		
	M2.0.Z.AQ	Super austenitic	961	f_n mm/rev	0.10	0.15	0.30	0.40	0.50	0.60
				Stock	0.05	0.10	0.10	0.10	0.20	0.20
				v_c m/min				30		
	M3.1.Z.AQ		674	f_n mm/rev	0.10	0.15	0.30	0.40	0.50	0.60
				Stock	0.05	0.10	0.10	0.10	0.20	0.20
				v_c m/min				30		
	M3.2.Z.AQ	Duplex (austenitic/ferritic)	674	f_n mm/rev	0.10	0.15	0.30	0.40	0.50	0.60
				Stock	0.05	0.10	0.10	0.10	0.20	0.20
				v_c m/min				40		
	M1.0.C.UT		674	f_n mm/rev	0.10	0.15	0.30	0.40	0.50	0.60
				Stock	0.05	0.10	0.10	0.10	0.20	0.20
				v_c m/min				40		
	M2.0.C.AQ			f_n mm/rev	0.10	0.15	0.30	0.40	0.50	0.60
				Stock	0.05	0.10	0.10	0.10	0.20	0.20
				v_c m/min				30		
	M3.1.C.AQ		1114	f_n mm/rev	0.20	0.30	0.50	0.80	1.10	1.50
				Stock	0.10	0.10	0.10	0.15	0.20	0.20

Inch values

CoroReamer™ 835 -MF					Ø mm					
ISO	MC No.	Material	N/mm²	Application data	< .197	.197 - .244	.244 - .315	.315 - .472	.472 - .630	.630 - .787
P		**Unalloyed steel**								
				v_c ft/min				98		
	P5.0.Z.PH		503	f_n inch/rev	.004	.006	.012	.016	.020	.024
				Stock	.002	.004	.004	.004	.008	.008
M		**Stainless steel**								
				v_c ft/min				131		
	M1.0.Z.AQ	Austenitic	811	f_n inch/rev	.004	.006	.012	.016	.020	.024
				Stock	.002	.004	.004	.004	.008	.008
				v_c ft/min				131		
	M2.0.Z.AQ	Super austenitic	961	f_n inch/rev	.004	.006	.012	.016	.020	.024
				Stock	.002	.004	.004	.004	.008	.008
				v_c ft/min				98		
	M3.1.Z.AQ		674	f_n inch/rev	.004	.006	.012	.016	.020	.024
				Stock	.002	.004	.004	.004	.008	.008
				v_c ft/min				98		
	M3.2.Z.AQ	Duplex (austenitic/ferritic)	674	f_n inch/rev	.004	.006	.012	.016	.020	.024
				Stock	.002	.004	.004	.004	.008	.008
				v_c ft/min				131		
	M1.0.C.UT		674	f_n inch/rev	.004	.006	.012	.016	.020	.024
				Stock	.002	.004	.004	.004	.008	.008
				v_c ft/min				131		
	M2.0.C.AQ			f_n inch/rev	.004	.006	.012	.016	.020	.024
				Stock	.002	.004	.004	.004	.008	.008
				v_c ft/min				98		
	M3.1.C.AQ		1114	f_n inch/rev	.008	.012	.020	.031	.043	.059
				Stock	.004	.004	.004	.006	.008	.008

General Information

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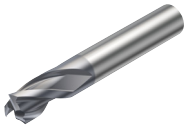
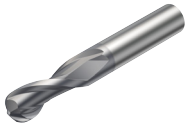
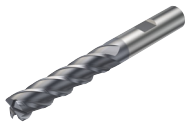
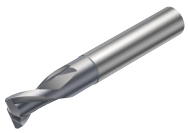
Customized solid milling tools

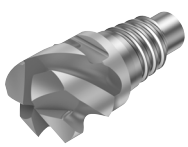
	CoroMill® Plura - Versatile			CoroMill® Plura - Optimized	
	Heavy roughing	**Medium roughing**	**Ball nose end mill for profiling**	**Heavy duty milling**	**High-feed side milling**
C					
D_c mm	2-25.4	2-25.4	2-25.4	2-25.4	4-25.4
ZEFP	2/3/4	3	2/3/4	4/5	4
FHA	30/35	45	0/20/30/40/45/50/60	38/42	37
Shank	HA/HB	HA/HB	HA/HB/ILO	HA/HB	HA/HB
RE	0.4xDC	0.4xDC	N/A	0.4xDC	0.4xDC
CHW	0.2xDC	0.2xDC	N/A	0.15xDC	0.15xDC
KCH	30-60	30-60	N/A	40-50	40-50
APMX	5xDC	5xDC	-	6xDC	5xDC
Grade	H10F/1620/1630	H10F/1620/1630	H10F/1630/N20C	H10F/1720/1730/1740	1630/1720/1730/1740

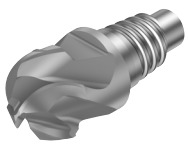
	CoroMill® Plura - Optimized				
	High Feed Side Milling ISO S	**Stable multi-operations milling**	**Hard part milling**	**Large chip removal**	**Roughing with chip breaker**
C					
D_c mm	4-38.1	2-32	2-20	2-25.4	5-32
ZEFP	4/5/6	3-8	2-8	2/3/4	3/8
FHA	42	30/50	0/20/30/40/45/50/55/60	25/30/45	20/30/40/45
Shank	HA/HB/ILO	HA/HB/ILO	HA/HB/ILO	HA/HB/RS	HA/HB/ILO
RE	0.4xDC	0.25XDC	0.495xDC	0.4xDC	0.495xDC
CHW	0.15xDC	0.2xDC	0.2xDC	0.2xDC	0.2xDC
KCH	40-50	20-60	20-60	15-60	20-60
APMX	4xDC	4xDC	5xDC	5xDC	5xDC
Grade	1745/1710	H10F/1610/1620/1630/1640/1725	H10F/1610/1620/1630/1640	H10F/1630/N20C	H10F/1610/1620/1630/1640

Customized solid milling tools

	CoroMill® Plura - Optimized		
	Finishing	**Ball nose end mill for profiling**	**Edging applications**
C			
D_c mm	2-32	2-25.4	4.0 - 12.7
ZEFP	2/10	2-4	Geometry-dependent
FHA	0/20/30/40/45/50/55/60	0/30/50/60	Geometry-dependent
Shank	HA/HB/ILO	HA/HB	SS
RE	0.495xDC	N/A	N/A
CHW	0.2xDC	N/A	N/A
KCH	20-60	N/A	N/A
APMX	5xDC	5xDC	5xDC
Grade	H10F/1610/1620/1630/ 1640	H10F/1620/1630	H10F/O10M/O10A/ O12M

Customized solid milling tools

	CoroMill® 316				
	Head for heavy duty milling	**Head for stable multi-operations milling**	**Head for high feed face milling**	**Head for large chip removal**	**Head for roughing with chip breaker**
C					
D_c mm	0,6xDC-DC	0,6xDC-DC	Nominal DC	0,6xDC-DC	0,6xDC-DC
ZEFP	4/5	3/4/5	3/4	3	4/5/6/8
FHA	38/42	50	50	45	40/45
Shank	EH	EH	EH	EH	EH
RE	0.4xDC	0.4xDC	0.4xDC	0.4xDC	0.4xDC
CHW	0.2xDC	0.2xDC	0.2xDC	0.2xDC	0.2xDC
KCH	40-50	40-50	40-50	40-50	40-50
APMX	0.55-1.2xDC	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC
Grade	H10F/1630	H10F/1030/1620/1730	H10F/1030/1620/1730	H10F/1030/1620/1730	H10F/1030/1620/1730

	CoroMill® 316			
	Head for finishing	**Head for chamfer milling**	Head for profiling milling	High feed side milling
C				
D_c mm	0,6xDC-DC	Nominal DC	0,6xDC-DC	0,6xDC-DC
ZEFP	6/8/10/12	4/6/8	2/4	6
FHA	50	0	40	42
Shank	EH	EH	EH	EH
RE	0.4xDC	0.4xDC	N/A	0.4xDC
CHW	0.2xDC	0.2xDC	N/A	0.2xDC
KCH	40-50	40-50	N/A	40-50
APMX	0.55-1-1.2-1.5XDC	0.55-1-1.2-1.5XDC	0,55-1-1,2-1,5XDC	0.5-1.5xDC
Grade	H10F/1030/1620/1730	H10F/1030/1620/1730	H10F/1030/1620/1730	1745

Customized solid carbide drills

C

	CoroDrill® 860-PM	CoroDrill® 860-MM	CoroDrill® 860-NM	CoroDrill® 860-SM	CoroDrill® 861-GP	CoroDrill® 861 - GM	CoroDrill® 862-GM
Application area	Optimized solution for steel	Optimized solution for stainless steel	Optimized solution for aluminum	Optimized solution for HRSA	Pilot drill	Drills for deep holes in multi-materials	Optimized solution small diameter
ISO application area	P	M	N	S	P M K N	P M K N	P M K N S
Drill diameter	3.0 - 20.00	3.0 - 20.00	3.0 - 20.00	3.0 - 16.00	3.0 - 20.00	3.0 - 20.00	1.801 - 2.999
Drill depth	<8 x Ø	<8 x Ø	<8 x Ø	<8 x Ø	<5 x Ø	<30 x Ø	<12 x Ø
Tolerance options	NO	YES	YES	YES	NO	NO	YES
Shank type	HA, HE	HA, HE	HA, HE	HA, HE	HA	HA	HA
Coolant	Internal & External	Internal	Internal & External	Internal & External	Internal	Internal	Internal
Drill type	1, 2 & 3	1 & 2	1, 2 & 4	1, 2 & 3	1 & 2	1	1
Coating options	NO	NO	YES	NO	NO	NO	NO
Corner chamfer	NO	NO	NO	NO	NO	NO	NO
Corner radius	NO	NO	NO	NO	NO	NO	NO
Point angle options	NO	NO	NO	NO	NO	NO	NO
Margin	Single	Single	Single	Single	Single	Double offset	Single
Edge rounding options	NO	NO	NO	NO	NO	NO	NO
Flute polishing	NO	NO	NO	NO	NO	Default	NO

Customized solid carbide drills

CoroDrill® 860-GM	CoroDrill® 400	CoroDrill® 430	CoroDrill® 865	CoroDrill® 460-XM	Rock drill	CoroDrill® 452	CoroDrill® 863
Optimized solution multi-materials	Straight flute for ISO K	3-flute for ISO K	Crankshaft oil holes ISO K & ISO P	Versatile solution multi-materials	Optimized Solution ISO-H	Hand drilling	Composites
P M K N S H	K	K	P K	P M K N S H	H	N S O	M N S O
3.0 - 20.00	3.0 - 25.00	3.0 - 25.00	3.0 - 10.00	3.0 - 25.00	7.0 - 20.00	2.0 - 12.7	4.0 - 11.2
<8 x Ø	<10 x Ø	<10 x Ø	<25 x Ø	<8 x Ø	<2 x Ø	<15 x Ø	<15 x Ø
YES	YES	YES	NO	YES	NO	NO	NO
HA, HE	HA & MQL	HA & MQL	HA MQL, Extended length MQL	HA, HE, SS, RR, MQL	HA	SS	SS, HA, RR, RS, THA
Internal & External	Internal & External	Internal & External	Internal	Internal & External	External	External	Internal and external
1, 2, 3, 4 & 5	1, 2, 3, 4, 5 & 6	1, 2, 4, 5 & 6	1	1, 2, 3, 4 & 5	1	1,4,6	1,4
NO	Default based on ISO K grade	Default based on ISO K grade	NO	TiAlNTop, TiAlN, TiN	NO	NO	1220, N20C
YES	YES	YES	NO	YES	YES	NO	NO
YES	YES	YES	NO	YES	YES	NO	NO
118° - 150°	90° - 180°	110° - 180°	NO	90° - 180°	127°	NO	NO
Single	Double	Single	Double offset	Single or double	Single	Single or double	Single
NO	YES	YES	NO	NO	YES	NO	NO
NO	YES	YES	Default	NO	YES	NO	NO

Customized tapping tools

C

	CoroTap™ 100	CoroTap™ 200	CoroTap™ 300	CoroTap™ 400
Product design	K	P M N S	P M N S	P
Substrate	HSS-E-PM/Solid Carbide	HSSE/HSS-E-PM	HSSE/HSS-E-PM	HSS-E-PM
Thread form	M,MF,UNC,UNF,UNJC,UNJF	M,MF,UNC,UNF,UN,UNEF,UNJC, UNJF,G	M,MF,UNC,UNF,UN,UNEF,UNJC, UNJF,G	M,MF,UNC,UNF,UN,UNEF,UNJC, UNJF,G
Thread size	M8-M16 1/4-5/8	M6-M16 1/4-5/8	M6-M16 1/4-5/8	M2-M16 4-40-5/8
BSG	DIN371,DIN376,DIN/ANSI	DIN371,DIN376,DIN/ ANSI,ISO,ANSI,JIS	DIN371,DIN376,DIN/ ANSI,ISO,ANSI,JIS	DIN2174,ISO,ANSI,DIN-ANSI,JIS
FHA			15,40,45	
Number of flutes	4/5	3/4	3/4	Depending on thread diameter
Direction of cut	Right or Left	Right or Left	Right or Left	Right or Left
THCHT	4H,6H,6G,4HX,6HX,2B,2BX,3B,3 BX	4H,6H,6G,4HX,6HX,6GX,7H,7G,7 GX,2B,2BX,3B,3BX	4H,6H,6G,4HX,6HX,6GX,7H,7G,7 GX	4H,4HX,6H,6HX,6G,6GX,7G,7GX, 7H,2B,2BX,3B,3BX
Oversize/Undersize	+/- 0.1 mm	+/- 0.1 mm	+/- 0.1 mm	+/- 0.1 mm
Chamfer type	C,E,F	E,C,B,A	E,C,B,A	C,E,F,A,B
LF	Depending on tap design	Depending on tap design	Depending on tap design	Depending on tap design
THL	Depending on tap design	Depending on tap design	Depending on tap design	Depending on tap design
LU	Depending on tap design	Depending on tap design	Depending on tap design	Depending on tap design
Coolant	None, Axial, Radial	None, Axial, Radial	None, Axial, Radial	None, Axial, Radial
Grade	D210,D215,E210	Cooltop,TIN,TICN,	Cooltop,TIN,TICN,	F125,F150,F115
Additional features	Backchamfer default	Back chamfer, Interrupted threads	Back chamfer, Interrupted threads	

Customized solid carbide reamers

	CoroReamer® 435	CoroReamer™ 835 - PF	CoroReamer™ 835
Application area	Versatile solutions	Optimized Solution ISO P	Optimized Solution for M, N, H, & titanium
ISO application area	P N K	P	M N S H
Drill diameter, mm	2.80 - 20.20	2.80 - 20.20	3.701 - 20.20
Hole Type	Through & Blind holes	Through & Blind holes	Through & Blind holes
Hole tolerance options	YES	YES	YES
Coolant	Internal	Internal	Internal
Coating options	NO	NO	NO

A new standard is developed

ISO 13399 is an international standard that strives to simplify the exchange of data for cutting tools. You will notice a slight difference through the new parameters and descriptions of each tool.

For the first time ever, there is a standardized way of describing product data regarding cutting tools. When all tools in the industry share the same parameters and definitions, communicating tool information between software systems becomes very straightforward.

How this benefits you

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

Short name	Preferred Name
ADJLN	Minimum adjustment limit
ADJLX	Maximum adjustment limit
ADJRG	Adjustment range
ALP	Axial clearance angle
AN	Clearance angle major
ANN	Minor clearance angle
APMX	Depth of cut maximum
APMX_EFW	Depth of cut maximum – End feed
APMX_FFW	Depth of cut maximum – Side feed
AZ	Maximum plunge depth
B	Shank width
BAWS	Workpiece side body angle
BAMS	Body angle machine side
BBD	Balanced by design
BBR	Balanced by rotational test
BCH	Corner chamfer length
BD	Body diameter
BHTA	Body half taper angle
BN	Face land width
BS	Wiper edge length
BSG	Basic standard group
BSR	Wiper edge radius
CDX	Cutting depth maximum
CEMR	Cutting edge major radius
CF	Spot chamfer
CHBA	Chamfer body angle
CHBL	Chamfer body length
CHW	Corner chamfer width
CICT	Cutting item count
$CICT_E$	Cutting item count – End position
$CICT_P$	Cutting item count – Peripheral position
$CICT_S$	Cutting item count – Side position
$CICT_T$	Cutting item count – Total
CND	Coolant entry diameter
CNSC	Coolant entry style code
CNT	Coolant entry thread size
COATING	Coating
CP	Max coolant pressure
CRKS	Connection retention knob thread size
CRNT	Coolant radial entry thread size
CTPT	Operation type
CUTDIA	Work piece parting diameter maximum
CW	Cutting width
CWN	Minimum cutting width
CWTOLL	Cutting width lower tolerance
CWTOLU	Cutting width upper tolerance
CWX	Cutting width maximum
CXSC	Coolant exit style code
CZC	Connection size code
CZC_{MS}	Connection size code machine side
CZC_{WS}	Connection size code workpiece side
D1	Fixing hole diameter
DAH	Diameter access hole
DAXIN	Axial groove inside diameter minimum

DAXN	Minimum axial-groove outside diameter
DAXX	Maximum axial groove outside diameter
DBC	Diameter bolt circle
DC	Cutting diameter
DCB	Connection bore diameter
DCBN	Connection bore diameter minimum
DCBX	Connection bore diameter maximum
DCF	Cutting diameter face contact
DCIN	Cutting diameter internal
DCN	Minimum cutting diameter
DCON	Connection diameter
$DCON_{MS}$	Connection diameter machine side
$DCON_{WS}$	Connection diameter work piece side
DCPS	Data chip provision size
$DCSF_{MS}$	Contact surface diameter machine side
$DCSF_{WS}$	Workpiece side contact surface diameter
DCX	Maximum cutting diameter
DHUB	Hub diameter
DIX	Maximum tool changer interference diameter
DMIN	Minimum bore diameter
DMM	Shank diameter
DN	Neck diameter
DRVCT	Drive count
DSGN	Design
EPSR	Insert included angle
FHA	Flute helix angle
FLGT	Flange thickness
FTDZ	For thread diameter size
H	Shank height
HA	Thread height theoretical
HB	Thread height difference
HBH	Head bottom offset height
HC	Actual thread height
HF	Functional height
HRY	Lowest point from reference plain
HTB	Body height
HTH	Height
IC	Inscribed circle diameter
INSL	Insert length
INSUC	Insert usage code
IZC	Insert size code
KAPR	Tool cutting edge angle
KAPR_EFW	Tool cutting edge angle – End feed
KCH	Corner chamfer
KRINS	Major cutting-edge angle
KWW	Keyway width
L	Cutting edge length
LAMS	Inclination angle
LB	Body length
LCF	Chip flute length
LCOX	Cut off length maximum
LE	Cutting edge effective length
LF	Functional length
LFN	Minimum functional length
LH	Head length
LPR	Protruding length
LS	Shank length
LSC	Clamping length
LSCN	Minimum clamping length
LSCS	Distance to clamping start
LSCX	Maximum clamping length
LSD	Dead shank length
LU	Usable length (max. recommended)
LU_BFW	Usable length – Back facing
LUX	Usable maximum length
MHD	Mounting hole distance
MIID	Master insert identification
$MIID_E$	Master insert identification – End position
$MIID_S$	Master insert identification – Side position
$MIID_C$	Master insert identification – Central position
$MIID_P$	Master insert identification – Peripheral position
$MIID_I$	Master insert identification – Intermediate position
MMCC	Code for preset torque
MMCX	Max cutting torque
NOF	Flute count
NT	Tooth count
OAH	Overall height
OAL	Overall length
OAW	Overall width

OH	Overhang recommended
OHN	Minimum overhang
OHX	Maximum overhang
ORDCODE	Order code
PCL	Peripheral cylindrical length
PDX	Profile distance ex
PDY	Profile distance ey
PHD	Premachined hole diameter
PHDX	Maximum premachined hole diameter
PL	Point length
PNA	Profile included angle
PRFRAD	Profile radius
PRSPC	Profile specification
PSIR	Tool lead angle
PSIRL	Major left hand cutting edge angle
PSIRR	Major right hand cutting edge angle
PSW	Pre-machined slot width
RADH	Radial body height
RADW	Radial body width
RAR	Right-hand relief angle
RE	Corner radius
REL	Corner radius left
RER	Corner radius right
RETOLL	Corner radius lower tolerance
RETOLU	Corner radius upper tolerance
RGL	regrind length
RMPX	Maximum ramping angle
RPMX	Rotational speed maximum
S	Insert thickness
SDL	Step diameter length
SIG	Point angle
SPTL	Split line
SSC	Insert seat size code
SSC_E	Insert seat size code – End position
SSC_P	Insert seat size code – Peripheral position
SSC_S	Insert seat size code – Side position
STA	Step included angle
SUBSTRATE	Substrate
TCDC	Tolerance class cutting diameter
TCDCON	Connection diameter tolerance
TCDMM	Shank diameter tolerance
TCHA	Achievable hole tolerance
TCHAL	Achievable hole tolerance lower
TCHAU	Achievable hole tolerance upper
TCT	Tolerance class tool
TCTR	Thread tolerance class
TD	Thread diameter
TDZ	Thread diameter size
TFLA	Tap floating length ahead
TFLB	Tap floating length behind
TG	Taper gradient
THBTP	Thread back taper property
THCA	Thread helix correction angle
THCHT	Threading chamfer type
THFT	Thread form type
THFTS	Thread form standard series
THL	Thread length
THUB	Hub thickness
TP	Thread pitch
TPI	Threads per inch
TPIN	Minimum threads per inch
TPIX	Maximum threads per inch
TPN	Minimum thread pitch
TPT	Thread profile type
TPX	Maximum thread pitch
TRMAX	Tap range max
TQ	Torque
TSYC	Tool style code
TTP	Thread type
ULDR	Usable length diameter ratio
VCX	Maximum cutting speed
W1	Insert width
WB	Body width
WF	Functional width
WFCIRP	Width to cutting item reference point
WSC	Clamping width
WT	Weight of item
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count (ZEFP)
ZWX	Maximum number of Wiper inserts

Conversion table

Metric to imperial

Distance

1 meter = 39.370 inch
1 meter = 3.281 feet
1 millimeter = 0.039 inch

Weight

1 kilogram = 2.205 pounds
1 kilogram = 35.274 ounces

Torque

1 Newton meter (Nm) = 0.738 pound-force feet (ft-lbs)

1 Newton meter (Nm) = 8.851 pound-force inches (in-lbs)

Imperial to metric

Distance

1 inch = 25.4 millimeter
1 foot = 0.3 meter
1 foot = 304.8 millimeter

Weight

1 pound = 0.45 kilogram
1 ounce = 28.35 gram

Torque

1 pound-force foot (ft-lbf) = 1.4 Newton meter (Nm)

1 pound-force inch (in-lbf) = 0.1 Newton meter (Nm)

Formulas and definitions:

	Metric	**Imperial**
v_c = Cutting speed	m/min (meter/minute)	ft/min (feet/minute)
n = Spindle speed	rpm (revolution per minute)	
v_f = table feed	mm/min	inch/min
z_n = total number of cutting edges		
z_c = number of effective cutting edges		
f_z = feed per tooth	mm/z	inch/z
f_n = Feed per revolution	mm/rev	inch/rev
h_{ex} = maximum thickness	mm	inch
a_p = Cutting depth	mm	inch
l_a = insert width	mm	inch
a_e = cutting width	mm	inch
a_e/D_c % = Radial immersion	%	%
T = Machining time	min	min
Q = Metal removal rate	cm^3/min	$inch^3/min$
nap = number of passes		
TPI = threads per inch		
k_c = specific cutting force	N/mm^2	lbs/in^2
R_a = Surface roughness	µm	µin

Insert size

iC = inscribed circle in inch

△ = cutting edge length in mm

Ifind

Our most practical tools collected for your convenience

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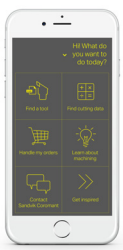


Reconditioning

We offer more than just traditional "regrinding." Our reconditioning service guarantees you will get the original performance of your tools to reduce your cost per application.

What we offer

B

100%

Reliability
Our knowledgeable specialists are available to offer support.

x3

Original performance
The original tool quality is guaranteed — up to three times.

50%

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

Products in service

C

Drilling

Milling

Reaming

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

Additional information

D

Reconditioning box
The box can be ordered in two sizes:
- Small (300 × 200 × 138 mm)
  Article number: 6949557
- Medium (400 × 300 × 138 mm)
  Article number: 6949558

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

Reconditioning service
- Tools will be inspected prior to reconditioning to ensure the tool can be reconditioned. If they cannot be reconditioned, the tools will be returned to you.
- A laser mark on the tool shank indicates each reconditioning service performed.
- The tools are delivered back in the original packaging.

What happens with your tools?
- Complete geometry restoration
- Drill length is reduced
- End mill diameter and length are reduced
  - Minimum diameter is about 0.9 × DC
- Reamer diameter tolerance is maintained

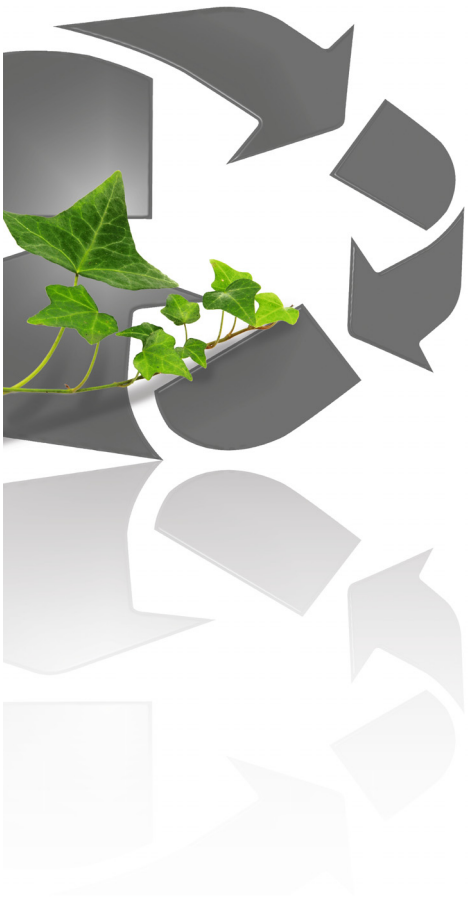
E

For prices, contact your local Sandvik Coromant representative.

For the sake of the environment

Get into the Coromant Recycling Concept (CRC) now!

The Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts (including CBN and PCD if “carrier” is cemented carbide) and solid carbide tools offered by Sandvik Coromant to all its customers.
In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers.
Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way.
All used hard-metal inserts are collected in the collection box at the workplace.
When the collection box is sufficiently full, its contents are transferred to the transport box.
The full transport box is then sent to the nearest Sandvik Coromant office or to your Coromant dealer who can also give you more information.



The benefits of the CRC speak for themselves

- A one-stop worldwide recycling system.
- For direct and trade customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.

Order collection boxes for each lathe, milling machine, drill or for your machining center. We recommend one collection box for inserts and one separate box for solid carbide tools for each cutting workplace.
For detailed instructions on how to sell your used cemented carbide, please visit www.sandvik.coromant.com and select your market.

	Order numbers
Collection box:	91617
Transport box for solid carbide tools (wooden):	92994
Transport box inserts (wooden):	92995

Safety information

Safety information in connection with grinding of cemented carbide

Material compositon

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

Routes of exposure

Grinding or heating of hard metal blanks or hard metal products will produce dust or fumes with dangerous ingredients that can be inhaled, swallowed or come in contact with the skin or eyes.

Acute toxicity

The dust is toxic by inhalation. Inhalation may cause irritation and inflammation of the airways. Significantly higher acute inhalation toxicity has been reported during simultaneous inhalation of cobalt and tungsten carbide compared to inhalation of cobalt alone.
Skin contact can cause irritation and rash. Personnel whose skin is sensitive may experience an allergic reaction.

Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction in the airways. Prolonged inhalation of increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers exposed in the past to high concentrations of tungsten carbide/cobalt carried an increased risk of developing lung cancer.
Cobalt and nickel are potent skin sensitizers. Repeated or prolonged contact can cause irritation.

Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation
Toxic by inhalation
Limited evidence of a carcinogenic effect.
May cause sensitization by inhalation and skin contact

Preventive measures

Avoid formation and inhalation of dust. Use adequate local exhaust ventilation to keep personal exposure well below the nationally authorised limits.
If ventilation is not available or adequate, use respirators nationally approved for the purpose.
Use safety goggles or glasses with side shields when necessary.
Avoid repeated skin contact. Wear suitable gloves. Wash skin thoroughly after handling.
Use suitable protective clothing. Launder clothing as needed.
Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.

Material cross reference list

ISO	MC	CMC	Country									
			Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
P	**Unalloyed steel**											
Steel	P1.1.Z.AN	01.1	S235JR G2	1.0038	4360 40 C	-	1311	A570.36	E 24-2 Ne	-	-	STKM 12A;C
	P1.1.Z.AN	01.1	S235J2 G3	1.0116	4360 40 B	-	1312	A573-81 65	E 24-U	Fe37-3	-	-
	P1.1.Z.AN	01.1	C15	1.0401	080M15	-	1350	1015	CC12	C15C16	F.111	-
	P1.1.Z.AN	01.1	C22	1.0402	050A20	2C/2D	1450	1020	CC20	C20C21	F.112	-
	P1.1.Z.AN	01.1	C15E	1.1141	080M15	32C	1370	1015	XC12	C16	C15K	S15C
	P1.1.Z.AN	01.1	C25E	1.1158	-	-	-	1025	-	-	-	S25C
	P1.1.Z.AN	01.1	S380N	1.8900	4360 55 E	-	2145	A572-60	-	FeE390KG	-	-
	P1.1.Z.AN	01.1	17MnV7	1.0870	4360 55 E	-	2142	A572-60	NFA 35-501 E 36	-	-	-
	P1.1.Z.AN	02.1	55Si7	1.0904	250A53	45	2085	9255	55S7	55Si8	56Si7	-
	P1.1.Z.AN	02.2	-	-	-	-	2090	9255	55S7	-	-	-
	P1.2.Z.AN	01.2	C35	1.0501	060A35	-	1550	1035	CC35	C35	F.113	-
	P1.2.Z.AN	01.2	C45	1.0503	080M46	-	1650	1045	CC45	C45	F.114	-
	P1.2.Z.AN	01.2	40Mn4	1.1157	150M36	15	-	1039	35M5	-	-	-
	P1.2.Z.AN	01.2	36MN5	1.1167	-	-	2120	1335	40M5	-	36Mn5	SMn438(H)
	P1.2.Z.AN	01.2	28Mn6	1.1170	150M28	14A	-	1330	20M5	C28Mn	-	SCMn1
	P1.2.Z.AN	01.2	C35G	1.1183	060A35	-	1572	1035	XC38TS	C36	-	S35C
	P1.2.Z.AN	01.2	C45E	1.1191	080M46	-	1672	1045	XC42	C45	C45K	S45C
	P1.2.Z.AN	01.2	C53G	1.1213	060A52	-	1674	1050	XC48TS	C53	-	S50C
	P1.2.Z.AN	01.3	C55	1.0535	070M55	-	1655	1055	-	C55	-	-
	P1.2.Z.AN	01.3	C55E	1.1203	070M55	-	-	1055	XC55	C50	C55K	S55C
	P1.2.Z.AN	02.1	S275J2G3	1.0144	4360 43C	-	1412	A573-81	E 28-3	-	-	SM 400A;B;C
	P1.2.Z.AN	02.1	S355J2G3+C2	1.0570	4360 50B	-	2132	-	E36-3	Fe52BFN/Fe52CFN	-	SM490A;B;C;YA;YB
	P1.2.Z.AN	02.1	S355J2G3	1.0841	150 M 19	-	2172	5120	20 MC 5	Fe52	F-431	-
	P1.3.Z.AN	01.3	C60E	1.0601	080A62	43D	-	1060	CC55	C60	-	-
	P1.3.Z.AN	01.3	C60E	1.1221	080A62	43D	1678	1060	XC60	C60	-	S58C
	P1.3.Z.AN	01.4	C101E	1.1274	060 A 96	-	1870	1095	XC 100	-	F-5117	-
	P1.3.Z.AN	01.4	C101u	1.1545	BW 1A	-	1880	W 1	Y105	C36KU	F-5118	SK 3
	P1.3.Z.AN	01.4	C105W1	-	BW2	-	2900	W210	Y120	C120KU	F.515	SUP4
	P1.3.Z.AN	02.1	S340 MGC	1.0961	-	-	-	9262	60SC7	60SiCr8	60SiCr8	-
	P1.4.Z.AN	01.1	11SMn30	1.0715	230M07	-	1912	1213	S250	CF9SMn28	11SMn28	SUM22
	P1.4.Z.AN	01.1	11SMnPb30	1.0718	-	-	1914	12L13	S250Pb	CF9SMnPb28	11SMnPb28	SUM22L
	P1.4.Z.AN	01.1	10SPb20	1.0722	-	-	-	-	10PbF2	CF10SPb20	10SPb20	-
	P1.4.Z.AN	01.1	11SMn37	1.0736	240M07	1B	-	1215	S 300	CF9SMn36	12SMn35	-
	P1.4.Z.AN	01.1	11SMnPb37	1.0737	-	-	1926	12L14	S300Pb	CF9SMnPb36	12SMnP35	-
	P1.4.Z.AN	01.2	35S20	1.0726	212M36	8M	1957	1140	35MF4	-	F210G	-
	P1.5.C.UT	01.1	GC16E	1.1142	030A04	1A	1325	1115	-	-	-	-
	Low-alloy steel											
	P2.1.Z.AN	02.1	16Mo3	1.5415	1501-240	-	2912	A204Gr.A	15D3	16Mo3KW	16Mo3	-
	P2.1.Z.AN	02.1	14Ni6	1.5622	-	-	-	A350LF5	16N6	14Ni6	15Ni6	-
	P2.1.Z.AN	02.1	21NiCrMo2	1.6523	805M20	362	2506	8620	20NCD2	20NiCrMo2	20NiCrMo2	SNCM220(H)
	P2.1.Z.AN	02.1	17CrNiMo6	1.6587	820A16	-	-	-	18NCD6	-	14NiCrMo13	-
	P2.1.Z.AN	02.1	15Cr3	1.7015	523M15	-	-	5015	12C3	-	-	SCr415(H)
	P2.1.Z.AN	02.1	55Cr3	1.7176	527A60	48	-	5155	55C3	-	-	SUP9(A)
	P2.1.Z.AN	02.1	15CrMo5	1.7262	-	-	2216	-	12CD4	-	12CrMo4	SCM415(H)
	P2.1.Z.AN	02.1	13CrMo4-5	1.7335	1501-620Gr27	-	-	A182 F11;F12	15CD3.5 15CD4.5	14CrMo4 5	14CrMo45	-
	P2.1.Z.AN	02.1	10CrMo9 10	1.7380	1501-622 Gr.31;45	-	2218	A182 F.22	12CD9, 10	12CrMo9, 10	TU.H	-
	P2.1.Z.AN	02.1	14MoV6 3	1.7715	1503-660-440	-	-	-	-	-	13MoCrV6	-
	P2.1.Z.AN	02.1	50CoMo4	1.7228	823M30	33	2512	-	-	653M31	-	-
	P2.1.Z.AN	02.2	14NiCr10	1.5732	-	-	-	3415	14NC11	16NiCr11	15NiCr11	SNC415(H)
	P2.1.Z.AN	02.2	14NiCr14	1.5752	655M13; A12	36A	-	3415;3310	12NC15	-	-	SNC815(H)
	P2.1.Z.AN	02.1/02.2	16MnCr5	1.7131	(527M20)	-	2511	5115	16MC5	16MnCr5	16MnCr5	-
	P2.1.Z.AN	02.1/02.2	34CrMo4	1.7220	708A37	19B	2234	4137;4135	35CD4	35CrMo4	34CrMo4	SCM432;SCCRM3
	P2.1.Z.AN	02.1/02.2	41CrMo4	1.7223	708M40	19A	2244	4140;4142	42CD4TS	41CrMo4	42CrMo4	SCM 440
	P2.1.Z.AN	02.1/02.2	42CrMo4	1.7225	708M40	19A	2244	4140	42CD4	42CrMo4	42CrMo4	SCM440(H)
	P2.1.Z.AN	03.11	14NiCrMo134	1.6657	832M13	36C	-	-	-	15NiCrMo13	14NiCrMo131	-
	P2.2.Z.AN	02.1	31CrMo12	1.8515	722 M 24	-	2240	-	30 CD 12	30CrMo12	F-1712	-
	P2.2.Z.AN	02.1	39CrMoV13 9	1.8523	897M39	40C	-	-	-	36CrMoV12	-	-
	P2.2.Z.AN	02.1	41CrS4	1.7039	524A14	-	2092	L1	-	105WCR 5	-	-
	P2.2.Z.AN	02.1	50NiCr13	1.2721	-	-	2550	L6	55NCV6	-	F-528	-
	P2.2.Z.AN	03.11	45WCrV7	1.2542	BS1	-	2710	S1	-	45WCrV8KU	45WCrSi8	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	36CrNiMo4	1.6511	816M40	110	-	9840	40NCD3	38NiCrMo4(KB)	35NiCrMo4	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	34CrNiMo6	1.6582	817M40	24	2541	4340	35NCD6	35NiCrMo6(KB)	-	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	34Cr4	1.7033	530A32	18B	-	5132	32C4	34Cr4(KB)	35Cr4	SCr430(H)
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	41Cr4	1.7035	530A40	18	-	5140	42C4	41Cr4	42Cr4	SCr440(H)
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	32CrMo12	1.7361	722M24	40B	2240	-	30CD12	32CrMo12	F.124.A	-
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	51CrV4	1.8159	735A50	47	2230	6150	50CV4	50CrV4	51CrV4	SUP10
	P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	41CrAlMo7	1.8509	905M39	41B	2940	-	40CAD6, 12	41CrAlMo7	41CrAlMo7	-
	P2.3.Z.AN	02.1	100Cr6	1.3505	534A99	31	2258	52100	100C6	100Cr6	F.131	SUJ2

Material cross reference list

ISO	MC	CMC	Country Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
P	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	105WCr6	1.2419	-	-	2140	-	105WC13	10WCr6	105WCr5	SKS31
	P2.3.Z.AN/H1.2.Z.HA	-	-	-	-	-	-	-	-	107WCr5KU	-	SKS2, SKS3
	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	-	1.2714	-	-	-	L6	55NCDV7	-	F.520.S	SKT4
	P2.3.Z.AN/H1.3.Z.HA	02.1/02.2	100Cr6	1.2067	BL3	-	-	L3	Y100C6	-	100Cr6	-
	P2.4.Z.AN	02.1	16MnCr5	1.7139	-	-	2127	-	-	-	-	-
	P2.5.Z.HT	02.1	16Mo5	1.5423	1503-245-420	-	-	4520	-	16Mo5	16Mo5	-
	P2.5.Z.HT	02.1	40NiCrMo8-4	1.6562	311-Type 7	-	-	8740	-	40NiCrMo2(KB)	40NiCrMo2	SNCM240
	P2.5.Z.HT	02.1	42Cr4	1.7045	-	-	2245	5140	-	-	42Cr4	SCr440
	P2.5.Z.HT	02.1	31NiCrMo14	1.5755	830 M 31	-	2534	-	-	-	F-1270	-
	P2.5.Z.HT	02.2	36NiCr6	1.5710	640A35	111A	-	3135	35NC6	-	-	SNC236
	P2.6.C.UT	02.1	22Mo4	1.5419	605A32	-	2108	8620	-	-	F520.S	-
	P2.6.C.UT	02.1/02.2	25CrMo4	1.7218	1717CDS110	-	2225	4130	25CD4	25CrMo4(KB)	AM26CrMo4	SCM420;SCM430
	P2.6.C.UT	06.2	-	-	-	-	2223	-	-	-	-	-
	High-alloy steel											
	P3.0.Z.AN	03.11	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU X250Cr12KU	X210Cr12	SKD1
	P3.0.Z.AN	03.11	X43Cr13	1.2083	-	-	2314	-	-	-	-	-
	P3.0.Z.AN	03.11	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU X40CrMoV511KU	X40CrMoV5	SKD61
	P3.0.Z.AN	03.11	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12
	P3.0.Z.AN	03.11	X210CrW12	1.2436	-	-	2312	-	-	X215CrW12 1KU	X210CrW12	SKD2
	P3.0.Z.AN	03.11	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU X30WCrV9 3KU	X30WCrV9	SKD5
	P3.0.Z.AN	03.11	X165CrMoV 12	1.2601	-	-	2310	-	-	X165CrMoW12KU	X160CrMoV12	-
	P3.0.Z.AN	03.21	X155CrMoV12-1	1.2379	-	-	2736	HNV3	-	-	-	-
	P3.0.Z.HT	03.11	X8Ni9	1.5662	1501-509;510	-	-	ASTM A353	-	X10Ni9	XBNi09	-
	P3.0.Z.HT	03.11	12Ni19	1.5680	-	-	-	2515	Z18N5	-	-	-
	P3.1.Z.AN	03.11	S6-5-2	1.3343	4959BA2	-	2715	D3	Z40CSD10	15NiCrMo13	-	SUH3
	P3.1.Z.AN	03.13	-	-	BM 2	-	2722	M 2	Z85WDCV	HS 6-5-2-2	F-5603.	SKH 51
	P3.1.Z.AN	03.13	HS 6-5-2-5	1.3243	BM 35	-	2723	M 35	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55
	P3.1.Z.AN	03.13	HS 2-9-2	1.3348	-	-	2782	M 7	-	HS 2-9-2	F-5607	-
	P3.2.C.AQ	06.33	G-X120Mn12	1.3401	Z120M12	-	2183	L3	Z120M12	XG120Mn12	X120Mn12	SCMnH/1
	Ferritic/martensitic stainless steel											
Steel	P5.0.Z.AN	05.11/15.11	X10CrAL13	1.4724	403S17	-	-	405	Z10C13	X10CrAl12	F.311	SUS405
	P5.0.Z.AN	05.11/15.11	X10CrAL18	1.4742	430S15	60	-	430	Z10CAS18	X8Cr17	F.3113	SUS430
	P5.0.Z.AN	05.11/15.11	X10CrAL2-4	1.4762	-	-	2322	446	Z10CAS24	X16Cr26	-	SUH446
	P5.0.Z.AN	05.11/15.11	X1CrMoTi18-2	1.4521	-	-	2326	S44400	-	-	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr13	1.4000	403S17	-	2301	403	Z6C13	X6Cr13	F.3110	SUS403
	P5.0.Z.AN/P5.0.Z.HT	-	X7Cr14	1.4001	-	-	-	-	-	-	F.8401	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X10Cr13	1.4006	410S21	56A	2302	410	Z10C14	X12Cr13	F.3401	SUS410
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr17	1.4016	430S15	960	2320	430	Z8C17	X8Cr17	F3113	SUS430
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrAL13	1.4002	405S17	-	-	405	Z8CA12	X6CrAl13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X20Cr13	1.4021	420S37	-	2303	420	Z20C13	X20Cr13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrMo17-1	1.4113	434S17	-	2325	434	Z8CD17.01	X8CrMo17	-	SUS434
	P5.0.Z.HT	03.11	X45CrS9-3-1	1.4718	401S45	52	-	HW3	Z45CS9	X45GrSi8	F322	SUH1
	P5.0.Z.HT	05.11/15.11	X85CrMoV18-2	1.4748	443S65	59	-	HNV6	Z80CSN20.02	X80CrSiNi20	F.320B	SUH4
	P5.0.Z.HT	05.11/15.11	X20CrMoV12-1	1.4922	-	-	2317	-	-	X20CrMoNi 12 01	-	-
	P5.0.Z.PH	05.11/15.11	X12CrS13	1.4005	416 S 21	-	2380	416	Z11CF13	X12 CrS 13	F-3411	SUS 416
	P5.0.Z.PH	05.11/15.11	X46Cr13	1.4034	420S45	56D	2304	-	Z40CM	X40Cr14	F.3405	SUS420J2
	P5.0.Z.PH	05.11/15.11	X19CrNi17-2	1.4057	431S29	57	2321	431	Z15CNi6.02	X16CrNi16	F.3427	SUS431
	P5.0.Z.PH	05.12/15.12	X5CrNiCuNb16-4	1.4542 1.4548	-	-	-	630	Z7CNU17-04	-	-	-
	P5.0.Z.PH	15.21	X4 CrNiMo16-5	1.4418	-	-	2387	-	Z6CND16-04-01	-	-	-
	P5.1.Z.AN/P5.0.Z.HT	05.11/15.11	X14CrMoS17	1.4104	-	-	2383	430F	Z10CF17	X10CrS17	F.3117	SUS430F

			Trade names
	P2.1.Z.AN	02.1	OVAKO 520M (Ovako Steel)
	P2.2.Z.AN	02.1	1.0045 FORMAX (Uddeholm Tooling)
	P2.2.Z.AN	02.1	IMACRO NIT (Imatra Steel)
	P2.5.Z.HT	02.2	INEXA 482 (XM) (Inexa Profil)
	P1.2.Z.AN		S355J2G3(XM)
	P1.2.Z.AN		C45(XM)
	P1.2.Z.AN		16MnCrS5(XM)
	P2.5.Z.HT		INEXA280(XM)
	P2.5.Z.HT	02.2	070M20(XM)
	P2.5.Z.HT	02.2	HARDOX 500 (SSAB – Swedish Steel Corp.)
	P2.5.Z.HT		WELDOX 700 (SSAB – Swedish Steel Corp.)

Material cross reference list

ISO	MC	CMC	Country Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
M	**Austenitic stainless steel**											
Stainless steel	M1.0.Z.AQ	05.11/15.11	X3CrNiMo13-4	1.4313	425C11	-	2385	CA6-NM	Z4CND13.4M Z38C13M	(G)X6CrNi304	-	SCS5
	M1.0.Z.AQ/M1.0.C.UT	05.11/15.11	X53CrMnNiN21-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN21 9	-	SUH35, SUH36
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiN18-10	1.4311	304S62	-	2371	304LN	Z2CN18.10	-	-	SUS304LN
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-13-3	1.4429	-	-	2375	316LN	Z2CND17.13	-	-	SUS316LN
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo17-12-2	1.4404	316S13	-	2348	316L	Z2CND17-12	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-14-3	1.4435	316S13	-	2353	316L	Z2CND17.12	X2CrNiMo17 12	-	SCS16, SUS316L
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X3CrNiMo17-3-3	1.4436	316S33	-	2343, 2347	316	Z6CND18-12-03	X8CrNiMo1713	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-15-4	1.4438	317S12	-	2367	317L	Z2CND19.15	X2CrNiMo18 16	-	SUS317L
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiNb18-10	1.4550	347S17	58F	2338	347	Z6CNNb18.10	X6CrNiNb18 11	F.3552 F.3524	SUS347
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiMoTi17-12-2	1.4571	320S17	58J	2350	316Ti	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X10CrNiMoNb 18-12	1.4583	-	-	-	318	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X15CrNiSi20-12	1.4828	309S24	-	-	309	Z15CNS20.12	-	-	SUH309
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-11-2	1.4406	301S21	58C	2370	308	Z1NCDU25.20	-	F.8414	SCS17
	M1.0.Z.AQ	05.21/15.21	X1CrNiMoCuN20-18-7	1.4547	-	-	2378	S31254	Z1CNDU20-18-06AZ	-	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X9CrNi18-8	1.4310	-	-	2331	301	Z12CN17.07	X12CrNi17 07	F.3517	SUS301
	M1.0.Z.PH	05.22/15.22	X7CrNiAL17-7	1.4568 1.4504	316S111	-	-	17-7PH	Z8CNA17-07	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNi19-11	1.4306	304S11 304S12	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-
	M1.1.Z.AQ	05.21/15.21	-	-	304S31	58E	2332, 2333	304	Z6CN18.09	X5CrNi18 10	F.3504 F.3541	SUS304
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S15	58E	2332	304	Z6CN18.09	X5CrNi18 10	F.3551	SUS304
	M1.1.Z.AQ	05.21/15.21	X5CrNiMo17-2-2	1.4401	316S16	58J	2347	316	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316
	M1.1.Z.AQ	05.21/15.21	X6CrNiTi18-10	1.4541	321S12	58B	2337	321	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321
	M1.2.Z.AQ	05.21/15.21	X8CrNiS18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303
	Super austenitic (Ni>20%) stainless steel											
	M2.0.C.AQ	20.11	G-X40NiCrSi36-18	1.4865	330C11	-	-	-	-	XG50NiCr39 19	-	SCH15
	M2.0.Z.AQ	05.21/15.21	X1NiCrMoCu25-20-5	1.4539	-	-	2562	UNS V 0890A	Z2 NCDU25-20	-	-	-
	M2.0.Z.AQ	05.21/15.21	X8CrNi25-21	1.4845	310S24	-	2361	310S	Z12CN25 20	X6CrNi25 20	F.331	SUH310
	M2.0.Z.AQ	20.11	X12NiCrSi36 16	1.4864	-	-	-	330	Z12NCS35.16	F-3313	-	SUH330
	M2.0.Z.AQ	05.23/15.23	X1NiCrMoCu31-27-4	1.4563	-	-	2584	NO8028	Z1NCDU31-27-03	-	-	-
	Duplex (austenitic/ferritic) stainless steel											
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X2CrNiN23-4	1.4362	-	-	2376	S31500	-	-	-	-
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X8CrNiMo27-5	-	-	-	2324	S32900	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiN23-4	-	-	-	2327	S32304	Z2CN23-04AZ	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	-	-	-	-	2328	-	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiMoN22-53	-	-	-	2377	S31803	Z2CND22-05-03	-	-	-

				Trade names
	M1.1.Z.AQ	05.21/15.21		SANMAC 304 (Sandvik Steel)
	M1.1.Z.AQ	05.21/15.21	1.0045	SANMAC 304L (Sandvik Steel)
	M1.1.Z.AQ	05.21/15.21		SANMAC 316 (Sandvik Steel)
	M1.1.Z.AQ	05.21/15.21		SANMAC 316L (Sandvik Steel)
	M1.0.Z.AQ	05.23/15.23		254 SMO
	M2.0.Z.AQ	05.23/15.23		654 SMO
	M3.2.Z.AQ	05.52/15.52		SANMAC SAF 2205 (Sandvik Steel)
	M3.2.Z.AQ	05.52/15.52		SANMAC SAF 2507 (Sandvik Steel)

Material cross reference list

ISO	MC	CMC	Country Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
K	**Malleable cast iron**											
	K1.1.C.NS	07.1	-	-	8 290/6	-	0814	-	MN 32-8	-	-	FCMB310
	K1.1.C.NS	07.1	EN-GJMB350-10	0.8135	B 340/12	-	0815	32510	MN 35-10	-	-	FCMW330
	K1.1.C.NS	07.2	EN-GJMB450-6	0.8145	P 440/7	-	0852	40010	Mn 450	GMN 45	-	FCMW370
	K1.1.C.NS	07.2	EN-GJMB550-4	0.8155	P 510/4	-	0854	50005	MP 50-5	GMN 55	-	FCMP490
					P 570/3		0858	70003	MP 60-3			FCMP540
	K1.1.C.NS	07.2	EN-GJMB650-2	0.8165	P570/3	-	0856	A220-70003	Mn 650-3	GMN 65	-	FCMP590
	K1.1.C.NS	07.3	EN-GJMB700-2	0.8170	P690/2	-	0862	A220-80002	Mn700-2	GMN 70	-	FCMP690
	Gray cast iron											
	K2.1.C.UT	08.1	-	-	-	-	0100	-	-	-	-	-
	K2.1.C.UT	08.1	EN-GJL-100	0.6010	-	-	0110	No 20 B	Ft 10 D	-	-	FC100
	K2.1.C.UT	08.1	EN-GJL-150	0.6015	Grade 150	-	0115	No 25 B	Ft 15 D	G 15	FG 15	FC150
	K2.1.C.UT	08.1	EN-GJL-200	0.6020	Grade 220	-	0120	No 30 B	Ft 20 D	G 20	-	FC200
	K2.1.C.UT	08.2	EN-GJL-250	0.6025	Grade 260	-	0125	No 35 B	Ft 25 D	G 25	FG 25	FC250
	K2.1.C.UT	08.2	EN-JLZ	0.6040	Grade 400	-	0140	No 55 B	Ft 40 D	-	-	-
	K2.2.C.UT	08.2	EN-GJL-300	0.6030	Grade 300	-	0130	No 45 B	Ft 30 D	G 30	FG 30	FC300
	K2.2.C.UT	08.2	EN-GJL-350	0.6035	Grade 350	-	0135	No 50 B	Ft 35 D	G 35	FG 35	FC350
	K2.3.C.UT	08.3	GGL-NiCr20-2	0.6660	L-NiCuCr202	-	0523	A436 Type 2	L-NC 202	-	-	-
Cast iron	**Nodular cast iron**											
	K3.1.C.UT	09.1	EN-GJS-400-15	0.7040	SNG 420/12	-	0717-02	60-40-18	FCS 400-12	GS 370-17	FGE 38-17	FCD400
	K3.1.C.UT	09.1	EN-GJS-400-18-LT	0.7043	SNG 370/17	-	0717-12	-	FGS 370-17	-	-	-
	K3.1.C.UT	09.1	EN-GJS-350-22-LT	0.7033	-	-	0717-15	-	-	-	-	-
	K3.1.C.UT	09.1	EN-GJS-800-7	0.7050	SNG 500/7	-	0727	80-55-06	FGS 500-7	GS 500	FGE 50-7	FCD500
	K3.2.C.UT	09.2	EN-GJS-600-3	0.7060	SNG 600/3	-	0732-03	-	FGS 600-3	-	-	FCD600
	K3.3.C.UT	09.2	EN-GJS-700-2	0.7070	SNG 700/2	-	0737-01	100-70-03	FGS 700-2	GS 700-2	FGS 70-2	FCD700
	K3.5.C.UT	-	EN-GJSA-XNiCr20-2	0.7660	Grade S6	-	0776	A43D2	S-NC 202	-	-	-
	Compacted graphite iron											
	K4.1.C.UT	-	EN-GJV-300									
	K4.1.C.UT	-	EN-GJV-350									
	K4.2.C.UT	-	EN-GJV-400									
	K4.2.C.UT	-	EN-GJV-450									
	K4.2.C.UT	-	EN-GJV-500									
	Austempered ductile iron											
	K5.1.C.NS	-	EN-GJS-800-8	-	-	-	-	ASTM A897 No. 1	-	-	-	-
	K5.1.C.NS	-	EN-GJS-1000-5	-	-	-	-	ASTM A897 No. 2	-	-	-	-
	K5.2.C.NS	-	EN-GJS-1200-2	-	-		-	ASTM A897 No. 3	-	-	-	-
	K5.2.C.NS	-	EN-GJS-1400-1	-	-	-	-	ASTM A897 No. 4	-	-	-	-
	K5.3.C.NS	-	-	-	-	-	-	ASTM A897 No. 5	-	-	-	-

Material cross reference list

ISO	MC	CMC	Country Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
N	**Aluminum based alloys**											
Non-ferrous metals	N1.3.C.AG	30.21	G-AlSi9MGWA	3.2373	-	-	4251	SC64D	A-S7G	-	-	C4BS
	N1.3.C.UT	30.21	G-ALMG5	-	LM5	-	4252	GD-AlSi12	A-SU12	-	-	AC4A
	N1.3.C.UT/N1.3.C.AG	30.21/30.22	-	-	LM25	-	4244	356.1	-	-	-	A5052
	N1.3.C.UT	-	GD-AlSi12	-	-	-	4247	A413.0	-	-	-	A6061
	N1.3.C.AG	-	GD-AlSi8Cu3	-	LM24	-	4250	A380.1	-	-	-	A7075
	N1.3.C.UT	-	G-AlSi12(Cu)	-	LM20	-	4260	A413.1	-	-	-	ADC12
	N1.3.C.UT	-	G-AlSi12	-	LM6	-	4261	A413.2	-	-	-	-
	N1.3.C.AG	-	G-AlSi10Mg(Cu)	-	LM9	-	4253	A360.2	-	-	-	-
S	**Nickel based alloys**											
Heat resistant super alloys	S2.0.Z.AG	20.22	S-NiCr13A16MoNb	LW2 4670	mar-46	-	-	5391	NC12AD	-	-	-
	S2.0.C.UT	20.24	NiCo15Cr10MoAlTi	LW2 4674	-	-	-	AMS 5397	-	-	-	-
	S2.0.Z.AG	20.22	NiFe35Cr14MoTi	LW2.4662	-	-	-	5660	ZSNCDT42	-	-	-
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	HR8	-	-	5383	NC19eNB	-	-	-
	S2.0.Z.AG	20.22	NiCr20TiAk	2.4631	Hr401.601	-	-	-	NC20TA	-	-	-
	S2.0.Z.AG	20.22	NiCr19Co11MoTi	2.4973	-	-	-	AMS 5399	NC19KDT	-	-	-
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	-	-	-	AMS 5544	NC20K14	-	-	-
	S2.0.Z.AN	20.21	-	2.4603	-	-	-	5390A	NC22FeD	-	-	-
	S2.0.Z.AN	20.21	NiCr22Mo9Nb	2.4856	-	-	-	5666	NC22FeDNB	-	-	-
	S2.0.Z.AN	20.21	NiCr20Ti	2.4630	HR5.203-4	-	-	-	NC20T	-	-	-
	S2.0.Z.AG	20.22	NiCu30AL3Ti	2.4375	3072-76	-	-	4676	-	-	-	-
	Cobalt base											
	-	-	CoCr20W15Ni	-	-	-	-	5537C, AMS	KC20WN	-	-	-
	S3.0.Z.AG	20.32	CoCr22W14Ni	LW2.4964	-	-	-	5772	KC22WN	-	-	-
	Titanium alloys											
	S4.2.Z.AN	23.22	TiAl5Sn2.5	3.7115.1	TA14/17	-	-	UNS R54520	T-A5E UNS R56400	-	-	-
	S4.2.Z.AN	23.22	TiAl6V4	3.7165.1	TA10-13/TA28	-	-	UNS R56401	T-A6V	-	-	-
	S4.3.Z.AN	23.22	TiAl5V5Mo5Cr3	-	-	-	-	-	-	-	-	-
	S4.2.Z.AN	23.22	TiAl4Mo4Sn4Si0.5	3.7185	-	-	-	-	-	-	-	-
			Trade names									
			Iron-based alloys									
	S2.0.Z.UT/S2.0.Z.AN	20.11	Incoloy 800									
			Nickel based alloys									
	S2.0.Z.AN	20.2	Haynes 600									
	S2.0.Z.AN	20.2	Nimocast PD16									
	S2.0.Z.AG	20.2	Nimonic PE 13									
	S2.0.Z.AG	20.2	Rene 95									
	S2.0.Z.AN	20.21	Hastelloy C									
	S2.0.Z.AN	20.21	Incoloy 825									
	S2.0.Z.AN	20.21	Inconel 600									
	S2.0.Z.AN	20.21	Monel 400									
	S2.0.Z.AG	20.22	Inconel 700									
	S2.0.Z.AG	S2.0.Z.AG	Inconel 718									
	S2.0.Z.AG	20.22	Mar – M 432									
	S2.0.Z.AG	20.22	Nimonic 901									
	S2.0.Z.AG	20.22	Waspaloy									
	S2.0.C.NS	20.24	Jessop G 64									
			Cobalt base									
	S3.0.Z.AG	20.3	Air Resist 213									
	S3.0.Z.AG	20.3	Jetalloy 209									
H	**Hardened materials**											
Hardened materials	H1.2.Z.HA	04.1	X100CrMo13	1.4108	-	-	2258 08	440A	-	-	-	C4BS
	H1.3.Z.HA	04.1	X110CrMoV15	1.4111	-	-	2534 05	610	-	-	-	AC4A
	H1.2.Z.HA	04.1	X65CrMo14	-	-	-	2541 06	0-2	-	-	-	AC4A

Code key for CoroMill® Plura

R	A	21	5	.	3	A	-	100	30	–	A	C	22	H
1	2	3	4		5	6	7	8	9	10	11	12	13	14

1 Direction of rotation

R Right hand
L Left hand

2 System of measurement

A Inch version

3 Type of tool

21 End mill

4 Drilling function

5 Non-drilling
6 Drilling

6 Number of teeth

1-9 1 to 9 teeth
A-Z 10 to 32 teeth

7 **Coolant**

C = Internal coolant supply
- = External coolant supply

8 Cutting diameter

Inch tools.
Cutting diameter DC in 1/64 inch.

Example: 10 = 5/32 inch

Metric tools.
Cutting diameter DC in 1/10 mm.

Example: 100 = 10.0 mm

9 Helix angle

Degree of helix rounded to nearest 5 degrees

12 Length of shank

S Short shank length
C Long shank length
K Shank length > "C"
L Shank length > "K"
X Shank length > "L"
E Short LF and LU
I Medium LF, medium LU
J Medium LF, long LU
O Long LF, medium LU
P Long LF, long LU

13 Max cutting depth, APMX

Inch tools.
Cutting length in 1/16 inch
If DC < 1/8 in 1/64 inch
Example: 09 = 9/16 inch for DC 3/16 inch

Metric tools.
Cutting length in mm
If D_c or D_{c2} < 3mm in 1/10 mm
Example:
07 = 7 mm for DC 6 mm
70 = 7 mm for DC 2.5 mm

Code key for CoroMill® Plura

5 Basic design of end mill

0	Concave chamfer end mill	**6**	Full radius (ball nose) with spherical form
1	Square form with/without corner chamfer, tight tolerance at DC	**7**	Conical straight form
2	Square form with corner radius	**8**	45° chamfer end mill
3	Square form with/without corner chamfer	**9**	30° chamfer end mill
4	Full radius (ball nose) form (6 or less teeth)	**H**	High feed end mill
5	Conical full radius (ball nose) form (6 or less teeth)	**T**	Turn-mill end mill

10 Corner radius/Conical angle

Corner radius				**Conical angle**	
Metric tools.		Inch tools.		Metric tools.	
– No radius		– No radius		– No radius/Angle	
A	<0.5 mm	A	1/64 inch	M	0.5°
B	0.5 mm	B	1/32 inch	N	1°
C	1.0 mm	C	3/64 inch	O	1.5°
D	1.5 mm	D	1/16 inch	P	2°
E	2.0 mm	E	5/64 inch	Q	2.5°
F	2.5 mm	F	3/32 inch	R	3°
etc.		etc.		S	3.5°
				T	4°
				etc.	

11 Shank type

A	Cylindrical
B	Weldon
C	Cylindrical with neck
E-J	Cylindrical with neck (Neck length/DC, mm)
E =	0.1 - 1.9 H = 6.0 - 7.9
F =	2.0 - 3.9 I = 8.0 - 9.9
G =	4.0 - 5.9 J = 10 - 11.9
Y =	Cylindrical with iLock

14 Geometry type

	Cutting edge	**TW % of DC**	**Rake angle γ°**
K	Kordell	50-60	9°-12°
B	Chip breaker	60	4°-7°
U	Kordell	<50	9°-12°
A	Straight	<45	12°-15°
P	Straight	45-55	9°-12°
N	Straight	56-65	9°-12°
L	Straight	66-75	4°-12°
G	Straight	50-75	-3°-3°
H	Straight	>75	<-3°
C	Compression router		

TW = Core diameter

Code key for CoroMill® Plura

2	S	3	4	0	–	1200	–	200	–	M	A	1640
1	2	3	4	5		6		7	8	9	10	11

1 Series

1: Versatile
2: Optimized

2 Face geometry

S: Straight corner radius, center cut

F: Straight corner radius, no center cut

P: Straight, center cut

N: Straight, no center cut

B: Ball nose

C: Chamfer tools

H: High-feed cutter

U: Chamfer radius

T: Turn mill

3 Flute helix angle

0: 0°<FHA≤15°
1: 15°<FHA≤25°
2: 25°<FHA≤35°
3: 35°<FHA≤45°
4: 45°<FHA≤55°
5: 55°<FHA≤65°

4 Average cutting length of tool style (APMX/DC)

0: 0-0.5 x DC
1: 0.6-1.0 x DC
2: 1.1-1.5 x DC
3: 1.6-2.0 x DC
4: 2.1-2.5 x DC
5: 2.6-3.0 x DC
6: 3.1-3.5 x DC
7: 3.6-4.0 x DC
8: 4.1-5.0 x DC
9: > 5.0 x DC

5 Running number to differentiate between tool style codes

6 Cutting diameter (DC) in 1/100.

E.g. 1200 = 12.00 mm

7 Corner radius, chamfer or chamfer radius in 1/100.

E.g. Corner radius 200 = 2 mm.
E.g. Chamfer 045 = 45°

8 Coolant

- No coolant
C: Radial exit coolant
A: Axial exit coolant

9 Primary ISO material

P: ISO P
K: ISO K
M: ISO M
S: ISO S
H: ISO H
N: ISO N
O: ISO O
X: Multi

10 Shank

A: Cylindrical
B: Weldon
C: Cylindrical with neck
D: Weldon with neck
G: Undersized

11 Grade

Code key for exchangeable milling heads

A	316	–	12	S	M	4	50	C	120	05	P
1	2		3	4	5	6	7	8	9	10	11

1 System of measurement	**2** Family name	**3** Size of interface	**4** Basic design
A = Inch version	E.g.: 316 = CoroMill® 316	EH coupling size E.g.: 12 = E12	S = Straight = 90° F = Straight no center cutting B = Ball nose C = Chamfer tools H = HFC (high-feed cutter) U = Chamfer radius

5 Length of head	**6** Number of edges	**7** Helix angle
M = Medium	E.g.: ZEFP = 4	Degree of helix

8 Coolant	**9** Cutting diameter	**10** Corner radius
- No coolant C Radial exit coolant A Axial exit coolant	Metric tools. E.g.: 120 = 12.0 mm Inch tools. E.g.: 050 = 0.5 inch	Metric tools. E.g.: 05 = RE 0.5 mm Inch tools. E.g.: 04 = RE 0.4 mm (.015")

11 Geometry

Geometry	Rake angle	Core diameter	
P	9-12°	50%	
L	4-12°	70%	
G	-3-3°	70%	
K	9-12°	60%	Kordell
A	12-15°		
D	-10°-0°		

Code key for CoroMill® Plura thread milling endmills

R	21	7	.	1	5	C	100	300	A	K	30	N
1	2	3		4	5	6	7	8	9	10	11	12

1 Direction of rotation

R Right hand

2 Type of tool

21 End mill

3 Function

7 Thread milling

4 Type of thread

1= Metric/Metric fine and MJ internal thread

2= Metric/Metric Fine external thread

3= UNC/UNF internal thread

4= UNC/UNF external thread

5= NPT internal thread

6= NPT external thread

7= NPTF internal thread

8= NPTF external thread

9= G internal thread

0= G external thread

5 Number of teeth

1-9 1 to 9 teeth

6 Cutting fluid supply

C Internal coolant

- No coolant through

7 Diameter of tool

Cutting diameter in 1/10 mm

8 Pitch

Pitch in 1/100 mm

9 Shank type

A Cylindrical shank

B Weldon shank

C Cylindrical shank with chamfer

10 Length of shank

S Short shank length
C Long shank length
K Shank length > "C"
L Shank length > "K"
X Shank length > "L"

11 Max cutting depth, APMX

Cutting length in mm (If DC or DCX < 3 mm in 1/10 mm)

12 Geometry type

N 10° helix, 9-12° rake angle, internal thread

H 30° helix, < 0° rake angle, internal thread

P 15° helix 9-10° rake angle

S 15° helix 4–5° rake angle

Code key for taps

T200	–	S	D	100	D	A	–	M3
1		2	3	4	5	6		7

1 Product family

2 ISO material

P = Steel
M = Stainless steel
K = Cast iron
S = Heat resistant super alloys

H = Hardened material

N = Non-ferrous material

X = Cross material

3 Level of material

E = Easy
M = Medium
D = Difficult

4 Number

1 0 0

Different nr for:
reinforced or straight shank
different chamfer, tool, coolant, etc.

5 Std

D = DIN
A = ANSI & DIN/ANSI
J = JIS
I = ISO

6 Thread form

A = M
B = MF
C = MJ
D = UN
E = UNC
F = UNF
G = UNEF
H = UNJC
I = UNJF
J = UNS
K = G
L = NPT
M = NPTF
N = NPSF
O = NPSM
P = EGM
Q = EGMF
R = EGUNC
S = EGUNF
T = PG
U = R
V = Rc
X = Rp
Y = BA
Z = EGUNJF

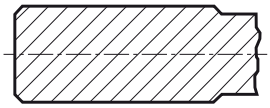
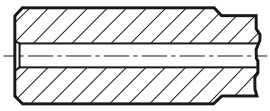
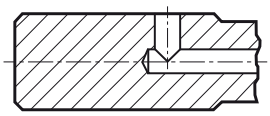
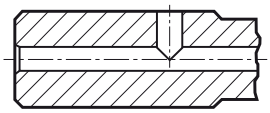
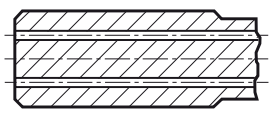
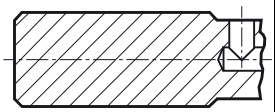
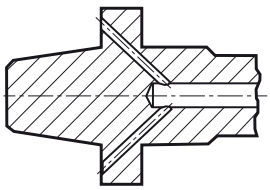
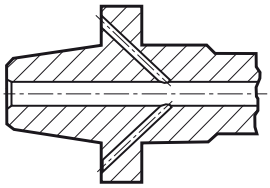
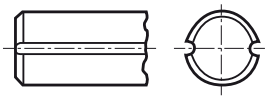
7 Dimension

Pitch only when needed, like in MF.

M3
M10x125 (No decimal given in pitch size)

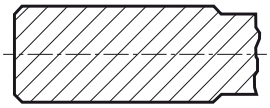
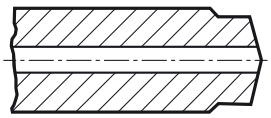
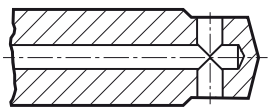
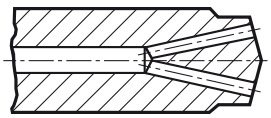
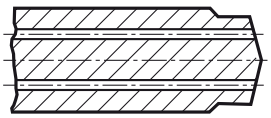
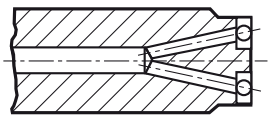
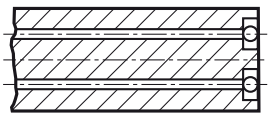
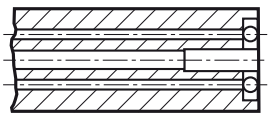
CNSC

Coolant entry style code

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

CXSC

Coolant exit style code

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

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