Tools for multi-materials

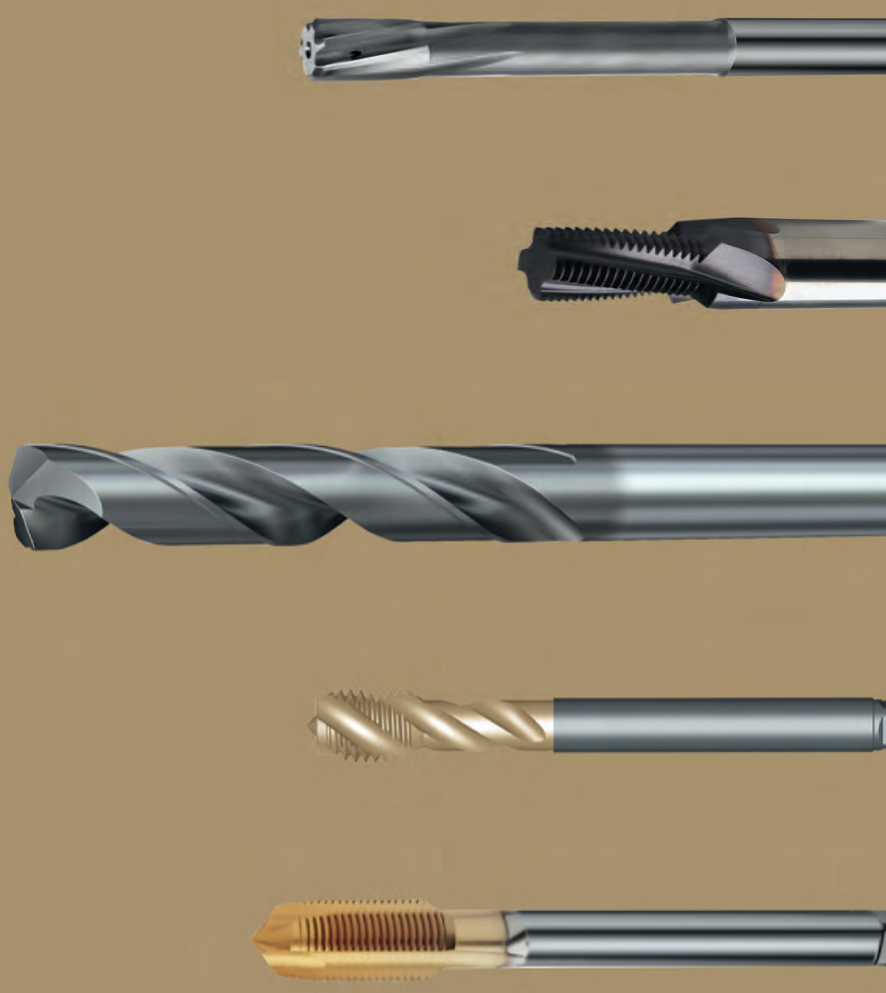
SOLID CARBIDE

V

Versatile

2024

Drills
Reamers
Taps (HSS)
Thread milling cutters



SANDVIK
Coromant

Tailor Made

Additional tool options for your special requirements.

Alongside our extensive standard range, we can also offer you tools in your required dimensions under our standard terms. With our Tailor Made service, you can define your specific dimensions without having to pay the price of a custom tool.

- Drawing and quote within 24 hours
- Tools within 10 to 20 days

… as well as customer-specific solutions

If neither standard nor Tailor Made solutions meet your requirements, you can completely rely on Sandvik Coromant's expertise for customer-specific tool solutions for very special applications.

Tailor Made range

CoroDrill® 460

- Drill diameter 3.0–25.0 mm
- Drilling depth
- Drill type
- Tolerance range
- Adaptor type and size
- Cutting fluid connection
- Coating

CoroTap™ -XM

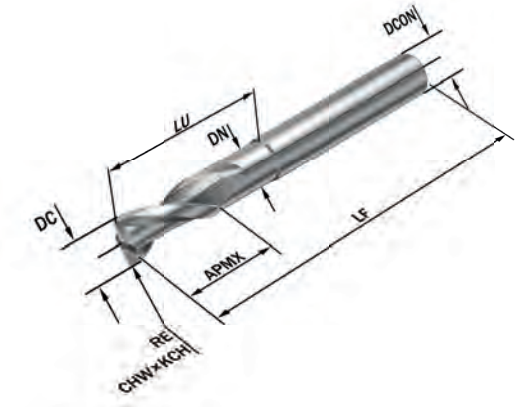
- Thread forms
- Lead
- DIN standards
- Tolerances
- Oversize/undersize
- Coatings
- Cutting fluid supply
- etc.

CoroReamer™ 435

- Diameter
- Tolerance range
- ISO-HF and ISO-NF geometries and grades

CoroMill® Plura

- Tool diameter DC 2–25 mm
- Number of teeth ZEFP 2–7
- Helix angle FHA 30°–45°
- Shank version, e.g. cylindrical/Weldon
- Corner chamfer/radius design CHW/RE CHW≤0.2xDC/RE≤0.4xDC
- Corner chamfer angle KCH 30°–50°
- Shank diameter DCON 3–25 mm
- Neck diameter DN
- Overall length LF
- Cutting-edge length in cut APMX ≤ 5xDC
- Usable length LU 1630 grade selection, H10F, 1620



Download the instructions for selecting Tailor Made tools in PDF format at www.sandvik.coromant.com
For additional information, please get in touch with your Sandvik Coromant contact.

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To make life easier for you, we have developed a new standard

ISO 13399 is an international standard simplifying the exchange of cutting tool data. You will notice that the parameters and descriptions for each tool have changed slightly.

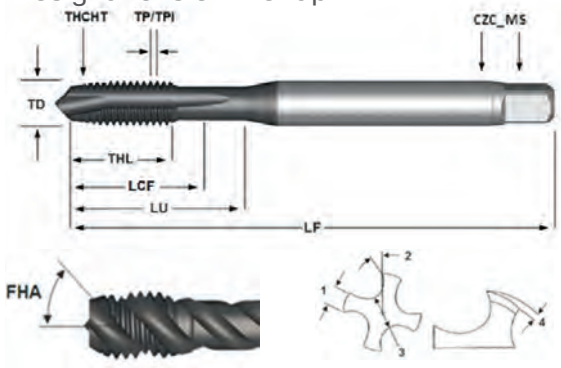
For the first time, there is a standardised format for describing product data for machining tools. If the same parameters and definitions are used in the tool industry, tool data can very simply be communicated between different software systems.

And what does that mean for you?

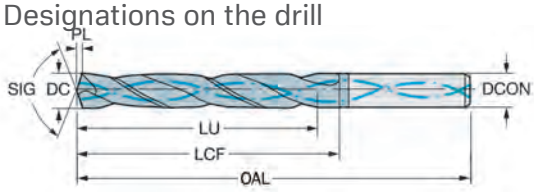
Simply put, it means that your system can communicate with ours, as they speak the same language. Download the product data from our website and use it directly in your CAD/CAM software to put together tools that you need in your production process. You don't have to spend a long time looking for information in catalogues and interpreting data. Just think of how much time this will save you!

Parameter abbreviation	Preferred designation
APMX	Max. depth of cut
B	Shank width
BSG	Standard
CHW	Corner chamfer width
COATING	Coating
CZCMS	Connection size on the machine
DC	Tool diameter
DCON	Adaptor diameter
DN	Neck diameter
FHA	Twist angle
HA	Theoretical thread height
HB	Difference in thread height
KAPK	Tool cutting edge angle
KCH	Corner chamfer
L	Cutting edge length
LCF	Chip flute length
LF	Functional length
LS	Shank length
LU	Usable length
NOF	Number of noses
OAL	Overall length
PL	Height of the cutting tip
SIG	Point angle
TCHA	Achievable hole tolerance
TCTR	Thread tolerance class
TD	Nominal thread diameter
TDZ	Thread number
THCHT	Chamfer
THFT	Thread type
THL	Thread length
TP/TPI	Thread lead
ULDR	Ratio of usable length to diameter
WCS	Clamping width

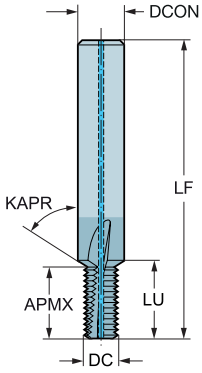
Designations on the tap



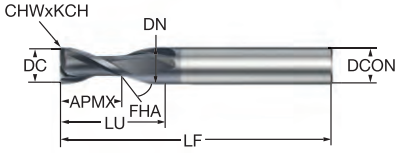
Designations on the drill



Designations on the thread milling cutter



Designations on the end mill



Drilling in many different materials

The CoroDrill®460-XM is a high-performance drill for various applications in countless materials. This drill guarantees exceptional added value without compromising on quality.

Tailor Made

P M K N S H

ISO application range

Features and benefits

- High productivity and consistant tool life
- Excellent hole quality
- Can be reground up to three times without any issues
- Smooth, efficient chip evacuation thanks to excellent coating and optimised chip flute design
- Internal and external coolant supply
- Cylindrical shank, form HA in accordance with DIN 6535

Application range

- Drilling depth 3–8×D
- Hole tolerance IT8–IT9
- Standard diameter 3.00–20.00 mm

Product range

Drilling

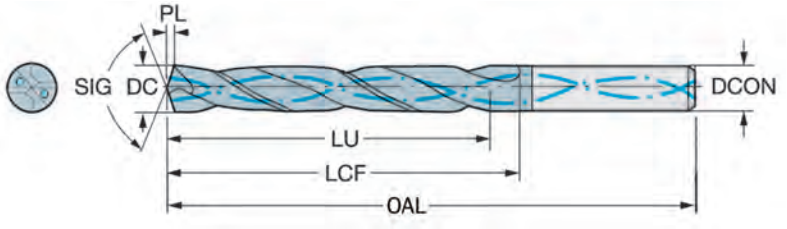
Drilling depth	Drill diameter, mm	Coolant	Geometry	Standard	Shank version	Grade
3xD	3-20	Internal/external	-XM	DIN 6537 K	DIN 6535 HA	GC34
5xD	3-20	Internal/external	-XM	DIN 6537 L	DIN 6535 HA	GC34
8xD	3-20	Internal	-XM	Coromant	Coromant	GC34

Step drilling

Drilling depth	Drill diameter, mm	Coolant	Geometry	Standard	Shank version	Grade
3xD	3.35-14.5	Internal	-XM	Coromant	Coromant	GC34

TCHA: H9
SIG: 140°
Grade: GC34

P M K N S H



		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
3.00	3xD	460.1-0300-009A1-XM	460.1-0300-009A0-XM	6	9	62	20	0,4	DIN 6537 K
3.00	5xD	460.1-0300-015A1-XM	460.1-0300-015A0-XM	6	15	66	28	0,4	DIN 6537 L
3.00	8xD	460.1-0300-023A1-XM		6	24	79	37	0,4	COROMANT
3.10	3xD	460.1-0310-009A1-XM	460.1-0310-009A0-XM	6	10	62	20	0,4	DIN 6537 K
3.10	5xD	460.1-0310-016A1-XM	460.1-0310-016A0-XM	6	16	66	28	0,4	DIN 6537 L
3.10	8xD	460.1-0310-023A1-XM		6	25	79	37	0,4	COROMANT
3.18	3xD	460.1-0318-010A1-XM	460.1-0318-010A0-XM	6	10	62	20	0,5	DIN 6537 K
3.18	5xD	460.1-0318-016A1-XM	460.1-0318-016A0-XM	6	16	66	28	0,5	DIN 6537 L
3.18	8xD	460.1-0318-024A1-XM		6	26	79	37	0,5	COROMANT
3.20	3xD	460.1-0320-010A1-XM	460.1-0320-010A0-XM	6	10	62	20	0,5	DIN 6537 K
3.20	5xD	460.1-0320-016A1-XM	460.1-0320-016A0-XM	6	17	66	28	0,5	DIN 6537 L
3.20	8xD	460.1-0320-024A1-XM		6	26	79	37	0,5	COROMANT
3.30	3xD	460.1-0330-010A1-XM	460.1-0330-010A0-XM	6	10	62	20	0,5	DIN 6537 K
3.30	5xD	460.1-0330-017A1-XM	460.1-0330-017A0-XM	6	17	66	28	0,5	DIN 6537 L
3.30	8xD	460.1-0330-025A1-XM		6	27	79	37	0,5	COROMANT
3.40	3xD	460.1-0340-010A1-XM	460.1-0340-010A0-XM	6	11	62	20	0,5	DIN 6537 K
3.40	5xD	460.1-0340-017A1-XM	460.1-0340-017A0-XM	6	18	66	28	0,5	DIN 6537 L
3.40	8xD	460.1-0340-026A1-XM		6	28	79	37	0,5	COROMANT
3.50	3xD	460.1-0350-011A1-XM	460.1-0350-011A0-XM	6	11	62	20	0,5	DIN 6537 K
3.50	5xD	460.1-0350-018A1-XM	460.1-0350-018A0-XM	6	18	66	28	0,5	DIN 6537 L
3.50	8xD	460.1-0350-026A1-XM		6	29	79	37	0,5	COROMANT
3.57	3xD	460.1-0357-011A1-XM	460.1-0357-011A0-XM	6	11	62	20	0,5	DIN 6537 K
3.57	8xD	460.1-0357-027A1-XM		6	29	79	37	0,5	COROMANT
3.60	3xD	460.1-0360-011A1-XM	460.1-0360-011A0-XM	6	11	62	20	0,5	DIN 6537 K
3.60	5xD	460.1-0360-018A1-XM		6	19	66	28	0,5	DIN 6537 L
3.70	3xD	460.1-0370-011A1-XM	460.1-0370-011A0-XM	6	12	62	20	0,5	DIN 6537 K
3.70	5xD	460.1-0370-019A1-XM	460.1-0370-019A0-XM	6	19	66	28	0,5	DIN 6537 L
3.70	8xD	460.1-0370-028A1-XM		6	29	79	37	0,5	COROMANT
3.80	3xD	460.1-0380-011A1-XM	460.1-0380-011A0-XM	6	12	66	24	0,5	DIN 6537 K
3.80	5xD	460.1-0380-019A1-XM	460.1-0380-019A0-XM	6	20	74	36	0,5	DIN 6537 L
3.80	8xD	460.1-0380-029A1-XM		6	31	90	48	0,5	COROMANT
3.90	3xD	460.1-0390-012A1-XM	460.1-0390-012A0-XM	6	12	66	24	0,6	DIN 6537 K
3.90	5xD	460.1-0390-020A1-XM		6	20	74	36	0,6	DIN 6537 L
3.97	3xD		460.1-0397-012A0-XM	6	13	66	24	0,6	DIN 6537 K
3.97	5xD	460.1-0397-020A1-XM	460.1-0397-020A0-XM	6	20	74	36	0,6	DIN 6537 L
3.97	8xD	460.1-0397-030A1-XM		6	32	90	48	0,6	COROMANT
4.00	3xD	460.1-0400-012A1-XM	460.1-0400-012A0-XM	6	13	66	24	0,6	DIN 6537 K
4.00	5xD	460.1-0400-020A1-XM	460.1-0400-020A0-XM	6	21	74	36	0,6	DIN 6537 L
4.00	8xD	460.1-0400-030A1-XM		6	33	90	48	0,6	COROMANT
4.05	3xD	460.1-0405-012A1-XM		6	13	66	24	0,6	DIN 6537 K
4.05	5xD	460.1-0405-020A1-XM		6	21	74	36	0,6	DIN 6537 L
4.10	3xD	460.1-0410-012A1-XM	460.1-0410-012A0-XM	6	13	66	24	0,6	DIN 6537 K
4.10	5xD	460.1-0410-021A1-XM	460.1-0410-021A0-XM	6	21	74	36	0,6	DIN 6537 L
4.10	8xD	460.1-0410-031A1-XM		6	33	90	48	0,6	COROMANT
4.20	3xD	460.1-0420-013A1-XM	460.1-0420-013A0-XM	6	13	66	24	0,6	DIN 6537 K
4.20	5xD	460.1-0420-021A1-XM	460.1-0420-021A0-XM	6	22	74	36	0,6	DIN 6537 L
4.20	8xD	460.1-0420-032A1-XM		6	34	90	48	0,6	COROMANT
4.30	3xD	460.1-0430-013A1-XM	460.1-0430-013A0-XM	6	14	66	24	0,6	DIN 6537 K
4.30	5xD	460.1-0430-022A1-XM	460.1-0430-022A0-XM	6	22	74	36	0,6	DIN 6537 L
4.30	8xD	460.1-0430-032A1-XM		6	35	90	48	0,6	COROMANT
4.37	3xD	460.1-0437-013A1-XM	460.1-0437-013A0-XM	6	14	66	24	0,6	DIN 6537 K
4.37	5xD	460.1-0437-022A1-XM	460.1-0437-022A0-XM	6	23	74	36	0,6	DIN 6537 L
4.37	8xD	460.1-0437-033A1-XM		6	36	90	48	0,6	COROMANT
4.40	3xD	460.1-0440-013A1-XM	460.1-0440-013A0-XM	6	14	66	24	0,6	DIN 6537 K
4.40	5xD	460.1-0440-022A1-XM	460.1-0440-022A0-XM	6	23	74	36	0,6	DIN 6537 L
4.50	3xD	460.1-0450-014A1-XM	460.1-0450-014A0-XM	6	14	66	24	0,7	DIN 6537 K
4.50	5xD	460.1-0450-023A1-XM	460.1-0450-023A0-XM	6	23	74	36	0,7	DIN 6537 L

TCHA: H9
SIG: 140°
Grade: GC34

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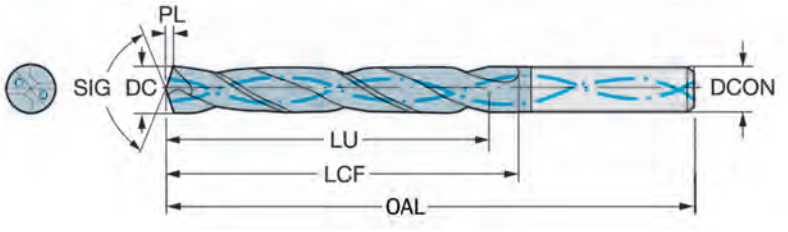
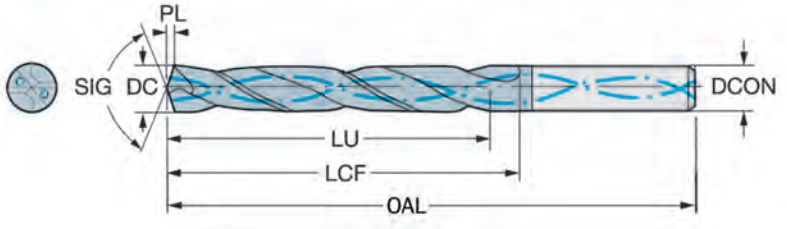


		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
4.50	8xD	460.1-0450-034A1-XM		6	37	90	48	0,7	COROMANT
4.60	8xD	460.1-0460-035A1-XM	460.1-0460-014A0-XM	6	38	90	48	0,7	COROMANT
4.60	3xD	460.1-0460-014A1-XM	460.1-0460-023A0-XM	6	15	66	24	0,7	DIN 6537 K
4.60	5xD	460.1-0460-023A1-XM		6	24	74	36	0,7	DIN 6537 L
4.70	3xD	460.1-0470-014A1-XM	460.1-0470-014A0-XM	6	15	66	24	0,7	DIN 6537 K
4.70	5xD	460.1-0470-024A1-XM	460.1-0470-024A0-XM	6	24	74	36	0,7	DIN 6537 L
4.70	8xD	460.1-0470-035A1-XM		6	38	90	48	0,7	COROMANT
4.76	3xD	460.1-0476-014A1-XM	460.1-0476-014A0-XM	6	15	66	28	0,7	DIN 6537 K
4.76	5xD	460.1-0476-024A1-XM	460.1-0476-024A0-XM	6	25	82	44	0,7	DIN 6537 L
4.76	8xD	460.1-0476-036A1-XM		6	39	104	62	0,7	COROMANT
4.80	3xD	460.1-0480-014A1-XM	460.1-0480-014A0-XM	6	15	66	28	0,7	DIN 6537 K
4.80	5xD	460.1-0480-024A1-XM	460.1-0480-024A0-XM	6	25	82	44	0,7	DIN 6537 L
4.80	8xD	460.1-0480-036A1-XM		6	39	104	62	0,7	COROMANT
4.90	3xD	460.1-0490-015A1-XM	460.1-0490-015A0-XM	6	15	66	28	0,7	DIN 6537 K
4.90	5xD	460.1-0490-025A1-XM	460.1-0490-025A0-XM	6	25	82	44	0,7	DIN 6537 L
5.00	3xD	460.1-0500-015A1-XM	460.1-0500-015A0-XM	6	16	66	28	0,7	DIN 6537 K
5.00	5xD	460.1-0500-025A1-XM	460.1-0500-025A0-XM	6	26	82	44	0,7	DIN 6537 L
5.00	8xD	460.1-0500-038A1-XM		6	41	104	62	0,7	COROMANT
5.05	3xD	460.1-0505-015A1-XM		6	16	66	28	0,7	DIN 6537 K
5.05	5xD	460.1-0505-025A1-XM		6	26	82	44	0,7	DIN 6537 L
5.10	3xD	460.1-0510-015A1-XM	460.1-0510-015A0-XM	6	16	66	28	0,7	DIN 6537 K
5.10	5xD	460.1-0510-026A1-XM	460.1-0510-026A0-XM	6	26	82	44	0,7	DIN 6537 L
5.10	8xD	460.1-0510-038A1-XM		6	42	104	62	0,7	COROMANT
5.16	3xD	460.1-0516-016A1-XM	460.1-0516-016A0-XM	6	16	66	28	0,8	DIN 6537 K
5.16	5xD	460.1-0516-026A1-XM	460.1-0516-026A0-XM	6	27	82	44	0,8	DIN 6537 L
5.16	8xD	460.1-0516-039A1-XM		6	42	104	62	0,8	COROMANT
5.20	3xD	460.1-0520-016A1-XM	460.1-0520-016A0-XM	6	16	66	28	0,8	DIN 6537 K
5.20	5xD	460.1-0520-026A1-XM	460.1-0520-026A0-XM	6	27	82	44	0,8	DIN 6537 L
5.20	8xD	460.1-0520-039A1-XM		6	42	104	62	0,8	COROMANT
5.50	3xD	460.1-0550-017A1-XM	460.1-0550-017A0-XM	6	17	66	28	0,8	DIN 6537 K
5.50	5xD	460.1-0550-028A1-XM	460.1-0550-028A0-XM	6	28	82	44	0,8	DIN 6537 L
5.50	8xD	460.1-0550-041A1-XM		6	45	104	62	0,8	COROMANT
5.56	3xD	460.1-0556-017A1-XM	460.1-0556-017A0-XM	6	18	66	28	0,8	DIN 6537 K
5.56	5xD	460.1-0556-028A1-XM	460.1-0556-028A0-XM	6	29	82	44	0,8	DIN 6537 L
5.56	8xD	460.1-0556-042A1-XM		6	45	104	62	0,8	COROMANT
5.60	3xD	460.1-0560-017A1-XM	460.1-0560-017A0-XM	6	18	66	28	0,8	DIN 6537 K
5.60	5xD	460.1-0560-028A1-XM	460.1-0560-028A0-XM	6	29	82	44	0,8	DIN 6537 L
5.70	3xD	460.1-0570-017A1-XM		6	18	66	28	0,8	DIN 6537 K
5.70	5xD	460.1-0570-029A1-XM		6	29	82	44	0,8	DIN 6537 L
5.70	8xD	460.1-0570-043A1-XM		6	46	104	62	0,8	COROMANT
5.80	3xD	460.1-0580-017A1-XM	460.1-0580-017A0-XM	6	18	66	28	0,9	DIN 6537 K
5.80	5xD	460.1-0580-029A1-XM	460.1-0580-029A0-XM	6	30	82	44	0,9	DIN 6537 L
5.80	8xD	460.1-0580-044A1-XM		6	47	104	62	0,9	COROMANT
5.95	3xD	460.1-0595-018A1-XM	460.1-0595-018A0-XM	6	17	66	28	0,9	DIN 6537 K
5.95	5xD	460.1-0595-030A1-XM	460.1-0595-030A0-XM	6	31	82	44	0,9	DIN 6537 L
5.95	8xD	460.1-0595-045A1-XM		6	49	104	62	0,9	COROMANT
6.00	3xD	460.1-0600-018A1-XM	460.1-0600-018A0-XM	6	19	66	28	0,9	DIN 6537 K
6.00	5xD	460.1-0600-030A1-XM	460.1-0600-030A0-XM	6	31	82	44	0,9	DIN 6537 L
6.00	8xD	460.1-0600-045A1-XM		6	49	104	62	0,9	COROMANT
6.05	3xD	460.1-0605-018A1-XM		8	19	79	34	0,9	DIN 6537 K
6.05	5xD	460.1-0605-030A1-XM		8	31	91	53	0,9	DIN 6537 L
6.10	3xD	460.1-0610-018A1-XM	460.1-0610-018A0-XM	8	19	79	34	0,9	DIN 6537 K
6.10	5xD	460.1-0610-031A1-XM	460.1-0610-031A0-XM	8	31	91	53	0,9	DIN 6537 L
6.10	8xD	460.1-0610-046A1-XM		8	50	126	84	0,9	COROMANT
6.20	3xD	460.1-0620-019A1-XM	460.1-0620-019A0-XM	8	20	79	34	0,9	DIN 6537 K

TCHA: H9
SIG: 140°
Grade: GC34

P M K N S H



		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
6.20	5xD	460.1-0620-031A1-XM	460.1-0620-031A0-XM	8	32	91	53	0,9	DIN 6537 L
6.20	8xD	460.1-0620-047A1-XM		8	51	126	84	0,9	COROMANT
6.30	3xD	460.1-0630-019A1-XM	460.1-0630-019A0-XM	8	20	79	34	0,9	DIN 6537 K
6.30	5xD	460.1-0630-032A1-XM		8	32	91	53	0,9	DIN 6537 L
6.35	3xD	460.1-0635-019A1-XM		8	20	79	34	0,9	DIN 6537 K
6.35	5xD	460.1-0635-032A1-XM	460.1-0635-019A0-XM	8	33	91	53	0,9	DIN 6537 L
6.35	8xD	460.1-0635-048A1-XM	460.1-0635-032A0-XM	8	52	126	84	0,9	COROMANT
6.40	3xD	460.1-0640-019A1-XM	460.1-0640-019A0-XM	8	20	79	34	0,9	DIN 6537 K
6.40	5xD	460.1-0640-032A1-XM		8	33	91	53	0,9	DIN 6537 L
6.50	3xD	460.1-0650-020A1-XM	460.1-0650-020A0-XM	8	21	79	34	1	DIN 6537 K
6.50	5xD	460.1-0650-033A1-XM	460.1-0650-033A0-XM	8	34	91	53	1	DIN 6537 L
6.50	8xD	460.1-0650-049A1-XM		8	53	126	84	1	COROMANT
6.60	3xD	460.1-0660-020A1-XM	460.1-0660-020A0-XM	8	21	79	34	1	DIN 6537 K
6.60	5xD	460.1-0660-033A1-XM	460.1-0660-033A0-XM	8	34	91	53	1	DIN 6537 L
6.60	8xD	460.1-0660-050A1-XM		8	54	126	84	1	COROMANT
6.70	3xD	460.1-0670-020A1-XM	460.1-0670-020A0-XM	8	21	79	34	1	DIN 6537 K
6.70	5xD	460.1-0670-034A1-XM	460.1-0670-034A0-XM	8	35	91	53	1	DIN 6537 L
6.70	8xD	460.1-0670-050A1-XM		8	55	126	84	1	COROMANT
6.75	3xD	460.1-0675-020A1-XM	460.1-0675-020A0-XM	8	21	79	34	1	DIN 6537 K
6.75	5xD	460.1-0675-034A1-XM	460.1-0675-034A0-XM	8	35	91	53	1	DIN 6537 L
6.75	8xD	460.1-0675-051A1-XM		8	55	126	84	1	COROMANT
6.80	3xD	460.1-0680-020A1-XM	460.1-0680-020A0-XM	8	21	79	34	1	DIN 6537 K
6.80	5xD	460.1-0680-034A1-XM	460.1-0680-034A0-XM	8	35	91	53	1	DIN 6537 L
6.80	8xD	460.1-0680-051A1-XM		8	55	126	84	1	COROMANT
6.90	3xD	460.1-0690-021A1-XM	460.1-0690-021A0-XM	8	22	79	34	1	DIN 6537 K
6.90	5xD	460.1-0690-035A1-XM	460.1-0690-035A0-XM	8	36	91	53	1	DIN 6537 L
6.90	8xD	460.1-0690-052A1-XM		8	56	126	84	1	COROMANT
7.00	3xD	460.1-0700-021A1-XM	460.1-0700-021A0-XM	8	22	79	34	1	DIN 6537 K
7.00	5xD	460.1-0700-035A1-XM	460.1-0700-035A0-XM	8	36	91	53	1	DIN 6537 L
7.00	8xD	460.1-0700-053A1-XM		8	57	126	84	1	COROMANT
7.10	3xD	460.1-0710-021A1-XM	460.1-0710-021A0-XM	8	22	79	41	1	DIN 6537 K
7.10	5xD	460.1-0710-036A1-XM		8	37	91	53	1	DIN 6537 L
7.14	3xD	460.1-0714-021A1-XM	460.1-0714-021A0-XM	8	23	79	41	1,1	DIN 6537 K
7.14	5xD	460.1-0714-036A1-XM	460.1-0714-036A0-XM	8	37	91	53	1,1	DIN 6537 L
7.14	8xD	460.1-0714-054A1-XM		8	58	126	84	1,1	COROMANT
7.20	8xD	460.1-0720-054A1-XM	460.1-0730-022A0-XM	8	59	126	84	1,1	COROMANT
7.30	3xD	460.1-0730-022A1-XM	460.1-0730-037A0-XM	8	23	79	41	1,1	DIN 6537 K
7.30	5xD	460.1-0730-037A1-XM		8	38	91	53	1,1	DIN 6537 L
7.40	3xD	460.1-0740-022A1-XM	460.1-0740-022A0-XM	8	23	79	41	1,1	DIN 6537 K
7.40	5xD	460.1-0740-037A1-XM	460.1-0740-037A0-XM	8	38	91	53	1,1	DIN 6537 L
7.40	8xD	460.1-0740-056A1-XM		8	60	126	84	1,1	COROMANT
7.50	3xD	460.1-0750-023A1-XM	460.1-0750-023A0-XM	8	24	79	41	1,1	DIN 6537 K
7.50	5xD	460.1-0750-038A1-XM	460.1-0750-038A0-XM	8	39	91	53	1,1	DIN 6537 L
7.50	8xD	460.1-0750-056A1-XM		8	61	126	84	1,1	COROMANT
7.54	3xD	460.1-0754-023A1-XM	460.1-0754-023A0-XM	8	24	79	41	1,1	DIN 6537 K
7.54	5xD	460.1-0754-038A1-XM	460.1-0754-038A0-XM	8	39	91	53	1,1	DIN 6537 L
7.60	3xD	460.1-0760-023A1-XM		8	24	79	41	1,1	DIN 6537 K
7.60	5xD	460.1-0760-038A1-XM		8	39	91	53	1,1	DIN 6537 L
7.60	8xD	460.1-0760-057A1-XM		8	62	126	84	1,1	COROMANT
7.70	3xD	460.1-0770-023A1-XM	460.1-0770-023A0-XM	8	24	79	41	1,1	DIN 6537 K
7.70	5xD	460.1-0770-039A1-XM		8	40	91	53	1,1	DIN 6537 L
7.70	8xD	460.1-0770-058A1-XM		8	63	126	84	1,1	COROMANT
7.80	3xD	460.1-0780-023A1-XM	460.1-0780-023A0-XM	8	25	79	41	1,2	DIN 6537 K
7.80	5xD	460.1-0780-039A1-XM	460.1-0780-039A0-XM	8	40	91	53	1,2	DIN 6537 L
7.80	8xD	460.1-0780-059A1-XM		8	64	126	84	1,2	COROMANT
7.90	3xD	460.1-0790-024A1-XM	460.1-0790-024A0-XM	8	25	79	41	1,2	DIN 6537 K
7.90	5xD	460.1-0790-040A1-XM	460.1-0790-040A0-XM	8	41	91	53	1,2	DIN 6537 L

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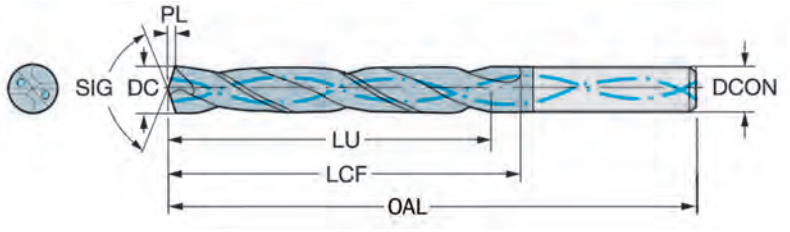

		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
7.94	3xD	460.1-0794-024A1-XM	460.1-0794-024A0-XM	8	25	79	41	1,2	DIN 6537 K
7.94	5xD	460.1-0794-040A1-XM	460.1-0794-040A0-XM	8	41	91	53	1,2	DIN 6537 L
7.94	8xD	460.1-0794-060A1-XM		8	65	126	84	1,2	COROMANT
8.00	3xD	460.1-0800-024A1-XM	460.1-0800-024A0-XM	8	25	79	41	1,2	DIN 6537 K
8.00	5xD	460.1-0800-040A1-XM	460.1-0800-040A0-XM	8	41	91	53	1,2	DIN 6537 L
8.00	8xD	460.1-0800-060A1-XM		8	65	126	84	1,2	COROMANT
8.05	3xD	460.1-0805-024A1-XM		10	25	89	47	1,2	DIN 6537 K
8.05	5xD	460.1-0805-040A1-XM		10	41	103	61	1,2	DIN 6537 L
8.10	3xD	460.1-0810-024A1-XM	460.1-0810-024A0-XM	10	26	89	47	1,2	DIN 6537 K
8.10	5xD	460.1-0810-041A1-XM	460.1-0810-041A0-XM	10	42	103	61	1,2	DIN 6537 L
8.10	8xD	460.1-0810-061A1-XM		10	66	152	106	1,2	COROMANT
8.20	3xD	460.1-0820-025A1-XM	460.1-0820-025A0-XM	10	26	89	47	1,2	DIN 6537 K
8.20	5xD	460.1-0820-041A1-XM	460.1-0820-041A0-XM	10	42	103	61	1,2	DIN 6537 L
8.20	8xD	460.1-0820-062A1-XM		10	67	152	106	1,2	COROMANT
8.33	3xD	460.1-0833-025A1-XM	460.1-0833-025A0-XM	10	26	89	47	1,2	DIN 6537 K
8.33	5xD	460.1-0833-042A1-XM		10	43	103	61	1,2	DIN 6537 L
8.33	8xD	460.1-0833-062A1-XM		10	68	152	106	1,2	COROMANT
8.40	3xD	460.1-0840-025A1-XM	460.1-0840-025A0-XM	10	26	89	47	1,2	DIN 6537 K
8.40	5xD	460.1-0840-042A1-XM	460.1-0840-042A0-XM	10	43	103	61	1,2	DIN 6537 L
8.40	8xD	460.1-0840-063A1-XM		10	68	152	106	1,2	COROMANT
8.50	3xD	460.1-0850-026A1-XM	460.1-0850-026A0-XM	10	27	89	47	1,3	DIN 6537 K
8.50	5xD	460.1-0850-043A1-XM	460.1-0850-043A0-XM	10	44	103	61	1,3	DIN 6537 L
8.50	8xD	460.1-0850-064A1-XM		10	69	152	106	1,3	COROMANT
8.60	3xD	460.1-0860-026A1-XM	460.1-0860-026A0-XM	10	27	89	47	1,3	DIN 6537 K
8.60	5xD	460.1-0860-043A1-XM	460.1-0860-043A0-XM	10	44	103	61	1,3	DIN 6537 L
8.60	8xD	460.1-0860-065A1-XM		10	70	152	106	1,3	COROMANT
8.70	3xD	460.1-0870-026A1-XM	460.1-0870-026A0-XM	10	27	89	47	1,3	DIN 6537 K
8.70	5xD	460.1-0870-044A1-XM	460.1-0870-044A0-XM	10	45	103	61	1,3	DIN 6537 L
8.70	8xD	460.1-0870-065A1-XM		10	71	152	106	1,3	COROMANT
8.73	3xD	460.1-0873-026A1-XM	460.1-0873-026A0-XM	10	28	89	47	1,3	DIN 6537 K
8.73	5xD	460.1-0873-044A1-XM	460.1-0873-044A0-XM	10	45	103	61	1,3	DIN 6537 L
8.73	8xD	460.1-0873-065A1-XM		10	71	152	106	1,3	COROMANT
8.80	3xD	460.1-0880-026A1-XM	460.1-0880-026A0-XM	10	28	89	47	1,3	DIN 6537 K
8.80	5xD	460.1-0880-044A1-XM	460.1-0880-044A0-XM	10	45	103	61	1,3	DIN 6537 L
8.80	8xD	460.1-0880-066A1-XM		10	72	152	106	1,3	COROMANT
8.90	3xD	460.1-0890-027A1-XM	460.1-0890-045A0-XM	10	28	89	47	1,3	DIN 6537 K
8.90	5xD	460.1-0890-045A1-XM		10	46	103	61	1,3	DIN 6537 L
9.00	3xD	460.1-0900-027A1-XM	460.1-0900-027A0-XM	10	28	89	47	1,3	DIN 6537 K
9.00	5xD	460.1-0900-045A1-XM	460.1-0900-045A0-XM	10	46	103	61	1,3	DIN 6537 L
9.00	8xD	460.1-0900-068A1-XM		10	73	152	106	1,3	COROMANT
9.10	3xD	460.1-0910-027A1-XM		10	29	89	47	1,3	DIN 6537 K
9.10	5xD	460.1-0910-046A1-XM	460.1-0910-046A0-XM	10	47	103	61	1,3	DIN 6537 L
9.13	3xD	460.1-0913-027A1-XM		10	29	89	47	1,4	DIN 6537 K
9.13	5xD	460.1-0913-046A1-XM		10	47	103	61	1,4	DIN 6537 L
9.13	8xD	460.1-0913-068A1-XM		10	74	152	106	1,4	COROMANT
9.30	3xD	460.1-0930-028A1-XM	460.1-0930-028A0-XM	10	29	89	47	1,4	DIN 6537 K
9.30	5xD	460.1-0930-047A1-XM	460.1-0930-047A0-XM	10	48	103	61	1,4	DIN 6537 L
9.30	8xD	460.1-0930-070A1-XM		10	76	152	106	1,4	COROMANT
9.40	3xD	460.1-0940-028A1-XM	460.1-0940-028A0-XM	10	30	89	47	1,4	DIN 6537 K
9.40	5xD	460.1-0940-047A1-XM	460.1-0940-047A0-XM	10	48	103	61	1,4	DIN 6537 L
9.50	3xD	460.1-0950-029A1-XM	460.1-0950-029A0-XM	10	30	89	47	1,4	DIN 6537 K
9.50	5xD	460.1-0950-048A1-XM	460.1-0950-048A0-XM	10	49	103	61	1,4	DIN 6537 L
9.50	8xD	460.1-0950-071A1-XM		10	77	152	106	1,4	COROMANT
9.53	3xD	460.1-0953-029A1-XM	460.1-0953-029A0-XM	10	30	89	47	1,4	DIN 6537 K

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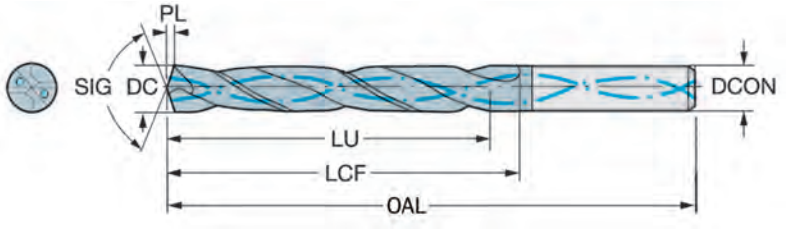

		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
9.53	5xD	460.1-0953-048A1-XM	460.1-0953-048A0-XM	10	49	103	61	1,4	DIN 6537 L
9.53	8xD	460.1-0953-071A1-XM		10	78	152	106	1,4	COROMANT
9.60	3xD	460.1-0960-029A1-XM	460.1-0960-029A0-XM	10	30	89	47	1,4	DIN 6537 K
9.60	5xD	460.1-0960-048A1-XM	460.1-0960-048A0-XM	10	49	103	61	1,4	DIN 6537 L
9.70	3xD	460.1-0970-029A1-XM	460.1-0970-029A0-XM	10	31	89	47	1,4	DIN 6537 K
9.70	5xD	460.1-0970-049A1-XM	460.1-0970-049A0-XM	10	48	103	61	1,4	DIN 6537 L
9.80	3xD	460.1-0980-029A1-XM	460.1-0980-029A0-XM	10	31	89	47	1,5	DIN 6537 K
9.80	5xD	460.1-0980-049A1-XM	460.1-0980-049A0-XM	10	48	103	61	1,5	DIN 6537 L
9.80	8xD	460.1-0980-074A1-XM		10	80	152	106	1,5	COROMANT
9.90	3xD	460.1-0990-030A1-XM		10	31	89	47	1,5	DIN 6537 K
9.90	5xD	460.1-0990-050A1-XM		10	48	103	61	1,5	DIN 6537 L
9.90	8xD	460.1-0990-074A1-XM		10	81	152	106	1,5	COROMANT
9.92	3xD	460.1-0992-030A1-XM		10	31	89	47	1,5	DIN 6537 K
9.92	5xD	460.1-0992-050A1-XM	460.1-0992-050A0-XM	10	48	103	61	1,5	DIN 6537 L
9.92	8xD	460.1-0992-074A1-XM		10	81	152	106	1,5	COROMANT
10.00	3xD	460.1-1000-030A1-XM	460.1-1000-030A0-XM	10	32	89	47	1,5	DIN 6537 K
10.00	5xD	460.1-1000-050A1-XM	460.1-1000-050A0-XM	10	48	103	61	1,5	DIN 6537 L
10.00	8xD	460.1-1000-075A1-XM		10	82	152	106	1,5	COROMANT
10.05	3xD	460.1-1005-030A1-XM		12	32	102	55	1,5	DIN 6537 K
10.05	5xD	460.1-1005-050A1-XM		12	52	118	71	1,5	DIN 6537 L
10.10	3xD	460.1-1010-030A1-XM	460.1-1010-030A0-XM	12	32	102	55	1,5	DIN 6537 K
10.10	5xD	460.1-1010-051A1-XM	460.1-1010-051A0-XM	12	52	118	71	1,5	DIN 6537 L
10.20	3xD	460.1-1020-031A1-XM	460.1-1020-031A0-XM	12	32	102	55	1,5	DIN 6537 K
10.20	5xD	460.1-1020-051A1-XM	460.1-1020-051A0-XM	12	53	118	71	1,5	DIN 6537 L
10.20	8xD	460.1-1020-077A1-XM		12	83	180	128	1,5	COROMANT
10.30	3xD	460.1-1030-031A1-XM	460.1-1030-031A0-XM	12	32	102	55	1,5	DIN 6537 K
10.30	5xD	460.1-1030-052A1-XM	460.1-1030-052A0-XM	12	53	118	71	1,5	DIN 6537 L
10.30	8xD	460.1-1030-077A1-XM		12	84	180	128	1,5	COROMANT
10.32	3xD	460.1-1032-031A1-XM		12	33	102	55	1,5	DIN 6537 K
10.32	5xD	460.1-1032-052A1-XM	460.1-1032-052A0-XM	12	53	118	71	1,5	DIN 6537 L
10.32	8xD	460.1-1032-077A1-XM		12	84	180	128	1,5	COROMANT
10.40	3xD	460.1-1040-031A1-XM	460.1-1040-031A0-XM	12	33	102	55	1,5	DIN 6537 K
10.40	5xD	460.1-1040-052A1-XM	460.1-1040-052A0-XM	12	54	118	71	1,5	DIN 6537 L
10.40	8xD	460.1-1040-078A1-XM		12	85	180	128	1,5	COROMANT
10.50	3xD	460.1-1050-032A1-XM	460.1-1050-032A0-XM	12	33	102	55	1,6	DIN 6537 K
10.50	5xD	460.1-1050-053A1-XM	460.1-1050-053A0-XM	12	54	118	71	1,6	DIN 6537 L
10.50	8xD	460.1-1050-079A1-XM		12	86	180	128	1,6	COROMANT
10.60	3xD	460.1-1060-032A1-XM	460.1-1060-032A0-XM	12	33	102	55	1,6	DIN 6537 K
10.60	5xD	460.1-1060-053A1-XM		12	55	118	71	1,6	DIN 6537 L
10.72	3xD	460.1-1072-032A1-XM	460.1-1072-032A0-XM	12	34	102	55	1,6	DIN 6537 K
10.72	5xD	460.1-1072-054A1-XM	460.1-1072-054A0-XM	12	55	118	71	1,6	DIN 6537 L
10.72	8xD	460.1-1072-080A1-XM		12	87	180	128	1,6	COROMANT
10.80	3xD		460.1-1080-032A0-XM	12	34	102	55	1,6	DIN 6537 L
11.00	3xD	460.1-1100-033A1-XM	460.1-1100-033A0-XM	12	35	102	55	1,6	DIN 6537 K
11.00	5xD	460.1-1100-055A1-XM	460.1-1100-055A0-XM	12	57	118	71	1,6	DIN 6537 L
11.00	8xD	460.1-1100-083A1-XM		12	90	180	128	1,6	COROMANT
11.11	3xD	460.1-1111-033A1-XM	460.1-1111-033A0-XM	12	35	102	55	1,7	DIN 6537 K
11.11	5xD	460.1-1111-056A1-XM	460.1-1111-056A0-XM	12	57	118	71	1,7	DIN 6537 L
11.11	8xD	460.1-1111-083A1-XM		12	91	180	128	1,7	COROMANT
11.20	3xD	460.1-1120-034A1-XM	460.1-1120-034A0-XM	12	35	102	55	1,7	DIN 6537 K
11.20	5xD	460.1-1120-056A1-XM	460.1-1120-056A0-XM	12	58	118	71	1,7	DIN 6537 L
11.20	8xD	460.1-1120-084A1-XM		12	91	180	128	1,7	COROMANT
11.40	3xD	460.1-1140-034A1-XM	460.1-1140-034A0-XM	12	36	102	55	1,7	DIN 6537 K
11.40	5xD	460.1-1140-057A1-XM	460.1-1140-057A0-XM	12	57	118	71	1,7	DIN 6537 L
11.50	3xD	460.1-1150-035A1-XM	460.1-1150-035A0-XM	12	36	102	55	1,7	DIN 6537 K
11.50	5xD	460.1-1150-058A1-XM	460.1-1150-058A0-XM	12	57	118	71	1,7	DIN 6537 L
11.50	8xD	460.1-1150-086A1-XM		12	94	180	128	1,7	COROMANT

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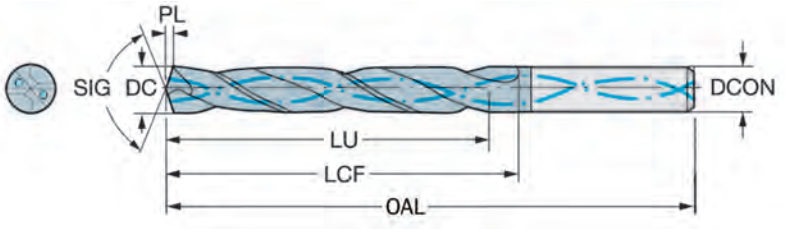
SIG: 140°
Grade: GC34

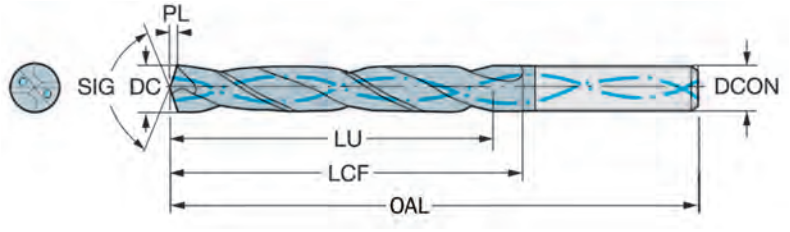
P M K N S H



		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
11.51	3xD	460.1-1151-035A1-XM		12	36	102	55	1,7	DIN 6537 K
11.51	5xD	460.1-1151-058A1-XM		12	57	118	71	1,7	DIN 6537 L
11.51	8xD	460.1-1151-086A1-XM		12	94	180	128	1,7	COROMANT
11.60	3xD	460.1-1160-035A1-XM	460.1-1160-035A0-XM	12	37	102	55	1,7	DIN 6537 K
11.60	5xD	460.1-1160-058A1-XM	460.1-1160-058A0-XM	12	57	118	71	1,7	DIN 6537 L
11.80	3xD	460.1-1180-035A1-XM	460.1-1180-035A0-XM	12	37	102	55	1,8	DIN 6537 K
11.80	5xD	460.1-1180-059A1-XM	460.1-1180-059A0-XM	12	57	118	71	1,8	DIN 6537 L
11.80	8xD	460.1-1180-089A1-XM		12	96	180	128	1,8	COROMANT
11.91	3xD	460.1-1191-036A1-XM		12	38	102	55	1,8	DIN 6537 K
11.91	5xD	460.1-1191-060A1-XM	460.1-1191-060A0-XM	12	57	118	71	1,8	DIN 6537 L
11.91	8xD	460.1-1191-089A1-XM		12	97	180	128	1,8	COROMANT
12.00	3xD	460.1-1200-036A1-XM	460.1-1200-036A0-XM	12	38	102	55	1,8	DIN 6537 K
12.00	5xD	460.1-1200-060A1-XM	460.1-1200-060A0-XM	12	57	118	71	1,8	DIN 6537 L
12.00	8xD	460.1-1200-090A1-XM		12	98	180	128	1,8	COROMANT
12.05	3xD	460.1-1205-036A1-XM		14	38	107	60	1,8	DIN 6537 K
12.05	5xD	460.1-1205-060A1-XM		14	62	124	77	1,8	DIN 6537 L
12.10	3xD	460.1-1210-036A1-XM	460.1-1210-036A0-XM	14	38	107	60	1,8	DIN 6537 K
12.10	5xD		460.1-1210-061A0-XM	14	62	124	77	1,8	DIN 6537 L
12.20	3xD	460.1-1220-037A1-XM	460.1-1220-037A0-XM	14	38	107	60	1,8	DIN 6537 K
12.20	5xD	460.1-1220-061A1-XM	460.1-1220-061A0-XM	14	62	124	77	1,8	DIN 6537 L
12.20	8xD	460.1-1220-092A1-XM		14	99	202	151	1,8	COROMANT
12.30	3xD	460.1-1230-037A1-XM	460.1-1230-037A0-XM	14	39	107	60	1,8	DIN 6537 K
12.30	5xD	460.1-1230-062A1-XM		14	62	124	77	1,8	DIN 6537 L
12.30	8xD	460.1-1230-092A1-XM		14	100	202	151	1,8	COROMANT
12.50	3xD	460.1-1250-038A1-XM	460.1-1250-038A0-XM	14	39	107	60	1,9	DIN 6537 K
12.50	5xD	460.1-1250-063A1-XM	460.1-1250-063A0-XM	14	62	124	77	1,9	DIN 6537 L
12.50	8xD	460.1-1250-094A1-XM		14	102	202	151	1,9	COROMANT
12.70	3xD	460.1-1270-038A1-XM	460.1-1270-038A0-XM	14	40	107	60	1,9	DIN 6537 K
12.70	5xD	460.1-1270-064A1-XM	460.1-1270-064A0-XM	14	62	124	77	1,9	DIN 6537 L
12.70	8xD	460.1-1270-095A1-XM		14	104	202	151	1,9	COROMANT
12.80	3xD	460.1-1280-038A1-XM	460.1-1280-038A0-XM	14	40	107	60	1,9	DIN 6537 K
12.80	5xD	460.1-1280-064A1-XM	460.1-1280-064A0-XM	14	62	124	77	1,9	DIN 6537 L
12.80	8xD	460.1-1280-096A1-XM		14	104	202	151	1,9	COROMANT
13.00	3xD	460.1-1300-039A1-XM	460.1-1300-039A0-XM	14	41	107	60	1,9	DIN 6537 K
13.00	5xD	460.1-1300-065A1-XM	460.1-1300-065A0-XM	14	61	124	77	1,9	DIN 6537 L
13.00	8xD	460.1-1300-098A1-XM		14	106	202	151	1,9	COROMANT
13.10	3xD	460.1-1310-039A1-XM	460.1-1310-039A0-XM	14	41	107	60	2	DIN 6537 K
13.10	5xD	460.1-1310-066A1-XM	460.1-1310-066A0-XM	14	61	124	77	2	DIN 6537 L
13.10	8xD	460.1-1310-098A1-XM		14	107	202	151	2	COROMANT
13.49	3xD	460.1-1349-041A1-XM	460.1-1349-041A0-XM	14	43	107	60	2	DIN 6537 K
13.49	5xD	460.1-1349-061A1-XM	460.1-1349-061A0-XM	14	61	124	77	2	DIN 6537 L
13.49	8xD	460.1-1349-101A1-XM		14	110	202	151	2	COROMANT
13.50	3xD	460.1-1350-041A1-XM	460.1-1350-041A0-XM	14	43	107	60	2	DIN 6537 K
13.50	5xD	460.1-1350-061A1-XM	460.1-1350-061A0-XM	14	61	124	77	2	DIN 6537 L
13.50	8xD	460.1-1350-101A1-XM		14	110	202	151	2	COROMANT
13.70	8xD	460.1-1370-103A1-XM		14	112	202	151	2	COROMANT
13.80	3xD	460.1-1380-041A1-XM	460.1-1380-041A0-XM	14	43	107	60	2,1	DIN 6537 K
13.80	4xD	460.1-1380-062A1-XM		14	60	124	77	2,1	DIN 6537 L
13.89	3xD	460.1-1389-042A1-XM		14	43	107	60	2,1	DIN 6537 K
13.89	4xD	460.1-1389-063A1-XM		14	60	124	77	2,1	DIN 6537 L
14.00	3xD	460.1-1400-042A1-XM	460.1-1400-042A0-XM	14	44	107	60	2,1	DIN 6537 K
14.00	5xD	460.1-1400-063A1-XM	460.1-1400-063A0-XM	14	63	124	77	2,1	DIN 6537 L
14.00	8xD	460.1-1400-105A1-XM		14	114	202	151	2,1	COROMANT
14.20	8xD	460.1-1420-107A1-XM		16	116	227	172	2,1	COROMANT

TCHA: H9
SIG: 140°
Grade: GC34

P M K N S H



		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
14.25	3xD	460.1-1425-043A1-XM	460.1-1425-043A0-XM	16	45	115	65	2,1	DIN 6537 K
14.25	5xD	460.1-1425-071A1-XM	460.1-1425-071A0-XM	16	69	133	83	2,1	DIN 6537 L
14.25	8xD	460.1-1425-107A1-XM		16	116	227	172	2,1	COROMANT
14.29	3xD	460.1-1429-043A1-XM	460.1-1429-043A0-XM	16	45	115	65	2,1	DIN 6537 K
14.29	5xD	460.1-1429-072A1-XM	460.1-1429-072A0-XM	16	69	133	83	2,1	DIN 6537 L
14.29	8xD	460.1-1429-107A1-XM		16	116	227	172	2,1	COROMANT
14.50	3xD	460.1-1450-044A1-XM	460.1-1450-044A0-XM	16	46	115	65	2,2	DIN 6537 K
14.50	5xD	460.1-1450-073A1-XM	460.1-1450-073A0-XM	16	69	133	83	2,2	DIN 6537 L
14.50	8xD	460.1-1450-109A1-XM		16	118	227	172	2,2	COROMANT
14.68	3xD	460.1-1468-044A1-XM	460.1-1468-044A0-XM	16	46	115	65	2,2	DIN 6537 K
14.68	5xD	460.1-1468-073A1-XM		16	68	133	83	2,2	DIN 6537 L
14.70	8xD	460.1-1470-110A1-XM		16	120	227	172	2,2	COROMANT
14.80	3xD	460.1-1480-044A1-XM	460.1-1480-044A0-XM	16	47	115	65	2,2	DIN 6537 K
14.80	5xD	460.1-1480-067A1-XM		16	68	133	83	2,2	DIN 6537 L
15.00	3xD	460.1-1500-045A1-XM	460.1-1500-045A0-XM	16	47	115	65	2,2	DIN 6537 K
15.00	5xD	460.1-1500-068A1-XM	460.1-1500-068A0-XM	16	68	133	83	2,2	DIN 6537 L
15.00	8xD	460.1-1500-113A1-XM		16	122	227	172	2,2	COROMANT
15.08	3xD	460.1-1508-045A1-XM		16	48	115	65	2,2	DIN 6537 K
15.08	5xD	460.1-1508-068A1-XM		16	68	133	83	2,2	DIN 6537 L
15.08	8xD	460.1-1508-113A1-XM		16	123	227	172	2,2	COROMANT
15.10	3xD	460.1-1510-045A1-XM	460.1-1510-045A0-XM	16	48	115	65	2,3	DIN 6537 K
15.10	4xD	460.1-1510-068A1-XM		16	68	133	83	2,3	DIN 6537 L
15.10	8xD	460.1-1510-113A1-XM		16	123	227	172	2,3	COROMANT
15.50	3xD	460.1-1550-047A1-XM	460.1-1550-047A0-XM	16	49	115	65	2,3	DIN 6537 K
15.50	4xD	460.1-1550-070A1-XM	460.1-1550-070A0-XM	16	68	133	83	2,3	DIN 6537 L
15.50	8xD	460.1-1550-116A1-XM		16	126	227	172	2,3	COROMANT
15.70	8xD	460.1-1570-118A1-XM		16	128	227	172	2,3	COROMANT
15.80	3xD	460.1-1580-047A1-XM	460.1-1580-047A0-XM	16	49	115	65	2,4	DIN 6537 K
15.80	4xD	460.1-1580-071A1-XM	460.1-1580-071A0-XM	16	67	133	83	2,4	DIN 6537 L
15.88	3xD	460.1-1588-048A1-XM	460.1-1588-047A0-XM	16	49	115	65	2,4	DIN 6537 K
15.88	4xD	460.1-1588-071A1-XM		16	67	133	83	2,4	DIN 6537 L
15.88	8xD	460.1-1588-119A1-XM		16	129	227	172	2,4	COROMANT
16.00	3xD	460.1-1600-048A1-XM	460.1-1600-048A0-XM	16	49	115	65	2,4	DIN 6537 K
16.00	4xD	460.1-1600-072A1-XM	460.1-1600-072A0-XM	16	67	133	83	2,4	DIN 6537 L
16.00	8xD	460.1-1600-120A1-XM		16	130	227	172	2,4	COROMANT
16.27	3xD	460.1-1627-049A1-XM	460.1-1627-049A0-XM	18	51	123	73	2,4	DIN 6537 K
16.27	5xD	460.1-1627-081A1-XM		18	77	143	93	2,4	DIN 6537 L
16.50	3xD	460.1-1650-050A1-XM	460.1-1650-050A0-XM	18	52	123	73	2,5	DIN 6537 K
16.50	5xD	460.1-1650-074A1-XM	460.1-1650-074A0-XM	18	77	143	93	2,5	DIN 6537 L
16.67	3xD	460.1-1667-050A1-XM	460.1-1667-050A0-XM	18	53	123	73	2,5	DIN 6537 K
16.67	5xD	460.1-1667-075A1-XM	460.1-1667-075A0-XM	18	76	143	93	2,5	DIN 6537 L
17.00	3xD	460.1-1700-051A1-XM	460.1-1700-051A0-XM	18	54	123	73	2,5	DIN 6537 K
17.00	4xD	460.1-1700-077A1-XM	460.1-1700-077A0-XM	18	76	143	93	2,5	DIN 6537 L
17.00	8xD	460.1-1700-128A1-XM		18	139	246	194	2,5	COROMANT
17.07	3xD	460.1-1707-051A1-XM	460.1-1707-051A0-XM	18	54	123	73	2,5	DIN 6537 K
17.07	4xD	460.1-1707-077A1-XM		18	76	143	93	2,5	DIN 6537 L
17.46	4xD	460.1-1746-079A1-XM	460.1-1746-079A0-XM	18	76	143	93	2,6	DIN 6537 L
17.50	3xD	460.1-1750-053A1-XM	460.1-1750-053A0-XM	18	55	123	73	2,6	DIN 6537 K
17.50	4xD	460.1-1750-079A1-XM	460.1-1750-079A0-XM	18	76	143	93	2,6	DIN 6537 L
17.50	8xD	460.1-1750-131A1-XM		18	143	246	194	2,6	COROMANT
17.80	3xD		460.1-1780-053A0-XM	18	55	123	73	2,7	DIN 6537 K
17.80	4xD	460.1-1780-080A1-XM		18	75	143	93	2,7	DIN 6537 L
17.86	3xD	460.1-1786-054A1-XM		18	55	123	73	2,7	DIN 6537 K
18.00	3xD	460.1-1800-054A1-XM	460.1-1800-054A0-XM	18	57	123	73	2,7	DIN 6537 K

TCHA: H9
SIG: 140°
Grade: GC34

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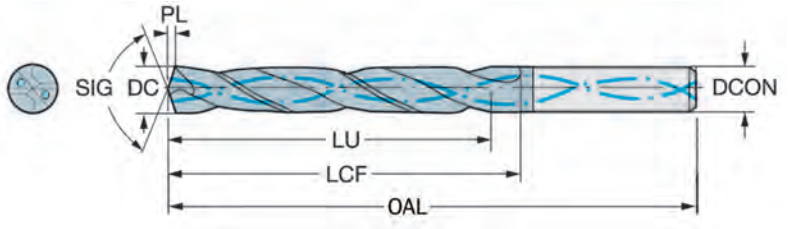
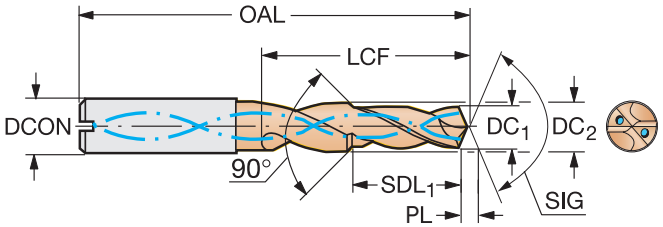


		Order number		Dimensions, mm					
DC	Drilling depth	with IC	without IC	DCON	LU	OAL	LCF	PL	BSG
18.00	4xD	460.1-1800-081A1-XM	460.1-1800-081A0-XM	18	79	143	93	2,7	DIN 6537 L
18.00	8xD	460.1-1800-135A1-XM		18	147	246	194	2,7	COROMANT
18.26	3xD	460.1-1826-055A1-XM		20	58	131	79	2,7	DIN 6537 K
18.26	5xD	460.1-1826-082A1-XM		20	86	153	101	2,7	DIN 6537 L
18.50	3xD	460.1-1850-056A1-XM	460.1-1850-056A0-XM	20	58	131	79	2,8	DIN 6537 K
18.50	5xD	460.1-1850-083A1-XM		20	86	153	101	2,8	DIN 6537 L
18.65	3xD	460.1-1865-056A1-XM		20	59	131	79	2,8	DIN 6537 K
18.65	5xD	460.1-1865-084A1-XM		20	86	153	101	2,8	DIN 6537 L
18.80	3xD	460.1-1880-056A1-XM		20	59	131	79	2,8	DIN 6537 K
19.00	3xD	460.1-1900-057A1-XM	460.1-1900-057A0-XM	20	60	131	79	2,8	DIN 6537 K
19.00	5xD	460.1-1900-086A1-XM	460.1-1900-086A0-XM	20	86	153	101	2,8	DIN 6537 L
19.00	8xD	460.1-1900-143A1-XM		20	155	269	215	2,8	COROMANT
19.05	3xD	460.1-1905-057A1-XM		20	60	131	79	2,8	DIN 6537 K
19.05	5xD	460.1-1905-086A1-XM		20	86	153	101	2,8	DIN 6537 L
19.50	3xD	460.1-1950-059A1-XM	460.1-1950-059A0-XM	20	61	131	79	2,9	DIN 6537 K
19.50	4xD	460.1-1950-088A1-XM	460.1-1950-088A0-XM	20	85	153	101	2,9	DIN 6537 L
19.50	8xD	460.1-1950-146A1-XM		20	159	269	215	2,9	COROMANT
19.80	3xD	460.1-1980-059A1-XM		20	62	131	79	3	DIN 6537 K
19.80	4xD	460.1-1980-089A1-XM	460.1-1980-089A0-XM	20	85	153	101	3	DIN 6537 L
20.00	3xD	460.1-2000-060A1-XM	460.1-2000-060A0-XM	20	63	131	79	3	DIN 6537 K
20.00	4xD	460.1-2000-090A1-XM	460.1-2000-090A0-XM	20	85	153	101	3	DIN 6537 L
20.00	8xD	460.1-2000-150A1-XM		20	163	269	215	3	COROMANT

CHAMFER DRILLING – CoroDrill® 460-XM

TCHA: H9
SIG: 140°
STA: 90°
Grade: GC34

P M K N S H



Order number					Dimensions, mm						
DC1	DC2	Drilling depth	SDL1	with IC	DCON	LU	OAL	LCF	LS	PL	BSG
5,00	6,75	3xD	14,13	460.2-0500-015A1-XM	8	15,73	79	43,5	36	0,73	COROMANT
5,10	6,89	3xD	14,11	460.2-0510-015A1-XM	8	15,75	79	43,5	36	0,75	COROMANT
6,85	9,25	3xD	19,80	460.2-0685-021A1-XM	10	22,01	89	54,4	40	1,01	COROMANT
6,90	9,32	3xD	19,79	460.2-0690-021A1-XM	10	22,02	89	54,4	40	1,02	COROMANT
8,50	11,48	3xD	24,51	460.2-0850-026A1-XM	12	27,26	102	65,3	45	1,26	COROMANT
8,70	11,75	3xD	24,48	460.2-0870-026A1-XM	12	27,29	102	65,3	45	1,29	COROMANT
9,00	12,15	3xD	25,43	460.2-0900-027A1-XM	14	28,33	112	76,2	45	1,33	COROMANT
10,25	13,84	3xD	29,21	460.2-1025-031A1-XM	14	32,52	112	76,2	45	1,52	COROMANT
14,00	18,90	3xD	39,55	460.2-1400-042A1-XM	20	44,09	142	108,8	50	2,09	COROMANT

CoroReamer™ 435-XF

The CoroReamer™ 435-XF is a versatile high-feed reamer. It allows for very close tolerances and offers a high-quality finish thanks to the internal coolant supply, special nose geometry and extremely uneven pitch of the cutting edges.

Tailor Made

Features and benefits

- High productivity and consistant tool life
- Excellent hole quality ≤ H7
- Can be reground up to three times without any issues
- Extremely uneven pitch for significantly improved hole roundness
- Internal coolant supply for improved swarf evacuation

P K N

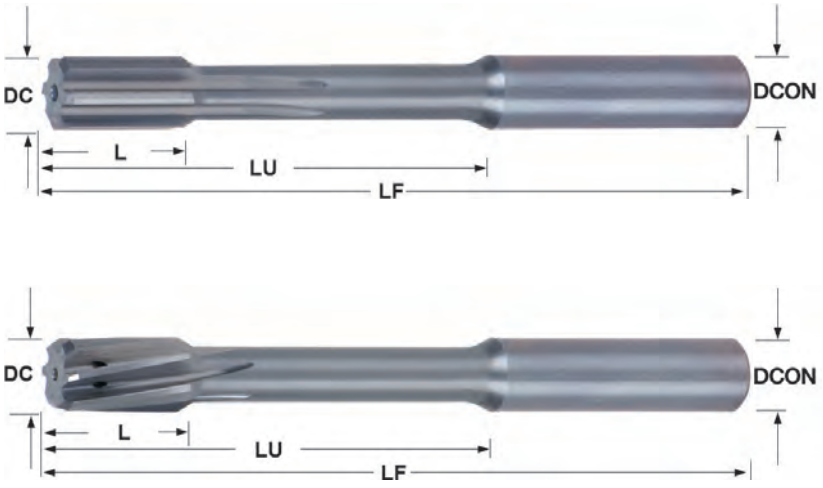
ISO application range

Product range

Chip flute design	Hole type	Internal cutting fluid supply	Geometry	Diameter range, mm	Grade	Shank version	Standard
Straight chip flute	Blind hole	Yes	435-XF	3,97-20,0	H10F	Cylindrical	Coromant
Twisted chip flute	Through-hole	Yes	435-XF	3,97-20,0	H10F	Cylindrical	Coromant

TCHA: H7
Grade: H10F

P K N



TCHA: H7
Grade: H10F

P K N

	Order number		Dimensions, mm			
DC	Straight flute for blind holes (GB)	Spiral chip flute for through-holes (DB)	DCON	L	LU	LF
4.00	435.B-0400-A1-XF	435.T-0400-A1-XF	6	12	39	74.40
4.01	435.B-0401-A1-XF		6	12	39	74.40
4.50	435.B-0450-A1-XF		6	12	39	74.32
5.00	435.B-0500-A1-XF	435.T-0500-A1-XF	6	12	39	74.25
5.01	435.B-0501-A1-XF		6	12	39	74.25
6.00	435.B-0600-A1-XF	435.T-0600-A1-XF	6	12	39	74.10
6.01	435.B-0601-A1-XF		6	12	39	74.10
6.02		435.T-0602-A1-XF	6	12	39	74.10
6.50		435.T-0650-A1-XF	8	16	64	99.02
7.00	435.B-0700-A1-XF	435.T-0700-A1-XF	8	16	64	98.95
8.00	435.B-0800-A1-XF	435.T-0800-A1-XF	8	16	64	98.80
8.01	435.B-0801-A1-XF		8	16	64	98.80
9.00		435.T-0900-A1-XF	10	20	60	98.65
9.50		435.T-0950-A1-XF	10	20	80	118.57
9.98		435.T-0998-A1-XF	10	20	80	118.50
10.00	435.B-1000-A1-XF	435.T-1000-A1-XF	10	20	80	118.50
10.01	435.B-1001-A1-XF	435.T-1001-A1-XF	10	20	80	118.50
11.00		435.T-1100-A1-XF	12	20	75	118.35
12.00	435.B-1200-A1-XF	435.T-1200-A1-XF	12	20	75	118.20
12.03	435.B-1203-A1-XF		12	20	75	118.19
13.00	435.B-1300-A1-XF	435.T-1300-A1-XF	14	22	85	128.05
14.00	435.B-1400-A1-XF	435.T-1400-A1-XF	14	22	85	127.90
15.00	435.B-1500-A1-XF	435.T-1500-A1-XF	16	22	82	127.75
16.00	435.B-1600-A1-XF	435.T-1600-A1-XF	16	25	102	147.60
17.00	435.B-1700-A1-XF	435.T-1700-A1-XF	18	25	102	147.45
18.00	435.B-1800-A1-XF	435.T-1800-A1-XF	18	25	102	147.30
19.00		435.T-1900-A1-XF	20	25	100	147.14
20.00	435.B-2000-A1-XF	435.T-2000-A1-XF	20	25	100	146.99

Tapping in many different materials

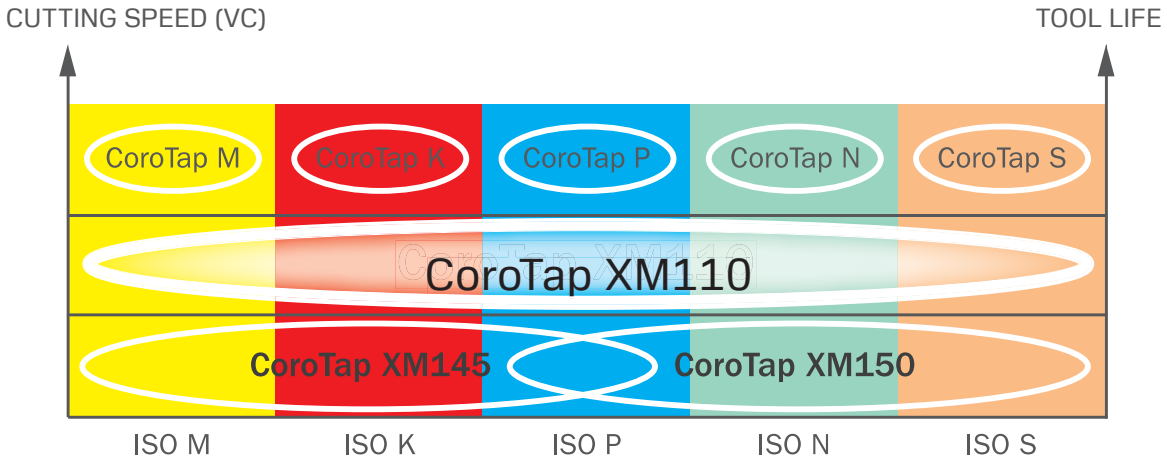
CoroTap™-XM is an obvious solution for tapping in numerous materials. Different grade options are available depending on your requirements. All options are suitable for virtually any material and guarantee exceptionally high machine capacity utilisation.

Features and benefits

- Reduces inventory and lowers costs
- Offers a long tool life
- Enables increased process reliability thanks to outstanding cutting edge geometry
- Large helix angles offer excellent swarf evacuation and machining up to 2.5 × D

Application range

- For through and blind holes
- Drilling depth to 2.5 × D
- Chamfer form E with minimal clearance in blind holes
- Tapping up to 350 HB (~1200 N/mm²)
- Suitable for all industrial sectors



Grades

C150/B150
(Uncoated)
for reduced “sticking” in soft materials

C145/B145
(Steam-tempered) for protecting and preventing build-up on the nose

C110/B110 (AlCrN coated) with a high level of wear resistance and hot hardness. Offers a long tool life and increased cutting speeds

C grade: HSS-PM, powdered high-speed steel with vanadium alloy, offers increased stability and toughness for good wear resistance.
B grade: HSS-E, high-alloy high-speed steel with cobalt for increased wear resistance and toughness for large diameters (> 17 mm)

Product range

Thread form	Range	Tolerance range	BSG	CoroTap™	Grade
M	M2-M64	6H	DIN	T200*/T300	C150/C145/C110 - B150/B145/ B110**
M	M3-M20	6G	DIN	T200/T300	C150/C145/C110 - B150/B145/B110
M	M3-M10	6H	DIN 376	T200/T300	C150/C145/C110 - B150/B145/B110
MF	M4-M30	6H	DIN	T200/T300	C150/C145/C110 - B150/B145/B110
UNC	#4-1"	2B	DIN	T200/T300	C150/C145/C110 - B150/B145/B110
UNF	#8-1"	2B	DIN	T200/T300	C150/C145/C110 - B150/B145/B110
G	1/8-1.1/2	Normal	DIN	T200***/T300	C150/C145/C110 - B150/B145/B110

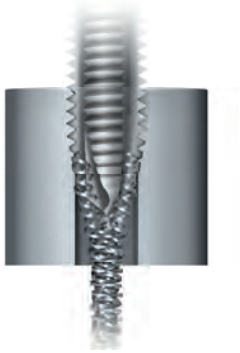
* Up to M30

** Up to M36 (T300)

*** Up to 1”

CoroTap™ 200

Tap for through-holes



Page	P.18			P.19			P.23			P.25			P.27			P.29		
	T200-XM100DA T200-XM101DA			T200-XM104DA T200-XM105DA			T200-XM100DB			T200-XM100DE T200-XM101DE			T200-XM100DF T200-XM101DF			T200-XM100DK		
Grade	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110
THFT (thread form)	M			M			MF			UNC			UNF			G		
	M2-M30			M3-M20			M4-M30			#4 - 1"			#8 - 1"			1/8 - 1"		
THCHT (chamfer)	B			B			B			B			B			B		
BSG (standard)	DIN 371/DIN 376			DIN 371/DIN 376			DIN 374			DIN 2184-1			DIN 2184-1			DIN 5156		
TCTR (tolerance)	6H			6G			6H			2B			2B			normal		
ULDR (depth)	2.5			2.5			2.5			2.5			2.5			2.5		

CoroTap™ 300

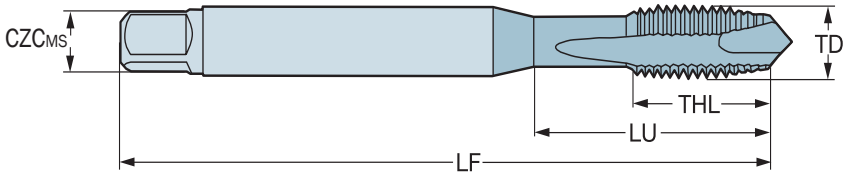
Tap for blind holes

Page	P.20	P.21	P.22	P.24	P.26	P.28	P.30
	T300-XM100DA T300-XM101DA	T300-XM104DA T300-XM105DA	T300-XM102DA T300-XM103DA	T300-XM100DB	T300-XM100DE T300-XM101DE	T300-XM100DF T300-XM101DF	T300-XM100DK
Grade	C150 B150 | C145 B145 | C110 B110	C150 B150 | C145 B145 | C110 B110	C150 B150 | C145 B145 | C110 B110	C150 B150 | C145 B145 | C110 B110	C150 B150 | C145 B145 | C110 B110	C150 B150 | C145 B145 | C110 B110	C150 B150 | C145 B145 | **C110 B110**
THFT (thread form)	M	M	M	MF	UNC	UNF	G
	M2-M64	M3-M20	M3-M20	M4-M30	#8-1"	#8-1"	1/8 - 1 1/2"
THCHT (chamfer)	C	C	E	C	C	C	C
BSG (standard)	DIN 371/DIN 376	DIN 371/DIN 376	DIN 371/DIN 376	DIN 374	DIN 2184-1	DIN 2184-1	DIN 5156
TCTR (tolerance)	6H	6G	6H	6H	2B	2B	normal
ULDR (depth)	2.5	2.5	2.5	2.5	2.5	2.5	2.5

CoroTap™ 200 tap for through-holes

Thread form metric

M	B 3.5-5	6H	HSS PM bis M16	HSS-E ab M18	DIN 371	DIN 376
2.5xD		P	M	K	N	S

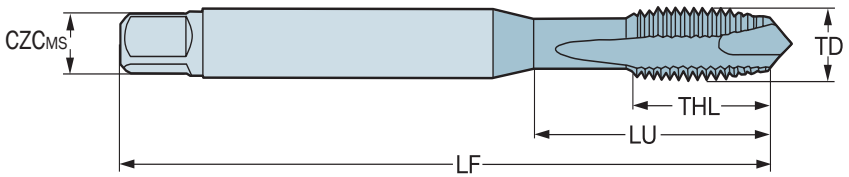


TDZ	CZC_{MS}			TP	Order number	Dimensions, mm					
	Shank		Square	Lead		TD	LF	LU	THL	NOF	BSG
M 2	2.80	x	2.10	0.40	T200-XM100DA-M2	2.0	45.0	9.0	6.0	2	DIN 371
M 2.5	2.80	x	2.10	0.45	T200-XM100DA-M2.5	2.5	50.0	12.5	8.0	2	DIN 371
M 3	3.50	x	2.70	0.50	T200-XM100DA-M3	3.0	56.0	18.0	8.9	3	DIN 371
M 3.5	4.00	x	3.00	0.60	T200-XM100DA-M3.5	3.5	56.0	20.0	10.8	3	DIN 371
M 4	4.50	x	3.40	0.70	T200-XM100DA-M4	4.0	63.0	21.0	11.7	3	DIN 371
M 4.5	6.00	x	4.90	0.75	T200-XM100DA-M4.5	4.5	70.0	25.0	13.0	3	DIN 371
M 5	6.00	x	4.90	0.80	T200-XM100DA-M5	5.0	70.0	25.0	12.6	3	DIN 371
M 6	6.00	x	4.90	1.00	T200-XM100DA-M6	6.0	80.0	30.0	14.5	3	DIN 371
M 7	7.00	x	5.50	1.00	T200-XM100DA-M7	7.0	80.0	30.0	14.5	3	DIN 371
M 8	8.00	x	6.20	1.25	T200-XM100DA-M8	8.0	90.0	35.0	17.4	3	DIN 371
M 10	10.00	x	8.00	1.50	T200-XM100DA-M10	10.0	100.0	39.0	19.2	3	DIN 371
M 12	9.00	x	7.00	1.75	T200-XM101DA-M12	12.0	110.0	83.0	23.0	3	DIN 376
M 14	11.00	x	9.00	2.00	T200-XM101DA-M14	14.0	110.0	81.0	25.0	3	DIN 376
M 16	12.00	x	9.00	2.00	T200-XM101DA-M16	16.0	110.0	68.0	25.0	3	DIN 376
M 18	14.00	x	11.00	2.50	T200-XM101DA-M18	18.0	125.0	81.0	30.0	4	DIN 376
M 20	16.00	x	12.00	2.50	T200-XM101DA-M20	20.0	140.0	95.0	30.0	4	DIN 376
M 22	18.00	x	14.50	2.50	T200-XM101DA-M22	22.0	140.0	93.0	34.0	4	DIN 376
M 24	18.00	x	14.50	3.00	T200-XM101DA-M24	24.0	160.0	113.0	38.0	4	DIN 376
M 27	20.00	x	16.00	3.00	T200-XM101DA-M27	27.0	160.0	97.0	38.0	4	DIN 376
M 30	22.00	x	18.00	3.50	T200-XM101DA-M30	30.0	180.0	115.0	45.0	4	DIN 376
M 3	2.20	x	1.80	0.50	T200-XM101DA-M3	3.0	56.0	37.0	10.0	3	DIN 376
M 4	2.80	x	2.10	0.70	T200-XM101DA-M4	4.0	63.0	43.0	11.9	3	DIN 376
M 5	3.50	x	2.70	0.80	T200-XM101DA-M5	5.0	70.0	49.0	13.2	3	DIN 376
M 6	4.50	x	3.40	1.00	T200-XM101DA-M6	6.0	80.0	59.0	15.1	3	DIN 376
M 8	6.00	x	4.90	1.25	T200-XM101DA-M8	8.0	90.0	67.0	18.0	3	DIN 376
M 10	7.00	x	5.50	1.50	T200-XM101DA-M10	10.0	100.0	77.0	20.0	3	DIN 376

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form metric, 6G tolerance



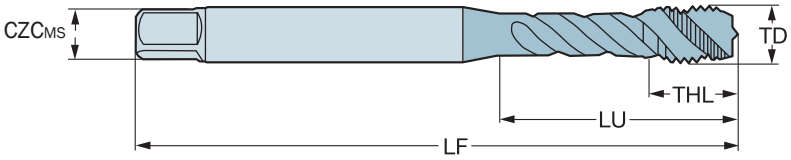
TDZ	CZC$_{MS}$			TP	Order number	Dimensions, mm					
	Shank		Square	Lead		TD	LF	LU	THL	NOF	BSG
M 3	3.50	x	2.70	0.50	T200-XM104DA-M3	3.0	56.0	18.0	8.9	3	DIN 371
M 4	4.50	x	3.40	0.70	T200-XM104DA-M4	4.0	63.0	21.0	12.0	3	DIN 371
M 5	6.00	x	4.90	0.80	T200-XM104DA-M5	5.0	70.0	25.0	13.0	3	DIN 371
M 6	6.00	x	4.90	1.00	T200-XM104DA-M6	6.0	80.0	30.0	15.0	3	DIN 371
M 8	8.00	x	6.20	1.25	T200-XM104DA-M8	8.0	90.0	35.0	18.0	3	DIN 371
M 10	10.00	x	8.00	1.50	T200-XM104DA-M10	10.0	100.0	39.0	20.0	3	DIN 371
M 12	9.00	x	7.00	1.75	T200-XM105DA-M12	12.0	110.0	83.0	23.0	3	DIN 376
M 16	12.00	x	9.00	2.00	T200-XM105DA-M16	16.0	110.0	68.0	25.0	3	DIN 376
M 20	16.00	x	12.00	2.50	T200-XM105DA-M20	20.0	140.0	95.0	30.0	4	DIN 376

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric

M	C 2 - 3.5	6H	HSS PM bis M16	HSS-E ab M18	DIN 371	DIN 376
2.5xD		P	M	K	N	S

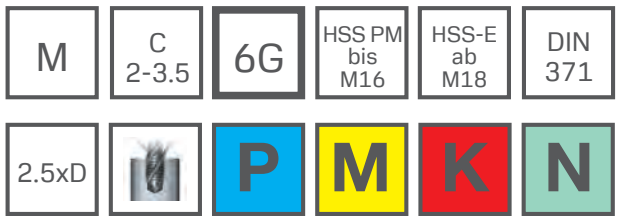


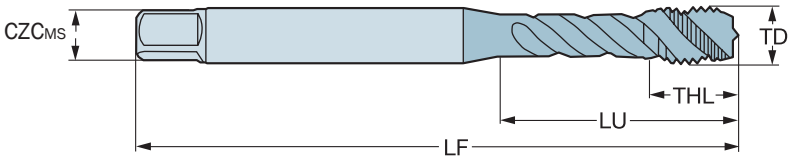
TDZ	CZC_{MS}			TP	Order number	Dimensions, mm					
	Shank		Square	Lead		TD	LF	LU	THL	NOF	BSG
M 2	2.80	x	2.10	0.40	T300-XM100DA-M2	2.0	45.0	9.0	4.0	3	DIN 371
M 2.5	2.80	x	2.10	0.45	T300-XM100DA-M2.5	2.5	50.0	12.5	4.0	3	DIN 371
M 3	3.50	x	2.70	0.50	T300-XM100DA-M3	3.0	56.0	18.0	5.9	3	DIN 371
M 3.5	4.00	x	3.00	0.60	T300-XM100DA-M3.5	3.5	56.0	20.0	6.3	3	DIN 371
M 4	4.50	x	3.40	0.70	T300-XM100DA-M4	4.0	63.0	21.0	6.7	3	DIN 371
M 5	6.00	x	4.90	0.80	T300-XM100DA-M5	5.0	70.0	21.0	7.7	3	DIN 371
M 6	6.00	x	4.90	1.00	T300-XM100DA-M6	6.0	80.0	31.0	10.0	3	DIN 371
M 7	7.00	x	5.50	1.00	T300-XM100DA-M7	7.0	80.0	31.0	10.0	3	DIN 371
M 8	8.00	x	6.20	1.25	T300-XM100DA-M8	8.0	90.0	35.0	11.6	3	DIN 371
M 10	10.00	x	8.00	1.50	T300-XM100DA-M10	10.0	100.0	39.0	15.1	3	DIN 371
M 12	9.00	x	7.00	1.75	T300-XM101DA-M12	12.0	110.0	83.0	16.0	3	DIN 376
M 14	11.00	x	9.00	2.00	T300-XM101DA-M14	14.0	110.0	81.0	20.0	3	DIN 376
M 16	12.00	x	9.00	2.00	T300-XM101DA-M16	16.0	110.0	68.0	20.0	4	DIN 376
M 18	14.00	x	11.00	2.50	T300-XM101DA-M18	18.0	125.0	81.0	25.0	4	DIN 376
M 20	16.00	x	12.00	2.50	T300-XM101DA-M20	20.0	140.0	95.0	25.0	4	DIN 376
M 22	18.00	x	14.50	2.50	T300-XM101DA-M22	22.0	140.0	93.0	25.0	4	DIN 376
M 24	18.00	x	14.50	3.00	T300-XM101DA-M24	24.0	160.0	113.0	30.0	4	DIN 376
M 27	20.00	x	16.00	3.00	T300-XM101DA-M27	27.0	160.0	97.0	30.0	4	DIN 376
M 30	22.00	x	18.00	3.50	T300-XM101DA-M30	30.0	180.0	115.0	36.0	4	DIN 376
M 33	25.00	x	20.00	3.50	T300-XM101DA-M33	33.0	180.0	113.0	36.0	4	DIN 376
M 36	28.00	x	22.00	4.00	T300-XM101DA-M36	36.0	200.0	131.0	40.0	4	DIN 376
M 39	32.00	x	24.00	4.00	T300-XM101DA-M39	39.0	200.0	102.0	40.0	4	DIN 376
M 42	32.00	x	24.00	4.50	T300-XM101DA-M42	42.0	200.0	102.0	45.0	4	DIN 376
M 48	36.00	x	29.00	5.00	T300-XM101DA-M48	48.0	250.0	147.0	50.0	4	DIN 376
M 64	50.00	x	39.00	6.00	T300-XM101DA-M64	64.0	315.0	178.0	60.0	6	DIN 376
M 6	4.50	x	3.40	1.00	T300-XM101DA-M6	6.0	80.0	59.0	10.0	3	**DIN 376**
M 8	6.00	x	4.90	1.25	T300-XM101DA-M8	8.0	90.0	67.0	12.0	3	**DIN 376**
M 10	7.00	x	5.50	1.50	T300-XM101DA-M10	10.0	100.0	77.0	15.0	3	**DIN 376**

C-Sorte: HSS-PM
B-Sorte: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric, 6G tolerance





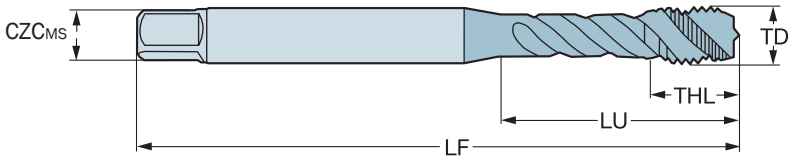
TDZ	CZC_{MS}			TP	Order number	Dimensions, mm					
	Shank		Square	Lead		TD	LF	LU	THL	NOF	BSG
M 3	3.50	x	2.70	0.50	T300-XM104DA-M3	3.0	56.0	18.0	5.9	3	DIN 371
M 4	4.50	x	3.40	0.70	T300-XM104DA-M4	4.0	63.0	21.0	6.7	3	DIN 371
M 5	6.00	x	4.90	0.80	T300-XM104DA-M5	5.0	70.0	25.0	7.7	3	DIN 371
M 6	6.00	x	4.90	1.00	T300-XM104DA-M6	6.0	80.0	31.0	10.0	3	DIN 371
M 8	8.00	x	6.20	1.25	T300-XM104DA-M8	8.0	90.0	35.0	12.0	3	DIN 371
M 10	10.00	x	8.00	1.50	T300-XM104DA-M10	10.0	100.0	39.0	15.1	3	DIN 371
M 12	9.00	x	7.00	1.75	T300-XM105DA-M12	12.0	110.0	83.0	16.0	3	DIN 376
M 14	11.00	x	9.00	2.00	T300-XM105DA-M14	14.0	110.0	81.0	20.0	3	DIN 376
M 16	12.00	x	9.00	2.00	T300-XM105DA-M16	16.0	110.0	68.0	20.0	4	DIN 376
M 20	16.00	x	12.00	2.50	T300-XM105DA-M20	20.0	140.0	95.0	25.0	4	DIN 376

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric, chamfer form E

M	E 1.5-2	6H	HSS PM bis M16	HSS-E ab M18	DIN 371	DIN 376
2.5xD		P	M	K	N	S



TDZ	CZC_{MS}			TP	Order number	Dimensions, mm					
	Shank		Square	Lead		TD	LF	LU	THL	NOF	BSG
M 3	3.50	x	2.70	0.50	T300-XM102DA-M3	3.0	56.0	18.0	5.9	3	DIN 371
M 4	4.50	x	3.40	0.70	T300-XM102DA-M4	4.0	63.0	21.0	6.7	3	DIN 371
M 5	6.00	x	4.90	0.80	T300-XM102DA-M5	5.0	70.0	21.0	7.7	3	DIN 371
M 6	6.00	x	4.90	1.00	T300-XM102DA-M6	6.0	80.0	31.0	10.0	3	DIN 371
M 8	8.00	x	6.20	1.25	T300-XM102DA-M8	8.0	90.0	35.0	11.6	3	DIN 371
M 10	10.00	x	8.00	1.50	T300-XM102DA-M10	10.0	100.0	39.0	15.1	3	DIN 371
M 12	9.00	x	7.00	1.75	T300-XM103DA-M12	12.0	110.0	83.0	16.0	3	DIN 376
M 14	11.00	x	9.00	2.00	T300-XM103DA-M14	14.0	110.0	81.0	20.0	3	DIN 376
M 16	12.00	x	9.00	2.00	T300-XM103DA-M16	16.0	110.0	68.0	20.0	4	DIN 376
M 20	16.00	x	12.00	2.50	T300-XM103DA-M20	20.0	95.0	140.0	25.0	4	DIN 376

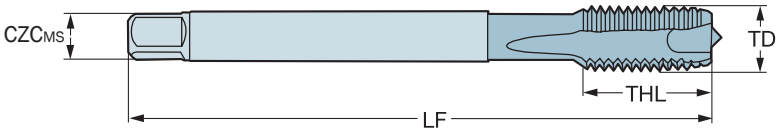
C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form metric fine

MF	B 3.5-5	6H	HSS PM bis MF16	HSS-E ab MF18	DIN 374	2.5xD

	P	M	K	N	S



TDZ		CZC_{MS}		Order number	Dimensions, mm					
	Shank		Square		TD	LF	LU	THL	NOF	BSG
MF 4x0.5	2.80	x	2.10	T200-XM100DB-M4X050	4.0	63.0	43.0	11.9	3	DIN 374
MF 5x0.5	3.50	x	2.70	T200-XM100DB-M5X050	5.0	70.0	49.0	13.2	3	DIN 374
MF 6x0.75	4.50	x	3.40	T200-XM100DB-M6X075	6.0	80.0	59.0	15.1	3	DIN 374
MF 8x0.75	6.00	x	4.90	T200-XM100DB-M8X075	8.0	80.0	57.0	14.9	3	DIN 374
MF 8x1	6.00	x	4.90	T200-XM100DB-M8X100	8.0	90.0	67.0	18.0	3	DIN 374
MF 10x0.75	7.00	x	5.50	T200-XM100DB-M10X075	10.0	90.0	67.0	17.6	3	DIN 374
MF 10x1	7.00	x	5.50	T200-XM100DB-M10X100	10.0	90.0	67.0	17.6	3	DIN 374
MF 10x1.25	7.00	x	5.50	T200-XM100DB-M10X125	10.0	100.0	77.0	19.8	3	DIN 374
MF 12x1	9.00	x	7.00	T200-XM100DB-M12X100	12.0	100.0	73.0	21.0	3	DIN 374
MF 12x1.25	9.00	x	7.00	T200-XM100DB-M12X125	12.0	100.0	73.0	21.0	3	DIN 374
MF 12x1.5	9.00	x	7.00	T200-XM100DB-M12X150	12.0	100.0	73.0	21.0	3	DIN 374
MF 14x1	11.00	x	9.00	T200-XM100DB-M14X100	14.0	100.0	71.0	21.0	3	DIN 374
MF 14x1.25	11.00	x	9.00	T200-XM100DB-M14X125	14.0	100.0	71.0	21.0	3	DIN 374
MF 14x1.5	11.00	x	9.00	T200-XM100DB-M14X150	14.0	100.0	71.0	21.0	3	DIN 374
MF 16x1	12.00	x	9.00	T200-XM100DB-M16X100	16.0	100.0	58.0	21.0	3	DIN 374
MF 16x1.5	12.00	x	9.00	T200-XM100DB-M16X150	16.0	100.0	58.0	21.0	3	DIN 374
MF 18x1	14.00	x	11.00	T200-XM100DB-M18X100	18.0	110.0	66.0	24.0	4	DIN 374
MF 18x1.5	14.00	x	11.00	T200-XM100DB-M18X150	18.0	110.0	66.0	24.0	4	DIN 374
MF 20x1	16.00	x	12.00	T200-XM100DB-M20X100	20.0	125.0	80.0	24.0	4	DIN 374
MF 20x1.5	16.00	x	12.00	T200-XM100DB-M20X150	20.0	125.0	80.0	24.0	4	DIN 374
MF 22x1.5	18.00	x	14.50	T200-XM100DB-M22X150	22.0	125.0	78.0	25.0	4	DIN 374
MF 24x1.5	18.00	x	14.50	T200-XM100DB-M24X150	24.0	140.0	93.0	28.0	4	DIN 374
MF 24x2	18.00	x	14.50	T200-XM100DB-M24X200	24.0	140.0	93.0	28.0	4	DIN 374
MF 25x1.5	18.00	x	14.50	T200-XM100DB-M25X150	25.0	140.0	93.0	28.0	4	DIN 374
MF 26x1.5	18.00	x	14.50	T200-XM100DB-M26X150	26.0	140.0	93.0	28.0	4	DIN 374
MF 27x2	20.00	x	16.00	T200-XM100DB-M27X200	27.0	140.0	77.0	28.0	4	DIN 374
MF 30x1.5	22.00	x	18.00	T200-XM100DB-M30X150	30.0	150.0	85.0	28.0	4	DIN 374
MF 30x2	22.00	x	18.00	T200-XM100DB-M30X200	30.0	150.0	85.0	28.0	4	DIN 374

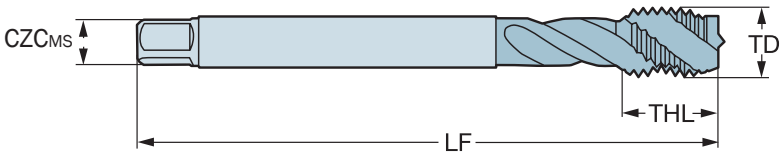
C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric fine

MF | C 2-3.5 | 6H | HSS PM up to MF16 | HSS-E from MF18 | DIN 374 | 2.5xD

P | M | K | N | S

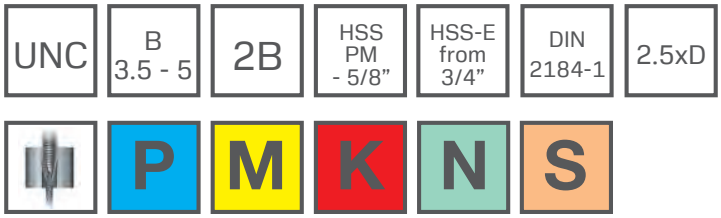


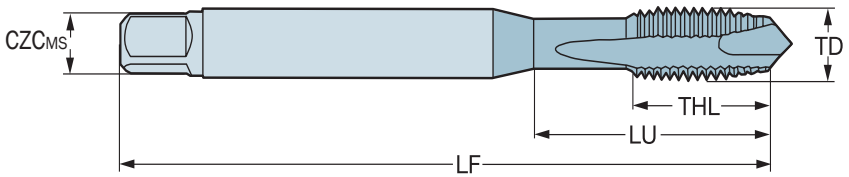
TDZ	CZC_{MS}			Order number	Dimensions, mm					
	Shank		Square		TD	LF	LU	THL	NOF	BSG
MF 4x0.5	2.80	x	2.10	T300-XM100DB-M4X050	4.0	63.0	43.0	6.8	3	DIN 374
MF 5x0.5	3.50	x	2.70	T300-XM100DB-M5X050	5.0	70.0	49.0	8.2	3	DIN 374
MF 6x0.75	4.50	x	3.40	T300-XM100DB-M6X075	6.0	80.0	59.0	10.0	3	DIN 374
MF 8x0.75	6.00	x	4.90	T300-XM100DB-M8X075	8.0	80.0	57.0	13.0	3	DIN 374
MF 8x1	6.00	x	4.90	T300-XM100DB-M8X100	8.0	90.0	67.0	13.0	3	DIN 374
MF 10x0.75	7.00	x	5.50	T300-XM100DB-M10X075	10.0	90.0	67.0	13.0	3	DIN 374
MF 10x1	7.00	x	5.50	T300-XM100DB-M10X100	10.0	90.0	67.0	13.0	3	DIN 374
MF 10x1.25	7.00	x	5.50	T300-XM100DB-M10X125	10.0	100.0	77.0	15.0	3	DIN 374
MF 12x1	9.00	x	7.00	T300-XM100DB-M12X100	12.0	100.0	73.0	15.0	3	DIN 374
MF 12x1.25	9.00	x	7.00	T300-XM100DB-M12X125	12.0	100.0	73.0	15.0	3	DIN 374
MF 12x1.5	9.00	x	7.00	T300-XM100DB-M12X150	12.0	100.0	73.0	15.0	3	DIN 374
MF 14x1	11.00	x	9.00	T300-XM100DB-M14X100	14.0	100.0	71.0	15.0	3	DIN 374
MF 14x1.25	11.00	x	9.00	T300-XM100DB-M14X125	14.0	100.0	71.0	15.0	3	DIN 374
MF 14x1.5	11.00	x	9.00	T300-XM100DB-M14X150	14.0	100.0	71.0	15.0	3	DIN 374
MF 16x1	12.00	x	9.00	T300-XM100DB-M16X100	16.0	100.0	58.0	15.0	4	DIN 374
MF 16x1.5	12.00	x	9.00	T300-XM100DB-M16X150	16.0	100.0	58.0	15.0	4	DIN 374
MF 18x1	14.00	x	11.00	T300-XM100DB-M18X100	18.0	110.0	66.0	17.0	4	DIN 374
MF 18x1.5	14.00	x	11.00	T300-XM100DB-M18X150	18.0	110.0	66.0	17.0	4	DIN 374
MF 20x1	16.00	x	12.00	T300-XM100DB-M20X100	20.0	125.0	80.0	17.0	4	DIN 374
MF 20x1.5	16.00	x	12.00	T300-XM100DB-M20X150	20.0	125.0	80.0	17.0	4	DIN 374
MF 22x1.5	18.00	x	14.50	T300-XM100DB-M22X150	22.0	125.0	78.0	17.0	4	DIN 374
MF 24x1.5	18.00	x	14.50	T300-XM100DB-M24X150	24.0	140.0	93.0	20.0	4	DIN 374
MF 24x2	18.00	x	14.50	T300-XM100DB-M24X200	24.0	140.0	93.0	20.0	4	DIN 374
MF 25x1.5	18.00	x	14.50	T300-XM100DB-M25X150	25.0	140.0	93.0	20.0	4	DIN 374
MF 26x1.5	18.00	x	14.50	T300-XM100DB-M26X150	26.0	140.0	93.0	20.0	4	DIN 374
MF 27x1.5	20.00	x	16.00	T300-XM100DB-M27X150	27.0	140.0	77.0	20.0	4	DIN 374
MF 27x2	20.00	x	16.00	T300-XM100DB-M27X200	27.0	140.0	77.0	20.0	4	DIN 374
MF 30x1.5	22.00	x	18.00	T300-XM100DB-M30X150	30.0	150.0	85.0	20.0	4	DIN 374
MF 30x2	22.00	x	18.00	T300-XM100DB-M30X200	30.0	150.0	85.0	20.0	4	DIN 374

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form UNC





TDZ	CZC_{MS}			Order number	Dimensions, mm					
	Shank		Square		TD	LF	LU	THL	NOF	BSG
UNC #4-40	3.50	x	2.70	T200-XM100DE-4-40	2.8	56.0	18.0	8.5	3	DIN 2184-1
UNC #5-40	3.50	x	2.70	T200-XM100DE-5-40	3.1	56.0	18.0	9.5	3	DIN 2184-1
UNC #6-32	4.00	x	3.00	T200-XM100DE-6-32	3.5	56.0	20.0	10.4	3	DIN 2184-1
UNC #8-32	4.50	x	3.40	T200-XM100DE-8-32	4.1	63.0	21.0	11.4	3	DIN 2184-1
UNC #10-24	6.00	x	4.90	T200-XM100DE-10-24	4.8	70.0	25.0	13.0	3	DIN 2184-1
UNC #12-24	6.00	x	4.90	T200-XM100DE-12-24	5.4	80.0	30.0	15.0	3	DIN 2184-1
UNC 1/4-20	7.00	x	5.50	T200-XM100DE-1/4	6.3	80.0	30.0	14.1	3	DIN 2184-1
UNC 5/16-18	8.00	x	6.20	T200-XM100DE-5/16	7.9	90.0	35.0	17.4	3	DIN 2184-1
UNC 3/8-16	10.00	x	8.00	T200-XM100DE-3/8	9.5	100.0	39.0	18.9	3	DIN 2184-1
UNC 7/16-14	8.00	x	6.20	T200-XM101DE-7/16	11.1	100.0	76.0	20.0	3	DIN 2184-1
UNC 1/2-13	9.00	x	7.00	T200-XM101DE-1/2	12.7	110.0	83.0	23.0	3	DIN 2184-1
UNC 5/8-11	12.00	x	9.00	T200-XM101DE-5/8	15.8	110.0	68.0	25.0	3	DIN 2184-1
UNC 3/4-10	14.00	x	11.00	T200-XM101DE-3/4	19.0	125.0	81.0	30.0	4	DIN 2184-1
UNC 7/8-9	18.00	x	14.50	T200-XM101DE-7/8	22.2	140.0	93.0	34.0	4	DIN 2184-1
UNC 1"-8	18.00	x	14.50	T200-XM101DE-1	25.4	160.0	113.0	38.0	4	DIN 2184-1

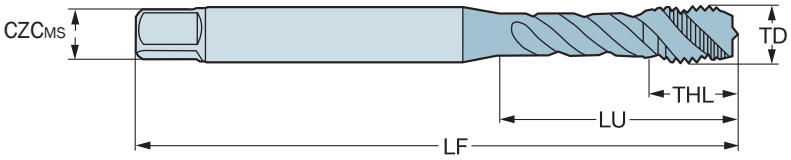
C-Sorte: HSS-PM
B-Sorte: HSS-E

CoroTap™ 300 tap for blind holes

Thread form UNC

UNC	C 2-3.5	2B	HSS PM - 5/8”	HSS-E from 3/4”	DIN 2184-1	2.5xD

	P	M	K	N	S

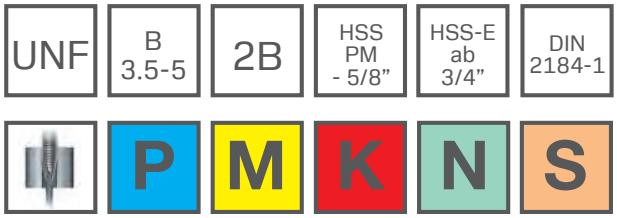


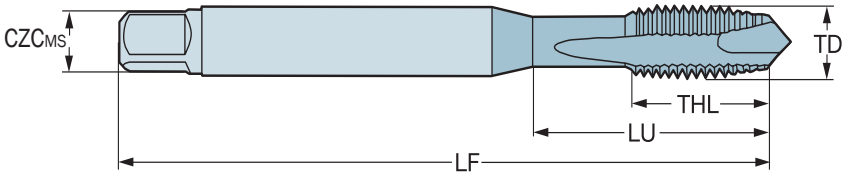
TDZ	CZC_{MS}	Order number	Dimensions, mm					
	Shank	Square		TD	LF	LU	THL	NOF	BSG
UNC #4-40	3.50	x 2.70	T300-XM100DE-4-40	2.8	56.0	18.0	5.6	3	DIN 2184-1
UNC #5-40	3.50	x 2.70	T300-XM100DE-5-40	3.1	56.0	18.0	5.6	3	DIN 2184-1
UNC #6-32	4.00	x 3.00	T300-XM100DE-6-32	3.5	56.0	20.0	6.5	3	DIN 2184-1
UNC #8-32	4.50	x 3.40	T300-XM100DE-8-32	4.1	63.0	21.0	6.5	3	DIN 2184-1
UNC #10-24	6.00	x 4.90	T300-XM100DE-10-24	4.8	70.0	25.0	8.0	3	DIN 2184-1
UNC #12-24	6.00	x 4.90	T300-XM100DE-12-24	5.4	80.0	30.0	10.0	3	DIN 2184-1
UNC 1/4-20	7.00	x 5.50	T300-XM100DE-1/4	6.3	80.0	30.0	10.0	3	DIN 2184-1
UNC 5/16-18	8.00	x 6.20	T300-XM100DE-5/16	7.9	90.0	35.0	12.0	3	DIN 2184-1
UNC 3/8-16	10.00	x 8.00	T300-XM100DE-3/8	9.5	100.0	39.0	15.0	3	DIN 2184-1
UNC 7/16-14	8.00	x 6.20	T300-XM101DE-7/16	11.1	100.0	75.7	15.0	3	DIN 2184-1
UNC 1/2-13	9.00	x 7.00	T300-XM101DE-1/2	12.7	110.0	82.7	18.0	3	DIN 2184-1
UNC 5/8-11	12.00	x 9.00	T300-XM101DE-5/8	15.8	110.0	67.7	20.0	4	DIN 2184-1
UNC 3/4-10	14.00	x 11.00	T300-XM101DE-3/4	19.0	125.0	80.7	25.0	4	DIN 2184-1
UNC 7/8-9	18.00	x 14.50	T300-XM101DE-7/8	22.2	140.0	92.7	25.0	4	DIN 2184-1
UNC 1"-8	18.00	x 14.50	T300-XM101DE-1	25.4	160.0	112.7	30.0	4	DIN 2184-1

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form UNF





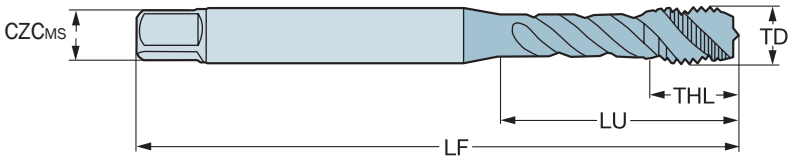
TDZ	CZC$_{MS}$			Order number	Dimensions, mm					
	Shank		Square		TD	LF	LU	THL	NOF	BSG
UNF #8-36	4.50	x	3.40	T200-XM100DF-8-36	4.1	63.0	21.0	11.4	3	DIN 2184-1
UNF #10-32	6.00	x	4.90	T200-XM100DF-10-32	4.8	70.0	25.0	12.2	3	DIN 2184-1
UNF 1/4-28	7.00	x	5.50	T200-XM100DF-1/4	6.3	80.0	30.0	14.1	3	DIN 2184-1
UNF 5/16-24	8.00	x	6.20	T200-XM100DF-5/16	7.9	90.0	35.0	17.4	3	DIN 2184-1
UNF 3/8-24	10.00	x	8.00	T200-XM100DF-3/8	9.5	100.0	39.0	18.9	3	DIN 2184-1
UNF 7/16-20	8.00	x	6.20	T200-XM101DF-7/16	11.1	100.0	76.0	20.0	3	DIN 2184-1
UNF 1/2-20	9.00	x	7.00	T200-XM101DF-1/2	12.7	110.0	83.0	23.0	3	DIN 2184-1
UNF 5/8-18	12.00	x	9.00	T200-XM101DF-5/8	15.8	110.0	68.0	25.0	3	DIN 2184-1
UNF 3/4-16	14.00	x	11.00	T200-XM101DF-3/4	19.0	125.0	81.0	30.0	4	DIN 2184-1
UNF 7/8-14	18.00	x	14.50	T200-XM101DF-7/8	22.2	140.0	93.0	34.0	4	DIN 2184-1
UNF 1"-12	18.00	x	14.50	T200-XM101DF-1	25.4	160.0	113.0	38.0	4	DIN 2184-1

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form UNF

UNF	C 2-3.5	2B	HSS PM - 5/8"	HSS-E from 3/4"	DIN 2184-1	2.5xD
	P	M	K	N	S	



TDZ	CZC_{MS}	Order number	Dimensions, mm					
	Shank	Square		TD	LF	LU	THL	NOF	BSG
UNF #8-36	4.50	x 3.40	T300-XM100DF-8-36	4.1	63.0	21.0	6.5	3	DIN 2184-1
UNF #10-32	6.00	x 4.90	T300-XM100DF-10-32	4.8	70.0	25.0	7.3	3	DIN 2184-1
UNF 1/4-28	7.00	x 5.50	T300-XM100DF-1/4	6.3	80.0	30.0	10.0	3	DIN 2184-1
UNF 5/16-24	8.00	x 6.20	T300-XM100DF-5/16	7.9	90.0	35.0	12.0	3	DIN 2184-1
UNF 3/8-24	10.00	x 8.00	T300-XM100DF-3/8	9.5	100.0	39.0	15.0	3	DIN 2184-1
UNF 7/16-20	8.00	x 6.20	T300-XM101DF-7/16	11.1	100.0	75.7	15.0	3	DIN 2184-1
UNF 1/2-20	9.00	x 7.00	T300-XM101DF-1/2	12.7	110.0	83.0	18.0	3	DIN 2184-1
UNF 5/8-18	12.00	x 9.00	T300-XM101DF-5/8	15.8	110.0	67.7	20.0	4	DIN 2184-1
UNF 3/4-16	14.00	x 11.00	T300-XM101DF-3/4	19.0	125.0	77.5	25.0	4	DIN 2184-1
UNF 7/8-14	18.00	x 14.50	T300-XM101DF-7/8	22.2	140.0	92.7	25.0	4	DIN 2184-1

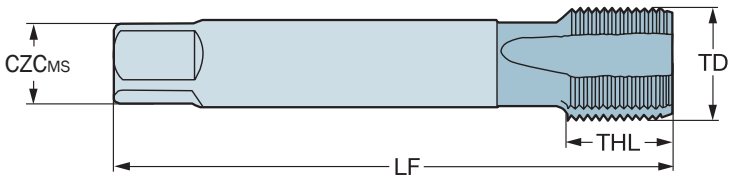
C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form G

G	B 3.5-5	Normal	HSS PM - 3/8”	HSS-E from 1/2”	DIN 5156	2.5xD

	P	M	K	N	S



TDZ	CZC$_{MS}$			Order number	Dimensions, mm					
	Shank		Square		TD	LF	LU	THL	NOF	BSG
G 1/8-28	7.00	x	5.50	T200-XM100DK-1/8	9.7	90.0	67.0	18.0	3	DIN 5156
G 1/4-19	11.00	x	9.00	T200-XM100DK-1/4	13.1	100.0	71.0	21.0	3	DIN 5156
G 3/8-19	12.00	x	9.00	T200-XM100DK-3/8	16.6	100.0	58.0	21.0	4	DIN 5156
G 1/2-14	16.00	x	12.00	T200-XM100DK-1/2	20.9	125.0	80.0	24.0	4	DIN 5156
G 5/8-14	18.00	x	14.50	T200-XM100DK-5/8	22.9	125.0	78.0	24.0	4	DIN 5156
G 3/4-14	20.00	x	16.00	T200-XM100DK-3/4	26.4	140.0	77.0	28.0	4	DIN 5156
G 1"-11	25.00	x	20.00	T200-XM100DK-1	33.2	160.0	93.0	30.0	4	DIN 5156

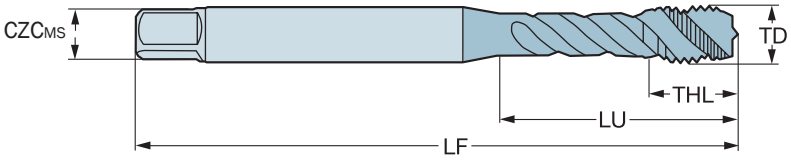
C-Sorte: HSS-PM
B-Sorte: HSS-E

CoroTap™ 300 tap for blind holes

Thread form G

G	C 2-3.5	Normal	HSS PM - 3/8"	HSS-E from 1/2"	DIN 5156	2.5xD

	P	M	K	N	S



TDZ		CZC$_{MS}$		Order number	Dimensions, mm					
	Shank		Square		TD	LF	LU	THL	NOF	BSG
G 1/8-28	7.00	x	5.50	T300-XM100DK-1/8	9.7	90.0	67.0	13.0	3	DIN 5156
G 1/4-19	11.00	x	9.00	T300-XM100DK-1/4	13.1	100.0	71.0	15.0	3	DIN 5156
G 3/8-19	12.00	x	9.00	T300-XM100DK-3/8	16.6	100.0	58.0	15.0	4	DIN 5156
G 1/2-14	16.00	x	12.00	T300-XM100DK-1/2	20.9	125.0	80.0	18.0	4	DIN 5156
G 5/8-14	18.00	x	14.50	T300-XM100DK-5/8	22.9	125.0	78.0	18.0	4	DIN 5156
G 3/4-14	20.00	x	16.00	T300-XM100DK-3/4	26.4	140.0	77.0	20.0	4	DIN 5156
G 1"-11	25.00	x	20.00	T300-XM100DK-1	33.2	160.0	93.0	22.0	4	DIN 5156
G 1.1/4-11	32.00	x	24.00	T300-XM100DK-1.1/4	41.9	170.0	72.0	22.0	4	DIN 5156
G 1.1/2-11	36.00	x	29.00	T300-XM100DK-1.1/2	47.8	190.0	87.0	23.0	4	DIN 5156

C grade: HSS-PM
B grade: HSS-E

Advantages of thread milling

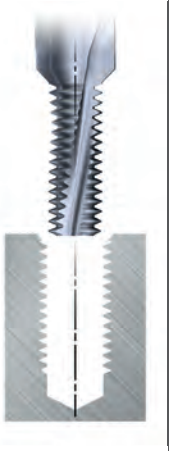
- Production of different thread tolerances through radius compensation
- Low torque required
- Easy machining of long-chipping materials
- Machining of hard materials
- High level of process reliability
- Production of different threads with a single tool (with the same lead, e.g. M10x1.5, M12x1.5)

Application

- Left and right threads with a single tool
- Thread length up to 3xD
- For smaller thread diameters ≥ 3.2 mm
- Thread machining down to near the base of the hole

ISO application range

Thread milling

Machining process including chamfering						
						
1. Positioning	2. Chamfering	3. Thread positioning	4. 180° insertion	5. 360° thread machining	6. 180° removal	7. Removal

Machining process with multiple passes (helical machining)				
				
1. Positioning over the hole	2. Insertion to the required thread depth	3. Radial plunging into the thread 180°/1/2 lead	4. Production of the thread through helical plunging	5. Return to the initial position

You can find NC programs and cutting values in our CoroPlus® Tool Guide.

Thread milling cutters

Metric/metric fine				UNC/UNF	NTP/NTPF	G
universal			ISO H	universal		
M 4–24/MF 6–18	MF 6–18/M 20–24	M 3–16	M 6–14/MF 12–14	1/4–3/4	1/8–1/2	1/8–1
with IC	without IC	with IC and chamfer	without IC	with IC	without IC	without IC
						
R217.1xC..AC/K..N	R217.1x..AC..N	R217.1x..CC..K	R217.1x..AC..M	R217.3xC..AC..M	R217.5x..AC..N	R217.9x..BC..N
P.34	P.35	P.36	P.37	P.38	P.39	P.40
1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice
P O M K N S	P O M K N S	P O M K N S	P S H O	P O M K N S	P O M K N S	P O M K N S H
2xD	2xD	2xD	2xD	2xD	2xD	2xD
1630	1630	1630	1620	1630	1630	1630

Thread milling cutter for helix machining

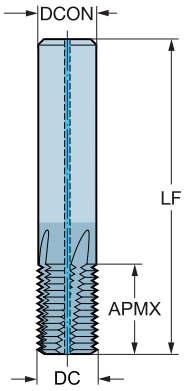
Metric/metric fine			UNC/UNF	
universal		ISO H+S	universal	
M 1.6–12	TP 0.5–2	M 2–6	#1–5/16	1/4–5/16
without IC				
				
R217.3x..AC..P	326..VM-TH	R217.1x..AC..S	R217.3x..AC..P	A326..VM-TH
S.41	S.44	S.42	S.43	S.44
1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice	1st choice/ 2nd choice
P H M K N	P M K N S	P S H O	P M K N S	P M K N S
2xD/3xD	2xD	2xD	3xD	2xD
1620	1025	1610	1620	1025

CoroMill® Plura – thread milling cutter

For internal threads
Cylindrical shank

M	MF	IC	2xD	GRADE	TCDCON
4-24	6-18			1630	h6

P	M	K	N	S

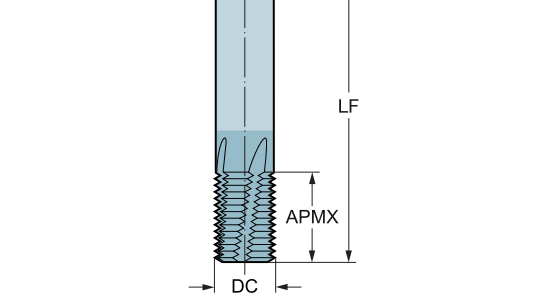


Thread	Order number		Dimensions, mm					
FTDZ		Grade	DC	APMX	IK	ZEPF	DCON	LF
M4x0.7	R217.13-032070AC08N	1630	3.20	8.40	ohne	3	6.00	57.00
M5x0.8	R217.13-041080AC11N	1630	4.10	11.20	ohne	3	6.00	57.00
M6x1.0	R217.14C045100AC13N	1630	4.50	13.00	mit	4	6.00	57.00
M8x1.25	R217.14C060125AK17N	1630	6.00	17.50	mit	4	6.00	65.00
M10x1.5	R217.14C075150AK21N	1630	7.50	21.00	mit	4	8.00	72.00
M12x1.75	R217.14C095175AK26N	1630	9.50	26.25	mit	4	10.00	80.00
M14x2.0	R217.15C100200AK30N	1630	10.00	30.00	mit	5	10.00	83.00
M16x2.0	R217.15C120200AK34N	1630	12.00	34.00	mit	5	12.00	92.00
M20x2.5	R217.15C160250AK42N	1630	16.00	42.50	mit	5	16.00	105.00
M24x3.0	R217.15C190300AK50N	1630	19.00	50.00	mit	5	20.00	125.00
MF6x0,5	R217.13C048050AC10N	1630	4.80	10.00	mit	3	6.00	57.00
MF8x0.75	R217.13C060075AC12N	1630	6.00	12.00	mit	3	6.00	57.00
MF10x1.0	R217.14C080100AC16N	1630	8.00	16.00	mit	4	8.00	63.00
MF14x1.5	R217.14C120150AC22N	1630	12.00	22.50	mit	4	12.00	83.00
MF18x1.5	R217.15C160150AC30N	1630	16.00	30.00	mit	5	16.00	92.00

CoroMill® Plura – thread milling cutter

For internal threads
Cylindrical shank

M	MF	GRADE	TCDCON
20-24	6-28	1630	h6



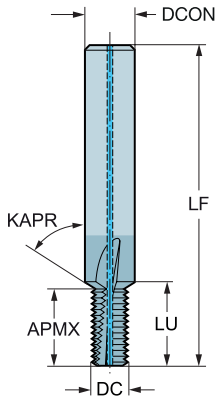
Thread	Order number	Dimensions, mm				
FTDZ		DC	APMX	ZEFP	DCON	LF
MF 6x0.5	R217.13-048050AC10N 1630	4.80	10.00	3	6.00	57.00
MF 8x0.75	R217.13-060075AC12N 1630	6.00	12.00	3	6.00	57.00
MF 8x1.0	R217.13-060100AC12N 1630	6.00	12.00	3	6.00	57.00
MF 10x1	R217.14-080100AC16N 1630	8.00	16.00	4	8.00	63.00
MF 12x1	R217.14-100100AC20N 1630	10.00	20.00	4	10.00	72.00
MF 14x1	R217.14-120100AC22N 1630	12.00	22.00	4	12.00	83.00
MF 16x1	R217.15-140100AC26N 1630	14.00	26.00	5	14.00	83.00
MF 12x1.5	R217.14-100150AC20N 1630	10.00	21.00	4	10.00	72.00
MF 14x1.5	R217.14-120150AC22N 1630	12.00	22.50	4	12.00	83.00
MF 16x1.5	R217.15-140150AC26N 1630	14.00	27.00	5	14.00	83.00
MF 20x2	R217.15-160200AC30N 1630	16.00	30.00	5	16.00	92.00
MF 24x2	R217.15-200200AC35N 1630	20.00	36.00	5	20.00	104.00
MF 28x2	R217.16-250200AC46N 1630	25.00	46.00	6	25.00	121.00
M 20x2.5	R217.15-160250AC42N 1630	16.00	42.50	5	16.00	105.00
M 24x3	R217.15-190300AC50N 1630	19.00	50.00	5	20.00	125.00

CoroMill® Plura – thread milling cutter with chamfer

For internal threads
Cylindrical shank

M 3-16	IC	2xD	GRADE 1630	TCDCON h6

P	M	K	N	S



Thread	Order number	Dimensions, mm						
FTDZ		DC	APMX	LU	IK	ZEFP	DCON	LF
M3X0.5	R217.13-023050CC06K 1630	2.30	5.00	6.00	ohne	3	6.00	52.00
M4X0.70	R217.13C032070CC08K 1630	3.20	8.80	9.50	mit	3	6.00	48.20
M5X0.80	R217.13C041080CC11K 1630	4.10	10.72	11.67	mit	3	6.00	46.28
M6x1.0	R217.13C048100CC13K 1630	4.80	12.78	13.58	mit	3	8.00	50.22
M8x1.25	R217.13C065125CC17K 1630	6.50	17.35	18.24	mit	3	10.00	54.65
M10x1.5	R217.13C082150CC21K 1630	8.20	22.41	23.41	mit	3	12.00	60.59
M12x1.75	R217.14C099175CC26K 1630	9.90	26.00	27.00	mit	4	14.00	57.00
M14x2.0	R217.14C116200CC30K 1630	11.60	31.30	32.40	mit	4	16.00	60.70
M16X2.0	R217.14C136200CC34K 1630	13.60	33.30	34.40	mit	4	18.00	58.70

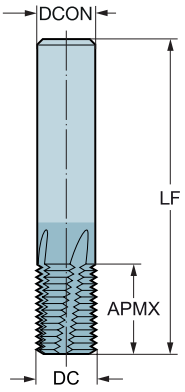
KAPR: 45°

CoroMill® Plura – thread milling cutter for hard machining

For internal threads
Cylindrical shank

M	MF	1,5xD	GRADE	TCDCON
6-14	12-14		1620	h6

P H



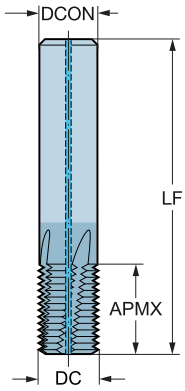
Thread	Order number	Dimensions, mm				
FTDZ		DC	APMX	ZEPF	DCON	LF
M6x1.0	R217.14-045100AC10M 1620	4.50	10.00	4	6.00	57.00
M8x1.25	R217.15-060125AC12M 1620	6.00	12.50	5	6.00	57.00
M10x1.5	R217.15-080150AC16M 1620	8.00	16.50	5	8.00	63.00
M12x1.75	R217.15-090175AC19M 1620	9.00	19.25	5	10.00	72.00
M14x2.0	R217.15-120200AC26M 1620	12.00	26.00	5	12.00	83.00
MF12x1	R217.15-100100AC20M 1620	10.00	20.00	5	10.00	72.00
MF14x1.5	R217.16-120150AC27M 1620	12.00	27.00	6	12.00	83.00

CoroMill® Plura – thread milling cutter

For internal threads
Cylindrical shankt

UNC	UNF	IC	2xD	GRADE	TCDCON
1/4- 3/4	1/4- 3/4			1630	h6

P	M	K	N	S



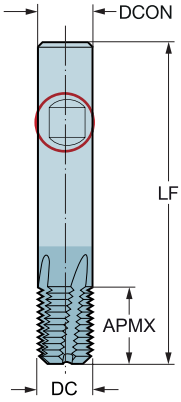
Thread	Order number	Dimensions, inches				
FTDZ		DC	APMX	ZEPF	DCON	LF
1/4-20 UNC	R217.33C048200AC13N 1630	.189	.551	3	.236	2.244
5/16-18 UNC	R217.33C055180AC14N 1630	.217	.556	3	.236	2.244
3/8-16 UNC	R217.34C075160AC19N 1630	.295	.750	4	.315	2.480
7/16-14 UNC	R217.34C080140AC19N 1630	.315	.785	4	.315	2.480
1/2-13 UNC	R217.34C100130AC21N 1630	.394	.846	4	.394	2.835
9/16-12 UNC	R217.34C100120AC21N 1630	.394	.833	4	.315	2.835
5/8-11 UNC	R217.34C120110AC25N 1630	.472	1000	4	.472	3.268
3/4-10 UNC	R217.35C140100AC33N 1630	.551	1300	5	.551	3.268
1/4-28 UNF	R217.33C048280AC13N 1630	.189	.536	3	.236	2.244
5/16-24 UNF	R217.33C060240AC13N 1630	.236	.541	3	.236	2.244
7/16-20 UNF	R217.34C080200AC19N 1630	.315	.750	4	.315	2.480
9/16-18 UNF	R217.34C100180AC22N 1630	.394	.889	4	.394	2.835
3/4-16 UNF	R217.35C140160AC31N 1630	.551	1250	5	.551	3.268

CoroMill® Plura – thread milling cutter

For internal threads
Weldon

NTP 1/8 - 1/2	NPTF 1/8 - 1/2	2xD	GRADE 1630	TCDCON h6	6535 HB

P	M	K	N	S



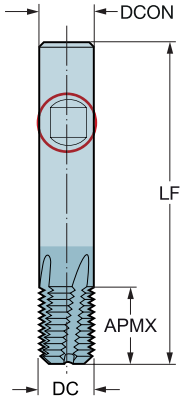
Thread	Order number	Dimensions, inches				
FTDZ		DC	APMX	ZEPF	DCON	LF
1/8-27 NPT	R217.53-079270AC11N 1630	.311	.453	3	.315	2.284
1/4-18 NPT	R217.53-099180AC15N 1630	.390	.627	3	.394	2.598
1/2-14 NPT	R217.54-159140AC20N 1630	.626	.806	4	.630	3.228
1/2-14 NPT	R217.55-199115AC27N 1630	.784	1068	5	.787	3.622
1/8-27 NPTF	R217.73-079270AC11N 1630	.311	.453	3	.315	2.284
1/4-18 NPTF	R217.73-099180AC15N 1630	.390	.627	3	.394	2.598
1/2-14 NPTF	R217.74-159140AC20N 1630	.626	.806	4	.630	3.228

CoroMill® Plura – thread milling cutter

For internal and external machining
Weldon

G 1/8- 3”	2xD	GRADE 1630	TCDCON h6	6535 HB

P	M	K	N	S	H

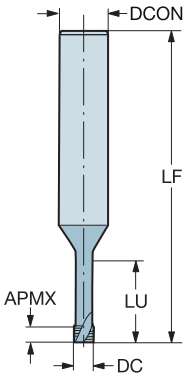


Thread	Order number	Dimensions, mm				
FTDZ		DC	APMX	ZEPF	DCON	LF
G1/8	R217.93-060280BC15N 1630	6.00	15.40	3	6.00	57.00
G1/4	R217.94-100190BC20N 1630	10.00	20.00	4	10.00	72.00
G3/8	R217.95-140190BC26N 1630	14.00	26.70	5	14.00	83.00
G1/2 5/8	R217.95-160140BC30N 1630	16.00	30.80	5	16.00	92.00
G5/8 3/4 7/8	R217.95-200140BC35N 1630	20.00	36.20	4	20.00	104.00
G1"-3"	R217.95-250110BC45N 1630	25.00	46.15	5	25.00	121.00

CoroMill® Plura – thread milling cutter for helical machining

For internal threads
Cylindrical shank

M 6-12	MF 2,5-36	2-3xD	GRADE 1620/ H07F	TCDCON h6
P	M	K	N	S



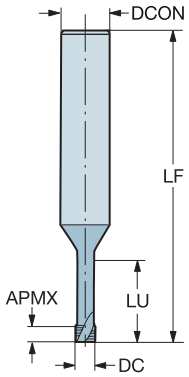
Thread	Fine	Lead	Order number	Dimensions, mm					
FTDZ	Gewinde	TP		DC	APMX	LU	ZEFP	DCON	LF
M 1.6	MF 2.5-3.5	0.35	R217.13-012035AC03P 1620	1.20	0.53	3.73	3	3.00	37.82
M 2		0.4	R217.13-015040AC04P 1620	1.55	1.00	4.60	3	6.00	56.80
M 2.5		0.45	R217.13-019045AC05P 1620	1.95	1.13	5.68	3	6.00	56.77
M 3	MF 4-8	0.5	R217.13-023050AC06P 1620	2.30	1.25	6.75	3	6.00	56.75
M 4		0.7	R217.13-031070AC08P 1620	3.10	1.75	9.05	3	6.00	56.65
M 5		0.8	R217.13-040080AC10P 1620	4.00	2.00	11.20	3	6.00	56.60
M 6	MF 8-30	1.00	R217.13-048100AC12P 1620	4.80	2.50	13.50	3	6.00	56.50
M 8	MF 10-16	1.25	R217.13-064125AC16P 1620	6.40	3.13	17.90	3	8.00	63.00
M 10	MF 12-36	1.5	R217.14-082150AC20P 1620	8.20	3.75	22.30	4	10.00	71.25
M 12		1.75	R217.15-095175AC24P 1620	9.50	4.38	26.70	5	10.00	71.12
M 1.6	MF 2.5-3.5	0.35	R217.13-012035AC05P H07F	1.20	0.53	5.33	3	3.00	37.82
M 2		0.4	R217.13-015040AC06P H07F	1.55	1.00	6.60	3	6.00	56.80
M 2.5		0.45	R217.13-019045AC07P H07F	1.95	1.13	8.18	3	6.00	56.77
M 3	MF 4-8	0.5	R217.13-023050AC09P H07F	2.30	1.25	9.75	3	6.00	56.75
M 4		0.7	R217.13-031070AC12P H07F	3.10	1.75	13.05	3	6.00	56.65
M 5		0.8	R217.13-040080AC15P H07F	4.00	2.00	16.20	3	6.00	56.60
M 6	MF 10-30	1.00	R217.13-048100AC18P H07F	4.80	2.50	19.50	3	6.00	59.50

CoroMill® Plura – thread milling cutter for hard machining

For internal threads
Cylindrical shank

M 2-6 | MF 2,5-30 | 2xD | GRADE 1610 | TCDCON h6

P H



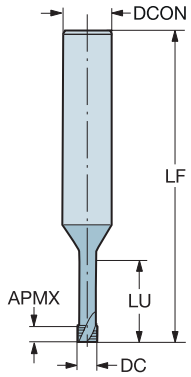
Thread	Fine	Lead	Order number	Dimensions, mm					
FTDZ	Gewinde	TP		DC	APMX	LU	ZEFP	DCON	LF
M 2	MF 2.5-3.5	0.40	R217.13-015040AC04S 1610	1.50	0.60	4.60	3	6.00	56.80
M 2.5		0.45	R217.13-019045AC05S 1610	1.95	0.68	5.68	3	6.00	56.77
M 3	MF 4-8	0.50	R217.13-023050AC06S 1610	2.30	0.75	6.75	3	6.00	56.75
M 4		0.70	R217.13-031070AC08S 1610	3.10	1.05	9.05	3	6.00	56.65
M 5		0.80	R217.14-040080AC10S 1610	4.00	1.20	11.20	4	6.00	56.60
M 6	MF 8-30	1.00	R217.14-048100AC12S 1610	4.80	1.50	13.50	4	6.00	56.50

CoroMill® Plura – thread milling cutter for helical machining

For internal threads
Cylindrical shank

UNC #1/64 - 5/16	UNF #2/64 - 5/16	3xD	GRADE 1620	TCDCON h6

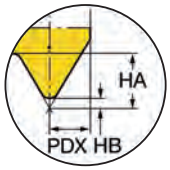
P	M	K	N	S

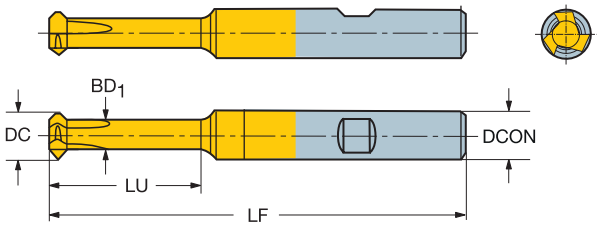


Thread	Lead	Order number	Dimensions, inch					
FTDZ	TP		DC	APMX	LU	ZEFP	DCON	LF
UNC # 1-64	64.0	R217.33-013640AC05P 1620	.053	.023	.244	3	.236	23
UNC #2-56	56.0	R217.33-016560AC06P 1620	.063	.027	.285	3	.236	236
UNC #4-40	40.0	R217.33-021400AC08P 1620	.083	.062	.374	3	.236	236
UNC #6-32	32.0	R217.33-026320AC10P 1620	.102	.078	.463	3	.236	236
UNC #8-32	32.0	R217.33-032320AC12P 1620	.128	.078	.539	3	.236	236
UNC #10-24	24.0	R217.33-035240AC14P 1620	.140	.104	.634	3	.236	2223
UNC 1/4	20.0	R217.33-048200AC19P 1620	.191	.125	.827	3	.236	2219
UNC 5/16	18.0	R217.33-062180AC24P 1620	.244	.139	1022	3	.315	2453
UNF #6-40	40.0	R217.33-027400AC10P 1620	.108	.037	.453	3	.236	2230
UNF #10-32	32.0	R217.33-038320AC14P 1620	.152	.047	.618	3	.236	2228
UNF 1/4	28.0	R217.33-052280AC19P 1620	.207	.054	.805	3	.236	2226
UNF 5/16	24.0	R217.33-065240AC24P 1620	.258	.062	1000	3	.315	2459

CoroMill® Plura – thread milling cutter for helical machining

For internal threads
Cylindrical shank





Metric version

Order number		Lead, mm		Dimensions, mm								
DC		Min.	Max.	APMX	LU	ZEFP	DCON	LF	DN	HA	HB	BD
5.80	326R06-B15050VM-TH 1025	0.5	1.5	1.94	15.00	3	6.00	58.00	3.5	0.97	0.06	5.00
7.80	326R08-B25050VM-TH 1025	0.5	1.5	1.94	25.00	3	8.00	68.00	5.5	0.97	0.06	5.50
7.80	326R08-B25100VM-TH 1025	1.0	2.0	2.62	25.00	3	8.00	68.00	5	1.31	0.12	5.00

Inch version

Order number		Lead, mm		Dimensions, inches								
DC		Min.	Max.	APMX	LU	ZEFP	DCON	LF	DN	HA	HB	BD
.228	A326R06-M15050VM-TH 1025	16	50	.076	.591	3	.250	2.284	.138	.038	.002	.197
.307	A326R08-M25050VM-TH 1025	16	50	.076	.984	3	.312	2.677	.216	.038	.002	.217
.307	A326R08-M25100VM-TH 1025	12	24	.103	.984	3	.312	2.677	.197	.051	.004	.197

Cutting data for the CoroDrill® 460: Cutting speed

Internal cutting fluid supply

ISO	MC no.	Material	Hard-ness Brinell	3 - 5 x D	8 x D
				Cutting speed v_c m/min	Cutting speed v_c m/min
			HB	DC 3.00 - 20.00mm	DC 3.00 - 20.00mm
P		Non-alloy carbon steel		(min. – starting value – max.)	(min. – starting value – max.)
	P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	125	100-125-150	104-130-156
					104-130-156
	P1.2.Z.AN	S355J2G3; C45; 40Mn6; St52	150	88-110-132	88-110-132
	P1.3.Z.AN	S340 MGC; C60; C105W1	170	88-110-132	88-110-132
		Steel with high carbon content			
	P1.3.Z.AN	S340 MGC; C60; C105W1	210	88-110-132	88-110-132
		Low-alloy steel			
	P2.1.Z.AN	17CrNiMo6; 16MnCr5	175	88-110-132	88-110-132
	P2.5.Z.HT.1	34CrNiMo6 V; 51CrV4 V; 41CrAlMo7 V	275	60-75-90	72-90-108
	P2.5.Z.HT.2	30CrNiMo8; 36CrNiMo4; 50CrV4	350	52-65-78	64-80-96
		High-alloy steel			
	P3.0.Z.AN	X210Cr12; X100CrMoV5 1; X155CrMoV12-1	200	76-95-114	80-100-120
	P3.0.Z.HT.1	See hardened above	300	52-65-78	64-80-96
		Cast steel			
	P1.5.C.UT	GC16E (1.1142)	150	88-110-132	88-110-132
	P2.6.C.UT	22Mo4; 25CrMo4	200	76-95-114	80-100-120
M		Stainless steel			
	M1.0.Z.AQ	1.4301; 1.4404	200	32-40-48	24-30-36
	M2.0.Z.AQ	X1NiCrMoCu25-20-5; X8CrNi25-21; X12NiCrSi36 16	200	32-40-48	24-30-36
	M3.1.Z.AQ	X2CrNiN23-4; X8CrNiMo27-5; 1.4362	230	28-35-42	20-25-30
	M3.2.Z.AQ	X2CrNiMoN22-53; X2CrNiN23-4	260	28-35-42	20-25-30
	M1.0.C.UT	1.4848; X2CrNiMo17-12-2; X2CrNiMoN17-11-2	200	32-40-48	24-30-36
	M2.0.C.AQ	654 SMO	200	32-40-48	24-30-36
	M3.1.C.AQ	X2CrNiN23-4; X8CrNiMo27-5	230	28-35-42	20-25-30
K		Malleable cast iron			
	K1.1.C.NS	EN-GJMB350-10; EN-GJMB550-4; EN-GJMB700-2	200	64-80-96	60-75-90
		Grey cast iron			
	K2.1.C.UT	EN-GJL-150; EN-GJL-200; EN-GJL-250 (GG25)	180	88-110-132	92-115-138
	K2.2.C.UT	EN-GJL-300; EN-GJL-350	245	88-110-132	92-115-138
	K2.3.C.UT	GGL-NiCr20-2	175	64-80-96	60-75-90
		Ductile cast iron			
	K3.1.C.UT	EN-GJS-400-15; N-GJS-800-7; EN-GJS-400-18-LT (GGG40)	155	64-80-96	60-75-90
	K3.2.C.UT	EN-GJS-600-3 (GGG50)	215	64-80-96	60-75-90
	K3.3.C.UT	EN-GJS-700-2	265	64-80-96	60-75-90
	K3.5.C.UT	EN-GJSA-XNiCr20-2	190	64-80-96	60-75-90
	K5.1.C.NS	EN-GJS-800-8; EN-GJS-1000-5	300	64-80-96	60-75-90
N		Aluminium alloys			
	N1.2.Z.UT	EN AW-7075	60	200-250-300	216-270-324
	N1.2.Z.AG	AlMgSi1	100	200-250-300	216-270-324
	N1.3.C.UT	G-AlMg5	75	200-250-300	216-270-324
	N1.3.C.AG	GD-AlSi8Cu3	90	160-200-240	144-180-216
	N1.4.C.NS	AlSi21CuNiMg	130	120-150-180	72-90-108
		Copper-based alloys			
	N3.3.U.UT	CuZn39Pb3	110	176-220-264	176-220-264
	N3.1.U.UT	Brass, copper	100	100-125_150	100-125-150
S		Titanium			
	S4.1.Z.UT	Ti99,5; TiCu2; 3 7064	200	44-55-66	
	S4.2.Z.AN	TiAl6V4; TiAl4Mo4Sn2Si0,5	330	32-40-48	
H	H1.1.Z.HA	40CrMnMo7; 55NiCrMoV6; X42Cr13	50 HRC	24-30-36	
	H2.0.C.UT.4	100Cr6; 1.3505	64 HRC	20-25-30	

Cutting data for the CoroDrill® 460 – feed 3 x D

Internal cutting fluid supply

ISO	MC no.	Drill diameter, mm: 3	4	6	8	10	12	16	20
		Feed fn mm/rev (min. – starting value – max.)							
P	P1.1.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
		0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P1.2.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P1.3.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P1.3.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P2.1.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P2.5.Z.HT.1	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P2.5.Z.HT.2	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P3.0.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P3.0.Z.HT.1	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P1.5.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P2.6.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
M	M1.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.Z.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	M3.2.Z.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	M1.0.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.C.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.C.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
K	K1.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K2.1.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.2.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.1.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.2.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.5.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K5.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
N	N1.2.Z.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.2.Z.AG	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.3.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.3.C.AG	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N1.4.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N3.3.U.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N3.1.U.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
S	S4.1.Z.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.086-0.107-0.128	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
		0.056-0.070-0.084	0.064-0.080-0.096	0.056-0.070-0.084	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	S4.2.Z.AN	0.056-0.070-0.084	0.064-0.080-0.096	0.056-0.070-0.084	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
H	H1.1.Z.HA	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	H2.0.C.UT.4	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288

Cutting data for the CoroDrill® 460 – feed 5 x D

Internal cutting fluid supply

ISO	MC no.	Drill diameter, mm: 3	4	6	8	10	12	16	20
		Feed fn mm/rev (min. – starting value – max.)							
P	P1.1.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
		0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P1.2.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P1.3.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P1.3.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P2.1.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P2.5.Z.HT.1	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P2.5.Z.HT.2	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P3.0.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P3.0.Z.HT.1	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P1.5.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P2.6.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
M	M1.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.Z.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	M3.2.Z.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	M1.0.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.C.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.C.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
K	K1.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K2.1.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.2.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.1.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.2.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.5.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K5.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
N	N1.2.Z.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.2.Z.AG	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.3.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.3.C.AG	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N1.4.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N3.3.U.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N3.1.U.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
S	S4.1.Z.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
		0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	S4.2.Z.AN	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
H	H1.1.Z.HA	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	H2.0.C.UT.4	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288

Cutting data for the CoroDrill® 460 – feed 8 x D

Internal cutting fluid supply

ISO	MC no.	Drill diameter, mm: 3	4	6	8	10	12	16	20
		Feed fn mm/rev (min. – starting value – max.)							
P	P1.1.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
		0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P1.2.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P1.3.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P1.3.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P2.1.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P2.5.Z.HT.1	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P2.5.Z.HT.2	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P3.0.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P3.0.Z.HT.1	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P1.5.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P2.6.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
M	M1.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.2.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M1.0.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.C.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.C.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
K	K1.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K2.1.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.2.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.1.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.2.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.5.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K5.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
N	N1.2.Z.UT	0.120-0.150-0.180	0.144-0.180-0.216	0.200-0.250-0.300	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.440-0.550-0.660	0.464-0.580-0.696
	N1.2.Z.AG	0.120-0.150-0.180	0.144-0.180-0.216	0.200-0.250-0.300	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.440-0.550-0.660	0.464-0.580-0.696
	N1.3.C.UT	0.120-0.150-0.180	0.144-0.180-0.216	0.200-0.250-0.300	0.264-0.330-0.396	0.336-0.420-0.504	0.384-0.480-0.576	0.440-0.550-0.660	0.464-0.580-0.696
	N1.3.C.AG	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.4.C.NS	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N3.3.U.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N3.1.U.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.1224-0.153-0.1836	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408

Cutting data for the CoroDrill® 460: Cutting speed

External cutting fluid supply

ISO	MC no.	Material	Härte Brinell	3 - 5 x D
				Cutting speed v_c m/min
			HB	DC 3.00 - 20.00mm
		Non-alloy carbon steel		(min. – starting value – max.)
	P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	125	80-100-125
	P1.2.Z.AN	S355J2G3; C45; 40Mn6; St52	150	70.4-88-110
	P1.3.Z.AN	S340 MGC; C60; C105W1	170	70.4-88-110
		Steel with high carbon content		
	P1.3.Z.AN	S340 MGC; C60; C105W1	210	70.4-88-110
		Low-alloy steel		
P	P2.1.Z.AN	17CrNiMo6; 16MnCr5	175	70.4-88-110
	P2.5.Z.HT.1	34CrNiMo6 V; 51CrV4 V; 41CrAlMo7 V	275	48-60-75
	P2.5.Z.HT.2	30CrNiMo8; 36CrNiMo4; 50CrV4	350	41.6-52-65
		High-alloy steel		
	P3.0.Z.AN	X210Cr12; X100CrMoV5 1; X155CrMoV12-1	200	60.8-76-95
	P3.0.Z.HT.1	See hardened above	300	41.6-52-65
		Cast steel		
	P1.5.C.UT	GC16E (1.1142)	150	70.4-88-110
	P2.6.C.UT	22Mo4; 25CrMo4	200	60.8-76-95
		Stainless steel		
	M1.0.Z.AQ	1.4301; 1.4404	200	22.4-28-35
	M2.0.Z.AQ	X1NiCrMoCu25-20-5; X8CrNi25-21; X12NiCrSi36 16	200	22.4-28-35
M	M3.1.Z.AQ	X2CrNiN23-4; X8CrNiMo27-5; 1.4362	230	19.2-24-30
	M3.2.Z.AQ	X2CrNiMoN22-53; X2CrNiN23-4	260	19.2-24-30
	M1.0.C.UT	1.4848; X2CrNiMo17-12-2; X2CrNiMoN17-11-2	200	22.4-28-35
	M2.0.C.AQ	654 SMO	200	22.4-28-35
	M3.1.C.AQ	X2CrNiN23-4; X8CrNiMo27-5	230	19.2-24-30
		Malleable cast iron		
	K1.1.C.NS	EN-GJMB350-10; EN-GJMB550-4; EN-GJMB700-2	200	51.2-64-80
		Grey cast iron		
	K2.1.C.UT	EN-GJL-150; EN-GJL-200; EN-GJL-250 (GG25)	180	70.4-88-110
	K2.2.C.UT	EN-GJL-300; EN-GJL-350	245	70.4-88-110
K	K2.3.C.UT	GGL-NiCr20-2	175	51.2-64-80
		Ductile cast iron		
	K3.1.C.UT	EN-GJS-400-15; N-GJS-800-7; EN-GJS-400-18-LT (GGG40)	155	51.2-64-80
	K3.2.C.UT	EN-GJS-600-3 (GGG50)	215	51.2-64-80
	K3.3.C.UT	EN-GJS-700-2	265	51.2-64-80
	K3.5.C.UT	EN-GJSA-XNiCr20-2	190	51.2-64-80
	K5.1.C.NS	EN-GJS-800-8; EN-GJS-1000-5	300	51.2-64-80
		Aluminium alloys		
	N1.2.Z.UT	EN AW-7075	60	160-200-250
	N1.2.Z.AG	AlMgSi1	100	160-200-250
	N1.3.C.UT	G-AlMg5	75	160-200-250
N	N1.3.C.AG	GD-AlSi8Cu3	90	128-160-200
	N1.4.C.NS	AlSi21CuNiMg	130	96-120-150
		Copper-based alloys		
	N3.3.U.UT	CuZn39Pb3	110	140.8-176-220
	N3.1.U.UT	Brass, copper	100	80-100-125
		Titanium		
S	S4.1.Z.UT	Ti99,5; TiCu2; 3 7064	200	32.5-44-55
	S4.2.Z.AN	TiAl6V4; TiAl4Mo4Sn2Si0,5	330	25.6-32-40
H	H1.1.Z.HA	40CrMnMo7; 55NiCrMoV6; X42Cr13	50HRC	19.2-24-30
	H2.0.C.UT.4	100Cr6; 1.3505	64HRC	16-20-25

Cutting data for the CoroDrill® 460 – feed 3 x D

External cutting fluid supply

ISO	MC no.	Drill diameter, mm: 3	4	6	8	10	12	16	20
		Feed fn mm/rev (min. – starting value – max.)							
P	P1.1.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
		0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P1.2.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P1.3.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P1.3.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P2.1.Z.AN	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P2.5.Z.HT.1	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P2.5.Z.HT.2	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P3.0.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P3.0.Z.HT.1	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P1.5.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	P2.6.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
M	M1.0.Z.AQ	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
	M2.0.Z.AQ	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
	M3.1.Z.AQ	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
	M3.2.Z.AQ	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
	M1.0.C.UT	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
	M2.0.C.AQ	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
	M3.1.C.AQ	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
K	K1.1.C.NS	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K2.1.C.UT	0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
	K2.2.C.UT	0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
	K2.3.C.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.1.C.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.2.C.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.3.C.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.5.C.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K5.1.C.NS	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
N	N1.2.Z.UT	0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
	N1.2.Z.AG	0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
	N1.3.C.UT	0.104-0.130-0.156	0.12-0.15-0.18	0.16-0.20-0.24	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.36-0.45-0.54
	N1.3.C.AG	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N1.4.C.NS	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N3.3.U.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N3.1.U.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.16-0.20-0.24	0.20-0.25-0.30	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
S	S4.1.Z.UT	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.16-0.20-0.24	0.184-0.230-0.276	0.192-0.240-0.288
		0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
	S4.2.Z.AN	0.032-0.040-0.048	0.04-0.05-0.06	0.056-0.070-0.084	0.072-0.090-0.108	0.088-0.110-0.132	0.104-0.130-0.156	0.136-0.170-0.204	0.152-0.190-0.228
H	H1.1.Z.HA	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.16-0.20-0.24	0.184-0.230-0.276	0.192-0.240-0.288
	H2.0.C.UT.4	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.16-0.20-0.24	0.184-0.230-0.276	0.192-0.240-0.288

Cutting data for the CoroDrill® 460 – feed 5 x D

External cutting fluid supply

ISO	MC no.	Drill diameter, mm: 3	4	6	8	10	12	16	20
		Feed fn mm/rev (min. – starting value – max.)							
P	P1.1.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
		0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P1.2.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P1.3.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P1.3.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P2.1.Z.AN	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P2.5.Z.HT.1	0.080-0.100-0.120	0.092-0.115-0.184	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.384	0.256-0.320-0.384	0.272-0.340-0.408
	P2.5.Z.HT.2	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P3.0.Z.AN	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P3.0.Z.HT.1	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	P1.5.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	P2.6.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
M	M1.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.Z.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.Z.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	M3.2.Z.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	M1.0.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M2.0.C.AQ	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	M3.1.C.AQ	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
K	K1.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K2.1.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.2.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	K2.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.1.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.2.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.3.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K3.5.C.UT	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	K5.1.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
N	N1.2.Z.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.2.Z.AG	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.3.C.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N1.3.C.AG	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N1.4.C.NS	0.080-0.100-0.120	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
	N3.3.U.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
	N3.1.U.UT	0.104-0.130-0.156	0.120-0.150-0.180	0.160-0.200-0.240	0.208-0.260-0.312	0.264-0.330-0.396	0.304-0.380-0.456	0.344-0.430-0.516	0.360-0.450-0.540
S	S4.1.Z.UT	0.08-0.10-0.12	0.092-0.115-0.138	0.122-0.153-0.184	0.160-0.200-0.240	0.200-0.250-0.300	0.224-0.280-0.336	0.256-0.320-0.384	0.272-0.340-0.408
		0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	S4.2.Z.AN	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
H	H1.1.Z.HA	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288
	H2.0.C.UT.4	0.056-0.070-0.084	0.064-0.080-0.096	0.086-0.107-0.128	0.112-0.140-0.168	0.136-0.170-0.204	0.160-0.200-0.240	0.184-0.230-0.276	0.192-0.240-0.288

Cutting data for the CoroReamer™ 435

Cutting speed

ISO	MC no.	Material	N/mm²	HB	XF (v_c) m/min Min.	XF (v_c) m/min Starting value	XF (v_c) m/min Max.
P		Non-alloy carbon steel					
	P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	428	125	24	30	36
	P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	639	190	24	30	36
	P1.2.Z.AN	S355J2G3; C45; 40Mn6; St52	639	190	24	30	36
	P1.2.Z.HT	See heat-treated above	708	210	20	25	30
	P1.3.Z.AN	S340 MGC; C60; C105W1	639	190	24	30	36
	P1.3.Z.HT	See heat-treated above	991	300	16	20	24
		Low-alloy steel					
	P2.1.Z.AN	17CrNiMo6; 16MnCr5	591	175	24	30	36
	P2.2.Z.AN	31CrMo12; 34CrNiMo6; 51CrV4; 42CrMo4	811	240	20	25	30
	P2.3.Z.AN	100Cr6; 105WCr6	867	260	16	20	24
	P2.5.Z.HT.1	34CrNiMo6 V; 51CrV4 V; 41CrAlMo7 V	961	285	16	20	24
		Cast steel					
	P1.5.C.UT	GC16E (1.1142)	503	150	24	30	36
	P2.6.C.UT	22Mo4; 25CrMo4	674	200	20	25	30
		High-alloy steel					
	P3.0.Z.AN	X210Cr12; X100CrMoV5 1; X155CrMoV12-1	674	200	20	25	30
	P3.0.Z.HT.1	See hardened above	1282	380	12	15	18
	P3.1.Z.AN	S6-5-2; HS 6-5-2-5; HS 2-9-2	839	250	20	25	30
	P5.0.Z.HT.1	X6Cr17; X6CrMo17-1; X20CrMoV12-1	1114	330	20	25	30
	P5.0.Z.PH		503	330			
M		Stainless steel					
	M1.0.Z.AQ	1.4301; 1.4404	811	200			
	M2.0.Z.AQ	X1NiCrMoCu25-20-5; X8CrNi25-21; X12NiCrSi36 16	961	200			
	M3.1.Z.AQ	X2CrNiN23-4; X8CrNiMo27-5; 1.4362	674	230			
	M3.2.Z.AQ	X2CrNiMoN22-53; X2CrNiN23-4	674	260			
	M1.0.C.UT	1.4848; X2CrNiMo17-12-2; X2CrNiMoN17-11-2	674	200			
	M2.0.C.AQ	654 SMO		200			
	M3.1.C.AQ	X2CrNiN23-4; X8CrNiMo27-5	1114	230			
K		Malleable cast iron					
	K1.1.C.NS	EN-GJMB350-10; EN-GJMB550-4; EN-GJMB700-2	428	200	24	30	36
		Grey cast iron					
	K2.1.C.UT	EN-GJL-150; EN-GJL-200; EN-GJL-250 (GG25)	639	180	32	40	48
	K2.2.C.UT	EN-GJL-300; EN-GJL-350	639	245	32	40	48
	K2.3.C.UT	GGL-NiCr20-2	708	175	24	30	36
		Ductile cast iron					
	K3.1.C.UT	EN-GJS-400-15; N-GJS-800-7; EN-GJS-400-18-LT (GGG40)	639	155	24	30	36
	K3.2.C.UT	EN-GJS-600-3 (GGG50)	991	215	24	30	36
	K3.3.C.UT	EN-GJS-700-2	503	265	24	30	36
	K3.5.C.UT	EN-GJSA-XNiCr20-2	591	190	24	30	36
	K5.1.C.NS	EN-GJS-800-8; EN-GJS-1000-5	961	300	24	30	36
N		Aluminium alloys					
	N1.2.Z.UT	EN AW-7075	400	60	64	80	96
	N1.2.Z.AG	AlMgSi1	650	100	64	80	96
	N1.3.C.UT	G-AlMg5	600	75	64	80	96
	N1.3.C.AG	GD-AlSi8Cu3	700	90	64	80	96
	N1.4.C.NS	AlSi21CuNiMg	700	130	64	80	96
		Copper-based alloys					
	N3.3.U.UT	CuZn39Pb3	550	110	64	80	96
	N3.1.U.UT	Brass, copper	1350	100	64	80	96

Cutting data for the CoroReamer™ 435

Feed

ISO	MC no.	3	5	8	10	12	16	20
					fn mm/rev			
P	P1.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.2.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.2.Z.HT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.3.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.3.Z.HT	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P2.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P2.2.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P2.3.Z.AN	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P2.5.Z.HT.1	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P1.5.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P2.6.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P3.0.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P3.0.Z.HT.1	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P3.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P5.0.Z.HT.1	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P5.0.Z.PH	0.16	0.2	0.27	0.32	0.36	0.41	0.47
M	M1.0.Z.AQ							
	M2.0.Z.AQ							
	M3.1.Z.AQ							
	M3.2.Z.AQ							
	M1.0.C.UT							
	M2.0.C.AQ							
	M3.1.C.AQ							
K	K1.1.C.NS	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K2.1.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K2.2.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K2.3.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.1.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.2.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.3.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.5.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K5.1.C.NS	0.16	0.2	0.27	0.32	0.36	0.41	0.47
N	N1.2.Z.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.2.Z.AG	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.3.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.3.C.AG	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.4.C.NS	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N3.3.U.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N3.1.U.UT	0.18	0.25	0.35	0.39	0.43	0.5	0.53

Cutting data for the CoroTap™ 200/300

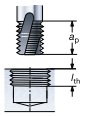
Cutting speed

ISO	MC no.	Material	Hardness Brinell	Grade B/C110			Grade B/C145			Grade B/C150		
				1.5xD	2xD	2.5xD	1.5xD	2xD	2.5xD	1.5xD	2xD	2.5xD
			HB	v_c (m/min)			v_c (m/min)			v_c (m/min)		
P		Non-alloy carbon steel										
	P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT	See heat-treated above	190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN	S355J2G3; C45; 40Mn6; St52	190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT	See heat-treated above	210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN	S340 MGC; C60; C105W1	190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT	See heat-treated above	300	21	17	15	12	10	9	12	10	9
		Low-alloy steel										
	P2.1.Z.AN	17CrNiMo6; 16MnCr5	175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN	31CrMo12; 34CrNiMo6; 51CrV4; 42CrMo4	240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN	100Cr6; 105WCr6	260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1	34CrNiMo6 V; 51CrV4 V; 41CrAlMo7 V	285	21	17	15	12	10	9	12	10	9
		High-alloy steel										
	P3.0.Z.AN	X210Cr12; X100CrMoV5 1; X155CrMoV12-1	200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1	See hardened above	380	10	8	7	6	5	4	6	5	4
	P3.1.Z.AN	S6-5-2; HS 6-5-2-5; HS 2-9-2	250	31	26	22	20	16	14	20	16	14
		Cast steel										
	P1.5.C.UT	GC16E (1.1142)	150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT	22Mo4; 25CrMo4	200	31	26	22	20	16	14	20	16	14
		Ferritic/martensitic stainless steel										
	P5.0.Z.HT.1	X6Cr17; X6CrMo17-1; X20CrMoV12-1	330	32	26	22	20	16	14	20	16	14
	P5.0.Z.PH	X85CrMoV18-2; X19CrNi17-2; X4 CrNiMo16-5	330	12	10	9	5	4	3			
M		Austenitic stainless steel										
	M1.0.Z.AQ	1.4301; 1.4404	200	10	8	7	7	6	5			
	M1.0.C.UT	1.4848; X2CrNiMo17-12-2; X2CrNiMoN17-11-2	230	10	8	7	7	6	5			
		Super austenitic stainless steel										
	M2.0.Z.AQ	X1NiCrMoCu25-20-5; X8CrNi25-21; X12NiCrSi36 16	200	10	8	7	7	6	5			
	M2.0.C.AQ	654 SMO	260	10	8	7	7	6	5			
		Stainless (austenitic/ferritic) duplex steels										
	M3.1.Z.AQ	X2CrNiN23-4; X8CrNiMo27-5; 1.4362	200	6	5	4	5	4	3			
	M3.2.Z.AQ	X2CrNiMoN22-53; X2CrNiN23-4	200	6	5	4	5	4	3			
	M3.1.C.AQ	X2CrNiN23-4; X8CrNiMo27-5	230	6	5	4	5	4	3			
K		Malleable cast iron										
	K1.1.C.NS	EN-GJMB350-10; EN-GJMB550-4; EN-GJMB700-2	200	24	20	17	18	15	13	18	15	13
		Grey cast iron										
	K2.1.C.UT	EN-GJL-150; EN-GJL-200; EN-GJL-250 (GG25)	180	23	19	16	18	15	13	18	15	13
	K2.2.C.UT	EN-GJL-300; EN-GJL-350	245	16	13	11	10	8	7	10	8	7
	K2.3.C.UT	GGL-NiCr20-2	175	24	20	17	18	15	13	18	15	13
		Ductile cast iron										
	K3.1.C.UT	EN-GJS-400-15; N-GJS-800-7; EN-GJS-400-18-LT (GGG40)	155	24	20	17	18	15	13	18	15	13
	K3.2.C.UT	EN-GJS-600-3 (GGG50)	215	24	20	17	18	15	13	18	15	13
	K3.3.C.UT	EN-GJS-700-2	265	24	20	17	18	15	13	18	15	13
	K3.5.C.UT	EN-GJSA-XNiCr20-2	190	24	20	17	18	15	13	18	15	13
	K5.1.C.NS	EN-GJS-800-8; EN-GJS-1000-5	300	16	13	11	10	8	7	10	8	7
N		Aluminium alloys										
	N1.2.Z.UT	EN AW-7075	60	49	40	34				43	35	30
	N1.2.Z.AG	AlMgSi1	100	49	40	34				43	35	30
	N1.3.C.UT	G-AlMg5	75	49	40	34				43	35	30
	N1.3.C.AG	GD-AlSi8Cu3	90	31	25	21				24	20	17
	N1.4.C.NS	AlSi21CuNiMg	130	21	18	15				18	15	13
		Copper-based alloys										
	N3.3.U.UT	CuZn39Pb3	110	46	38	32				37	30	26
	N3.1.U.UT	Brass, copper	100	18	15	13				15	12	10
S		Iron-based super alloys										
	S1.0.U.AN	TMG 1.7.3	200	9	8	6				6	5	4
		Nickel-based super alloys										
	S2.0.Z.UT	TMG 2.1; PMG 4.3	275	9	8	6				6	5	4
	S2.0.Z.AN	Inconel, Hastelloy, Rene 41	250	9	8	6				6	5	4
	S2.1.Z.AN	TMG 1.1.2; PMG 5.1	125	23	19	16				15	12	10
		Titanium-based alloy										
	S4.1.Z.UT	TiAl6V4	200	21	18	15				18	15	13

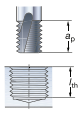
= only valid for CoroTap™ 200

Cutting data for the CoroMill® Plura thread milling cutter

Cutting speed and feed recommendations



$l_{Th} = 0.5 \times a_p$



$l_{Th} = a_p$

ISO	MC no.	Material	Hardness HB	Hardness HRC	Thread	Dimensions, mm DC	Dimensions, mm ZEFP	Cutting speed v_c m/min	Feed/tooth f_z mm	Cutting speed v_c m/min	Feed/tooth f_z mm
P	Non-alloy carbon steel				M4	3.2	3	152	0.030	141	0.018
	P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	125		M10	8.2	4	132	0.052	124	0.029
					M20	16	5	141	0.130	131	0.069
	Low-alloy steel				M4	3.2	3	147	0.012	137	0.006
	P2.5.Z.HT	34CrNiMo6 V; 51CrV4 V; 41CrAlMo7 V	300		M10	8.2	4	164	0.086	153	0.050
					M20	16	5	173	0.089	162	0.118
	High-alloy steel				M4	3.2	3	163	0.035	151	0.015
	P3.0.Z.HT	See hardened above	450		M10	8.2	4	164	0.061	153	0.049
					M20	16	5	173	0.012	162	0.118
M	Stainless steel				M4	3.2	3	81	0.024	75	0.009
	P5.0.Z.AN	X6Cr17; X6CrMo17-1; X20CrMoV12-1	200		M10	8.2	4	82	0.052	76	0.036
					M20	16	5	86	0.089	93	0.089
	M1.0.Z.AQ	1.4301; 1.4404	200		M4	3.2	3	53	0.018	49	0.007
					M10	8.2	4	53	0.052	50	0.027
					M20	16	5	56	0.089	53	0.072
	M3.1.Z.AQ	X2CrNiN23-4; X8CrNiMo27-5; 1.4362	230		M4	3.2	3	53	0.018	49	0.007
					M10	8.2	4	53	0.052	50	0.027
					M20	16	5	56	0.131	53	0.074
K	Malleable cast iron				M4	3.2	3	80	0.020	77	0.016
	K1.1.C.NS	EN-GJMB350-10; EN-GJMB550-4; EN-GJMB700-2			M10	8.2	4	89	0.061	83	0.036
					M20	16	5	82	0.084	83	0.089
	Grey cast iron				M4	3.2	3	76	0.018	73	0.014
	K2.2.C.UT	EN-GJL-300; EN-GJL-350			M10	8.2	4	86	0.038	79	0.034
					M20	16	5	79	0.075	80	0.080
	Ductile cast iron	EN-GJS-400-15; N-GJS-800-7; EN-GJS-400-18-LT (GGG40)			M4	3.2	3	101	0.027	97	0.020
	K3.1.C.UT	EN-GJS-600-3 (GGG50)			M10	8.2	4	104	0.047	105	0.048
		EN-GJS-700-2			M20	16	5	104	0.089	97	0.067
N	Aluminium				M4	3.2	3	503	0.040	503	0.035
	N1.2.Z.UT	EN AW-7075	60		M10	8.2	4	1120	0.089	1060	0.061
					M20	16	5	1130	0.089	1060	0.089
	N1.3.C.UT	G-AlMg5	95		M4	3.2	3	434	0.040	404	0.018
					M10	8.2	4	461	0.061	432	0.061
					M20	16	5	467	0.089	436	0.089
			150		M4	3.2	3	273	0.028	262	0.021
					M10	8.2	4	278	0.053	260	0.026
					M20	16	5	282	0.089	263	0.071
S	Heat-resistant alloys				M4	3.2	3	35	0.006	35	0.003
		TMG 1.7.3			M10	8.2	4	37	0.023	35	0.013
	S1.0.U.AN		200		M20	16	5	38	0.066	38	0.063
	Titanium alloys				M4	3.2	3	30	0.030	29	0.020
	S2.0.Z.AG	TiAl6V4; TiAl4Mo4Sn2Si0,5	300		M10	8.2	4	32	0.013	30	0.007
					M20	16	5	32	0.037	30	0.018
	S4.2.Z.AN		300		M4	3.2	3	55	0.012	51	0.060
		Inconel, Hastelloy, Rene 41			M10	8.2	4	58	0.037	54	0.020
					M20	12	6	59	0.089	55	0.051
H	H1.3.Z.HA	40CrMnMo7; 55NiCrMoV6; X42Cr13		55	M4	4.5	4	43	0.010	40	0.005
					M10	8.2	5	42	0.022	45	0.035
					M20	12	5	45	0.042	42	0.021
	H1.3.Z.HA	100Cr6; 1.3505		60	M4	4.5	4	30	0.005	30	0.003
					M10	8.2	5	29	0.011	28	0.006
					M20	12	5	30	0.022	28	0.010

Code key for taps

T200	-	S	D	100	D	A	-	M3
1		2	3	4	5	6		7

1: Product range	2: ISO material	3: Ease of machining of the material
T100 = straight-fluted tap T200 = straight-fluted tap with spiral point T300 = spiral-fluted tap T400 = fluteless tap	P = Stahl M = Rostfreier Stahl K = Grauguss S = Warmfeste Superlegierungen H = Gehärtete Werkstoffe N = NE-Metalle X = Multimaterial	E = easy M = moderate D = difficult

4: Product markings	5: Standard	6: Thread form
1 0 0 Different product markings for: Reinforced or straight shank, different chamfer, cutting fluid supply, etc.	D = DIN A = ANSI & DIN/ANSI J = JIS I = ISO	A = M B = MF C = MJ D = UN E = UNC F = UNF G = UNEF 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

7: Dimensions Lead only if necessary, as in MF.
M3 K = G M10x125

Code key for drilling

460	-	1	-	0635	-	02	A	1	-	P
1		2		3		4	5	6		7

1: Range name

2: Tool type

1 = straight drill, 1 diameter
2 = straight drill, 1 diameter + chamfer

3: Major diameter in mm

4: Recommended max. hole depth in mm
(new tool before reconditioning)

5: Adaptor type

A = cylindrical shank

6: Cutting fluid

0 = without cutting fluid holes
1 = with cutting fluid holes

7: Primary ISO material

P: ISO P
M: ISO M
K: ISO K
N: ISO N
S: ISO S
H: ISO H

CoroTap™

Hole size – recommendations

Tap M

M: DIN 13			Metric	
TDZ		TP	PHD	PHDX 5H/6H
M 1*	x	0.25	0.75	0.785
M 1.1*	x	0.25	0.85	0.885
M 1.2*	x	0.25	0.95	0.985
M 1.4*	x	0.30	1.10	1.142
M 1.6	x	0.35	1.25	1.321
M 1.8	x	0.35	1.45	1.521
M 2	x	0.40	1.60	1.679
M 2.2	x	0.45	1.75	1.838
M 2.3	x	0.40	1.85	1.938
M 2.5	x	0.45	2.05	2.138
M 2.6	x	0.45	2.15	2.238
M 3	x	0.50	2.50	2.599
M 3.5	x	0.60	2.90	3.010
M 4	x	0.70	3.30	3.422
M 4.5	x	0.75	3.70	3.878
M 5	x	0.80	4.20	4.334
M 6	x	1.00	5.00	5.153
M 7	x	1.00	6.00	6.153
M 8	x	1.25	6.80	6.912
M 9	x	1.25	7.80	7.912
M 10	x	1.50	8.50	8.676
M 11	x	1.50	9.50	9.676
M 12	x	1.75	10.20	10.441
M 14	x	2.00	12.00	12.210
M 16	x	2.00	14.00	14.210
M 18	x	2.50	15.50	15.744
M 20	x	2.50	17.50	17.744
M 22	x	2.50	19.50	19.744
M 24	x	3.00	21.00	21.252
M 27	x	3.00	24.00	24.252
M 30	x	3.50	26.50	26.771
M 33	x	3.50	29.50	29.771
M 36	x	4.00	32.00	32.270
M 39	x	4.00	35.00	35.270
M 42	x	4.50	37.50	37.799
M 45	x	4.50	40.50	40.799
M 48	x	5.00	43.00	43.297
M 52	x	5.00	47.00	47.297
M 56	x	5.50	50.50	50.796
M 64	x	6.00	58.00	58.305

Notes:

TP: Thread lead
TDZ: Thread form and size
PHD: Diameter, pilot hole
PHDX: Max. diameter, pilot hole

Tap MF

MF: DIN 13			Metric	
TDZ		TP	PHD	PHDX 5H/6H
M 2.5	×	0.35	2.15	2.221
M 3.0	×	0.35	2.65	2.721
M 3.5	×	0.35	3.15	3.221
M 4.0	×	0.50	3.50	3.599
M 4.5	×	0.50	4.00	4.099
M 5.0	×	0.50	4.50	4.599
M 5.5	×	0.50	5.00	5.099
M 6.0	×	0.75	5.25	5.378
M 7.0	×	0.75	6.25	6.378
M 8.0	×	0.50	7.50	7.599
M 8.0	×	0.75	7.25	7.378
M 8.0	×	1.00	7.00	7.153
M 9.0	×	0.75	8.25	8.378
M 9.0	×	1.00	8.00	8.153
M 10	×	0.75	9.25	9.378
M 10	×	1.00	9.00	9.153
M 10	×	1.25	8.80	8.912
M 11	×	0.75	10.25	10.378
M 11	×	1.00	10.00	10.153
M 12	×	1.00	11.00	11.153
M 12	×	1.25	10.75	10.912
M 12	×	1.50	10.50	10.676
M 14	×	1.00	13.00	13.153
M 14	×	1.25	12.75	12.912
M 14	×	1.50	12.50	12.676
M 15	×	1.00	14.00	14.153
M 15	×	1.50	13.50	13.676
M 16	×	1.00	15.00	15.153
M 16	×	1.25	14.80	14.912
M 16	×	1.50	14.50	14.676
M 17	×	1.00	16.00	16.153
M 17	×	1.50	15.50	15.676
M 18	×	1.00	17.00	17.153
M 18	×	1.50	16.50	16.676
M 20	×	1.00	19.00	19.153
M 20	×	1.50	18.50	18.676
M 20	×	2.00	18.00	18.210
M 22	×	1.00	21.00	21.153
M 22	×	1.50	20.50	20.676
M 22	×	2.00	20.00	20.210
M 24	×	1.00	23.00	23.153
M 24	×	1.50	22.50	22.676
M 24	×	2.00	22.00	22.210
M 25	×	1.00	24.00	24.153
M 25	×	1.50	23.50	23.676
M 25	×	2.00	23.00	23.210
M 27	×	1.00	26.00	26.153
M 27	×	1.50	25.50	25.676
M 27	×	2.00	25.00	25.210
M 28	×	1.00	27.00	27.153
M 28	×	1.50	26.50	26.676
M 28	×	2.00	26.00	26.210
M 30	×	1.00	29.00	29.153
M 30	×	1.50	28.50	28.676
M 30	×	2.00	28.00	28.210
M 30	×	3.00	27.00	27.252
M 32	×	1.50	30.50	30.676
M 32	×	2.00	30.00	30.210
M 33	×	1.50	31.50	31.676
M 33	×	2.00	31.00	31.210
M 33	×	3.00	30.00	30.252
M 35	×	1.50	33.50	33.676
M 36	×	1.50	34.50	34.676

CoroTap™

Hole size – recommendations

Tap UNC

UNC: ASME B1.1			Metric		
TDZ		TP	PHD	PHDX 2B	PHDX 3B
Nr. 1	-	0.25	1.55	1.582	1.582
Nr. 2	-	0.25	1.85	1.872	1.872
Nr. 3	-	0.25	2.10	2.146	2.146
Nr. 4	-	0.30	2.35	2.385	2.385
Nr. 5	-	0.35	2.65	2.697	2.697
Nr. 6	-	0.35	2.85	2.896	2.896
Nr. 8	-	0.40	3.50	3.531	3.528
Nr. 10	-	0.45	3.90	3.962	3.950
Nr. 12	-	0.40	4.50	4.597	4.590
1/4	-	0.45	5.10	5.268	5.250
5/16	-	0.45	6.60	6.734	6.680
3/8	-	0.50	8.00	8.164	8.082
7/16	-	0.60	9.40	9.550	9.441
1/2	-	0.70	10.80	11.013	10.881
9/16	-	0.75	12.20	12.456	12.301
5/8	-	0.80	13.50	13.868	13.693
3/4	-	1.00	16.50	16.833	16.324
7/8	-	1.00	19.50	19.748	19.520
1	-	1.25	22.25	22.598	22.344
1 1/8	-	1.25	25.00	25.349	25.082
1 1/4	-	1.50	28.00	28.524	28.258
1 3/8	-	1.50	30.75	31.120	30.851
1 1/2	-	1.75	34.00	34.295	34.026
1 3/4	-	2.00	39.50	39.814	39.560
2	-	2.00	45.00	45.598	45.367

Tap UNF

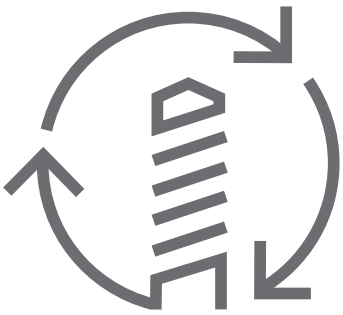
UNF: ASME B1.1			Metric		
TDZ		TP	PHD*	PHDX 2B	PHDX 3B
Nr. 1	-	72	1.55	1.613	1.613
Nr. 2	-	64	1.85	1.913	1.913
Nr. 3	-	56	2.15	2.197	2.197
Nr. 4	-	48	2.40	2.459	2.459
Nr. 5	-	44	2.70	2.741	2.741
Nr. 6	-	40	2.95	3.023	3.012
Nr. 8	-	36	3.50	3.607	3.597
Nr. 10	-	32	4.10	4.166	4.168
Nr. 12	-	28	4.60	4.724	4.717
1/4	-	28	5.50	5.580	5.563
5/16	-	24	6.90	7.038	6.995
3/8	-	24	8.50	8.626	8.565
7/16	-	20	9.90	10.030	9.947
1/2	-	20	11.50	11.618	11.524
9/16	-	18	12.90	13.084	12.969
5/8	-	18	14.50	14.671	14.554
3/4	-	16	17.50	17.689	17.546
7/8	-	14	20.40	20.663	20.493
1	-	12	23.25	23.569	23.363
1 1/8	-	12	26.50	26.744	26.538
1 1/4	-	12	29.50	29.919	29.713
1 3/8	-	12	32.75	33.094	32.888
1 1/2	-	12	36.00	36.269	36.063

Tap G

M: DIN 13			Metric	
TDZ		TP	PHD	PHDX
G 1/16	-	28	6.80	6.843
G 1/8	-	28	8.80	8.848
G 1/4	-	19	11.80	11.890
G 3/8	-	19	15.25	15.395
G 1/2	-	14	19.00	19.173
G 5/8	-	14	21.00	21.129
G 3/4	-	14	24.50	24.659
G 7/8	-	14	28.25	28.419
G 1	-	11	30.75	30.932
G 1 1/8	-	11	35.50	35.580
G 1 1/4	-	11	39.50	39.593
G 1 1/2	-	11	45.25	45.486

TP: Thread lead
TDZ: Thread form and size
PHD: Diameter, pilot hole
PHDX: Max. diameter, pilot hole

Reconditioning



Reconditioning worn solid carbide tools is a good way to extend their tool life while dramatically reducing the costs associated with purchasing new tools. If you are not yet familiar with our reconditioning service, it‘s time to give it a try.

100%

Reliability

Our specialists are always available to assist you with their expertise.

Original quality

Consistent quality in every reconditioning process.

50%

Savings

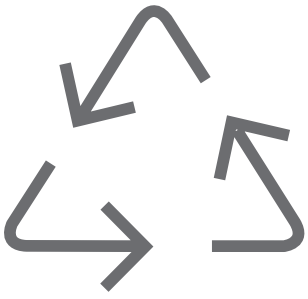
Reconditioning can lower your tool costs by up to 50%.

Find out more about reconditioning on our website at www.sandvik.coromant.com/reconditioning

Recycling: For the good of the environment

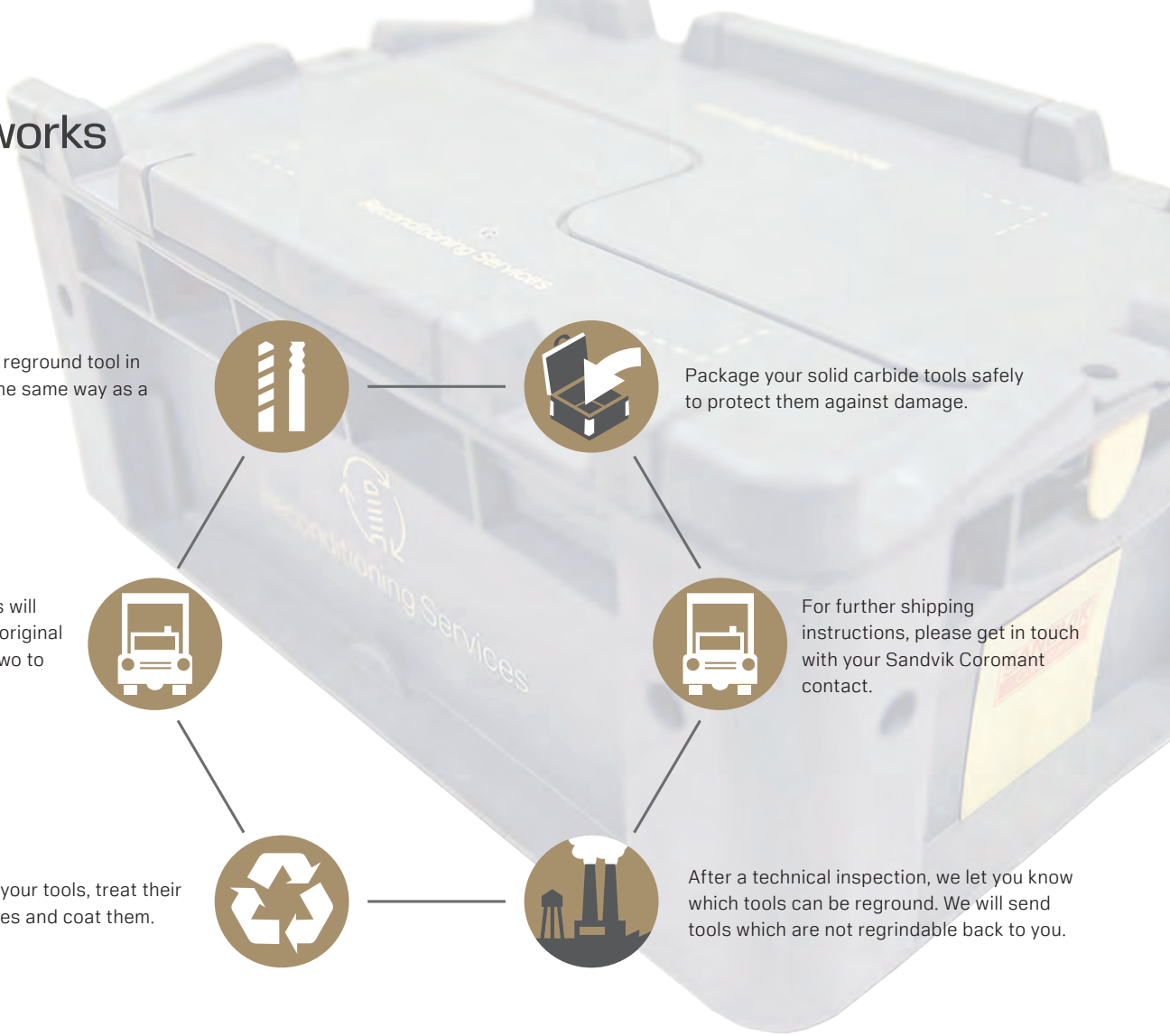
Did you know that you can earn money with your used tools? All you have to do is let us recycle them for you.

If it is no longer profitable for you to have the tool reground, the solid carbide can be recycled through our recycling scheme, which pays market prices for carbide. Not only do you earn money, you also help to reduce the environmental impact of producing new tools and minimise the use of the tungsten.



Find out more about recycling on our website at www.sandvik.coromant.com/reconditioning

How it works



Use your reground tool in exactly the same way as a new tool.

Package your solid carbide tools safely to protect them against damage.

The reground tools will be returned in the original packaging within two to three weeks.

For further shipping instructions, please get in touch with your Sandvik Coromant contact.

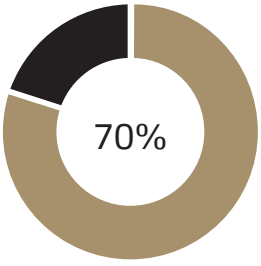
We regrind your tools, treat their cutting edges and coat them.

After a technical inspection, we let you know which tools can be reground. We will send tools which are not regrindable back to you.

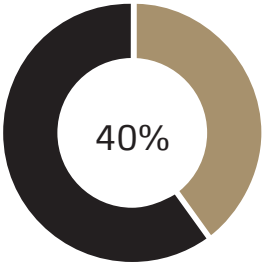
Sandvik Coromant recovers more than 80% of the sold solid carbide.

Advantages for the environment

Instead of using raw materials extracted from ore, producing new tools from recycled carbide uses 70% less energy.



Production using recycled materials reduces carbon dioxide emissions by a total of 40%.



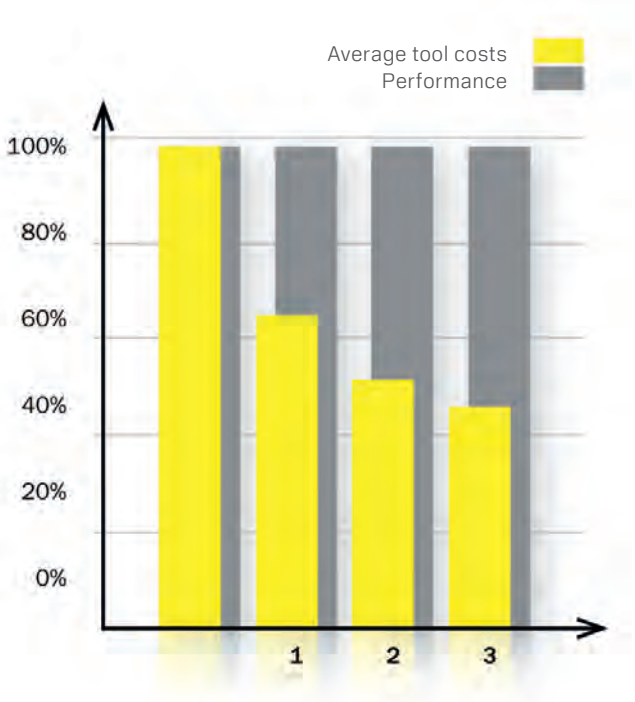
Tools with reconditioning service

Would you like to try out our reconditioning service? We not only regrind carbide drills, but milling cutters and reamers too.

You can see which products can be reground thanks to the reconditioning symbol in our catalogues and on our website.

Products capable of being reconditioned

Drilling	Milling	Reaming
		



Ratio of performance to tool costs

Each reconditioning process gives you consistent tool quality while dramatically reducing costs.

It all starts with an order for a box

STEP 1	Go to www.sandvik.coromant.com
STEP 2	Search for „Reconditioning box“. Place an order for a box and submit a pick-up request through the contact channels below.
STEP 3	Follow the packaging instructions in the box. For further shipping instructions, get in touch with your contact.
STEP 4	Your tools will be picked up by a carrier selected by us.
STEP 5	Your tools will be inspected and your order processed.
STEP 6	Your tool return will be initiated.

The box is available in two sizes:
- Standard box (300 x 200 x 138 mm)
  Article number: 6949557
- Large box (400 x 300 x 138 mm)
  Article number: 6949558

All Sandvik Coromant tool types can be sent in the same box.

Please note:

It is only possible to place an online order in selected countries. Please get in touch with your Sandvik Coromant contact if you are unable to order the box online.

What happens to your tools?

- Before being reground, your tools are inspected in detail to establish whether they are suitable for reconditioning.
  Tools that cannot be reground will be returned.
- Complete reconditioning of the geometry
- New coating*
- Drill length is reduced
- Diameter and length of the end mill are reduced
- Each reconditioning operation is recorded on the shank using laser marking
- The tools are returned in the original packaging

* Coatings may vary depending on the service availability

For the good of the environment

Use the Coromant Recycling Concept (CRC)!

The Coromant Recycling Concept (CRC) is a comprehensive service for used carbide cutting inserts – available to all Sandvik Coromant customers. In the context of the increasing consumption of non-renewable raw materials, every manufacturer has a duty to use dwindling resources economically. Sandvik Coromant offers to collect and recycle used carbide indexable inserts and solid carbide tools in an environmentally friendly way. All used carbide indexable inserts and solid tools are collected in the collection box at your workplace. Once the transport box is full, it is sent to your nearest Sandvik Coromant branch or to your Sandvik Coromant dealer.
They can also provide you with more information.

The advantages of the CRC speak for themselves

- A global recycling system under one roof.
- For direct customers and dealers.
- Simple process with collection and transport boxes.
- Less waste, reduced impact on the environment.
- Improved use of resources.
- We also accept carbide indexable inserts from other manufacturers.

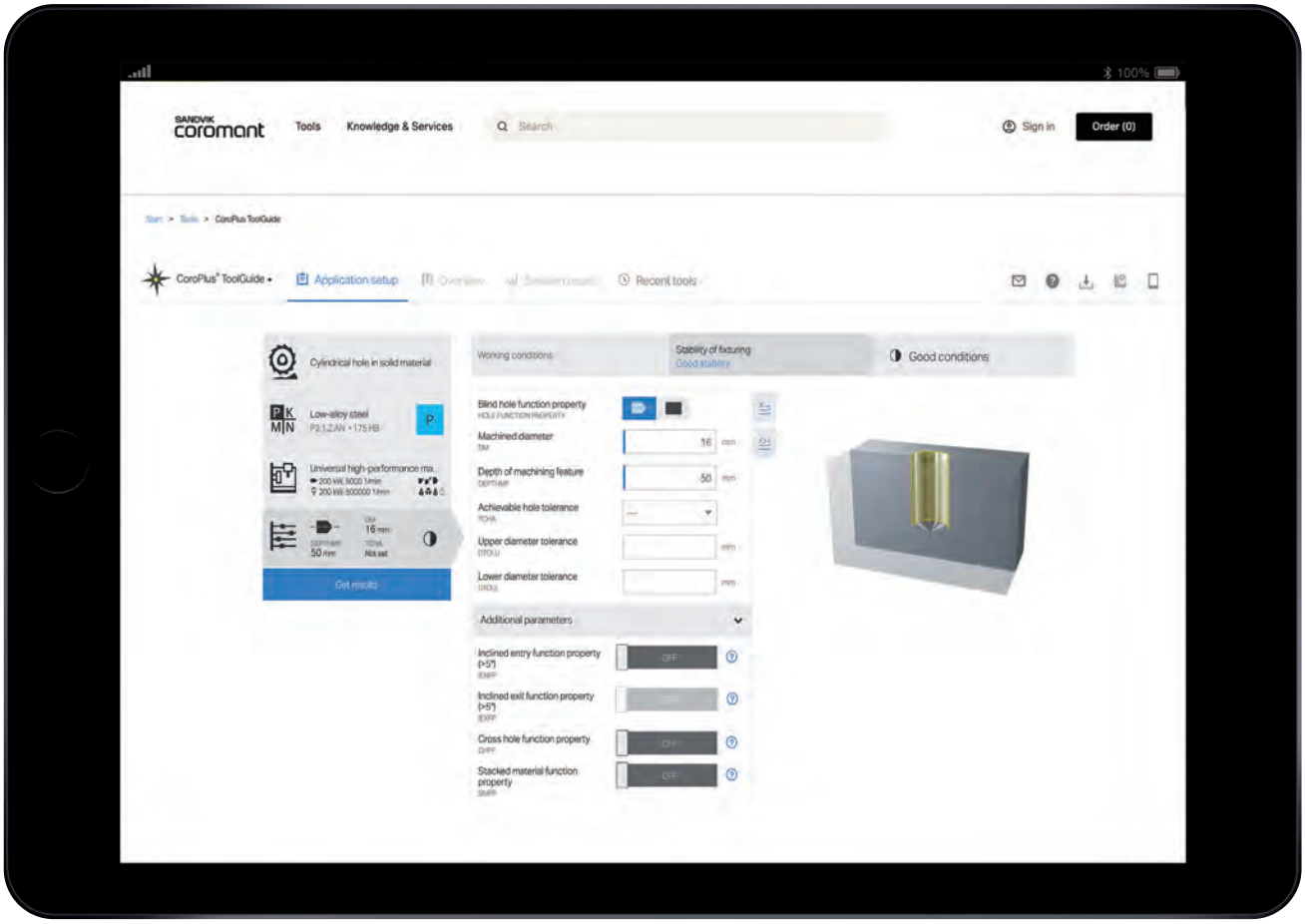
Order a collection box for every lathe, milling machine and drill, or for your machining centre. We recommend one collection box for indexable inserts and a separate box for solid carbide tools for each workplace. For more details about the sale of your used indexable inserts and solid carbide tools, please visit sandvik.coromant.com and choose your market.

Coromant Recycling Concept	Order numbers
Collection box	91617
Transport box for solid carbide tools (wood)	92994
Transport box for turning inserts (wood)	92995

Fast and accurate tool recommendations

CoroPlus® ToolGuide is an online tool selection application providing tool recommendation and application advice specific to your machine and material.

Take a closer look!
www.sandvik.coromant.com/toolguide



ANDROID APP ON Google play

Available on the App Store

Local support is just a click away

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