SANDVIK
Coromant

2020.1

# Nuovi utensili da taglio

Tornitura generale A
Fresatura B
Foratura C
Barenatura D
Adattatori per utensili rotanti E
Accessori F
Informazioni generali G

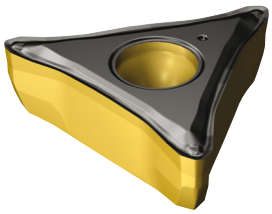
## Tornitura generale

CoroTurn® Prime

### Geometria raschiante L3WX per inserti di tipo A

Per la finitura di materiali duttili, p.es. acciai ad elevata resistenza, acciai forgiati a freddo e acciai inossidabili duplex, caratterizzati da elevati requisiti di finitura superficiale

Vedere pagina A2



CoroTurn® TR e CoroTurn® 107

### Con possibilità di refrigerante sopra e sotto l'inserto

Refrigerante sotto l'inserto per maggiore durata utensile e produttività, specialmente in applicazioni caratterizzate da forte produzione di calore sull'inserto. Refrigerante sopra l'inserto per migliore controllo truciolo

Vedere sezione A

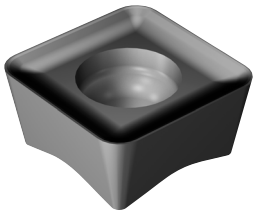
## Fresatura

Inserto CoroMill® 415 per fresatura

### Nuova geometria d'inserto

Nuova geometria M-M30 per CoroMill® 415 per entrambe le dimensioni d'inserto iC05 e iC07, che si aggiungono al precedente assortimento con geometria M-M30.

Vedere pagina B2



Fresa CoroMill® 390 per spallamenti retti

### Fresa leggera per spallamenti

Frese nella versione in pollici per l'utilizzo in abbinamento con gli adattatori antivibranti Silent Tools™ per applicazioni esigenti e caratterizzate dalla presenza di sporgenze lunghe

Vedere pagina B3

CoroMill® Plura

### Fresatura pesante

Da 10–25 mm (.625–.750") Scelta prioritaria per le lavorazioni pesanti in ISO P e ISO M.

Vedere pagina B4

CoroMill® 316

### Qualità GC1730

La qualità GC1730 sostituisce la preesistente qualità GC1030
Scelta prioritaria per la sgrossatura su materiali ISO P e ISO M

Vedere la Sezione B

## Foratura

CoroDrill® DS20

### Punta ad inserti multitaglienti

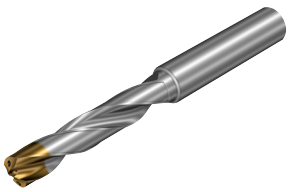
Assortimento esteso, con nuovi diametri delle punte e nuove dimensioni degli inserti

Vedere pagina C2

CoroDrill® 860-GM

### Punta integrale di metallo duro

Una soluzione per la foratura ad elevate prestazioni, per fori corti nella maggior parte dei materiali. La punta offre una robusta sicurezza di processo, un'elevata integrità dei fori ed un'eccellente durata dell'utensile, ed è ideale per applicazioni di ingegneria generale oppure collegate all'industria automobilistica.



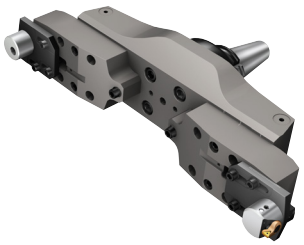
Vedere pagina C5

## Barenatura

CoroBore 826

### CoroBore® XL

Nuove teste di barenatura ad alta precisione CoroBore® 826 con ugelli ad alta precisione

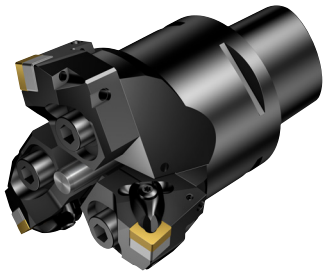


Vedere pagina D3

CoroBore® BR30

### Estensione della gamma

Sono ora disponibili diametri più grandi.



Vedere pagina D2

## Sistemi di portautensili

CoroChuck™ 930

### Assortimento esteso, con nuove dimensioni dei modelli sottili e a stilo

Progettato per tutte le applicazioni e tutti i componenti in cui sono richieste accessibilità e prestazioni elevate

Vedere la Sezione E

# Tornitura generale


## CoroTurn® Prime

Inserti A2

## CoroTurn® TR

Utensili per esterni A4-A6

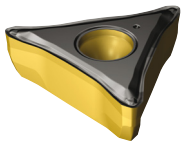
## CoroTurn® 107

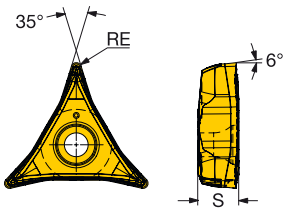
Utensili per esterni A7-A10


Per informazioni sulla gamma completa, visitare il sito www.sandvik.coromant.com/it

# CoroTurn® Prime, inserto per tornitura

**Inserto di tipo A**

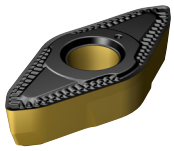


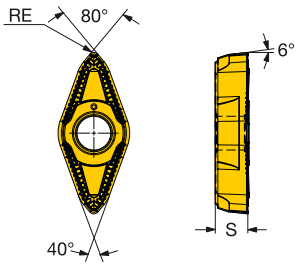



| | | SSC | S | RE | CODICE ISO | P 4325 |
|---|---|---|---|---|---|---|
| Finitura | L3WX | CP-A | 6.00<br>*.236* | 0.79<br>*.031* | CP-A1108-L3WX | ★ |

# CoroTurn® Prime, inserto per tornitura

**Inserto di tipo B**






| | | SSC | S | REEQ | RE | CODICE ISO | M 2025 |
|---|---|---|---|---|---|---|---|
| Media | H3 | CP-B | 5.00 | 0.8 | 0.79 | CP-B1108-H3 | ★ |
| | | | *.197* | *.031* | *.031* | | |

SSC = Deve corrispondere al codice di misura SSC sull'utensile.

G2

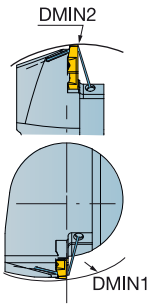
# Unità di taglio CoroTurn® TR per tornitura

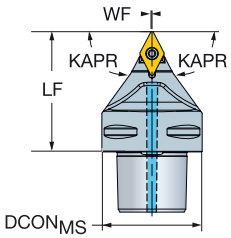
**Bloccaggio a vite**

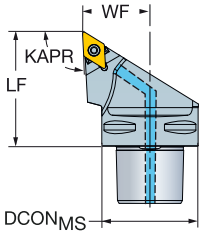
**Coromant Capto® - adduzione interna di refrigerante**

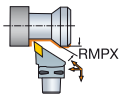
TR-DC

| | Cx-TR-D13NCN..C | Cx-TR-D13JCR/L..C |
|---|---|---|
| KAPR | 62.5° | 93.0° |
| PSIR | 27.5° | -3.0° |




| | | CZCMS | DMIN1 | DMIN2 | RMPX | CNSC | Codice di ordinazione | Dimensioni in mm e pollici DCONMS | LF | WF | BAR PSI | NM | KG | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  | 13 | C4 | 251.0 | 150.0 | 27° | 3 | **C4-TR-D13JCR/L-27050C** | 40 | 50.0 | 27.0 | 150 | 3.0 | 0.37 | TR-DC1308 |
| | | | *9.882* | *5.906* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | | C5 | 249.0 | 175.0 | 27° | 3 | **C5-TR-D13JCR/L-35060C** | 50 | 60.0 | 35.0 | 150 | 3.0 | 0.69 | TR-DC1308 |
| | | | *9.803* | *6.890* | | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | C6 | 253.0 | 240.0 | 27° | 3 | **C6-TR-D13JCR/L-45065C** | 63 | 65.0 | 45.0 | 150 | 3.0 | 1.39 | TR-DC1308 |
| | | | *9.961* | *9.449* | | | | *2.480* | *2.559* | *1.772* | *2175* | | | |
| | | C8 | 253.0 | 250.0 | 27° | 3 | **C8-TR-D13JCR/L-55080C** | 80 | 80.0 | 55.0 | 150 | 3.0 | 2.54 | TR-DC1308 |
| | | | *9.961* | *9.843* | | | | *3.150* | *3.150* | *2.165* | *2175* | | | |
| | 13 | C4 | | 140.0 | 57° | 3 | **C4-TR-D13NCN-00050C** | 40 | 50.0 | 0.5 | 150 | 3.0 | 0.32 | TR-DC1308 |
| | | | | *5.512* | | | | *1.575* | *1.969* | *.020* | *2175* | | | |
| | | C5 | | 165.0 | 57° | 3 | **C5-TR-D13NCN-00060C** | 50 | 60.0 | 0.5 | 150 | 3.0 | 0.62 | TR-DC1308 |
| | | | | *6.496* | | | | *1.969* | *2.362* | *.020* | *2175* | | | |
| | | C6 | | 190.0 | 57° | 3 | **C6-TR-D13NCN-00065C** | 63 | 65.0 | 0.5 | 150 | 3.0 | 1.06 | TR-DC1308 |
| | | | | *7.480* | | | | *2.480* | *2.559* | *.020* | *2175* | | | |

N = Neutro, R = Destro, L = Sinistro

Parti di ricambio

| Vite per inserto | Vite M4 per chiusura passaggio refrigerante | Ugello per refrigerante | Punta per viti inserto |
|---|---|---|---|
| 5513 020-01 | 3213 010-256 | 5691 026-03 | 5680 084-15 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

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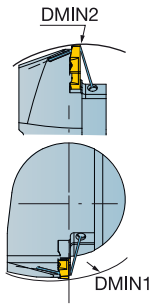
# Unità di taglio CoroTurn® TR per tornitura

**Bloccaggio a vite**

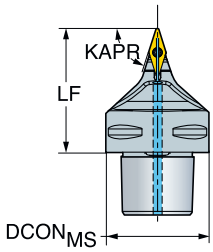
**Coromant Capto® - adduzione interna di refrigerante**

TR-VB

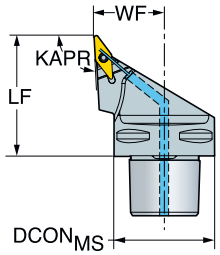
KAPR
PSIR

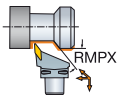



Cx-TR-V13VBN..C
72.5°
17.5°




Cx-TR-V13JBR/L..C
93.0°
-3.0°




| | | | | | | | | Dimensioni in mm e pollici | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | CZC$_{MS}$ | DMIN$_1$ | DMIN$_2$ | RMPX | CNSC | **Codice di ordinazione** | DCON$_{MS}$ | LF | WF | BAR PSI | NM | KG | MIID |
|  | 13 | C4 | 253.0 | 140.0 | 50° | 3 | **C4-TR-V13JBR/L-27050C** | 40 | 50.0 | 27.0 | 150 | 2.0 | 0.34 | TR-VB1308 |
| | | | *9.961* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | | C5 | 228.0 | 165.0 | 50° | 3 | **C5-TR-V13JBR/L-35060C** | 50 | 60.0 | 35.0 | 150 | 2.0 | 0.68 | TR-VB1308 |
| | | | *8.976* | *6.496* | | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | C6 | 232.0 | 190.0 | 50° | 3 | **C6-TR-V13JBR/L-45065C** | 63 | 65.0 | 45.0 | 150 | 2.0 | 1.13 | TR-VB1308 |
| | | | *9.134* | *7.480* | | | | *2.480* | *2.559* | *1.772* | *2175* | | | |
| | | C8 | 233.0 | 250.0 | 50° | 3 | **C8-TR-V13JBR/L-55080C** | 80 | 80.0 | 55.0 | 150 | 2.0 | 2.44 | TR-VB1308 |
| | | | *9.173* | *9.843* | | | | *3.150* | *3.150* | *2.165* | *2175* | | | |
| | 13 | C4 | | 140.0 | 70° | 3 | **C4-TR-V13VBN-00050C** | 40 | 50.0 | 0.5 | 150 | 2.0 | 0.29 | TR-VB1308 |
| | | | | *5.512* | | | | *1.575* | *1.969* | *.020* | *2175* | | | |
| | | C5 | | 165.0 | 70° | 3 | **C5-TR-V13VBN-00060C** | 50 | 60.0 | 0.5 | 150 | 2.0 | 0.58 | TR-VB1308 |
| | | | | *6.496* | | | | *1.969* | *2.362* | *.020* | *2175* | | | |
| | | C6 | | 190.0 | 70° | 3 | **C6-TR-V13VBN-00065C** | 63 | 65.0 | 0.5 | 150 | 2.0 | 1.00 | TR-VB1308 |
| | | | | *7.480* | | | | *2.480* | *2.559* | *.020* | *2175* | | | |

N = Neutro, R = Destro, L = Sinistro

| Parti di ricambio | | | |
|---|---|---|---|
| Vite per inserto | Vite M4 per chiusura passaggio refrigerante | Ugello per refrigerante | Punta per viti inserto |
| 5513 020-64 | 3213 010-256 | 5691 026-03 | 5680 084-21 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

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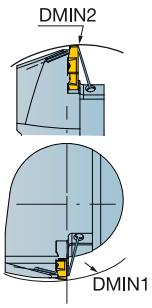
# Unità di taglio CoroTurn® TR per tornitura

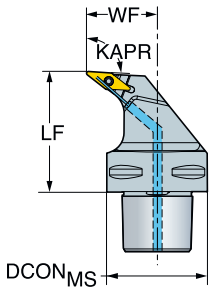
**Bloccaggio a vite**

**Coromant Capto® - adduzione interna di refrigerante**

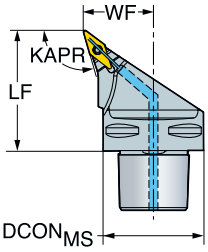
KAPR



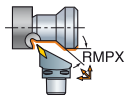
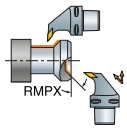

Cx-TR-V13UBR/L..C
93.0°




Cx-TR-V13HBR/L..C
107.5°




TR-VB

| | | CZC$_{MS}$ | DMIN$_1$ | DMIN$_2$ | RMPX | CNSC | Codice di ordinazione | DCON$_{MS}$ | LF | WF | BAR PSI | NM | KG | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Dimensioni in mm e pollici | | | | | | |
|  | 13 | C5 | 99.0 | 165.0 | 35° | 3 | **C5-TR-V13HBR/L-35060C** | 50 | 60.0 | 35.0 | 150 | 2.0 | 0.64 | TR-VB1308 |
| | | | *3.898* | *6.496* | | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | C6 | 150.0 | 190.0 | 35° | 3 | **C6-TR-V13HBR/L-45065C** | 63 | 65.0 | 45.0 | 150 | 2.0 | 1.15 | TR-VB1308 |
| | | | *5.906* | *7.480* | | | | *2.480* | *2.559* | *1.772* | *2175* | | | |
| | | C8 | 133.0 | 250.0 | 35° | 3 | **C8-TR-V13HBR/L-55080C** | 80 | 80.0 | 55.0 | 150 | 2.0 | 2.46 | TR-VB1308 |
| | | | *5.236* | *9.843* | | | | *3.150* | *3.150* | *2.165* | *2175* | | | |
| | | C4 | 95.0 | 140.0 | 35° | 3 | **C4-TR-V13HBR/L-27050C** | 40 | 50.0 | 27.0 | 150 | 2.0 | 0.35 | TR-VB1308 |
| | | | *3.740* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
|  | 13 | C5 | 67.0 | 165.0 | 50° | 3 | **C5-TR-V13UBR/L-35060C** | 50 | 60.0 | 35.0 | 150 | 2.0 | 0.71 | TR-VB1308 |
| | | | *2.638* | *6.496* | | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | C6 | 118.0 | 190.0 | 50° | 3 | **C6-TR-V13UBR/L-45065C** | 63 | 65.0 | 45.0 | 150 | 2.0 | 1.24 | TR-VB1308 |
| | | | *4.646* | *7.480* | | | | *2.480* | *2.559* | *1.772* | *2175* | | | |
| | | C8 | 100.0 | 250.0 | 50° | 3 | **C8-TR-V13UBR/L-55080C** | 80 | 80.0 | 55.0 | 150 | 2.0 | 2.61 | TR-VB1308 |
| | | | *3.937* | *9.843* | | | | *3.150* | *3.150* | *2.165* | *2175* | | | |
| | | C4 | 54.0 | 140.0 | 50° | 3 | **C4-TR-V13UBR/L-27050C** | 40 | 50.0 | 27.0 | 150 | 2.0 | 0.38 | TR-VB1308 |
| | | | *2.126* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |

N = Neutro, R = Destro, L = Sinistro

Parti di ricambio

| Vite per inserto | Vite M4 per chiusura passaggio refrigerante | Ugello per refrigerante | Punta per viti inserto |
|---|---|---|---|
| 5513 020-64 | 3213 010-256 | 5691 026-03 | 5680 084-21 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

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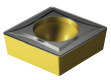
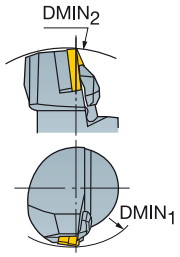
# CoroTurn® 107, unità di taglio per tornitura

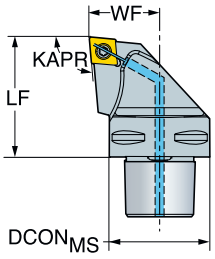
**Bloccaggio a vite**

**Coromant Capto® - Adduzione di refrigerante di precisione**

KAPR 95.0°
PSIR -5.0°

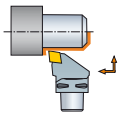





CCMT, CCGT
CCGX, CCET

CCMW

| | IC | $CZC_{MS}$ | $DMIN_1$ | $DMIN_2$ | CNSC | Codice di ordinazione | $DCON_{MS}$ | LF | WF | BAR PSI | NM | KG | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Dimensioni in mm e pollici | | | | | | | | | | |
|  | 09 3/8 | C3 | 265.0 | 700.0 | 3 | **C3-SCLCR/L-22040-09C** | 32 | 40.0 | 22.0 | 150 | 3.0 | 0.20 | CCMT 09 T3 08 |
| | | | *10.433* | *27.559* | | | *1.260* | *1.575* | *.866* | *2175* | | | |
| | | C4 | 272.0 | 600.0 | 3 | **C4-SCLCR/L-27050-09C** | 40 | 50.0 | 27.0 | 150 | 3.0 | 0.43 | CCMT 09 T3 08 |
| | | | *10.709* | *23.622* | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | 12 1/2 | C4 | 210.0 | 600.0 | 3 | **C4-SCLCR/L-27050-12C** | 40 | 50.0 | 27.0 | 150 | 3.0 | 0.44 | CCMT 12 04 08 |
| | | | *8.268* | *23.622* | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | | C5 | 204.0 | 550.0 | 3 | **C5-SCLCR/L-35060-12C** | 50 | 60.0 | 35.0 | 150 | 3.0 | 0.77 | CCMT 12 04 08 |
| | | | *8.032* | *21.654* | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | C6 | 208.0 | 800.0 | 3 | **C6-SCLCR/L-45065-12C** | 63 | 65.0 | 45.0 | 150 | 3.0 | 1.34 | CCMT 12 04 08 |
| | | | *8.189* | *31.496* | | | *2.480* | *2.559* | *1.772* | *2175* | | | |

R = Destro, L = Sinistro

| | | | Parti di ricambio | |
|---|---|---|---|---|
| | | $CZC_{MS}$ | Vite per inserto | Ugello |
| 09 | 3/8 | C3-C5 | 5513 020-09 | 5691 026-13 |
| 12 | 1/2 | C4-C5 | 5513 020-17 | 5691 026-13 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

G2

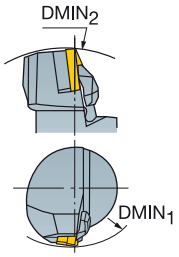
G5

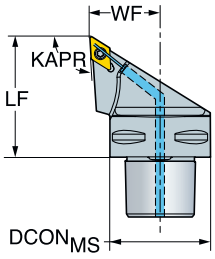
# CoroTurn® 107, unità di taglio per tornitura

**Bloccaggio a vite**

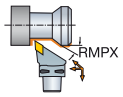
**Coromant Capto® - Adduzione di refrigerante di precisione**

KAPR 93.0°
PSIR -3.0°




DCMT, DCMX
DCGT, DCGX, DCET
DCMW

| | IC | | $CZC_{MS}$ | $DMIN_1$ | $DMIN_2$ | RMPX | CNSC | Codice di ordinazione | $DCON_{MS}$ | LF | WF | BAR PSI | NM | KG | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  | 11 | 3/8 | C3 | 244.0 | 135.0 | 27° | 3 | C3-SDJCR/L-22040-11C | 32 | 40.0 | 22.0 | 150 | 3.0 | 0.19 | DCMT 11 T3 08 |
| | | | | *9.606* | *5.315* | | | | *1.260* | *1.575* | *.866* | *2175* | | | |
| | | | C4 | 246.0 | 140.0 | 27° | 3 | C4-SDJCR/L-27050-11C | 40 | 50.0 | 27.0 | 150 | 3.0 | 0.38 | DCMT 11 T3 08 |
| | | | | *9.685* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | | | C5 | 250.0 | 165.0 | 27° | 3 | C5-SDJCR/L-35060-11C | 50 | 60.0 | 35.0 | 150 | 3.0 | 0.70 | DCMT 11 T3 08 |
| | | | | *9.843* | *6.496* | | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | | C6 | 250.0 | 190.0 | 27° | 3 | C6-SDJCR/L-45065-11C | 63 | 65.0 | 45.0 | 150 | 3.0 | 1.19 | DCMT 11 T3 08 |
| | | | | *9.843* | *7.480* | | | | *2.480* | *2.559* | *1.772* | *2175* | | | |

Dimensioni in mm e pollici

R = Destro, L = Sinistro

Parti di ricambio

| Vite per inserto | Vite del supporto | Supporto | Vite M4 per chiusura passaggio refrigerante | Ugello per refrigerante | Punta per viti inserto |
|---|---|---|---|---|---|
| 5513 020-01 | 5512 090-01 | 5322 263-01 | 3213 010-256 | 5691 026-03 | 5680 084-15 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

ISO 13399 G2

CNSC CXSC G5

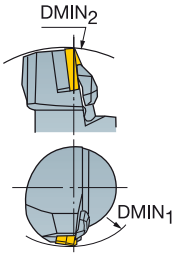
# CoroTurn® 107, unità di taglio per tornitura

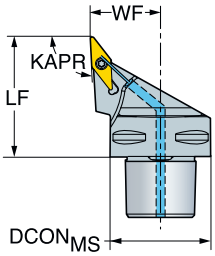
**Bloccaggio a vite**

**Coromant Capto® - Adduzione di refrigerante di precisione**

KAPR 93.0°
PSIR -3.0°

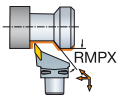
Cx-SVJBR/L..C




VBMT, VBGT
VCGX,
VCGT, VCET

VBMW, VCMW

| | | | | | | | | | Dimensioni in mm e pollici | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | $CZC_{MS}$ | $DMIN_1$ | $DMIN_2$ | RMPX | CNSC | **Codice di ordinazione** | $DCON_{MS}$ | LF | WF | BAR PSI | NM | KG | MIID |
|  | 11 | 1/4 | C3 | 368.0 | 116.0 | 50° | 3 | **C3-SVJBR/L-2204011B1C** | 32 | 40.0 | 22.0 | 150 | 0.9 | 0.18 | VBMT 11 03 04 |
| | | | | *14.488* | *4.567* | | | | *1.260* | *1.575* | *.866* | *2175* | | | |
| | | | C4 | 434.0 | 140.0 | 50° | 3 | **C4-SVJBL-2705011B1C** | 40 | 50.0 | 27.0 | 150 | 0.9 | 0.36 | VBMT 11 03 04 |
| | | | | *17.087* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | | | C4 | 434.0 | 140.0 | 50° | 3 | **C4-SVJBR-2705011B1C** | 40 | 50.0 | 27.0 | 150 | 3.0 | 0.36 | VBMT 11 03 04 |
| | | | | *17.087* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | 16 | 3/8 | C4 | 270.0 | 140.0 | 50° | 3 | **C4-SVJBR/L-27050-16C** | 40 | 50.0 | 27.0 | 150 | 3.0 | 0.33 | VBMT 16 04 08 |
| | | | | *10.630* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | | | C5 | 270.0 | 165.0 | 50° | 3 | **C5-SVJBR/L-35060-16C** | 50 | 60.0 | 35.0 | 150 | 3.0 | 0.63 | VBMT 16 04 08 |
| | | | | *10.630* | *6.496* | | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | | C6 | 270.0 | 190.0 | 50° | 3 | **C6-SVJBR/L-45065-16C** | 63 | 65.0 | 45.0 | 150 | 3.0 | 1.14 | VBMT 16 04 08 |
| | | | | *10.630* | *7.480* | | | | *2.480* | *2.559* | *1.772* | *2175* | | | |
| | | | C8 | 272.0 | 248.0 | 50° | 3 | **C8-SVJBR/L-55080-16C** | 80 | 80.0 | 55.0 | 150 | 3.0 | 2.40 | VBMT 16 04 08 |
| | | | | *10.709* | *9.764* | | | | *3.150* | *3.150* | *2.165* | *2175* | | | |

R = Destro, L = Sinistro

| | Parti di ricambio | | | | | |
|---|---|---|---|---|---|---|
| MIID | Vite per inserto | Vite del supporto | Supporto | Vite M4 per chiusura passaggio refrigerante | Ugello per refrigerante | Punta per viti inserto |
| VBMT 11 | 5513 020-03 | - | - | 3213 010-256 | 5691 026-03 | 5680 084-15 |
| VBMT 16 | 5513 020-01 | 5512 090-01 | 5322 270-01 | 3213 010-256 | 5691 026-03 | 5680 084-15 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

ISO 13399 G2

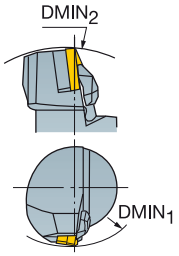
CNSC CXSC G5

# CoroTurn® 107, unità di taglio per tornitura

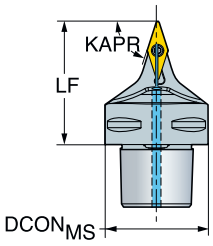
**Bloccaggio a vite**

**Coromant Capto® - adduzione interna di refrigerante**

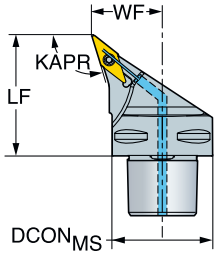
KAPR
PSIR




Cx-SVVBN..C
72.5°
17.5°

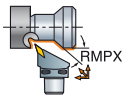
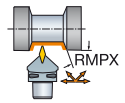



Cx-SVHBR/L..C
107.5°
-17.5°




VBMT, VBGT
VCGX,
VCGT, VCET

VBMW, VCMW

| | | | | | Dimensioni in mm e pollici | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | | | BAR PSI | NM | KG | |
| | | | $CZC_{MS}$ | $DMIN_1$ | $DMIN_2$ | RMPX | CNSC | **Codice di ordinazione** | $DCON_{MS}$ | LF | WF | | | | MIID |
|  | 16 | 3/8 | C4 | 124.0 | 140.0 | 35° | 3 | **C4-SVHBR/L-27050-16C** | 40 | 50.0 | 27.0 | 150 | 3.0 | 0.35 | VBMT 16 04 08 |
| | | | | *4.882* | *5.512* | | | | *1.575* | *1.969* | *1.063* | *2175* | | | |
| | | | C5 | 124.0 | 165.0 | 35° | 3 | **C5-SVHBR/L-35060-16C** | 50 | 60.0 | 35.0 | 150 | 3.0 | 0.63 | VBMT 16 04 08 |
| | | | | *4.882* | *6.496* | | | | *1.969* | *2.362* | *1.378* | *2175* | | | |
| | | | C6 | 134.0 | 190.0 | 35° | 3 | **C6-SVHBR/L-45065-16C** | 63 | 65.0 | 45.0 | 150 | 3.0 | 1.14 | VBMT 16 04 08 |
| | | | | *5.276* | *7.480* | | | | *2.480* | *2.559* | *1.772* | *2175* | | | |
|  | 16 | 3/8 | C5 | | 165.0 | 70° | 3 | **C4-SVVBN-00055-16C** | 50 | 60.0 | 0.6 | 150 | 3.0 | 0.31 | VBMT 16 04 08 |
| | | | | | *6.496* | | | | *1.969* | *2.362* | *.024* | *2175* | | | |
| | | | C5 | | 165.0 | 70° | 3 | **C5-SVVBN-00060-16C** | 50 | 60.0 | 0.6 | 150 | 3.0 | 0.55 | VBMT 16 04 08 |
| | | | | | *6.496* | | | | *1.969* | *2.362* | *.024* | *2175* | | | |
| | | | C6 | | 190.0 | 70° | 3 | **C6-SVVBN-00065-16C** | 63 | 65.0 | 0.6 | 150 | 3.0 | 0.97 | VBMT 16 04 08 |
| | | | | | *7.480* | | | | *2.480* | *2.559* | *.024* | *2175* | | | |

B1 = Per inserto con spessore 03 = 3.18 mm (2 = 1/8").

N = Neutro, R = Destro, L = Sinistro

Parti di ricambio

| Vite per inserto | Vite del supporto | Supporto | Vite M4 per chiusura passaggio refrigerante | Ugello per refrigerante | Punta per viti inserto |
|---|---|---|---|---|---|
| 5513 020-01 | 5512 090-01 | 5322 270-01 | 3213 010-256 | 5691 026-03 | 5680 084-15 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

G2 G5

# Fresatura

## Utensili di fresatura ad avanzamenti elevati

CoroMill® 415 B2

## Utensili per fresatura di spallamenti

CoroMill® 390 B3

## Utensili integrali ottimizzati per fresatura

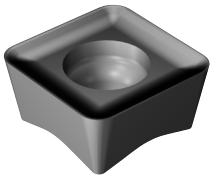
CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante B4-B9
Testina in metallo duro integrale CoroMill® 316 per fresatura a elevato carico di trucioli B11
Testina in metallo duro integrale CoroMill® 316 per sgrossatura con rompitrucioli B12
Testina in metallo duro integrale CoroMill® 316 per profilatura B13-B14
Testina in metallo duro integrale CoroMill® 316 per finitura B15-B16
Testina in metallo duro integrale CoroMill® 316 per fresatura di smussi B17-B19

## Dati di taglio

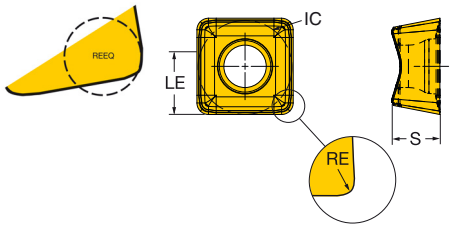
B20-B25

Per informazioni sulla gamma completa, visitare il sito www.sandvik.coromant.com/it

# Inserto CoroMill® 415 per fresatura



KRINS 15°




| | | RE | Codice di ordinazione | P | M | | | | S | | | H | | Dimensioni, millimetri | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1130 | 1040 | 1130 | S30T | S40T | 1130 | S30T | S40T | 1010 | 1130 | IC | LE | S | REEQ |
| Media | 05 | 1.20 | 415N-05 02 12E-M30 | | ★ | | ☆ | ☆ | | ★ | ☆ | | | 5.0 | 3.0 | 2.21 | 2.00 |
| | | .047 | | | | | | | | | | | | .197 | .118 | .087 | .079 |
| | 05 | 1.20 | 415N-05 02 12M-M30 | ★ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 5.0 | 3.0 | 2.21 | 2.00 |
| | | .047 | | | | | | | | | | | | .197 | .118 | .087 | .079 |
| | 07 | 2.00 | 415N-07 03 20E-M30 | | ★ | | ☆ | ☆ | | ★ | ☆ | | | 7.0 | 3.0 | 3.07 | 2.20 |
| | | .079 | | | | | | | | | | | | .276 | .118 | .121 | .087 |
| | 07 | 2.00 | 415N-07 03 20M-M30 | ★ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 7.0 | 3.0 | 3.07 | 2.80 |
| | | .079 | | | | | | | | | | | | .276 | .118 | .121 | .110 |

415N-05 02 12M-M30 aumenta il DC di 1.0 mm, riducendo il DCX di 0.26 mm e la LF di 0.13 mm 415N-07 03 20M-M30 aumenta il DC di 1.7 mm, riducendo il DCX di 0.44 mm e la LF di 0.22 mm (in confronto all'utilizzo dell'utensile con MIID)

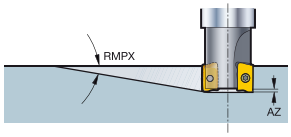
ITA

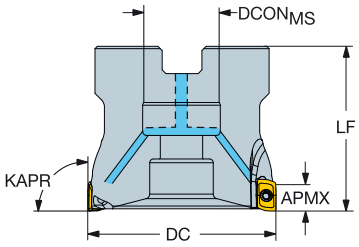
# Fresa CoroMill® 390 per spallamenti retti

**Manicotto - adduzione interna di refrigerante**

**Fresa leggera per spallamenti**

KAPR 90°




## Versione in pollici

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Codice di ordinazione | Dimensioni, pollici DCONMS | ISO | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 11 | 3/4 | .217 | .394 | 1° | .039 | 1 | 3 | **RA390-051R19LW-11L** | .750 | A | 1.181 | .8 | 0.15 | 10000 | 3 | R390-11.. |
| | 11 | 3/4 | .217 | .394 | 1° | .039 | 1 | 4 | **RA390-051R19LW-11M** | .750 | A | 1.181 | .8 | 0.15 | 10000 | 4 | R390-11.. |

| | | Parti di ricambio | |
|---|---|---|---|
| DC | | Vite per inserto | Vite |
| 2.000 | 11 | 5513 020-35 | 3213 030-606 |

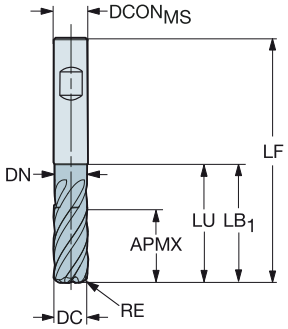
Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

G2 G5

# CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante

**Per acciaio**

| | |
|---|---|
| FHA | 38° |
| BSG | COROMANT |
| TCDC | h10 |
| TCDCON | h6 |




## Versione metrica

| DC | $CZC_{MS}$ | APMX | RE | LU | ZEFP | Codice di ordinazione | P 1730 | K 1730 | $DCON_{MS}$ | LF | DN | $LB_1$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.0 | 10 | 22.0 | 0.50 | 30.0 | 5 | 2F342-1000-050-PD | ★ | ☆ | 10.0 | 72.0 | 9.5 | 30.0 |
| | 10 | 22.0 | 1.00 | 30.0 | 5 | 2F342-1000-100-PD | ★ | ☆ | 10.0 | 72.0 | 9.5 | 30.0 |
| | 10 | 22.0 | 2.00 | 30.0 | 5 | 2F342-1000-200-PD | ★ | ☆ | 10.0 | 72.0 | 9.5 | 30.0 |
| 12.0 | 12 | 26.0 | 0.50 | 36.0 | 5 | 2F342-1200-050-PD | ★ | ☆ | 12.0 | 83.0 | 11.4 | 36.0 |
| | 12 | 26.0 | 1.00 | 36.0 | 5 | 2F342-1200-100-PD | ★ | ☆ | 12.0 | 83.0 | 11.4 | 36.0 |
| | 12 | 26.0 | 2.00 | 36.0 | 5 | 2F342-1200-200-PD | ★ | ☆ | 12.0 | 83.0 | 11.4 | 36.0 |
| 16.0 | 16 | 34.0 | 0.50 | 42.0 | 5 | 2F342-1600-050-PD | ★ | ☆ | 16.0 | 92.0 | 15.2 | 42.0 |
| | 16 | 34.0 | 1.00 | 42.0 | 5 | 2F342-1600-100-PD | ★ | ☆ | 16.0 | 92.0 | 15.2 | 42.0 |
| | 16 | 34.0 | 2.00 | 42.0 | 5 | 2F342-1600-200-PD | ★ | ☆ | 16.0 | 92.0 | 15.2 | 42.0 |
| 20.0 | 20 | 42.0 | 1.00 | 52.0 | 5 | 2F342-2000-100-PD | ★ | ☆ | 20.0 | 104.0 | 19.0 | 52.0 |
| | 20 | 42.0 | 2.00 | 52.0 | 5 | 2F342-2000-200-PD | ★ | ☆ | 20.0 | 104.0 | 19.0 | 52.0 |

Dimensioni, millimetri

## Versione in pollici

| DC | $CZC_{MS}$ | APMX | RE | LU | ZEFP | Codice di ordinazione | P 1730 | K 1730 | $DCON_{MS}$ | LF | DN | $LB_1$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 5/8 | 1.315 | .030 | 1.625 | 5 | 2F342-1588-076-PD | ★ | ☆ | .625 | 3.500 | .594 | 1.626 |
| | 5/8 | 1.315 | .060 | 1.625 | 5 | 2F342-1588-152-PD | ★ | ☆ | .625 | 3.500 | .594 | 1.626 |
| .750 | 3/4 | 1.626 | .030 | 1.937 | 5 | 2F342-1905-076-PD | ★ | ☆ | .750 | 4.000 | .713 | 1.937 |
| | 3/4 | 1.626 | .060 | 1.937 | 5 | 2F342-1905-152-PD | ★ | ☆ | .750 | 4.000 | .713 | 1.937 |

Dimensioni, pollici

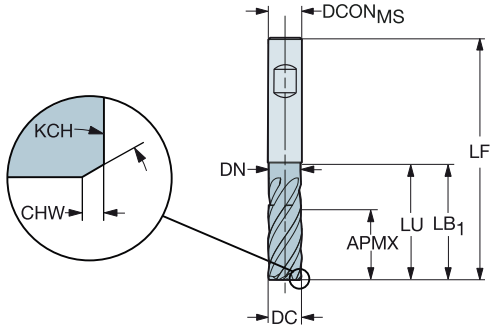
B20 B26 G2 G6

ITA

# CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante

**Per acciaio**

| | |
|---|---|
| FHA | 38° |
| BSG | COROMANT |
| TCDC | h10 |
| TCDCON | h6 |




## Versione metrica

| DC | $CZC_{MS}$ | APMX | CHW | KCH | LU | ZEFP | Codice di ordinazione | P 1730 | K 1730 | $DCON_{MS}$ | LF | DN | $LB_1$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Dimensioni, millimetri | | | | | |
| 10.0 | 10 | 22.0 | 0.15 | 45° | 30.0 | 5 | 2N342-1000-PD | ★ | ☆ | 10.0 | 72.0 | 9.5 | 30.0 |
| 12.0 | 12 | 26.0 | 0.15 | 45° | 36.0 | 5 | 2N342-1200-PD | ★ | ☆ | 12.0 | 83.0 | 11.4 | 36.0 |
| 16.0 | 16 | 34.0 | 0.25 | 45° | 42.0 | 5 | 2N342-1600-PD | ★ | ☆ | 16.0 | 92.0 | 15.2 | 42.0 |
| 20.0 | 20 | 42.0 | 0.25 | 45° | 52.0 | 5 | 2N342-2000-PD | ★ | ☆ | 20.0 | 104.0 | 19.0 | 52.0 |
| 25.0 | 25 | 52.0 | 0.25 | 45° | 63.0 | 5 | 2N342-2500-PD | ★ | ☆ | 25.0 | 121.0 | 24.0 | 63.0 |

## Versione in pollici

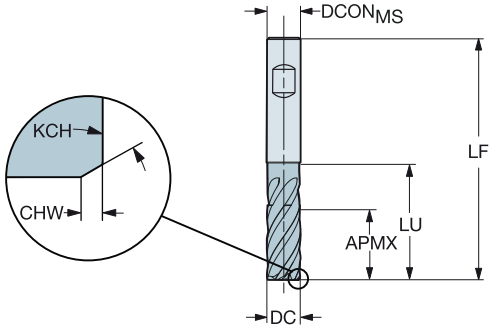
| DC | $CZC_{MS}$ | APMX | CHW | KCH | LU | ZEFP | Codice di ordinazione | P 1730 | K 1730 | $DCON_{MS}$ | LF | DN | $LB_1$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Dimensioni, pollici | | | | | |
| .625 | 5/8 | 1.315 | .010 | 45° | 1.625 | 5 | 2N342-1588-PD | ★ | ☆ | .625 | 3.500 | .594 | 1.625 |
| .750 | 3/4 | 1.626 | .010 | 45° | 1.937 | 5 | 2N342-1905-PD | ★ | ☆ | .750 | 4.000 | .713 | 1.937 |

B20 B26 G2 G6

# CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante

**Per acciaio**

| | |
|---|---|
| FHA | 42° |
| BSG | COROMANT |
| TCDC | h10 |
| TCDCON | h6 |




## Versione metrica

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

## Versione in pollici

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

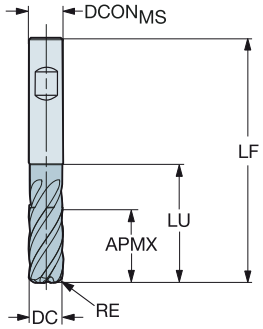
B20 B26 G2 G6

ITA

# CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante

**Per acciaio**

| | |
|---|---|
| FHA | 42° |
| BSG | COROMANT |
| TCDC | h10 |
| TCDCON | h6 |




## Versione metrica

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

Dimensioni, millimetri

## Versione in pollici

| DC | $CZC_{MS}$ | APMX | RE | LU | ZEFP | Codice di ordinazione | P 1730 | K 1730 | $DCON_{MS}$ | LF |
|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 5/8 | 1.313 | .030 | 1.313 | 4 | 2S342-1588-076-PB | ★ | ☆ | .625 | 3.500 |
| | 5/8 | 1.315 | .060 | 1.315 | 4 | 2S342-1588-152-PB | ★ | ☆ | .625 | 3.500 |
| .750 | 3/4 | 1.625 | .030 | 1.625 | 4 | 2S342-1905-076-PB | ★ | ☆ | .750 | 4.315 |
| | 3/4 | 1.625 | .060 | 1.625 | 4 | 2S342-1905-152-PB | ★ | ☆ | .750 | 4.315 |

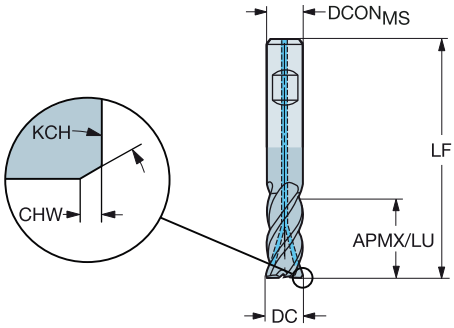
Dimensioni, pollici

B20 B26 G2 G6

# CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante

**Per acciaio inossidabile**

| | |
|---|---|
| FHA | 38° |
| BSG | COROMANT |
| TCDC | h10 |
| TCDCON | h6 |




**Versione metrica**

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

Dimensioni, millimetri

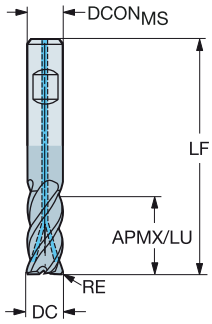
B20 B26 G2 G6

ITA

# CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante

**Per acciaio inossidabile**

| | |
|---|---|
| BSG | COROMANT |
| TCDC | h10 |
| TCDCON | h6 |




**Versione metrica**

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

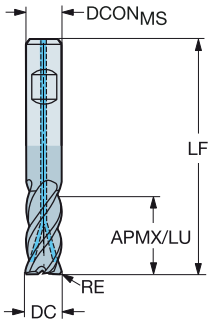
Dimensioni, millimetri

B20 B26 G2 G6

# CoroMill® Plura, fresa candela in metallo duro integrale per fresatura pesante

**Per acciaio inossidabile**

| | |
|---|---|
| BSG | COROMANT |
| TCDC | h10 |
| TCDCON | h6 |




**Versione in pollici**

| DC | $CZC_{MS}$ | APMX | RE | LU | CNSC | CXSC | ZEFP | FHA | Codice di ordinazione | M 1740 | S 1740 | $DCON_{MS}$ | LF |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 5/8 | 1.313 | .030 | 1.313 | 1 | 4 | 4 | 38° | 2S342-1588-076CMB | ★ | ☆ | .625 | 3.780 |
| | 5/8 | 1.313 | .060 | 1.313 | 1 | 4 | 4 | 38° | 2S342-1588-152CMB | ★ | ☆ | .625 | 3.780 |
| | 5/8 | 1.313 | .090 | 1.313 | 1 | 4 | 4 | 38° | 2S342-1588-229CMB | ★ | ☆ | .625 | 3.780 |
| | 5/8 | 1.313 | .120 | 1.313 | 1 | 4 | 4 | 38° | 2S342-1588-305CMB | ★ | ☆ | .625 | 3.780 |
| .750 | 3/4 | 1.625 | .030 | 1.625 | 1 | 4 | 4 | 38° | 2S342-1905-076CMB | ★ | ☆ | .750 | 4.315 |
| | 3/4 | 1.625 | .060 | 1.625 | 1 | 4 | 4 | 38° | 2S342-1905-152CMB | ★ | ☆ | .750 | 4.315 |
| | 3/4 | 1.625 | .090 | 1.625 | 1 | 4 | 4 | 38° | 2S342-1905-229CMB | ★ | ☆ | .750 | 4.315 |
| | 3/4 | 1.625 | .120 | 1.625 | 1 | 4 | 4 | 38° | 2S342-1905-305CMB | ★ | ☆ | .750 | 4.315 |
| | 3/4 | 1.625 | .190 | 1.625 | 1 | 4 | 4 | 38° | 2S342-1905-483CMB | ★ | ☆ | .750 | 4.315 |

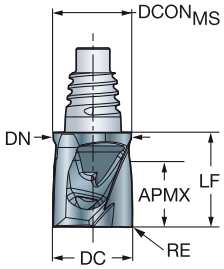
B20 B26 G2 G6

ITA

# Testina in metallo duro integrale CoroMill® 316 per fresatura a elevato carico di trucioli

**Per componenti multimateriale con durezza ≤ 48 HRc**

| | |
|---|---|
| FHA | 10° |
| BSG | COROMANT |
| TCDC | h10 |




## Versione metrica

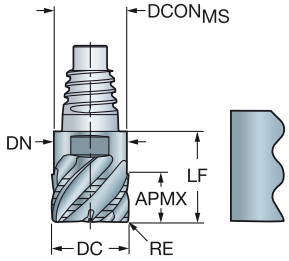
| DC | $CZC_{MS}$ | APMX | RE | ZEFP | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | $DCON_{MS}$ | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | Dimensioni, millimetri | | | | | | |
| 10.0 | E10 | 8.0 | 0.50 | 2 | 316-10SM210-10005P | ★ | ★ | ☆ | ☆ | 9.7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

B21 B26 G2

# Testina in metallo duro integrale CoroMill® 316 per sgrossatura con rompitrucioli

**Per componenti multimateriale con durezza ≤ 48 HRc**

| | |
|---|---|
| FHA | 45° |
| BSG | COROMANT |
| TCDC | h12 |




## Versione metrica

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

## Versione in pollici

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

B22 B26 G2



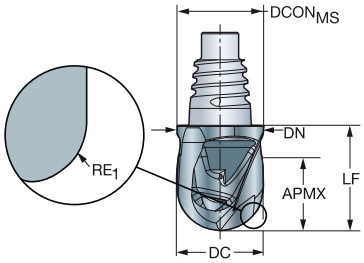
SANDVIK Coromant

ITA

# Testina in metallo duro integrale CoroMill® 316 per profilatura

**Per componenti multimateriale con durezza ≤ 48 HRc**

| | |
|---|---|
| BSG | COROMANT |
| TCDC | h9 |
| PSIR | 0° |



## Versione metrica

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

## Versione in pollici

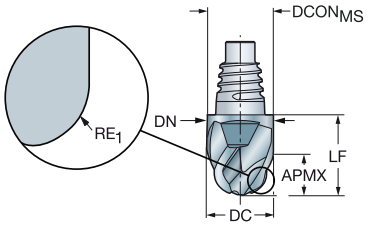
| DC | CZCMS | APMX | RE1 | ZEFP | FHA | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | Dimensioni, pollici DCONMS | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .375 | E10 | .315 | .188 | 2 | 10° | A316-10BM210-03750G | ★ | ★ | ☆ | ☆ | .364 | .465 | .382 |
| .500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

B25 B26 G2

# Testina in metallo duro integrale CoroMill® 316 per profilatura

**Per componenti multimateriale con durezza ≤ 48 HRc**

| | |
|---|---|
| BSG | COROMANT |
| TCDC | h9 |
| PSIR | 0° |



## Versione metrica

| DC | $CZC_{MS}$ | APMX | $RE_1$ | ZEFP | FHA | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | Dimensioni, millimetri $DCON_{MS}$ | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.0 | E10 | 5.5 | 5.00 | 4 | 40° | 316-10BM440-10050G | ★ | ★ | ☆ | ☆ | 9.7 | 12.4 | 9.7 |
| 12.0 | E12 | 6.5 | 6.00 | 4 | 40° | 316-12BM440-12060G | ★ | ★ | ☆ | ☆ | 11.7 | 14.5 | 11.7 |
| 16.0 | E16 | 8.5 | 8.00 | 4 | 40° | 316-16BM440-16080G | ★ | ★ | ☆ | ☆ | 15.5 | 18.7 | 15.5 |
| 20.0 | E20 | 11.0 | 10.00 | 2 | 40° | 316-20BM240-200AG | ★ | ★ | ☆ | ☆ | 19.3 | 21.3 | 19.3 |
| | E20 | 11.0 | 10.00 | 4 | 40° | 316-20BM440-200AG | ★ | ★ | ☆ | ☆ | 19.3 | 21.3 | 19.3 |
| 25.0 | E25 | 13.5 | 12.50 | 4 | 40° | 316-25BM440-250DG | ★ | ★ | ☆ | ☆ | 24.2 | 25.6 | 24.2 |

## Versione in pollici

| DC | $CZC_{MS}$ | APMX | $RE_1$ | ZEFP | FHA | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | Dimensioni, pollici $DCON_{MS}$ | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .375 | E10 | .209 | .188 | 4 | 40° | A316-10BM440-03750G | ★ | ★ | ☆ | ☆ | .364 | .488 | .364 |
| .500 | E12 | .276 | .250 | 4 | 40° | A316-12BM440-05060G | ★ | ★ | ☆ | ☆ | .484 | .575 | .484 |
| .625 | E16 | .335 | .313 | 4 | 40° | A316-16BM440-06280G | ★ | ★ | ☆ | ☆ | .610 | .736 | .610 |
| .750 | E20 | .413 | .375 | 4 | 40° | A316-20BM440-075AG | ★ | ★ | ☆ | ☆ | .728 | .839 | .728 |
| 1.000 | E25 | .551 | .500 | 4 | 40° | A316-25BM440-100CG | ★ | ★ | ☆ | ☆ | .965 | 1.008 | .965 |

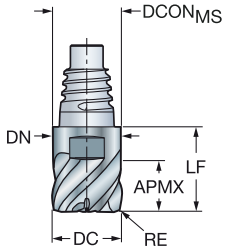
B25 B26 G2

ITA

# Testina in metallo duro integrale CoroMill® 316 per finitura

**Per componenti multimateriale con durezza ≤ 48 HRc**

| | |
|---|---|
| FHA | 50° |
| BSG | COROMANT |
| TCDC | h9 |



## Versione metrica

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

## Versione in pollici

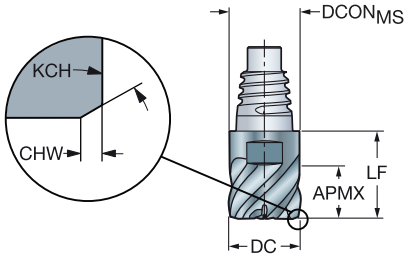
| DC | $CZC_{MS}$ | APMX | RE | ZEFP | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | $DCON_{MS}$ | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | | Dimensioni, pollici | | |
| .375 | E10 | .209 | .015 | 6 | A316-10FM650-03704L | ★ | ★ | ☆ | ☆ | .364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

B23 B26 G2

# Testina in metallo duro integrale CoroMill® 316 per finitura

**Per componenti multimateriale con durezza ≤ 48 HRc**

| | |
|---|---|
| FHA | 50° |
| BSG | COROMANT |
| TCDC | h10 |



**Versione metrica**

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

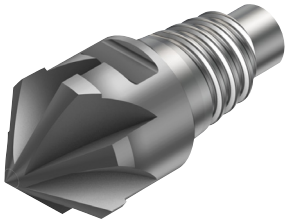
B23 B26 G2

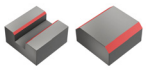
ITA

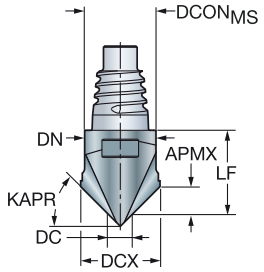
# Testina in metallo duro integrale CoroMill® 316 per fresatura di smussi

**Per componenti multimateriale con durezza ≤ 48 HRc**

BSG COROMANT








## Versione metrica

| KAPR | CZCMS | APMX | ZEFP | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | Dimensioni, millimetri DCONMS | DC | DCX | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 15° | E12 | 1.20 | 6 | 316-12CM600-12015G | ★ | ★ | ☆ | ☆ | 11.70 | 3.00 | 12.0 | 14.50 | 11.7 |
| 30° | | 2.60 | 6 | 316-12CM600-12030G | ★ | ★ | ☆ | ☆ | 11.70 | 3.00 | 12.0 | 13.60 | 11.7 |
| 45° | E10 | 4.25 | 4 | 316-10CM400-10045G | ★ | ★ | ☆ | ☆ | 9.70 | 1.50 | 10.0 | 11.66 | 9.7 |
| 45° | E12 | 4.50 | 6 | 316-12CM600-12045G | ★ | ★ | ☆ | ☆ | 11.70 | 3.00 | 12.0 | 13.00 | 11.7 |
| 45° | E16 | 6.00 | 8 | 316-16CM800-16045G | ★ | ★ | ☆ | ☆ | 15.50 | 4.00 | 16.0 | 16.70 | 15.5 |
| 60° | E10 | 5.60 | 4 | 316-10CM400-10060G | ★ | ★ | ☆ | ☆ | 9.70 | 3.50 | 10.0 | 12.40 | 9.7 |
| 60° | E12 | 6.50 | 6 | 316-12CM600-12060G | ★ | ★ | ☆ | ☆ | 11.70 | 4.50 | 12.0 | 14.50 | 11.7 |

## Versione in pollici

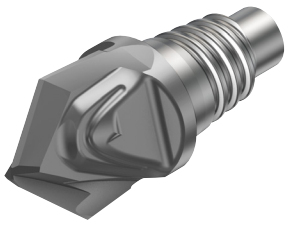
| KAPR | CZCMS | APMX | ZEFP | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | Dimensioni, pollici DCONMS | DC | DCX | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30° | E10 | .073 | 4 | A316-10CM400-03730G | ★ | ★ | ☆ | ☆ | .364 | .118 | .375 | .454 | .364 |
| 30° | E12 | .110 | 6 | A316-12CM600-05030G | ★ | ★ | ☆ | ☆ | .484 | .118 | .500 | .541 | .484 |
| 30° | E16 | .146 | 8 | A316-16CM800-06230G | ★ | ★ | ☆ | ☆ | .610 | .118 | .625 | .702 | .610 |
| 45° | E10 | .128 | 4 | A316-10CM400-03745G | ★ | ★ | ☆ | ☆ | .364 | .118 | .375 | .429 | .364 |
| 45° | E12 | .191 | 6 | A316-12CM600-05045G | ★ | ★ | ☆ | ☆ | .484 | .118 | .500 | .516 | .484 |
| 45° | E16 | .256 | 8 | A316-16CM800-06245G | ★ | ★ | ☆ | ☆ | .610 | .256 | .625 | .736 | .610 |
| 49° | E12 | .220 | 6 | A316-12CM600-05049G | ★ | ★ | ☆ | ☆ | .484 | .118 | .500 | .575 | .484 |
| 49° | E16 | .291 | 8 | A316-16CM800-06249G | ★ | ★ | ☆ | ☆ | .610 | .118 | .625 | .736 | .610 |
| 60° | E10 | .222 | 4 | A316-10CM400-03760G | ★ | ★ | ☆ | ☆ | .364 | .118 | .375 | .488 | .364 |
| 60° | E12 | .280 | 6 | A316-12CM600-05060G | ★ | ★ | ☆ | ☆ | .484 | .177 | .500 | .575 | .484 |
| 60° | E16 | .303 | 8 | A316-16CM800-06260G | ★ | ★ | ☆ | ☆ | .610 | .276 | .625 | .736 | .610 |

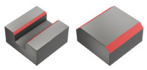
B24 B26 G2

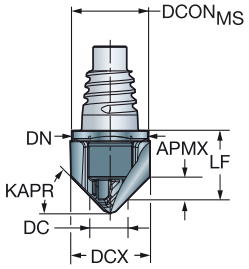
# Testina in metallo duro integrale CoroMill® 316 per fresatura di smussi

**Per componenti multimateriale con durezza ≤ 48 HRc**

BSG COROMANT








## Versione metrica

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

## Versione in pollici

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

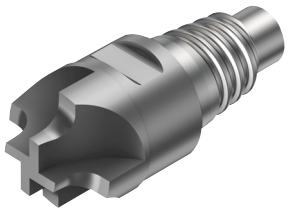
B24 B26 G2

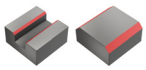
ITA

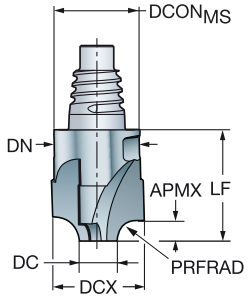
# Testina in metallo duro integrale CoroMill® 316 per fresatura di smussi

**Per componenti multimateriale con durezza ≤ 48 HRc**

BSG COROMANT








## Versione metrica

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

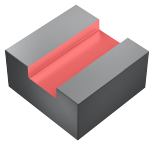
## Versione in pollici

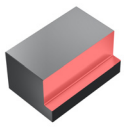
| PRFRAD | CZC$_{MS}$ | APMX | ZEFP | Codice di ordinazione | P 1730 | M 1730 | K 1730 | S 1730 | Dimensioni, pollici DCON$_{MS}$ | DC | DCX | LF | DN |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .062 | E10 | .062 | 4 | A316-10UM400-03715G | ★ | ★ | ☆ | ☆ | .364 | .236 | .375 | .488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

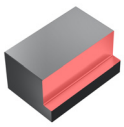
B24 B26 G2

# Velocità di taglio consigliate

**Ottimizzata - fresa candela in metallo duro integrale CoroMill® Plura per fresatura pesante**







| | | | | | $a_e$ = 1.0 x DC<br>$a_p$ = 1.0 x DC | | | $a_e$ = 0.5 x DC<br>$a_p$ = 1.0 x DC | | | $a_e$ = 0.25 x DC<br>$a_p$ = 1.0 x DC | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| ISO | **Codice MC** | **CMC** | **Materiale** | **HB** | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min |
| P | P1.2.Z.AN | 01.2 | Acciaio non legato | 190 | D01 | 150 | 492 | D02 | 180 | 590 | D03 | 250 | 820 |
| | P2.2.Z.AN | 02.2 | Acciaio debolmente legato | 240 | D04 | 120 | 394 | D02 | 145 | 475 | D03 | 200 | 656 |
| | P3.0.Z.HT | 03.21 | Acciaio fortemente legato | 380 | D04 | 80 | 262 | D02 | 95 | 311 | D03 | 135 | 442 |
| M | P5.0.Z.AN | 05.11 | Acciaio inossidabile ferritico/martensitico | 200 | D04 | 115 | 377 | D02 | 140 | 459 | D03 | 195 | 639 |
| | M1.0.Z.AQ | 05.21 | Acciaio inossidabile austenitico | 200 | D04 | 80 | 262 | D05 | 100 | 328 | D06 | 140 | 459 |
| | M3.2.Z.AQ | 05.51 | Acciaio inox Duplex (austenitico/ferritico) | 260 | D04 | 80 | 262 | D08 | 95 | 311 | D09 | 135 | 442 |
| K | K1.1.C.NS | 07.2 | Ghisa malleabile | 200 | D01 | 150 | 492 | D02 | 180 | 590 | D03 | 250 | 820 |
| | K2.1.C.UT | 08.2 | Ghisa grigia | 180 | D01 | 150 | 492 | D02 | 180 | 590 | D03 | 250 | 820 |
| | K3.2.C.UT | 09.2 | Ghisa nodulare | 215 | D01 | 160 | 525 | D02 | 190 | 623 | D03 | 270 | 885 |
| S | S2.0.Z.AG | 20.22 | Leghe a base di nichel | 350 | D07 | 20 | 148 | D08 | 25 | 180 | D09 | 32 | 246 |
| | S4.2.Z.AN | 23.22 | Leghe a base di titanio | 320 | D07 | 40 | 262 | D08 | 50 | 311 | D09 | 60 | 442 |

Per dati di taglio ottimizzati, vedere CoroPlus® ToolGuide.

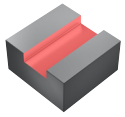
## Avanzamenti consigliati

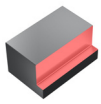
mm/dente
*pollici/dente*

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

# Velocità di taglio consigliate

**Ottimizzata - testina in metallo duro integrale CoroMill® 316 per fresatura a elevato carico di trucioli**





| | | | | | $a_e$ = 1.0 x DC<br>$a_p$ = 0.5 x DC | | | $a_e$ = 0.5 x DC<br>$a_p$ = 0.5 x DC | | | $a_e$ = 0.1 x DC<br>$a_p$ = 0.75 x DC | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| ISO | Codice MC | CMC | Materiale | HB | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min |
| P | P1.2.Z.AN | 01.2 | Acciaio non legato | 190 | O01 | 145 | 476 | O02 | 195 | 640 | O03 | 290 | 951 |
| | P2.2.Z.AN | 02.2 | Acciaio debolmente legato | 240 | O01 | 110 | 361 | O02 | 150 | 492 | O03 | 225 | 738 |
| | P3.0.Z.HT | 03.21 | Acciaio fortemente legato | 380 | O01 | 55 | 180 | O02 | 75 | 246 | O03 | 115 | 377 |
| M | P5.0.Z.AN | 05.11 | Acciaio inossidabile ferritico/martensitico | 200 | O01 | 75 | 246 | O02 | 100 | 328 | O03 | 150 | 492 |
| | M1.0.Z.AQ | 05.21 | Acciaio inossidabile austenitico | 200 | O06 | 60 | 197 | O05 | 85 | 279 | O04 | 125 | 410 |
| | M3.2.Z.AQ | 05.51 | Acciaio inox Duplex (austenitico/ferritico) | 260 | O06 | 75 | 246 | O05 | 100 | 328 | O04 | 150 | 492 |
| K | K1.1.C.NS | 07.2 | Ghisa malleabile | 200 | O01 | 140 | 459 | O02 | 185 | 607 | O03 | 280 | 919 |
| | K2.1.C.UT | 08.2 | Ghisa grigia | 180 | O01 | 75 | 246 | O02 | 105 | 344 | O03 | 155 | 509 |
| | K3.2.C.UT | 09.2 | Ghisa nodulare | 215 | O01 | 110 | 361 | O02 | 150 | 492 | O03 | 220 | 722 |
| S | S1.0.U.AG | 20.12 | Superleghe a base di ferro | 280 | O06 | 20 | 66 | O05 | 25 | 82 | O04 | 40 | 131 |
| | S2.0.Z.AG | 20.22 | Leghe a base di nichel | 350 | O06 | 15 | 49 | O05 | 25 | 82 | O04 | 35 | 115 |
| | S4.2.Z.AN | 23.22 | Leghe a base di titanio | 320 | O06 | 25 | 82 | O05 | 35 | 115 | O04 | 50 | 164 |

Per dati di taglio ottimizzati, vedere CoroPlus® ToolGuide.

## Avanzamenti consigliati

mm/dente
*pollici/dente*

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

# Velocità di taglio consigliate

**Ottimizzata - testina in metallo duro integrale CoroMill® 316 per sgrossatura con rompitrucioli**

| | | | | $a_e$ = 1.0 x DC | | | $a_e$ = 0.5 x DC | | | $a_e$ = 0.1 x DC | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | $a_p$ = 0.5 x DC | | | $a_p$ = 1.0 x DC | | | $a_p$ = 1.5 x DC | | |
| ISO | Codice MC | CMC | Materiale | HB | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min |
| P | P1.2.Z.AN | 01.2 | Acciaio non legato | 190 | L01 | 170 | 558 | L02 | 220 | 722 | L03 | 315 | 1033 |
| | P2.2.Z.AN | 02.2 | Acciaio debolmente legato | 240 | L01 | 120 | 394 | L02 | 160 | 525 | L03 | 230 | 755 |
| | P3.0.Z.HT | 03.21 | Acciaio fortemente legato | 380 | L01 | 80 | 262 | L02 | 100 | 328 | L03 | 140 | 459 |
| M | P5.0.Z.AN | 05.11 | Acciaio inossidabile ferritico/martensitico | 200 | L01 | 50 | 164 | L02 | 65 | 213 | L03 | 95 | 312 |
| | M1.0.Z.AQ | 05.21 | Acciaio inossidabile austenitico | 200 | L04 | 60 | 197 | L05 | 75 | 246 | L06 | 115 | 377 |
| | M3.2.Z.AQ | 05.51 | Acciaio inox Duplex (austenitico/ferritico) | 260 | L04 | 50 | 164 | L05 | 65 | 213 | L06 | 95 | 312 |
| K | K1.1.C.NS | 07.2 | Ghisa malleabile | 200 | L01 | 130 | 427 | L02 | 170 | 558 | L03 | 245 | 804 |
| | K2.1.C.UT | 08.2 | Ghisa grigia | 180 | L01 | 130 | 427 | L02 | 170 | 558 | L03 | 245 | 804 |
| | K3.2.C.UT | 09.2 | Ghisa nodulare | 215 | L01 | 115 | 377 | L02 | 155 | 509 | L03 | 220 | 722 |
| N | N1.2.Z.AG | 30.12 | Leghe a base di alluminio | 100 | L08 | 1270 | 4167 | L09 | 1610 | 5282 | L07 | 2150 | 7054 |
| | N1.3.C.UT | 30.21 | Leghe a base di alluminio | 75 | L08 | 310 | 1017 | L09 | 380 | 1247 | L07 | 540 | 1772 |
| | N1.4.C.NS | 30.42 | Leghe a base di alluminio | 130 | L08 | 110 | 361 | L09 | 150 | 492 | L07 | 220 | 722 |
| | N3.2.C.UT | 33.2 | Rame e leghe di rame | 90 | L08 | 170 | 558 | L09 | 230 | 755 | L07 | 320 | 1050 |
| S | S1.0.U.AG | 20.12 | Superleghe a base di ferro | 280 | L04 | 20 | 66 | L05 | 30 | 98 | L06 | 50 | 164 |
| | S2.0.Z.AG | 20.22 | Superleghe a base di nichel | 350 | L04 | 20 | 66 | L05 | 30 | 98 | L06 | 50 | 164 |
| | S4.2.Z.AN | 23.22 | Leghe a base di titanio | 320 | L04 | 50 | 164 | L05 | 80 | 262 | L06 | 130 | 427 |

Per dati di taglio ottimizzati, vedere CoroPlus® ToolGuide.

## Avanzamenti consigliati

mm/dente
*pollici/dente*

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

ITA

# Velocità di taglio consigliate

**Ottimizzata - testina in metallo duro integrale CoroMill® 316 per finitura**

| | | | | | $a_e$ = 0.1 x DC | | | $a_e$ = 0.05 x DC | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | $a_p$ = 1.0 x DC | | | $a_p$ = 1.5 x DC | | |
| ISO | Codice MC | CMC | Materiale | HB | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min |
| P | P1.2.Z.AN | 01.2 | Acciaio non legato | 190 | J01 | 280 | 919 | J02 | 330 | 1083 |
| | P2.2.Z.AN | 02.2 | Acciaio debolmente legato | 240 | J01 | 205 | 673 | J02 | 240 | 787 |
| | P3.0.Z.HT | 03.21 | Acciaio fortemente legato | 380 | J01 | 120 | 394 | J02 | 140 | 459 |
| M | P5.0.Z.AN | 05.11 | Acciaio inossidabile ferritico/martensitico | 200 | J01 | 80 | 262 | J02 | 95 | 312 |
| | M1.0.Z.AQ | 05.21 | Acciaio inossidabile austenitico | 200 | J03 | 100 | 328 | J04 | 115 | 377 |
| | M3.2.Z.AQ | 05.51 | Acciaio inox Duplex (austenitico/ferritico) | 260 | J03 | 80 | 262 | J04 | 95 | 312 |
| K | K1.1.C.NS | 07.2 | Ghisa malleabile | 200 | J01 | 220 | 722 | J04 | 255 | 837 |
| | K2.1.C.UT | 08.2 | Ghisa grigia | 180 | J01 | 220 | 722 | J02 | 255 | 837 |
| | K3.2.C.UT | 09.2 | Ghisa nodulare | 215 | J01 | 140 | 459 | J02 | 165 | 541 |
| S | S1.0.U.AG | 20.12 | Superleghe a base di ferro | 280 | J03 | 50 | 164 | J04 | 60 | 197 |
| | S2.0.Z.AG | 20.22 | Leghe a base di nichel | 350 | J03 | 50 | 164 | J04 | 60 | 197 |
| | S4.2.Z.AN | 23.22 | Leghe a base di titanio | 320 | J03 | 80 | 262 | J04 | 95 | 312 |
| H | H1.1.Z.HA | 04.1 | Acciaio - grado di durezza 50 | 50HRC | J03 | 120 | 394 | J04 | 140 | 459 |
| | H1.2.Z.HA | 04.1 | Acciaio - grado di durezza 55 | 55HRC | J03 | 120 | 394 | J04 | 140 | 459 |
| | H1.3.Z.HA | 04.1 | Acciaio - grado di durezza 60 | 60HRC | J03 | 70 | 230 | J04 | 80 | 262 |

Per dati di taglio ottimizzati, vedere CoroPlus® ToolGuide.

## Avanzamenti consigliati

mm/dente
*pollici/dente*

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

# Velocità di taglio consigliate

**Ottimizzata - testina in metallo duro integrale CoroMill® 316 per fresatura di smussi**

$a_e$ = 0.1 x DC

$a_p$ = 0.1 x DC

| ISO | Codice MC | CMC | Materiale | HB | $f_z$ | $v_c$ m/min | $v_c$ piedi/min |
|---|---|---|---|---|---|---|---|
| P | P1.2.Z.AN | 01.2 | Acciaio non legato | 190 | C01 | 320 | 1050 |
| | P2.2.Z.AN | 02.2 | Acciaio debolmente legato | 240 | C01 | 220 | 722 |
| | P3.0.Z.HT | 03.21 | Acciaio fortemente legato | 380 | C01 | 130 | 427 |
| M | P5.0.Z.AN | 05.11 | Acciaio inossidabile ferritico/martensitico | 200 | C01 | 90 | 295 |
| | M1.0.Z.AQ | 05.21 | Acciaio inossidabile austenitico | 200 | C02 | 110 | 361 |
| | M3.2.Z.AQ | 05.51 | Acciaio inox Duplex (austenitico/ferritico) | 260 | C02 | 70 | 230 |
| K | K1.1.C.NS | 07.2 | Ghisa malleabile | 200 | C01 | 240 | 787 |
| | K2.1.C.UT | 08.2 | Ghisa grigia | 180 | C01 | 240 | 787 |
| | K3.2.C.UT | 09.2 | Ghisa nodulare | 215 | C01 | 215 | 705 |
| N | N1.2.Z.AG | 30.12 | Leghe a base di alluminio | 100 | C03 | 2300 | 7546 |
| | N1.3.C.UT | 30.21 | Leghe a base di alluminio | 75 | C03 | 370 | 1214 |
| | N1.4.C.NS | 30.42 | Leghe a base di alluminio | 130 | C03 | 240 | 787 |
| | N3.2.C.UT | 33.2 | Rame e leghe di rame | 90 | C03 | 680 | 2231 |
| S | S1.0.U.AG | 20.12 | Superleghe a base di ferro | 280 | C02 | 50 | 164 |
| | S2.0.Z.AG | 20.22 | Leghe a base di nichel | 350 | C02 | 50 | 164 |
| | S4.2.Z.AN | 23.22 | Leghe a base di titanio | 320 | C02 | 90 | 295 |
| H | H1.1.Z.HA | 04.1 | Acciaio - grado di durezza 50 | 50HRC | C02 | 70 | 230 |

Per dati di taglio ottimizzati, vedere CoroPlus® ToolGuide.

## Avanzamenti consigliati

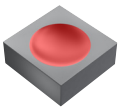
mm/dente
*pollici/dente*

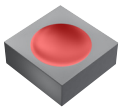
| $D_c$ | 1 | 2 | 3 | 4 | 6 | 6.35 | 8 | 9.525 | 10 | 12 | 12.7 | 14 | 15.875 | 16 | 20 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $f_z$ | *0.039* | *0.079* | *0.118* | *0.157* | *0.236* | *0.250* | *0.315* | *0.375* | *0.394* | *0.472* | *0.500* | *0.551* | *0.625* | *0.630*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

ITA

# Velocità di taglio consigliate

## Ottimizzata - testina in metallo duro integrale CoroMill® 316 per profilatura





| ISO | Codice MC | CMC | Materiale | HB | $a_e$ = 0.05 x DC | | | $a_e$ = 0.01 x DC | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | $f_z$ | $v_c$ m/min | $v_c$ piedi/min | $f_z$ | $v_c$ m/min | $v_c$ piedi/min |
| P | P1.2.Z.AN | 01.2 | Acciaio non legato | 190 | N01 | 300 | 984 | N04 | 360 | 1181 |
| | P2.2.Z.AN | 02.2 | Acciaio debolmente legato | 240 | N01 | 220 | 722 | N04 | 265 | 869 |
| | P3.0.Z.HT | 03.21 | Acciaio fortemente legato | 380 | N01 | 130 | 427 | N04 | 150 | 492 |
| M | P5.0.Z.AN | 05.11 | Acciaio inossidabile ferritico/martensitico | 200 | N01 | 90 | 295 | N05 | 100 | 328 |
| | M1.0.Z.AQ | 05.21 | Acciaio inossidabile austenitico | 200 | N02 | 110 | 361 | N05 | 130 | 427 |
| | M3.2.Z.AQ | 05.51 | Acciaio inox Duplex (austenitico/ferritico) | 260 | N02 | 90 | 295 | N04 | 100 | 328 |
| K | K1.1.C.NS | 07.2 | Ghisa malleabile | 200 | N01 | 240 | 787 | N04 | 290 | 951 |
| | K2.1.C.UT | 08.2 | Ghisa grigia | 180 | N01 | 240 | 787 | N04 | 290 | 951 |
| | K3.2.C.UT | 09.2 | Ghisa nodulare | 215 | N01 | 215 | 705 | N04 | 255 | 837 |
| N | N1.2.Z.AG | 30.12 | Leghe a base di alluminio | 100 | N03 | 1765 | 5791 | N06 | 1765 | 5791 |
| | N1.3.C.UT | 30.21 | Leghe a base di alluminio | 75 | N03 | 755 | 2477 | N06 | 910 | 2986 |
| | N1.4.C.NS | 30.42 | Leghe a base di alluminio | 130 | N03 | 280 | 919 | N06 | 335 | 1099 |
| | N3.2.C.UT | 33.2 | Rame e leghe di rame | 90 | N03 | 505 | 1657 | N06 | 615 | 2018 |
| S | S1.0.U.AG | 20.12 | Superleghe a base di ferro | 280 | N02 | 50 | 164 | N05 | 70 | 230 |
| | S2.0.Z.AG | 20.22 | Superleghe a base di nichel | 350 | N02 | 50 | 164 | N05 | 70 | 230 |
| | S4.2.Z.AN | 23.22 | Leghe a base di titanio | 320 | N02 | 100 | 328 | N05 | 130 | 427 |
| H | H1.1.Z.HA | 04.1 | Acciaio - grado di durezza 50 | 50HRC | N02 | 145 | 476 | N05 | 175 | 574 |
| | H1.2.Z.HA | 04.1 | Acciaio - grado di durezza 55 | 55HRC | N02 | 145 | 476 | N05 | 175 | 574 |
| | H1.3.Z.HA | 04.1 | Acciaio - grado di durezza 60 | 60HRC | N02 | 85 | 279 | N05 | 100 | 328 |
| O | O7.0.S.UT | | Grafite | | N03 | 800 | 2625 | N06 | 850 | 2789 |

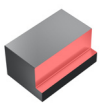
Per dati di taglio ottimizzati, vedere CoroPlus® ToolGuide.

### Avanzamenti consigliati

mm/dente
*pollici/dente*

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

## Ottimizzata - fresa a candela in metallo duro integrale CoroMill® Plura per applicazioni di contornatura
## Per materiali compositi



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

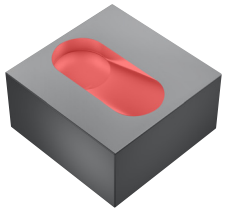
L'avanzamento è il medesimo per tutti i diametri.

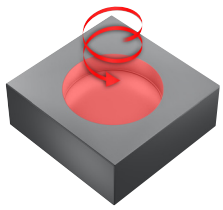
# Massimo angolo di penetrazione

**CoroMill® Plura - Ottimizzata**

**CoroMill® Plura - Versatile**

**CoroMill® 316**





| ISO | Materiale | Numero di denti (ZEFP) ≤ 2 | 3 | 4 | 5 | ≥ 6 |
|---|---|---|---|---|---|---|
| P | Acciaio (Durezza <300HB) | 9 | 7 | 5 | 5 | ≤ 4 |
| | Acciaio (Durezza >300HB) | 7 | 5 | 4 | 3 | ≤ 3 |
| M | Acciaio inossidabile | 5 | 5 | 5 | 4 | ≤ 4 |
| K | Ghisa | 10 | 10 | 8 | 6 | ≤ 5 |
| N | Metalli non ferrosi | 15 | 12 | 10 | 10 | ≤ 10 |
| S | Superleghe e titanio | 5 | 5 | 4 | 4 | ≤ 3 |
| H | Materiali duri | 2 | 2 | 1.5 | 1.5 | ≤ 1.5 |
| O | Non ISO | 15 | 12 | 10 | 10 | ≤ 10 |

## Qualità per fresatura

| | P | M | K | N | S | H | O | Ad umido | A secco | Descrizione |
|---|---|---|---|---|---|---|---|---|---|---|
| 1610 | + | | | | | ++ | | ✗ | ✓ | Substrato ultrafine e rivestimento CIL. Adatta per finitura e semifinitura sui materiali ISO H (e ISO P duri). Non adatta per valori di $a_e$ elevati. Per condizioni stabili. |
| 1620 | + | ++ | + | | + | + | | ✓ | ✓ | Qualità versatile simile a 1630. Adatta alla maggior parte dei materiali. Elevata resistenza all'usura. Più forte sui materiali ISO S e ISO M rispetto a 1630. |
| 1630 | ++ | + | ++ | | + | | + | ✓ | ✓ | Qualità versatile simile a 1620. Adatta alla maggior parte dei materiali. Più forte sui materiali ISO P e ISO K rispetto a 1620. È consigliabile la lavorazione a secco. |
| 1640 | + | ++ | + | | ++ | | | ✓ | ✓ | Qualità molto tenace per carichi di truciolo elevati (valore di $a_e$ elevato). Adatta alla maggior parte dei materiali. Adatta alla lavorazione con refrigerante. Adatta a condizioni instabili. |
| H10F | | | | ++ | | | + | ✓ | ✗ | Qualità priva di rivestimento per la lavorazione di materiali ISO N e alcuni ISO O (ad es. materiali termoplastici). |
| N20C | | | | + | | | ++ | ✓ | ✓ | Qualità con rivestimento in diamante per grafite, compositi e materiali ISO N ad alto contenuto di silicio (circa >9%). |
| 1700 | | | | | | ++ | | ✗ | ✓ | Qualità molto dura per la lavorazione sui materiali ISO H. |
| 1710 | | | | | ++ | | | ✓ | ✗ | Substrato a grana fine, duro e resistente all'usura. Nuovo rivestimento con proprietà di riduzione dell'adesione. Qualità specifica per leghe di nichel. |
| 1730 | ++ | + | ++ | | + | | | ✓ | ✓ | Qualità 1730 di nuova generazione. Qualità versatile più tenace e completa rispetto a 1630. È consigliabile la lavorazione a secco. |
| 1740 | + | ++ | + | | ++ | | | ✓ | ✓ | Qualità 1740 di nuova generazione. Nuovo substrato di dimensioni inferiori al micron e rivestimento TiAlN per aumentare la tenacità e ampliare l'area di applicazione rispetto a 1640. Perfetta quando si lavora con il refrigerante. |
| 1745 | | | | | ++ | | | ✓ | ✗ | Substrato tenace con grana inferiore al micron e nuovo rivestimento di silicio. Qualità specifica per leghe di titanio. |
| P10 | + | + | + | | + | + | | ✓ | ✓ | Solo un tipo di utensile ha questa qualità. Fresa a testa sferica lunga. Qualità molto simile a 1620. |



SANDVIK Coromant

# Foratura


## Punte ad inserti multitaglienti

CoroDrill® DS20 C2-C4

## Utensili integrali ottimizzati per foratura

CoroDrill® 860, punta in metallo duro integrale C5-C13

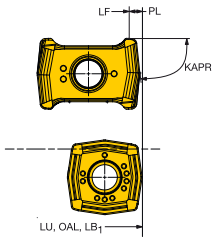
## Dati di taglio C36-C35

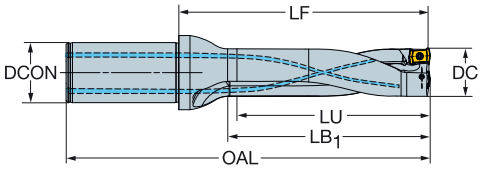

Per informazioni sulla gamma completa, visitare il sito www.sandvik.coromant.com/it

# Punta a inserti multitaglienti CoroDrill® DS20

**Attacco cilindrico con piano parallelo secondo ISO 9766**

**Adduzione interna di refrigerante**




## Dimensioni in mm

| DC | | | LU | CZC$_{MS}$ | ADJLX | TCHAL | TCHAU | Codice di ordinazione | DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | KAPR | BAR | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Dimensioni, millimetri | | | | | | | | |
| 28.00 | 04C | 04P | 112.00 | 32 | 2.12 | 0.00 | 0.33 | DS20-D2800L32-04 | 32.00 | 140.16 | 201.00 | 116.00 | 0.83 | 81° | 10 | 0.743 | 13000 |
| | | | 140.00 | 32 | 2.12 | 0.00 | 0.33 | DS20-D2800L32-05 | 32.00 | 168.16 | 229.00 | 144.00 | 0.83 | 81° | 10 | 0.809 | 8000 |
| | | | 168.00 | 32 | 2.12 | -0.10 | 0.40 | DS20-D2800L32-06 | 32.00 | 196.16 | 257.00 | 172.00 | 0.83 | 81° | 10 | 0.874 | 6000 |
| | | | 196.00 | 32 | 2.12 | -0.10 | 0.40 | DS20-D2800L32-07 | 32.00 | 224.16 | 285.00 | 200.00 | 0.83 | 81° | 10 | 0.939 | 4000 |
| 29.00 | 04C | 04P | 116.00 | 32 | 1.84 | 0.00 | 0.33 | DS20-D2900L32-04 | 32.00 | 144.16 | 205.00 | 120.00 | 0.83 | 81° | 10 | 0.773 | 12000 |
| | | | 145.00 | 32 | 1.84 | 0.00 | 0.33 | DS20-D2900L32-05 | 32.00 | 173.16 | 234.00 | 149.00 | 0.83 | 81° | 10 | 0.846 | 8000 |
| | | | 174.00 | 32 | 1.84 | -0.10 | 0.40 | DS20-D2900L32-06 | 32.00 | 202.16 | 263.00 | 178.00 | 0.83 | 81° | 10 | 0.918 | 5000 |
| | | | 203.00 | 32 | 1.84 | -0.10 | 0.40 | DS20-D2900L32-07 | 32.00 | 231.16 | 292.00 | 207.00 | 0.83 | 81° | 10 | 0.991 | 4000 |
| 30.00 | 04C | 04P | 120.00 | 32 | 1.56 | 0.00 | 0.33 | DS20-D3000L32-04 | 32.00 | 148.16 | 209.00 | 124.00 | 0.83 | 81° | 10 | 0.805 | 12000 |
| | | | 150.00 | 32 | 1.56 | 0.00 | 0.33 | DS20-D3000L32-05 | 32.00 | 178.16 | 239.00 | 154.00 | 0.83 | 81° | 10 | 0.885 | 8000 |
| | | | 180.00 | 32 | 1.56 | -0.10 | 0.40 | DS20-D3000L32-06 | 32.00 | 208.16 | 269.00 | 184.00 | 0.83 | 81° | 10 | 0.966 | 5000 |
| | | | 210.00 | 32 | 1.56 | -0.10 | 0.40 | DS20-D3000L32-07 | 32.00 | 238.16 | 299.00 | 214.00 | 0.83 | 81° | 10 | 1.046 | 4000 |
| 31.00 | 04C | 04P | 124.00 | 40 | 1.28 | 0.00 | 0.35 | DS20-D3100L40-04 | 40.00 | 158.16 | 229.00 | 128.00 | 0.83 | 81° | 10 | 1.250 | 12000 |
| | | | 155.00 | 40 | 1.28 | 0.00 | 0.35 | DS20-D3100L40-05 | 40.00 | 189.16 | 260.00 | 159.00 | 0.83 | 81° | 10 | 1.339 | 7000 |
| | | | 186.00 | 40 | 1.28 | -0.10 | 0.40 | DS20-D3100L40-06 | 40.00 | 220.16 | 291.00 | 190.00 | 0.83 | 81° | 10 | 1.428 | 5000 |
| | | | 217.00 | 40 | 1.28 | -0.10 | 0.40 | DS20-D3100L40-07 | 40.00 | 251.16 | 322.00 | 221.00 | 0.83 | 81° | 10 | 1.516 | 4000 |
| 32.00 | 04C | 04P | 128.00 | 40 | 1.00 | 0.00 | 0.35 | DS20-D3200L40-04 | 40.00 | 162.16 | 233.00 | 132.00 | 0.83 | 81° | 10 | 1.286 | 11000 |
| | | | 160.00 | 40 | 1.00 | 0.00 | 0.35 | DS20-D3200L40-05 | 40.00 | 194.16 | 265.00 | 164.00 | 0.83 | 81° | 10 | 1.384 | 7000 |
| | | | 192.00 | 40 | 1.00 | -0.10 | 0.40 | DS20-D3200L40-06 | 40.00 | 226.16 | 297.00 | 196.00 | 0.83 | 81° | 10 | 1.481 | 5000 |
| | | | 224.00 | 40 | 1.00 | -0.10 | 0.40 | DS20-D3200L40-07 | 40.00 | 258.16 | 329.00 | 228.00 | 0.83 | 81° | 10 | 1.579 | 3000 |
| 33.00 | 04C | 04P | 132.00 | 40 | 0.72 | 0.00 | 0.35 | DS20-D3300L40-04 | 40.00 | 165.16 | 236.00 | 136.00 | 0.83 | 81° | 10 | 1.313 | 11000 |
| | | | 165.00 | 40 | 0.72 | 0.00 | 0.35 | DS20-D3300L40-05 | 40.00 | 198.16 | 269.00 | 169.00 | 0.83 | 81° | 10 | 1.420 | 7000 |
| | | | 198.00 | 40 | 0.72 | -0.10 | 0.40 | DS20-D3300L40-06 | 40.00 | 231.16 | 302.00 | 202.00 | 0.83 | 81° | 10 | 1.527 | 5000 |
| | | | 231.00 | 40 | 0.72 | -0.10 | 0.40 | DS20-D3300L40-07 | 40.00 | 264.16 | 335.00 | 235.00 | 0.83 | 81° | 10 | 1.634 | 3000 |

## Dimensioni in pollici

| DC | | | LU | CZC$_{MS}$ | ADJLX | TCHAL | TCHAU | Codice di ordinazione | DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Dimensioni, pollici | | | | | | | | |
| 1.125 | 04C | 04P | 4.500 | 1 1/4 | .077 | .000 | .013 | DS20-D2858LX31-04 | 1.250 | 5.587 | 7.982 | 4.642 | .033 | 81° | 145 | 1.660 | 13000 |
| | | | 5.625 | 1 1/4 | .077 | .000 | .013 | DS20-D2858LX31-05 | 1.250 | 6.712 | 9.107 | 5.767 | .033 | 81° | 145 | 1.814 | 8000 |
| | | | 6.750 | 1 1/4 | .077 | -.004 | .016 | DS20-D2858LX31-06 | 1.250 | 7.837 | 10.232 | 6.892 | .033 | 81° | 145 | 1.966 | 5000 |
| | | | 7.875 | 1 1/4 | .077 | -.004 | .016 | DS20-D2858LX31-07 | 1.250 | 8.962 | 11.357 | 8.017 | .033 | 81° | 145 | 2.120 | 4000 |
| 1.187 | 04C | 04P | 4.748 | 1 1/4 | .059 | .000 | .013 | DS20-D3015LX31-04 | 1.250 | 5.830 | 8.225 | 4.890 | .033 | 81° | 145 | 1.768 | 12000 |
| | | | 5.935 | 1 1/4 | .059 | .000 | .013 | DS20-D3015LX31-05 | 1.250 | 7.017 | 9.412 | 6.077 | .033 | 81° | 145 | 1.948 | 8000 |
| | | | 7.122 | 1 1/4 | .059 | -.004 | .016 | DS20-D3015LX31-06 | 1.250 | 8.204 | 10.599 | 7.264 | .033 | 81° | 145 | 2.127 | 5000 |
| | | | 8.309 | 1 1/4 | .059 | -.004 | .016 | DS20-D3015LX31-07 | 1.250 | 9.391 | 11.786 | 8.451 | .033 | 81° | 145 | 2.308 | 4000 |
| 1.250 | 04C | 04P | 5.000 | 1 1/2 | .042 | .000 | .014 | DS20-D3175LX38-04 | 1.500 | 6.292 | 9.081 | 5.142 | .033 | 81° | 145 | 2.680 | 11000 |
| | | | 6.250 | 1 1/2 | .042 | .000 | .014 | DS20-D3175LX38-05 | 1.500 | 7.542 | 10.331 | 6.392 | .033 | 81° | 145 | 2.890 | 7000 |
| | | | 7.500 | 1 1/2 | .042 | -.004 | .016 | DS20-D3175LX38-06 | 1.500 | 8.792 | 11.581 | 7.642 | .033 | 81° | 145 | 3.101 | 5000 |
| | | | 8.750 | 1 1/2 | .042 | -.004 | .016 | DS20-D3175LX38-07 | 1.500 | 10.042 | 12.831 | 8.892 | .033 | 81° | 145 | 3.311 | 3000 |

| Parti di ricambio |
|---|
| Vite per inserto |
| 5513 020-57 |

Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

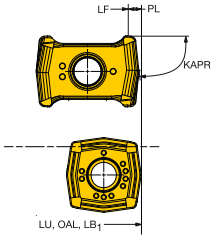
C4 G2 G5

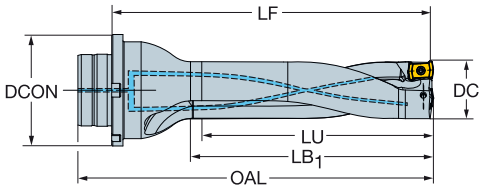
ITA

# Punta a inserti multitaglienti CoroDrill® DS20

**Interfaccia punta modulare**

**Adduzione interna di refrigerante**




| | | | | | | | | | Dimensioni, millimetri | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | **Codice di ordinazione** | $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | BAR | KG | RPMX |
| 28.00 | 04C | 04P | 112.00 | MDI-32 | 2.12 | 0.00 | 0.33 | **DS20-D2800DM32-04** | 32.00 | 150.16 | 166.00 | 116.00 | 0.83 | 81° | 10 | 0.705 | 13000 |
| | | | 196.00 | MDI-32 | 2.12 | -0.10 | 0.40 | **DS20-D2800DM32-07** | 32.00 | 234.16 | 250.00 | 200.00 | 0.83 | 81° | 10 | 0.901 | 4000 |
| 28.57 | 04C | 04P | 114.30 | MDI-32 | 1.95 | 0.00 | 0.33 | **DS20-D2858DM32-04** | 32.00 | 151.82 | 167.65 | 117.90 | 0.83 | 81° | 10 | 0.718 | 13000 |
| | | | 200.02 | MDI-32 | 1.95 | -0.10 | 0.40 | **DS20-D2858DM32-07** | 32.00 | 237.54 | 253.37 | 203.63 | 0.83 | 81° | 10 | 0.927 | 4000 |
| 29.00 | 04C | 04P | 116.00 | MDI-32 | 1.84 | 0.00 | 0.33 | **DS20-D2900DM32-04** | 32.00 | 154.16 | 170.00 | 120.00 | 0.83 | 81° | 10 | 0.734 | 12000 |
| | | | 203.00 | MDI-32 | 1.84 | -0.10 | 0.40 | **DS20-D2900DM32-07** | 32.00 | 241.16 | 257.00 | 207.00 | 0.83 | 81° | 10 | 0.952 | 4000 |
| 30.00 | 04C | 04P | 120.00 | MDI-32 | 1.56 | 0.00 | 0.33 | **DS20-D3000DM32-04** | 32.00 | 158.16 | 174.00 | 124.00 | 0.83 | 81° | 10 | 0.766 | 12000 |
| | | | 210.00 | MDI-32 | 1.56 | -0.10 | 0.40 | **DS20-D3000DM32-07** | 32.00 | 248.16 | 264.00 | 214.00 | 0.83 | 81° | 10 | 1.008 | 4000 |
| 30.14 | 04C | 04P | 120.59 | MDI-32 | 1.51 | 0.00 | 0.33 | **DS20-D3015DM32-04** | 32.00 | 157.99 | 173.82 | 124.20 | 0.83 | 81° | 10 | 0.767 | 12000 |
| | | | 211.04 | MDI-32 | 1.51 | -0.10 | 0.40 | **DS20-D3015DM32-07** | 32.00 | 248.44 | 264.27 | 214.65 | 0.83 | 81° | 10 | 1.012 | 4000 |
| 31.00 | 04C | 04P | 124.00 | MDI-32 | 1.28 | 0.00 | 0.35 | **DS20-D3100DM32-04** | 32.00 | 164.16 | 180.00 | 128.00 | 0.83 | 81° | 10 | 0.818 | 12000 |
| | | | 217.00 | MDI-32 | 1.28 | -0.10 | 0.40 | **DS20-D3100DM32-07** | 32.00 | 256.16 | 272.00 | 221.00 | 0.83 | 81° | 10 | 1.075 | 4000 |
| 31.75 | 04C | 04P | 127.00 | MDI-32 | 1.07 | 0.00 | 0.35 | **DS20-D3175DM32-04** | 32.00 | 166.27 | 182.10 | 130.60 | 0.83 | 81° | 10 | 0.839 | 11000 |
| | | | 222.25 | MDI-32 | 1.07 | -0.10 | 0.40 | **DS20-D3175DM32-07** | 32.00 | 261.49 | 277.33 | 225.85 | 0.83 | 81° | 10 | 1.125 | 3000 |
| 32.00 | 04C | 04P | 128.00 | MDI-40 | 1.00 | 0.00 | 0.35 | **DS20-D3200DM40-04** | 40.00 | 175.16 | 191.00 | 132.00 | 0.83 | 81° | 10 | 1.260 | 11000 |
| | | | 224.00 | MDI-40 | 1.00 | -0.10 | 0.40 | **DS20-D3200DM40-07** | 40.00 | 271.16 | 287.00 | 228.00 | 0.83 | 81° | 10 | 1.553 | 3000 |
| 33.00 | 04C | 04P | 132.00 | MDI-40 | 0.72 | 0.00 | 0.35 | **DS20-D3300DM40-04** | 40.00 | 179.16 | 195.00 | 136.00 | 0.83 | 81° | 10 | 1.299 | 11000 |
| | | | 231.00 | MDI-40 | 0.72 | -0.10 | 0.40 | **DS20-D3300DM40-07** | 40.00 | 278.16 | 294.00 | 235.00 | 0.83 | 81° | 10 | 1.620 | 3000 |

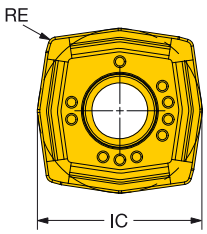
| Parti di ricambio |
|---|
| Vite per inserto |
| 5513 020-57 |

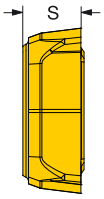
Per l'elenco completo delle parti di ricambio, accedere a www.sandvik.coromant.com

C4 G2 G5

# Inserto per foratura CoroDrill® DS20

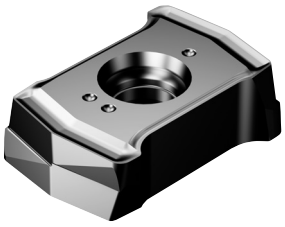
## Inserto centrale

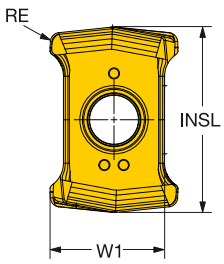


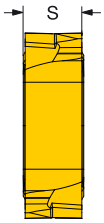




| | INSUC | Codice di ordinazione | P 1344 | P 1144 | M 1344 | K H13A | K 1344 | N 1344 | N H13A | S 1344 | H 1344 | Dimensioni, millimetri S | RE | IC |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 04C | C | DS20-0407-C-L5 | ★ | ★ | | ★ | ☆ | ★ | ☆ | ★ | | 3.20 | 0.35 | 11.1 |
| | | | | | | | | | | | | *.126* | *.014* | *.436* |
| | C | DS20-0407-C-M7 | ★ | | ★ | | | | | | ☆ | 3.20 | 0.35 | 11.1 |
| | | | | | | | | | | | | *.126* | *.014* | *.436* |

## Inserto periferico






| | INSUC | Codice di ordinazione | P 4324 | P 4334 | P 4344 | M 2044 | M 4334 | M 4344 | K 4324 | K 4334 | K 4344 | N 4344 | N H13A | S 2044 | S 4344 | S H13A | H 4334 | H 4344 | Dimensioni, millimetri S | RE | W1 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 04P | P | DS20-0407-P-H5W | | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 4.25 | 0.70 | 9.2 |
| | | | | | | | | | | | | | | | | | | | *.167* | *.028* | *.366* |
| | P | DS20-0407-P-L5W | ☆ | ★ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ☆ | | | | 4.25 | 0.70 | 9.2 |
| | | | | | | | | | | | | | | | | | | | *.167* | *.028* | *.366* |
| | P | DS20-0407-P-L6W | | | ☆ | | | ☆ | | | ☆ | ☆ | | | ★ | | | ★ | 4.25 | 0.70 | 9.2 |
| | | | | | | | | | | | | | | | | | | | *.167* | *.028* | *.366* |
| | P | DS20-0407-P-M7W | ☆ | ★ | ☆ | | | | ☆ | ★ | ☆ | | | | | | ☆ | ☆ | 4.25 | 0.70 | 9.2 |
| | | | | | | | | | | | | | | | | | | | *.167* | *.028* | *.366* |
| | P | DS20-0407-P-S5W | | | | | | ☆ | | | | ☆ | ★ | | ★ | ☆ | | | 4.25 | 0.70 | 9.2 |
| | | | | | | | | | | | | | | | | | | | *.167* | *.028* | *.366* |

C2 C14 G2



SANDVIK Coromant

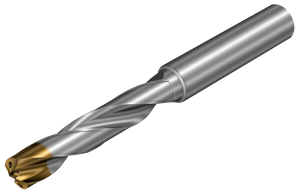
ITA

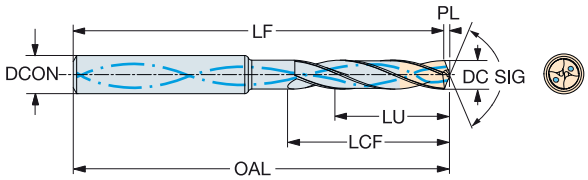
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione interna di refrigerante**

TCHA H9
SIG 140°






| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | P | M | K | N | S | H | Dimensioni in mm e pollici | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | X1BM | X1BM | X1BM | X1BM | X1BM | X1BM | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| 3.00 | .118 | 9.5 | .374 | 3 | 6 | 860.1-0300-009A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.5 | 2.421 | 20 | .787 | 0.5 | .020 |
| 3.00 | .118 | 15.5 | .610 | 5 | 6 | 860.1-0300-015A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.5 | 2.579 | 28 | 1.102 | 0.5 | .020 |
| 3.00 | .118 | 24.5 | .965 | 8 | 6 | 860.1-0300-024A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.6 | 3.094 | 37 | 1.457 | 0.4 | .016 |
| 3.10 | .122 | 9.9 | .390 | 3 | 6 | 860.1-0310-009A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.5 | 2.421 | 20 | .787 | 0.5 | .020 |
| 3.10 | .122 | 16.1 | .634 | 5 | 6 | 860.1-0310-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.5 | 2.579 | 28 | 1.102 | 0.5 | .020 |
| 3.10 | .122 | 25.4 | 1.000 | 8 | 6 | 860.1-0310-025A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.6 | 3.094 | 37 | 1.457 | 0.4 | .016 |
| 3.17 | .125 | 10.1 | .398 | 3 | 6 | 860.1-0317-010A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.5 | 2.421 | 20 | .787 | 0.5 | .020 |
| 3.17 | .125 | 16.4 | .646 | 5 | 6 | 860.1-0317-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.5 | 2.579 | 28 | 1.102 | 0.5 | .020 |
| 3.18 | .125 | 26.0 | 1.024 | 8 | 6 | 860.1-0318-026A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.5 | 3.091 | 37 | 1.457 | 0.5 | .020 |
| 3.20 | .126 | 10.2 | .402 | 3 | 6 | 860.1-0320-010A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.5 | 2.421 | 20 | .787 | 0.5 | .020 |
| 3.20 | .126 | 16.6 | .654 | 5 | 6 | 860.1-0320-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.5 | 2.579 | 28 | 1.102 | 0.5 | .020 |
| 3.20 | .126 | 26.2 | 1.032 | 8 | 6 | 860.1-0320-026A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.5 | 3.091 | 37 | 1.457 | 0.5 | .020 |
| 3.30 | .130 | 10.5 | .413 | 3 | 6 | 860.1-0330-010A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 65.4 | 2.575 | 20 | .787 | 0.6 | .024 |
| 3.30 | .130 | 17.1 | .673 | 5 | 6 | 860.1-0330-017A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 61.4 | 2.417 | 28 | 1.102 | 0.6 | .024 |
| 3.30 | .130 | 27.0 | 1.063 | 8 | 6 | 860.1-0330-027A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.5 | 3.091 | 37 | 1.457 | 0.5 | .020 |
| 3.40 | .134 | 10.8 | .425 | 3 | 6 | 860.1-0340-010A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.40 | .134 | 17.6 | .693 | 5 | 6 | 860.1-0340-017A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.40 | .134 | 27.8 | 1.094 | 8 | 6 | 860.1-0340-027A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.5 | 3.091 | 37 | 1.457 | 0.5 | .020 |
| 3.45 | .136 | 11.0 | .433 | 3 | 6 | 860.1-0345-010A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.45 | .136 | 17.9 | .705 | 5 | 6 | 860.1-0345-017A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.50 | .138 | 11.1 | .437 | 3 | 6 | 860.1-0350-011A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.50 | .138 | 18.1 | .713 | 5 | 6 | 860.1-0350-018A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.50 | .138 | 28.6 | 1.126 | 8 | 6 | 860.1-0350-028A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.5 | 3.091 | 37 | 1.457 | 0.5 | .020 |
| 3.57 | .141 | 11.4 | .449 | 3 | 6 | 860.1-0357-011A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 65.4 | 2.575 | 20 | .787 | 0.6 | .024 |
| 3.57 | .141 | 18.5 | .728 | 5 | 6 | 860.1-0357-018A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 61.4 | 2.417 | 28 | 1.102 | 0.6 | .024 |
| 3.57 | .141 | 28.9 | 1.138 | 8 | 6 | 860.1-0357-028A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.5 | 3.091 | 37 | 1.457 | 0.5 | .020 |
| 3.60 | .142 | 11.5 | .453 | 3 | 6 | 860.1-0360-011A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.60 | .142 | 18.7 | .736 | 5 | 6 | 860.1-0360-018A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.70 | .146 | 11.8 | .465 | 3 | 6 | 860.1-0370-011A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.70 | .146 | 19.2 | .756 | 5 | 6 | 860.1-0370-019A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.70 | .146 | 28.8 | 1.134 | 8 | 6 | 860.1-0370-028A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 79 | 3.110 | 78.5 | 3.091 | 37 | 1.457 | 0.5 | .020 |
| 3.80 | .150 | 12.1 | .476 | 3 | 6 | 860.1-0380-012A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 24 | .945 | 0.6 | .024 |
| 3.80 | .150 | 19.7 | .776 | 5 | 6 | 860.1-0380-019A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.4 | 2.890 | 36 | 1.417 | 0.6 | .024 |
| 3.80 | .150 | 31.1 | 1.224 | 8 | 6 | 860.1-0380-031A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.5 | 3.524 | 48 | 1.890 | 0.5 | .020 |
| 3.90 | .154 | 12.4 | .488 | 3 | 6 | 860.1-0390-012A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 73.3 | 2.886 | 24 | .945 | 0.7 | .028 |
| 3.90 | .154 | 20.2 | .795 | 5 | 6 | 860.1-0390-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 65.3 | 2.571 | 36 | 1.417 | 0.7 | .028 |
| 3.97 | .156 | 20.6 | .811 | 5 | 6 | 860.1-0397-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 3.97 | .156 | 32.5 | 1.280 | 8 | 6 | 860.1-0397-032A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.4 | 3.520 | 48 | 1.890 | 0.6 | .024 |
| 4.00 | .157 | 12.7 | .500 | 3 | 6 | 860.1-0400-012A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 4.00 | .157 | 20.7 | .815 | 5 | 6 | 860.1-0400-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 4.00 | .157 | 32.7 | 1.287 | 8 | 6 | 860.1-0400-032A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.4 | 3.520 | 48 | 1.890 | 0.6 | .024 |
| 4.10 | .161 | 13.0 | .512 | 3 | 6 | 860.1-0410-013A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 73.3 | 2.886 | 24 | .945 | 0.7 | .028 |
| 4.10 | .161 | 21.2 | .835 | 5 | 6 | 860.1-0410-021A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 65.3 | 2.571 | 36 | 1.417 | 0.7 | .028 |
| 4.10 | .161 | 33.5 | 1.319 | 8 | 6 | 860.1-0410-033A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.4 | 3.520 | 48 | 1.890 | 0.6 | .024 |
| 4.20 | .165 | 13.4 | .528 | 3 | 6 | 860.1-0420-013A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 4.20 | .165 | 21.8 | .858 | 5 | 6 | 860.1-0420-021A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 4.20 | .165 | 34.4 | 1.354 | 8 | 6 | 860.1-0420-034A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.4 | 3.520 | 48 | 1.890 | 0.6 | .024 |
| 4.30 | .169 | 13.7 | .539 | 3 | 6 | 860.1-0430-013A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 73.3 | 2.886 | 24 | .945 | 0.7 | .028 |
| 4.30 | .169 | 22.3 | .878 | 5 | 6 | 860.1-0430-022A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 65.3 | 2.571 | 36 | 1.417 | 0.7 | .028 |
| 4.30 | .169 | 35.2 | 1.386 | 8 | 6 | 860.1-0430-035A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.4 | 3.520 | 48 | 1.890 | 0.6 | .024 |
| 4.36 | .172 | 13.9 | .547 | 3 | 6 | 860.1-0436-013A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 4.36 | .172 | 22.6 | .890 | 5 | 6 | 860.1-0436-022A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 4.37 | .172 | 35.8 | 1.409 | 8 | 6 | 860.1-0437-035A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.4 | 3.520 | 48 | 1.890 | 0.6 | .024 |
| 4.40 | .173 | 14.0 | .551 | 3 | 6 | 860.1-0440-014A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 4.40 | .173 | 22.8 | .898 | 5 | 6 | 860.1-0440-022A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 4.50 | .177 | 14.3 | .563 | 3 | 6 | 860.1-0450-014A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 24 | .945 | 0.8 | .031 |
| 4.50 | .177 | 23.3 | .917 | 5 | 6 | 860.1-0450-023A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.2 | 2.882 | 36 | 1.417 | 0.8 | .031 |
| 4.50 | .177 | 36.8 | 1.449 | 8 | 6 | 860.1-0450-036A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.3 | 3.516 | 48 | 1.890 | 0.7 | .028 |

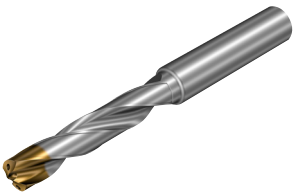
C30 G2 G5 G6

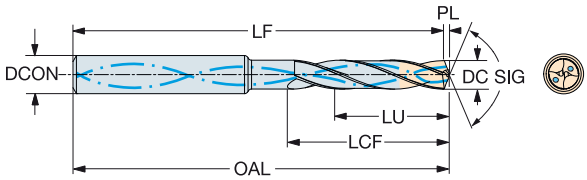
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione interna di refrigerante**

TCHA H9
SIG 140°






| | | | | | | | | | | | | Dimensioni in mm e pollici | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | P | M | K | N | S | H | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| | | | | | | | X1BM | X1BM | X1BM | X1BM | X1BM | X1BM | | | | | | | | | | |
| 4.55 | .179 | 14.5 | .571 | 3 | 6 | 860.1-0455-014A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 24 | .945 | 0.8 | .031 |
| 4.60 | .181 | 14.6 | .575 | 3 | 6 | 860.1-0460-014A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 73.2 | 2.882 | 24 | .945 | 0.8 | .031 |
| 4.60 | .181 | 23.8 | .937 | 5 | 6 | 860.1-0460-023A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 65.2 | 2.567 | 36 | 1.417 | 0.8 | .031 |
| 4.60 | .181 | 37.6 | 1.480 | 8 | 6 | 860.1-0460-037A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.3 | 3.516 | 48 | 1.890 | 0.7 | .028 |
| 4.70 | .185 | 14.6 | .575 | 3 | 6 | 860.1-0470-014A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 24 | .945 | 0.8 | .031 |
| 4.70 | .185 | 24.4 | .961 | 5 | 6 | 860.1-0470-024A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 73.2 | 2.882 | 36 | 1.417 | 0.8 | .031 |
| 4.70 | .185 | 38.5 | 1.516 | 8 | 6 | 860.1-0470-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 89.3 | 3.516 | 48 | 1.890 | 0.7 | .028 |
| 4.76 | .187 | 15.1 | .594 | 3 | 6 | 860.1-0476-015A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 28 | 1.102 | 0.8 | .031 |
| 4.76 | .187 | 24.7 | .972 | 5 | 6 | 860.1-0476-024A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 74 | 2.913 | 81.2 | 3.197 | 44 | 1.732 | 0.8 | .031 |
| 4.76 | .187 | 38.9 | 1.532 | 8 | 6 | 860.1-0476-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 90 | 3.543 | 103.3 | 4.067 | 62 | 2.441 | 0.7 | .028 |
| 4.80 | .189 | 15.3 | .602 | 3 | 6 | 860.1-0480-015A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 28 | 1.102 | 0.8 | .031 |
| 4.80 | .189 | 24.9 | .980 | 5 | 6 | 860.1-0480-024A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.2 | 3.197 | 44 | 1.732 | 0.8 | .031 |
| 4.80 | .189 | 39.3 | 1.547 | 8 | 6 | 860.1-0480-039A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 103.3 | 4.067 | 62 | 2.441 | 0.7 | .028 |
| 4.90 | .193 | 15.6 | .614 | 3 | 6 | 860.1-0490-015A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 28 | 1.102 | 0.8 | .031 |
| 4.90 | .193 | 25.4 | 1.000 | 5 | 6 | 860.1-0490-025A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.2 | 3.197 | 44 | 1.732 | 0.8 | .031 |
| 5.00 | .197 | 15.9 | .626 | 3 | 6 | 860.1-0500-015A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 28 | 1.102 | 0.8 | .031 |
| 5.00 | .197 | 25.9 | 1.020 | 5 | 6 | 860.1-0500-025A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.2 | 3.197 | 44 | 1.732 | 0.8 | .031 |
| 5.00 | .197 | 40.9 | 1.610 | 8 | 6 | 860.1-0500-040A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.2 | 3.630 | 62 | 2.441 | 0.8 | .031 |
| 5.10 | .201 | 16.2 | .638 | 3 | 6 | 860.1-0510-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 81.1 | 3.193 | 28 | 1.102 | 0.9 | .035 |
| 5.10 | .201 | 26.4 | 1.039 | 5 | 6 | 860.1-0510-026A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 92.1 | 3.626 | 44 | 1.732 | 0.9 | .035 |
| 5.10 | .201 | 41.7 | 1.642 | 8 | 6 | 860.1-0510-041A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 65.1 | 2.563 | 62 | 2.441 | 0.9 | .035 |
| 5.16 | .203 | 16.4 | .646 | 3 | 6 | 860.1-0516-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.1 | 2.563 | 28 | 1.102 | 0.9 | .035 |
| 5.16 | .203 | 26.7 | 1.051 | 5 | 6 | 860.1-0516-026A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.20 | .205 | 16.5 | .650 | 3 | 6 | 860.1-0520-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.1 | 2.563 | 28 | 1.102 | 0.9 | .035 |
| 5.20 | .205 | 26.9 | 1.059 | 5 | 6 | 860.1-0520-026A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.20 | .205 | 42.5 | 1.673 | 8 | 6 | 860.1-0520-042A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 65.1 | 2.563 | 62 | 2.441 | 0.9 | .035 |
| 5.30 | .209 | 27.2 | 1.071 | 5 | 6 | 860.1-0525-027A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.30 | .209 | 16.6 | .654 | 3 | 6 | 860.1-0530-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.1 | 2.563 | 28 | 1.102 | 0.9 | .035 |
| 5.30 | .209 | 27.5 | 1.083 | 5 | 6 | 860.1-0530-027A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.30 | .209 | 43.4 | 1.709 | 8 | 6 | 860.1-0530-043A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.1 | 3.626 | 62 | 2.441 | 0.9 | .035 |
| 5.40 | .213 | 16.5 | .650 | 3 | 6 | 860.1-0540-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 81.1 | 3.193 | 28 | 1.102 | 0.9 | .035 |
| 5.40 | .213 | 28.0 | 1.102 | 5 | 6 | 860.1-0540-027A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 65.1 | 2.563 | 44 | 1.732 | 0.9 | .035 |
| 5.40 | .213 | 44.2 | 1.740 | 8 | 6 | 860.1-0540-044A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 65.1 | 2.563 | 62 | 2.441 | 0.9 | .035 |
| 5.50 | .217 | 16.4 | .646 | 3 | 6 | 860.1-0550-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.1 | 2.563 | 28 | 1.102 | 0.9 | .035 |
| 5.50 | .217 | 28.5 | 1.122 | 5 | 6 | 860.1-0550-028A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.55 | .219 | 45.0 | 1.772 | 8 | 6 | 860.1-0550-045A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.1 | 3.626 | 62 | 2.441 | 0.9 | .035 |
| 5.56 | .219 | 28.8 | 1.134 | 5 | 6 | 860.1-0555-028A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.56 | .219 | 16.4 | .646 | 3 | 6 | 860.1-0556-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.1 | 2.563 | 28 | 1.102 | 0.9 | .035 |
| 5.56 | .219 | 28.8 | 1.134 | 5 | 6 | 860.1-0556-028A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.56 | .219 | 45.5 | 1.791 | 8 | 6 | 860.1-0556-045A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.1 | 3.626 | 62 | 2.441 | 0.9 | .035 |
| 5.60 | .220 | 16.3 | .642 | 3 | 6 | 860.1-0560-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 81.0 | 3.189 | 28 | 1.102 | 1.0 | .039 |
| 5.60 | .220 | 29.0 | 1.142 | 5 | 6 | 860.1-0560-029A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 92.0 | 3.622 | 44 | 1.732 | 1.0 | .039 |
| 5.60 | .220 | 45.8 | 1.803 | 8 | 6 | 860.1-0560-045A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 65.0 | 2.559 | 62 | 2.441 | 1.0 | .039 |
| 5.70 | .224 | 16.2 | .638 | 3 | 6 | 860.1-0570-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.0 | 2.559 | 28 | 1.102 | 1.0 | .039 |
| 5.70 | .224 | 29.5 | 1.161 | 5 | 6 | 860.1-0570-029A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.0 | 3.189 | 44 | 1.732 | 1.0 | .039 |
| 5.70 | .224 | 46.6 | 1.835 | 8 | 6 | 860.1-0570-046A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.0 | 3.622 | 62 | 2.441 | 1.0 | .039 |
| 5.80 | .228 | 16.2 | .638 | 3 | 6 | 860.1-0580-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.0 | 2.559 | 28 | 1.102 | 1.0 | .039 |
| 5.80 | .228 | 30.1 | 1.185 | 5 | 6 | 860.1-0580-030A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.0 | 3.189 | 44 | 1.732 | 1.1 | .042 |
| 5.80 | .228 | 47.5 | 1.870 | 8 | 6 | 860.1-0580-047A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.0 | 3.622 | 62 | 2.441 | 1.0 | .039 |
| 5.90 | .232 | 16.1 | .634 | 3 | 6 | 860.1-0590-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.0 | 2.559 | 28 | 1.102 | 1.0 | .039 |
| 5.90 | .232 | 48.3 | 1.902 | 8 | 6 | 860.1-0590-048A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.0 | 3.622 | 62 | 2.441 | 1.0 | .039 |
| 5.95 | .234 | 16.0 | .630 | 3 | 6 | 860.1-0595-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.0 | 2.559 | 28 | 1.102 | 1.1 | .043 |
| 6.00 | .236 | 16.0 | .630 | 3 | 6 | 860.1-0600-016A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.0 | 2.559 | 28 | 1.102 | 1.1 | .043 |
| 6.00 | .236 | 31.1 | 1.224 | 5 | 6 | 860.1-0600-031A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 82 | 3.228 | 81.0 | 3.189 | 44 | 1.732 | 1.1 | .043 |
| 6.00 | .236 | 49.1 | 1.933 | 8 | 6 | 860.1-0600-049A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 104 | 4.094 | 92.0 | 3.622 | 62 | 2.441 | 1.0 | .039 |
| 6.10 | .240 | 19.4 | .764 | 3 | 8 | 860.1-0610-019A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 78.0 | 3.071 | 34 | 1.339 | 1.1 | .044 |
| 6.10 | .240 | 31.6 | 1.244 | 5 | 8 | 860.1-0610-031A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 90.0 | 3.543 | 53 | 2.087 | 1.1 | .044 |
| 6.10 | .240 | 49.9 | 1.965 | 8 | 8 | 860.1-0610-049A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 78.0 | 3.071 | 84 | 3.307 | 1.0 | .039 |

C30 G2 G5 G6



SANDVIK Coromant

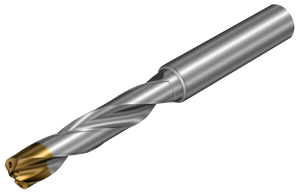
ITA

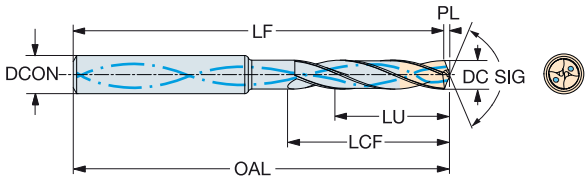
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione interna di refrigerante**

TCHA H9
SIG 140°





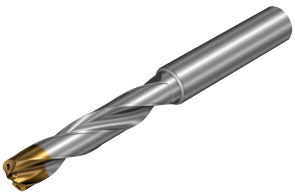

| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | P | M | K | N | S | H | Dimensioni in mm e pollici | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | X1BM | X1BM | X1BM | X1BM | X1BM | X1BM | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| 6.20 | .244 | 19.7 | .776 | 3 | 8 | 860.1-0620-019A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.1 | .044 |
| 6.20 | .244 | 32.1 | 1.264 | 5 | 8 | 860.1-0620-032A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 103.9 | 4.091 | 53 | 2.087 | 1.1 | .044 |
| 6.20 | .244 | 50.7 | 1.996 | 8 | 8 | 860.1-0620-050A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 77.9 | 3.067 | 84 | 3.307 | 1.1 | .043 |
| 6.30 | .248 | 20.0 | .787 | 3 | 8 | 860.1-0630-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.1 | .045 |
| 6.30 | .248 | 32.6 | 1.283 | 5 | 8 | 860.1-0630-032A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 77.9 | 3.067 | 53 | 2.087 | 1.1 | .045 |
| 6.30 | .248 | 51.5 | 2.028 | 8 | 8 | 860.1-0630-051A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 89.9 | 3.539 | 84 | 3.307 | 1.1 | .043 |
| 6.35 | .250 | 20.2 | .795 | 3 | 8 | 860.1-0635-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.2 | .045 |
| 6.35 | .250 | 32.9 | 1.295 | 5 | 8 | 860.1-0635-032A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.9 | 3.539 | 53 | 2.087 | 1.2 | .045 |
| 6.35 | .250 | 52.0 | 2.047 | 8 | 8 | 860.1-0635-051A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.9 | 4.091 | 84 | 3.307 | 1.1 | .043 |
| 6.40 | .252 | 20.4 | .803 | 3 | 8 | 860.1-0640-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.2 | .046 |
| 6.40 | .252 | 33.2 | 1.307 | 5 | 8 | 860.1-0640-033A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.9 | 3.539 | 53 | 2.087 | 1.2 | .046 |
| 6.40 | .252 | 52.4 | 2.063 | 8 | 8 | 860.1-0640-052A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.9 | 4.091 | 84 | 3.307 | 1.1 | .043 |
| 6.50 | .256 | 20.7 | .815 | 3 | 8 | 860.1-0650-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.2 | .047 |
| 6.50 | .256 | 33.7 | 1.327 | 5 | 8 | 860.1-0650-033A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 77.9 | 3.067 | 53 | 2.087 | 1.2 | .047 |
| 6.50 | .256 | 53.2 | 2.094 | 8 | 8 | 860.1-0650-053A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 89.9 | 3.539 | 84 | 3.307 | 1.1 | .043 |
| 6.60 | .260 | 20.6 | .811 | 3 | 8 | 860.1-0660-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.2 | .047 |
| 6.60 | .260 | 34.2 | 1.346 | 5 | 8 | 860.1-0660-034A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.9 | 3.539 | 53 | 2.087 | 1.2 | .047 |
| 6.60 | .260 | 54.0 | 2.126 | 8 | 8 | 860.1-0660-054A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.9 | 4.091 | 84 | 3.307 | 1.1 | .043 |
| 6.70 | .264 | 20.5 | .807 | 3 | 8 | 860.1-0670-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.2 | .048 |
| 6.70 | .264 | 34.7 | 1.366 | 5 | 8 | 860.1-0670-034A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.9 | 3.539 | 53 | 2.087 | 1.2 | .048 |
| 6.70 | .264 | 54.8 | 2.157 | 8 | 8 | 860.1-0670-054A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 77.9 | 3.067 | 84 | 3.307 | 1.1 | .043 |
| 6.75 | .266 | 20.5 | .807 | 3 | 8 | 860.1-0675-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 34 | 1.339 | 1.2 | .048 |
| 6.75 | .266 | 35.0 | 1.378 | 5 | 8 | 860.1-0675-034A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.8 | 3.535 | 53 | 2.087 | 1.2 | .048 |
| 6.80 | .268 | 20.4 | .803 | 3 | 8 | 860.1-0680-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 34 | 1.339 | 1.2 | .049 |
| 6.80 | .268 | 35.2 | 1.386 | 5 | 8 | 860.1-0680-035A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.8 | 3.535 | 53 | 2.087 | 1.2 | .049 |
| 6.80 | .268 | 55.6 | 2.189 | 8 | 8 | 860.1-0680-055A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.8 | 4.087 | 84 | 3.307 | 1.2 | .047 |
| 6.90 | .272 | 20.3 | .799 | 3 | 8 | 860.1-0690-020A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 34 | 1.339 | 1.3 | .049 |
| 6.90 | .272 | 35.8 | 1.409 | 5 | 8 | 860.1-0690-035A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.8 | 3.535 | 53 | 2.087 | 1.3 | .049 |
| 6.90 | .272 | 56.5 | 2.224 | 8 | 8 | 860.1-0690-056A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.8 | 4.087 | 84 | 3.307 | 1.2 | .047 |
| 7.00 | .276 | 22.3 | .878 | 3 | 8 | 860.1-0700-022A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 41 | 1.614 | 1.3 | .050 |
| 7.00 | .276 | 36.3 | 1.429 | 5 | 8 | 860.1-0700-036A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 103.8 | 4.087 | 53 | 2.087 | 1.3 | .050 |
| 7.00 | .276 | 57.3 | 2.256 | 8 | 8 | 860.1-0700-057A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 77.8 | 3.063 | 84 | 3.307 | 1.2 | .047 |
| 7.10 | .280 | 22.6 | .890 | 3 | 8 | 860.1-0710-022A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 41 | 1.614 | 1.3 | .051 |
| 7.10 | .280 | 36.8 | 1.449 | 5 | 8 | 860.1-0710-036A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.8 | 3.535 | 53 | 2.087 | 1.3 | .051 |
| 7.10 | .280 | 58.1 | 2.287 | 8 | 8 | 860.1-0710-058A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.8 | 4.087 | 84 | 3.307 | 1.2 | .047 |
| 7.14 | .281 | 22.7 | .894 | 3 | 8 | 860.1-0714-022A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 41 | 1.614 | 1.3 | .051 |
| 7.14 | .281 | 58.4 | 2.299 | 8 | 8 | 860.1-0714-058A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.8 | 4.087 | 84 | 3.307 | 1.2 | .047 |
| 7.20 | .283 | 22.9 | .902 | 3 | 8 | 860.1-0720-022A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 41 | 1.614 | 1.3 | .052 |
| 7.20 | .283 | 37.3 | 1.469 | 5 | 8 | 860.1-0720-037A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 77.8 | 3.063 | 53 | 2.087 | 1.3 | .052 |
| 7.30 | .287 | 23.2 | .913 | 3 | 8 | 860.1-0730-023A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 41 | 1.614 | 1.3 | .052 |
| 7.30 | .287 | 37.8 | 1.488 | 5 | 8 | 860.1-0730-037A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.8 | 3.535 | 53 | 2.087 | 1.3 | .052 |
| 7.40 | .291 | 23.5 | .925 | 3 | 8 | 860.1-0740-023A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.3 | .053 |
| 7.40 | .291 | 38.3 | 1.508 | 5 | 8 | 860.1-0740-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.7 | 3.532 | 53 | 2.087 | 1.3 | .053 |
| 7.40 | .291 | 60.5 | 2.382 | 8 | 8 | 860.1-0740-060A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.7 | 4.083 | 84 | 3.307 | 1.3 | .051 |
| 7.50 | .295 | 23.9 | .941 | 3 | 8 | 860.1-0750-023A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.4 | .054 |
| 7.50 | .295 | 38.8 | 1.528 | 5 | 8 | 860.1-0750-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 89.7 | 3.532 | 53 | 2.087 | 1.4 | .054 |
| 7.50 | .295 | 61.4 | 2.417 | 8 | 8 | 860.1-0750-061A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.7 | 4.083 | 84 | 3.307 | 1.3 | .051 |
| 7.54 | .297 | 24.0 | .945 | 3 | 8 | 860.1-0754-023A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.4 | .054 |
| 7.60 | .299 | 24.2 | .953 | 3 | 8 | 860.1-0760-024A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.4 | .054 |
| 7.60 | .299 | 38.7 | 1.524 | 5 | 10 | 860.1-0760-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 91 | 3.583 | 118.6 | 4.669 | 53 | 2.087 | 1.4 | .054 |
| 7.70 | .303 | 24.5 | .965 | 3 | 8 | 860.1-0770-024A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.4 | .055 |
| 7.70 | .303 | 63.0 | 2.480 | 8 | 8 | 860.1-0770-063A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.7 | 4.083 | 84 | 3.307 | 1.3 | .051 |
| 7.80 | .307 | 24.8 | .976 | 3 | 8 | 860.1-0780-024A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.4 | .056 |
| 7.80 | .307 | 38.6 | 1.520 | 5 | 8 | 860.1-0780-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 77.7 | 3.059 | 53 | 2.087 | 1.4 | .056 |
| 7.80 | .307 | 63.8 | 2.512 | 8 | 8 | 860.1-0780-063A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 89.7 | 3.532 | 84 | 3.307 | 1.3 | .051 |
| 7.90 | .311 | 25.1 | .988 | 3 | 8 | 860.1-0790-025A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.6 | 3.055 | 41 | 1.614 | 1.4 | .057 |
| 7.90 | .311 | 64.6 | 2.543 | 8 | 8 | 860.1-0790-064A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 103.6 | 4.079 | 84 | 3.307 | 1.4 | .055 |

C30 G2 G5 G6

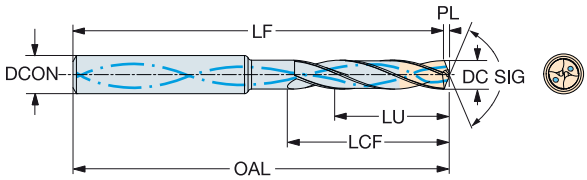
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione interna di refrigerante**



TCHA H9
SIG 140°




| | | | | | | | P | M | K | N | S | H | Dimensioni in mm e pollici | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | X1BM | X1BM | X1BM | X1BM | X1BM | X1BM | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| 7.94 | .313 | 25.3 | .996 | 3 | 8 | 860.1-0794-025A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.6 | 3.055 | 41 | 1.614 | 1.4 | .057 |
| 7.94 | .313 | 38.4 | 1.512 | 5 | 8 | 860.1-0794-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 77.6 | 3.055 | 53 | 2.087 | 1.4 | .057 |
| 7.94 | .313 | 65.0 | 2.559 | 8 | 8 | 860.1-0794-064A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 89.6 | 3.528 | 84 | 3.307 | 1.4 | .055 |
| 8.00 | .315 | 25.5 | 1.004 | 3 | 8 | 860.1-0800-025A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.6 | 3.055 | 41 | 1.614 | 1.5 | .057 |
| 8.00 | .315 | 38.4 | 1.512 | 5 | 8 | 860.1-0800-038A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 91 | 3.583 | 103.6 | 4.079 | 53 | 2.087 | 1.5 | .057 |
| 8.00 | .315 | 65.5 | 2.579 | 8 | 8 | 860.1-0800-065A1-GM | ★ | ★ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 126 | 4.961 | 77.6 | 3.055 | 84 | 3.307 | 1.4 | .055 |
| 8.10 | .319 | 25.8 | 1.016 | 3 | 10 | 860.1-0810-025A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.6 | 3.449 | 47 | 1.850 | 1.5 | .058 |
| 8.10 | .319 | 42.0 | 1.654 | 5 | 10 | 860.1-0810-041A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 87.6 | 3.449 | 61 | 2.402 | 1.5 | .058 |
| 8.10 | .319 | 66.3 | 2.610 | 8 | 10 | 860.1-0810-066A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 87.6 | 3.449 | 106 | 4.173 | 1.4 | .055 |
| 8.20 | .323 | 26.1 | 1.028 | 3 | 10 | 860.1-0820-026A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.6 | 3.449 | 47 | 1.850 | 1.5 | .059 |
| 8.20 | .323 | 42.5 | 1.673 | 5 | 10 | 860.1-0820-042A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 87.6 | 3.449 | 61 | 2.402 | 1.5 | .059 |
| 8.20 | .323 | 67.1 | 2.642 | 8 | 10 | 860.1-0820-067A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 101.6 | 4.000 | 106 | 4.173 | 1.4 | .055 |
| 8.30 | .327 | 26.4 | 1.039 | 3 | 10 | 860.1-0830-026A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.6 | 3.449 | 47 | 1.850 | 1.5 | .059 |
| 8.30 | .327 | 43.0 | 1.693 | 5 | 10 | 860.1-0830-043A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.6 | 4.000 | 61 | 2.402 | 1.5 | .059 |
| 8.30 | .327 | 67.9 | 2.673 | 8 | 10 | 860.1-0830-067A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 118.6 | 4.669 | 106 | 4.173 | 1.4 | .055 |
| 8.40 | .331 | 26.7 | 1.051 | 3 | 10 | 860.1-0840-026A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.6 | 3.449 | 47 | 1.850 | 1.5 | .060 |
| 8.40 | .331 | 43.5 | 1.713 | 5 | 10 | 860.1-0840-043A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.6 | 4.000 | 61 | 2.402 | 1.5 | .060 |
| 8.50 | .335 | 27.0 | 1.063 | 3 | 10 | 860.1-0850-027A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.5 | .061 |
| 8.50 | .335 | 44.0 | 1.732 | 5 | 10 | 860.1-0850-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.5 | 3.996 | 61 | 2.402 | 1.5 | .061 |
| 8.50 | .335 | 69.5 | 2.736 | 8 | 10 | 860.1-0850-069A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 118.5 | 4.665 | 106 | 4.173 | 1.5 | .059 |
| 8.60 | .339 | 27.4 | 1.079 | 3 | 10 | 860.1-0860-027A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.6 | .062 |
| 8.60 | .339 | 44.6 | 1.756 | 5 | 10 | 860.1-0860-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 118.5 | 4.665 | 61 | 2.402 | 1.6 | .062 |
| 8.60 | .339 | 70.4 | 2.772 | 8 | 10 | 860.1-0860-070A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 87.5 | 3.445 | 106 | 4.173 | 1.5 | .059 |
| 8.70 | .343 | 27.7 | 1.091 | 3 | 10 | 860.1-0870-027A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.6 | .062 |
| 8.70 | .343 | 45.0 | 1.772 | 5 | 10 | 860.1-0870-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 87.5 | 3.445 | 61 | 2.402 | 1.6 | .062 |
| 8.70 | .343 | 71.2 | 2.803 | 8 | 10 | 860.1-0870-071A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 101.5 | 3.996 | 106 | 4.173 | 1.5 | .059 |
| 8.73 | .344 | 27.8 | 1.094 | 3 | 10 | 860.1-0873-027A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.6 | .063 |
| 8.73 | .344 | 71.4 | 2.811 | 8 | 10 | 860.1-0873-071A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 118.5 | 4.665 | 106 | 4.173 | 1.6 | .063 |
| 8.80 | .346 | 28.0 | 1.102 | 3 | 10 | 860.1-0880-028A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.6 | .063 |
| 8.80 | .346 | 44.9 | 1.768 | 5 | 10 | 860.1-0880-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 87.5 | 3.445 | 61 | 2.402 | 1.6 | .063 |
| 8.90 | .350 | 28.3 | 1.114 | 3 | 10 | 860.1-0890-028A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.6 | .064 |
| 9.00 | .354 | 28.6 | 1.126 | 3 | 10 | 860.1-0900-028A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.6 | .064 |
| 9.00 | .354 | 44.7 | 1.760 | 5 | 10 | 860.1-0900-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 87.5 | 3.445 | 61 | 2.402 | 1.6 | .064 |
| 9.00 | .354 | 73.6 | 2.898 | 8 | 10 | 860.1-0900-073A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 101.5 | 3.996 | 106 | 4.173 | 1.6 | .064 |
| 9.13 | .359 | 29.1 | 1.146 | 3 | 10 | 860.1-0913-029A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.4 | 3.441 | 47 | 1.850 | 1.7 | .065 |
| 9.20 | .362 | 29.3 | 1.154 | 3 | 10 | 860.1-0920-029A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.4 | 3.441 | 47 | 1.850 | 1.7 | .066 |
| 9.30 | .366 | 29.6 | 1.165 | 3 | 10 | 860.1-0930-029A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.4 | 3.441 | 47 | 1.850 | 1.7 | .067 |
| 9.30 | .366 | 44.4 | 1.748 | 5 | 10 | 860.1-0930-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.4 | 3.992 | 61 | 2.402 | 1.7 | .067 |
| 9.40 | .370 | 44.4 | 1.748 | 5 | 10 | 860.1-0940-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.4 | 3.992 | 61 | 2.402 | 1.7 | .067 |
| 9.40 | .370 | 76.9 | 3.028 | 8 | 10 | 860.1-0940-076A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 131.4 | 5.173 | 106 | 4.173 | 1.7 | .067 |
| 9.50 | .374 | 30.2 | 1.189 | 3 | 10 | 860.1-0950-030A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.4 | 3.441 | 47 | 1.850 | 1.7 | .068 |
| 9.50 | .374 | 44.3 | 1.744 | 5 | 10 | 860.1-0950-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 131.4 | 5.173 | 61 | 2.402 | 1.7 | .068 |
| 9.50 | .374 | 77.7 | 3.059 | 8 | 10 | 860.1-0950-077A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 87.4 | 3.441 | 106 | 4.173 | 1.7 | .068 |
| 9.52 | .375 | 30.3 | 1.193 | 3 | 10 | 860.1-0952-030A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.4 | 3.441 | 47 | 1.850 | 1.7 | .068 |
| 9.52 | .375 | 44.3 | 1.744 | 5 | 10 | 860.1-0952-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.4 | 3.992 | 61 | 2.402 | 1.7 | .068 |
| 9.52 | .375 | 77.9 | 3.067 | 8 | 10 | 860.1-0952-077A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 131.4 | 5.173 | 106 | 4.173 | 1.7 | .068 |
| 9.60 | .378 | 30.2 | 1.189 | 3 | 10 | 860.1-0960-030A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.4 | 3.441 | 47 | 1.850 | 1.7 | .069 |
| 9.60 | .378 | 44.2 | 1.740 | 5 | 10 | 860.1-0960-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 87.4 | 3.441 | 61 | 2.402 | 1.7 | .069 |
| 9.70 | .382 | 30.1 | 1.185 | 3 | 10 | 860.1-0970-030A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.3 | 3.437 | 47 | 1.850 | 1.8 | .069 |
| 9.70 | .382 | 44.1 | 1.736 | 5 | 10 | 860.1-0970-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 131.3 | 5.169 | 61 | 2.402 | 1.8 | .069 |
| 9.70 | .382 | 79.4 | 3.126 | 8 | 10 | 860.1-0970-079A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 87.3 | 3.437 | 106 | 4.173 | 1.8 | .069 |
| 9.80 | .386 | 30.0 | 1.181 | 3 | 10 | 860.1-0980-030A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.3 | 3.437 | 47 | 1.850 | 1.8 | .070 |
| 9.80 | .386 | 44.0 | 1.732 | 5 | 10 | 860.1-0980-044A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.3 | 3.988 | 61 | 2.402 | 1.8 | .070 |
| 9.80 | .386 | 80.2 | 3.157 | 8 | 10 | 860.1-0980-080A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 131.3 | 5.169 | 106 | 4.173 | 1.8 | .070 |
| 9.90 | .390 | 30.0 | 1.181 | 3 | 10 | 860.1-0990-029A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.3 | 3.437 | 47 | 1.850 | 1.8 | .071 |
| 9.90 | .390 | 44.0 | 1.732 | 5 | 10 | 860.1-0990-043A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.3 | 3.988 | 61 | 2.402 | 1.8 | .071 |
| 9.92 | .391 | 30.0 | 1.181 | 3 | 10 | 860.1-0992-029A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.3 | 3.437 | 47 | 1.850 | 1.8 | .071 |
| 9.92 | .391 | 81.2 | 3.197 | 8 | 10 | 860.1-0992-081A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 87.3 | 3.437 | 106 | 4.173 | 1.8 | .071 |

C30 G2 G5 G6



SANDVIK Coromant

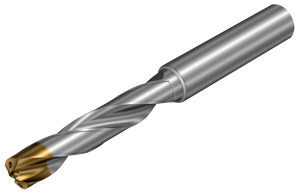
ITA

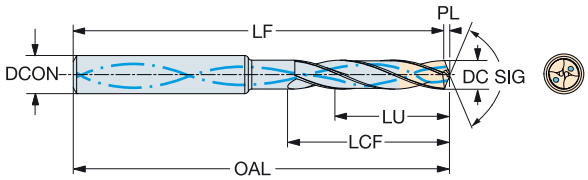
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione interna di refrigerante**

TCHA H9
SIG 140°





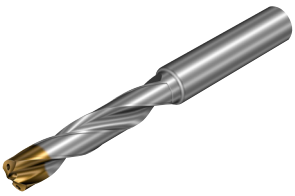

| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | P | M | K | N | S | H | Dimensioni in mm e pollici | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | X1BM | X1BM | X1BM | X1BM | X1BM | X1BM | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| 10.00 | .394 | 29.9 | 1.177 | 3 | 10 | 860.1-1000-029A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.3 | 3.437 | 47 | 1.850 | 1.8 | .072 |
| 10.00 | .394 | 43.9 | 1.728 | 5 | 10 | 860.1-1000-043A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 103 | 4.055 | 101.3 | 3.988 | 61 | 2.402 | 1.8 | .072 |
| 10.00 | .394 | 81.8 | 3.220 | 8 | 10 | 860.1-1000-081A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 152 | 5.984 | 131.3 | 5.169 | 106 | 4.173 | 1.8 | .072 |
| 10.10 | .398 | 32.1 | 1.264 | 3 | 12 | 860.1-1010-032A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 89 | 3.504 | 100.3 | 3.949 | 55 | 2.165 | 1.8 | .072 |
| 10.10 | .398 | 52.3 | 2.059 | 5 | 12 | 860.1-1010-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 103 | 4.055 | 116.3 | 4.579 | 71 | 2.795 | 1.8 | .072 |
| 10.10 | .398 | 82.6 | 3.252 | 8 | 12 | 860.1-1010-082A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 152 | 5.984 | 138.3 | 5.445 | 128 | 5.039 | 1.8 | .072 |
| 10.20 | .402 | 32.5 | 1.280 | 3 | 12 | 860.1-1020-032A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.3 | 3.949 | 55 | 2.165 | 1.9 | .073 |
| 10.20 | .402 | 52.9 | 2.083 | 5 | 12 | 860.1-1020-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 138.3 | 5.445 | 71 | 2.795 | 1.9 | .073 |
| 10.20 | .402 | 83.5 | 3.287 | 8 | 12 | 860.1-1020-083A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 100.3 | 3.949 | 128 | 5.039 | 1.9 | .073 |
| 10.30 | .406 | 32.8 | 1.291 | 3 | 12 | 860.1-1030-032A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .074 |
| 10.30 | .406 | 52.9 | 2.083 | 5 | 12 | 860.1-1030-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 138.2 | 5.441 | 71 | 2.795 | 1.9 | .074 |
| 10.30 | .406 | 84.3 | 3.319 | 8 | 12 | 860.1-1030-084A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 116.2 | 4.575 | 128 | 5.039 | 1.9 | .074 |
| 10.32 | .406 | 32.8 | 1.291 | 3 | 12 | 860.1-1032-032A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .074 |
| 10.32 | .406 | 52.9 | 2.083 | 5 | 12 | 860.1-1032-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.2 | 4.575 | 71 | 2.795 | 1.9 | .074 |
| 10.40 | .409 | 33.1 | 1.303 | 3 | 12 | 860.1-1040-033A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .075 |
| 10.40 | .409 | 52.8 | 2.079 | 5 | 12 | 860.1-1040-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 100.2 | 3.945 | 71 | 2.795 | 1.9 | .075 |
| 10.50 | .413 | 33.4 | 1.315 | 3 | 12 | 860.1-1050-033A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .075 |
| 10.50 | .413 | 52.7 | 2.075 | 5 | 12 | 860.1-1050-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.2 | 4.575 | 71 | 2.795 | 1.9 | .075 |
| 10.50 | .413 | 85.9 | 3.382 | 8 | 12 | 860.1-1050-085A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 138.2 | 5.441 | 128 | 5.039 | 1.9 | .075 |
| 10.60 | .417 | 33.7 | 1.327 | 3 | 12 | 860.1-1060-033A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .076 |
| 10.70 | .421 | 34.0 | 1.339 | 3 | 12 | 860.1-1070-034A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .077 |
| 10.70 | .421 | 52.5 | 2.067 | 5 | 12 | 860.1-1070-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.2 | 4.575 | 71 | 2.795 | 1.9 | .077 |
| 10.71 | .422 | 34.1 | 1.343 | 3 | 12 | 860.1-1071-034A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .077 |
| 10.71 | .422 | 52.5 | 2.067 | 5 | 12 | 860.1-1071-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.2 | 4.575 | 71 | 2.795 | 1.9 | .077 |
| 10.80 | .425 | 34.4 | 1.354 | 3 | 12 | 860.1-1080-034A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.1 | 3.941 | 55 | 2.165 | 2.0 | .077 |
| 10.80 | .425 | 52.5 | 2.067 | 5 | 12 | 860.1-1080-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 100.1 | 3.941 | 71 | 2.795 | 2.0 | .077 |
| 10.80 | .425 | 88.4 | 3.480 | 8 | 12 | 860.1-1080-088A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 116.1 | 4.571 | 128 | 5.039 | 2.0 | .077 |
| 11.00 | .433 | 35.0 | 1.378 | 3 | 12 | 860.1-1100-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.1 | 3.941 | 55 | 2.165 | 2.0 | .079 |
| 11.00 | .433 | 52.3 | 2.059 | 5 | 12 | 860.1-1100-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.1 | 4.571 | 71 | 2.795 | 2.0 | .079 |
| 11.00 | .433 | 90.0 | 3.543 | 8 | 12 | 860.1-1100-090A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 100.1 | 3.941 | 128 | 5.039 | 2.0 | .079 |
| 11.10 | .437 | 35.3 | 1.390 | 3 | 12 | 860.1-1110-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.1 | 3.941 | 55 | 2.165 | 2.0 | .080 |
| 11.10 | .437 | 52.2 | 2.055 | 5 | 12 | 860.1-1110-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 149.1 | 5.870 | 71 | 2.795 | 2.0 | .080 |
| 11.10 | .437 | 90.8 | 3.575 | 8 | 12 | 860.1-1110-090A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 100.1 | 3.941 | 128 | 5.039 | 2.0 | .080 |
| 11.11 | .437 | 35.4 | 1.394 | 3 | 12 | 860.1-1111-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.1 | 3.941 | 55 | 2.165 | 2.0 | .080 |
| 11.11 | .437 | 52.2 | 2.055 | 5 | 12 | 860.1-1111-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.1 | 4.571 | 71 | 2.795 | 2.0 | .080 |
| 11.20 | .441 | 35.6 | 1.402 | 3 | 12 | 860.1-1120-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.1 | 3.941 | 55 | 2.165 | 2.0 | .080 |
| 11.20 | .441 | 52.1 | 2.051 | 5 | 12 | 860.1-1120-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.1 | 4.571 | 71 | 2.795 | 2.0 | .080 |
| 11.30 | .445 | 52.1 | 2.051 | 5 | 12 | 860.1-1130-052A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.1 | 4.571 | 71 | 2.795 | 2.1 | .081 |
| 11.50 | .453 | 35.9 | 1.413 | 3 | 12 | 860.1-1150-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.0 | 3.937 | 55 | 2.165 | 2.1 | .082 |
| 11.50 | .453 | 51.9 | 2.043 | 5 | 12 | 860.1-1150-051A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.0 | 4.567 | 71 | 2.795 | 2.1 | .082 |
| 11.50 | .453 | 94.1 | 3.705 | 8 | 12 | 860.1-1150-094A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 149.0 | 5.866 | 128 | 5.039 | 2.1 | .082 |
| 11.60 | .457 | 35.8 | 1.409 | 3 | 12 | 860.1-1160-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.0 | 3.937 | 55 | 2.165 | 2.1 | .083 |
| 11.70 | .461 | 35.8 | 1.409 | 3 | 12 | 860.1-1170-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.0 | 3.937 | 55 | 2.165 | 2.1 | .084 |
| 11.80 | .465 | 35.7 | 1.406 | 3 | 12 | 860.1-1180-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.0 | 3.937 | 55 | 2.165 | 2.1 | .085 |
| 11.80 | .465 | 51.7 | 2.035 | 5 | 12 | 860.1-1180-051A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 149.0 | 5.866 | 71 | 2.795 | 2.1 | .085 |
| 11.80 | .465 | 96.5 | 3.799 | 8 | 12 | 860.1-1180-096A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 100.0 | 3.937 | 128 | 5.039 | 2.1 | .085 |
| 11.90 | .469 | 51.6 | 2.032 | 5 | 12 | 860.1-1190-051A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 118 | 4.646 | 116.0 | 4.567 | 71 | 2.795 | 2.2 | .085 |
| 11.90 | .469 | 97.4 | 3.835 | 8 | 12 | 860.1-1190-097A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 149.0 | 5.866 | 128 | 5.039 | 2.2 | .085 |
| 12.00 | .472 | 35.6 | 1.402 | 3 | 12 | 860.1-1200-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 99.9 | 3.933 | 55 | 2.165 | 2.2 | .086 |
| 12.00 | .472 | 51.6 | 2.032 | 5 | 14 | 860.1-1200-051A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 118 | 4.646 | 115.9 | 4.563 | 71 | 2.795 | 2.2 | .086 |
| 12.00 | .472 | 98.2 | 3.866 | 8 | 12 | 860.1-1200-098A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 180 | 7.087 | 148.9 | 5.862 | 128 | 5.039 | 2.2 | .086 |
| 12.10 | .476 | 56.7 | 2.232 | 5 | 14 | 860.1-1210-056A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 118 | 4.646 | 121.9 | 4.799 | 77 | 3.032 | 2.2 | .087 |
| 12.20 | .480 | 38.8 | 1.528 | 3 | 14 | 860.1-1220-038A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.9 | 4.130 | 60 | 2.362 | 2.2 | .087 |
| 12.20 | .480 | 56.6 | 2.228 | 5 | 14 | 860.1-1220-056A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 124 | 4.882 | 121.9 | 4.799 | 77 | 3.032 | 2.2 | .087 |
| 12.30 | .484 | 39.1 | 1.539 | 3 | 14 | 860.1-1230-039A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.9 | 4.130 | 60 | 2.362 | 2.2 | .088 |
| 12.30 | .484 | 100.6 | 3.961 | 8 | 14 | 860.1-1230-100A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 104.9 | 4.130 | 151 | 5.945 | 2.2 | .088 |
| 12.40 | .488 | 39.4 | 1.551 | 3 | 14 | 860.1-1240-039A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.9 | 4.130 | 60 | 2.362 | 2.3 | .089 |

C30 G2 G5 G6

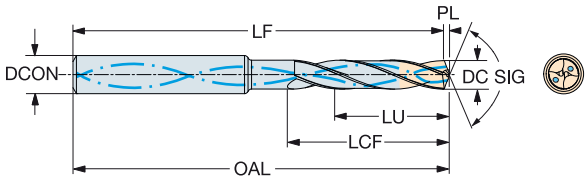
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione interna di refrigerante**



TCHA H9
SIG 140°




| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | P | M | K | N | S | H | Dimensioni in mm e pollici | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | X1BM | X1BM | X1BM | X1BM | X1BM | X1BM | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| 12.50 | .492 | 39.4 | 1.551 | 3 | 14 | 860.1-1250-039A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.9 | 4.130 | 60 | 2.362 | 2.3 | .090 |
| 12.50 | .492 | 56.4 | 2.220 | 5 | 14 | 860.1-1250-056A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 124 | 4.882 | 121.9 | 4.799 | 77 | 3.032 | 2.3 | .090 |
| 12.50 | .492 | 102.3 | 4.028 | 8 | 14 | 860.1-1250-102A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 157.9 | 6.217 | 151 | 5.945 | 2.3 | .090 |
| 12.70 | .500 | 39.2 | 1.543 | 3 | 14 | 860.1-1270-039A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.8 | 4.126 | 60 | 2.362 | 2.3 | .091 |
| 12.70 | .500 | 56.2 | 2.213 | 5 | 14 | 860.1-1270-056A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 124 | 4.882 | 121.8 | 4.795 | 77 | 3.032 | 2.3 | .091 |
| 12.70 | .500 | 103.9 | 4.091 | 8 | 14 | 860.1-1270-103A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 157.8 | 6.213 | 151 | 5.945 | 2.3 | .091 |
| 12.80 | .504 | 104.7 | 4.122 | 8 | 14 | 860.1-1280-104A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 157.8 | 6.213 | 151 | 5.945 | 2.3 | .092 |
| 13.00 | .512 | 39.0 | 1.535 | 3 | 14 | 860.1-1300-038A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.8 | 4.126 | 60 | 2.362 | 2.4 | .093 |
| 13.00 | .512 | 56.0 | 2.205 | 5 | 14 | 860.1-1300-055A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 124 | 4.882 | 121.8 | 4.795 | 77 | 3.032 | 2.4 | .093 |
| 13.00 | .512 | 106.4 | 4.189 | 8 | 14 | 860.1-1300-106A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 157.8 | 6.213 | 151 | 5.945 | 2.4 | .093 |
| 13.10 | .516 | 55.9 | 2.201 | 5 | 14 | 860.1-1310-055A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 124 | 4.882 | 121.7 | 4.791 | 77 | 3.032 | 2.4 | .094 |
| 13.25 | .522 | 38.8 | 1.528 | 3 | 14 | 860.1-1325-038A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.7 | 4.122 | 60 | 2.362 | 2.4 | .095 |
| 13.30 | .524 | 38.8 | 1.528 | 3 | 14 | 860.1-1330-036A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.6 | 4.118 | 60 | 2.362 | 2.4 | .095 |
| 13.50 | .531 | 38.6 | 1.520 | 3 | 14 | 860.1-1350-038A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.7 | 4.122 | 60 | 2.362 | 2.5 | .097 |
| 13.50 | .531 | 55.6 | 2.189 | 5 | 14 | 860.1-1350-055A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 124 | 4.882 | 121.7 | 4.791 | 77 | 3.032 | 2.5 | .097 |
| 13.50 | .531 | 110.5 | 4.350 | 8 | 14 | 860.1-1350-110A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 157.7 | 6.209 | 151 | 5.945 | 2.5 | .097 |
| 13.75 | .541 | 38.4 | 1.512 | 3 | 14 | 860.1-1375-038A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.6 | 4.118 | 60 | 2.362 | 2.5 | .099 |
| 13.80 | .543 | 112.9 | 4.445 | 8 | 14 | 860.1-1380-112A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 157.6 | 6.205 | 151 | 5.945 | 2.5 | .099 |
| 14.00 | .551 | 38.2 | 1.504 | 3 | 14 | 860.1-1400-038A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.6 | 4.118 | 60 | 2.362 | 2.5 | .100 |
| 14.00 | .551 | 55.2 | 2.173 | 3 | 16 | 860.1-1400-055A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 124 | 4.882 | 157.6 | 6.205 | 77 | 3.032 | 2.5 | .100 |
| 14.00 | .551 | 114.5 | 4.508 | 8 | 14 | 860.1-1400-114A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 202 | 7.953 | 104.6 | 4.118 | 151 | 5.945 | 2.5 | .100 |
| 14.25 | .561 | 42.4 | 1.669 | 3 | 16 | 860.1-1425-042A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.5 | 4.429 | 65 | 2.559 | 2.6 | .102 |
| 14.25 | .561 | 60.4 | 2.378 | 5 | 16 | 860.1-1425-060A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 133 | 5.236 | 112.5 | 4.429 | 83 | 3.268 | 2.6 | .102 |
| 14.29 | .563 | 42.4 | 1.669 | 3 | 16 | 860.1-1429-042A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.5 | 4.429 | 65 | 2.559 | 2.6 | .102 |
| 14.50 | .571 | 42.2 | 1.661 | 3 | 16 | 860.1-1450-042A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.5 | 4.429 | 65 | 2.559 | 2.6 | .104 |
| 14.50 | .571 | 60.2 | 2.370 | 5 | 16 | 860.1-1450-060A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 133 | 5.236 | 112.5 | 4.429 | 83 | 3.268 | 2.6 | .104 |
| 15.00 | .591 | 41.8 | 1.646 | 3 | 16 | 860.1-1500-041A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.4 | 4.425 | 65 | 2.559 | 2.7 | .107 |
| 15.00 | .591 | 59.8 | 2.354 | 3 | 16 | 860.1-1500-059A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 133 | 5.236 | 130.4 | 5.134 | 83 | 3.268 | 2.7 | .107 |
| 15.50 | .610 | 41.4 | 1.630 | 3 | 16 | 860.1-1550-041A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.3 | 4.421 | 65 | 2.559 | 2.8 | .111 |
| 15.87 | .625 | 41.1 | 1.618 | 3 | 16 | 860.1-1587-041A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.3 | 4.421 | 65 | 2.559 | 2.9 | .114 |
| 15.87 | .625 | 59.1 | 2.327 | 3 | 16 | 860.1-1587-059A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 133 | 5.236 | 130.3 | 5.130 | 83 | 3.268 | 2.9 | .114 |
| 16.00 | .630 | 41.0 | 1.614 | 3 | 16 | 860.1-1600-041A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.2 | 4.417 | 65 | 2.559 | 2.9 | .115 |
| 16.00 | .630 | 59.0 | 2.323 | 3 | 6 | 860.1-1600-059A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 133 | 5.236 | 112.2 | 4.417 | 83 | 3.268 | 2.9 | .115 |
| 16.00 | .630 | 130.9 | 5.154 | 8 | 16 | 860.1-1600-130A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 227 | 8.937 | 130.2 | 5.126 | 172 | 6.772 | 2.9 | .115 |

C30 G2 G5 G6



SANDVIK Coromant

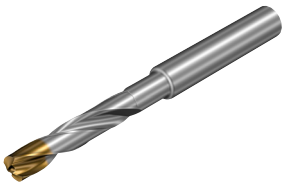
ITA

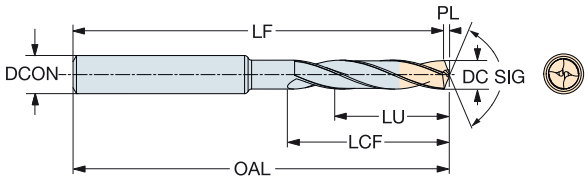
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione esterna di refrigerante**

TCHA H9
SIG 140°






| | | | | | | | P | M | K | N | H | Dimensioni in mm e pollici | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | X1BM | X1BM | X1BM | X1BM | X1BM | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| 3.00 | .118 | 9.5 | .374 | 3 | 6 | 860.1-0300-009A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.5 | 2.421 | 20 | .787 | 0.5 | .020 |
| 3.00 | .118 | 15.5 | .610 | 5 | 6 | 860.1-0300-015A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.5 | 2.579 | 28 | 1.102 | 0.5 | .020 |
| 3.10 | .122 | 9.9 | .390 | 3 | 6 | 860.1-0310-009A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.5 | 2.421 | 20 | .787 | 0.5 | .020 |
| 3.10 | .122 | 16.1 | .634 | 5 | 6 | 860.1-0310-016A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.5 | 2.579 | 28 | 1.102 | 0.5 | .020 |
| 3.20 | .126 | 10.2 | .402 | 3 | 6 | 860.1-0320-010A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.5 | 2.421 | 20 | .787 | 0.5 | .020 |
| 3.20 | .126 | 16.6 | .654 | 5 | 6 | 860.1-0320-016A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.5 | 2.579 | 28 | 1.102 | 0.5 | .020 |
| 3.30 | .130 | 10.5 | .413 | 3 | 6 | 860.1-0330-010A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.30 | .130 | 17.1 | .673 | 5 | 6 | 860.1-0330-017A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 61.4 | 2.417 | 28 | 1.102 | 0.6 | .024 |
| 3.38 | .133 | 17.5 | .689 | 5 | 6 | 860.1-0338-017A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.40 | .134 | 10.8 | .425 | 3 | 6 | 860.1-0340-010A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.40 | .134 | 17.6 | .693 | 5 | 6 | 860.1-0340-017A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.50 | .138 | 11.1 | .437 | 3 | 6 | 860.1-0350-011A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.50 | .138 | 18.1 | .713 | 5 | 6 | 860.1-0350-018A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.60 | .142 | 11.5 | .453 | 3 | 6 | 860.1-0360-011A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.60 | .142 | 18.7 | .736 | 5 | 6 | 860.1-0360-018A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.70 | .146 | 11.8 | .465 | 3 | 6 | 860.1-0370-011A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 62 | 2.441 | 61.4 | 2.417 | 20 | .787 | 0.6 | .024 |
| 3.70 | .146 | 19.2 | .756 | 5 | 6 | 860.1-0370-019A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 28 | 1.102 | 0.6 | .024 |
| 3.80 | .150 | 12.1 | .476 | 3 | 6 | 860.1-0380-012A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 24 | .945 | 0.6 | .024 |
| 3.80 | .150 | 19.7 | .776 | 5 | 6 | 860.1-0380-019A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 73.4 | 2.890 | 36 | 1.417 | 0.6 | .024 |
| 3.90 | .154 | 12.4 | .488 | 3 | 6 | 860.1-0390-012A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 3.90 | .154 | 20.2 | .795 | 5 | 6 | 860.1-0390-020A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 4.00 | .157 | 12.7 | .500 | 3 | 6 | 860.1-0400-012A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 4.00 | .157 | 20.7 | .815 | 5 | 6 | 860.1-0400-020A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 4.10 | .161 | 13.0 | .512 | 3 | 6 | 860.1-0410-013A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 73.3 | 2.886 | 24 | .945 | 0.7 | .028 |
| 4.10 | .161 | 21.2 | .835 | 5 | 6 | 860.1-0410-021A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 65.3 | 2.571 | 36 | 1.417 | 0.7 | .028 |
| 4.20 | .165 | 13.4 | .528 | 3 | 6 | 860.1-0420-013A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 4.20 | .165 | 21.8 | .858 | 5 | 6 | 860.1-0420-021A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 73.3 | 2.886 | 36 | 1.417 | 0.7 | .028 |
| 4.30 | .169 | 13.7 | .539 | 3 | 6 | 860.1-0430-013A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 73.3 | 2.886 | 24 | .945 | 0.7 | .028 |
| 4.30 | .169 | 22.3 | .878 | 5 | 6 | 860.1-0430-022A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 65.3 | 2.571 | 36 | 1.417 | 0.7 | .028 |
| 4.40 | .173 | 14.0 | .551 | 3 | 6 | 860.1-0440-014A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 24 | .945 | 0.7 | .028 |
| 4.50 | .177 | 14.3 | .563 | 3 | 6 | 860.1-0450-014A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 24 | .945 | 0.8 | .031 |
| 4.50 | .177 | 23.3 | .917 | 5 | 6 | 860.1-0450-023A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 73.2 | 2.882 | 36 | 1.417 | 0.8 | .031 |
| 4.60 | .181 | 14.6 | .575 | 3 | 6 | 860.1-0460-014A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 73.2 | 2.882 | 24 | .945 | 0.8 | .031 |
| 4.60 | .181 | 23.8 | .937 | 5 | 6 | 860.1-0460-023A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 74 | 2.913 | 65.2 | 2.567 | 36 | 1.417 | 0.8 | .031 |
| 4.70 | .185 | 14.6 | .575 | 3 | 6 | 860.1-0470-014A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 24 | .945 | 0.8 | .031 |
| 4.80 | .189 | 15.3 | .602 | 3 | 6 | 860.1-0480-015A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 28 | 1.102 | 0.8 | .031 |
| 4.80 | .189 | 24.9 | .980 | 5 | 6 | 860.1-0480-024A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 81.2 | 3.197 | 44 | 1.732 | 0.8 | .031 |
| 4.90 | .193 | 15.6 | .614 | 3 | 6 | 860.1-0490-015A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 28 | 1.102 | 0.8 | .031 |
| 5.00 | .197 | 15.9 | .626 | 3 | 6 | 860.1-0500-015A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 28 | 1.102 | 0.8 | .031 |
| 5.00 | .197 | 25.9 | 1.020 | 5 | 6 | 860.1-0500-025A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 81.2 | 3.197 | 44 | 1.732 | 0.8 | .031 |
| 5.10 | .201 | 16.2 | .638 | 3 | 6 | 860.1-0510-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 81.1 | 3.193 | 28 | 1.102 | 0.9 | .035 |
| 5.10 | .201 | 26.4 | 1.039 | 5 | 6 | 860.1-0510-026A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 65.1 | 2.563 | 44 | 1.732 | 0.9 | .035 |
| 5.20 | .205 | 16.5 | .650 | 3 | 6 | 860.1-0520-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 81.1 | 3.193 | 28 | 1.102 | 0.9 | .035 |
| 5.20 | .205 | 26.9 | 1.059 | 5 | 6 | 860.1-0520-026A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 92.1 | 3.626 | 44 | 1.732 | 0.9 | .035 |
| 5.30 | .209 | 16.6 | .654 | 3 | 6 | 860.1-0530-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.1 | 2.563 | 28 | 1.102 | 0.9 | .035 |
| 5.30 | .209 | 27.5 | 1.083 | 5 | 6 | 860.1-0530-027A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.40 | .213 | 16.5 | .650 | 3 | 6 | 860.1-0540-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 92.1 | 3.626 | 28 | 1.102 | 0.9 | .035 |
| 5.50 | .217 | 16.4 | .646 | 3 | 6 | 860.1-0550-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.1 | 2.563 | 28 | 1.102 | 0.9 | .035 |
| 5.50 | .217 | 28.5 | 1.122 | 5 | 6 | 860.1-0550-028A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 81.1 | 3.193 | 44 | 1.732 | 0.9 | .035 |
| 5.60 | .220 | 16.3 | .642 | 3 | 6 | 860.1-0560-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 81.0 | 3.189 | 28 | 1.102 | 1.0 | .039 |
| 5.60 | .220 | 29.0 | 1.142 | 5 | 6 | 860.1-0560-029A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 65.0 | 2.559 | 44 | 1.732 | 1.0 | .039 |
| 5.80 | .228 | 16.2 | .638 | 3 | 6 | 860.1-0580-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.0 | 2.559 | 28 | 1.102 | 1.0 | .039 |
| 5.90 | .232 | 30.6 | 1.205 | 5 | 6 | 860.1-0590-030A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 81.0 | 3.189 | 44 | 1.732 | 1.0 | .039 |
| 6.00 | .236 | 16.0 | .630 | 3 | 6 | 860.1-0600-016A0-GM | ★ | ☆ | ★ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.0 | 2.559 | 28 | 1.102 | 1.0 | .039 |
| 6.00 | .236 | 31.1 | 1.224 | 5 | 6 | 860.1-0600-031A0-GM | ★ | | ★ | ☆ | ☆ | 6.0 | .236 | 82 | 3.228 | 81.0 | 3.189 | 44 | 1.732 | 1.0 | .039 |
| 6.10 | .240 | 19.4 | .764 | 3 | 8 | 860.1-0610-019A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 90.0 | 3.543 | 34 | 1.339 | 1.0 | .039 |
| 6.10 | .240 | 31.6 | 1.244 | 5 | 8 | 860.1-0610-031A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 104.0 | 4.094 | 53 | 2.087 | 1.0 | .039 |
| 6.20 | .244 | 19.7 | .776 | 3 | 8 | 860.1-0620-019A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 89.9 | 3.539 | 34 | 1.339 | 1.1 | .043 |
| 6.20 | .244 | 32.1 | 1.264 | 5 | 8 | 860.1-0620-032A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 77.9 | 3.067 | 53 | 2.087 | 1.1 | .043 |

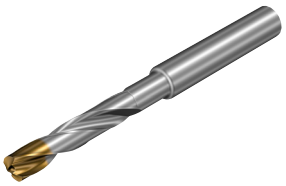
C30 G2 G5 G6

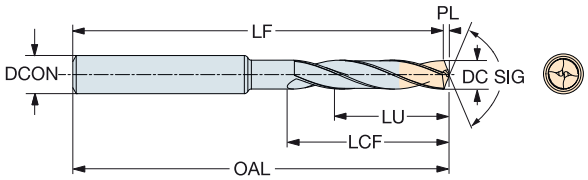
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione esterna di refrigerante**

TCHA H9
SIG 140°






| | | | | | | | P | M | K | N | H | Dimensioni in mm e pollici | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DC | DC" | LU | LU" | ULDR | $CZC_{MS}$ | Codice di ordinazione | X1BM | X1BM | X1BM | X1BM | X1BM | $DCON_{MS}$ | $DCON_{MS}$" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
| 6.30 | .248 | 20.0 | .787 | 3 | 8 | 860.1-0630-020A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 103.9 | 4.091 | 34 | 1.339 | 1.1 | .043 |
| 6.30 | .248 | 32.6 | 1.283 | 5 | 8 | 860.1-0630-032A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 77.9 | 3.067 | 53 | 2.087 | 1.1 | .043 |
| 6.40 | .252 | 33.2 | 1.307 | 5 | 8 | 860.1-0640-033A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 89.9 | 3.539 | 53 | 2.087 | 1.1 | .043 |
| 6.50 | .256 | 20.7 | .815 | 3 | 8 | 860.1-0650-020A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.1 | .043 |
| 6.50 | .256 | 33.7 | 1.327 | 5 | 8 | 860.1-0650-033A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 89.9 | 3.539 | 53 | 2.087 | 1.1 | .043 |
| 6.60 | .260 | 20.6 | .811 | 3 | 8 | 860.1-0660-020A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.9 | 3.067 | 34 | 1.339 | 1.1 | .043 |
| 6.70 | .264 | 20.5 | .807 | 3 | 8 | 860.1-0670-020A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 89.9 | 3.539 | 34 | 1.339 | 1.1 | .043 |
| 6.70 | .264 | 34.7 | 1.366 | 5 | 8 | 860.1-0670-034A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 103.9 | 4.091 | 53 | 2.087 | 1.1 | .043 |
| 6.80 | .268 | 20.4 | .803 | 3 | 8 | 860.1-0680-020A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 34 | 1.339 | 1.2 | .047 |
| 6.80 | .268 | 35.2 | 1.386 | 5 | 8 | 860.1-0680-035A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 89.8 | 3.535 | 53 | 2.087 | 1.2 | .047 |
| 6.90 | .272 | 35.8 | 1.409 | 5 | 8 | 860.1-0690-035A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 89.8 | 3.535 | 53 | 2.087 | 1.2 | .047 |
| 7.00 | .276 | 22.3 | .878 | 3 | 8 | 860.1-0700-022A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 89.8 | 3.535 | 41 | 1.614 | 1.2 | .047 |
| 7.00 | .276 | 36.3 | 1.429 | 5 | 8 | 860.1-0700-036A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 77.8 | 3.063 | 53 | 2.087 | 1.2 | .047 |
| 7.10 | .280 | 22.6 | .890 | 3 | 8 | 860.1-0710-022A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 41 | 1.614 | 1.2 | .047 |
| 7.20 | .283 | 22.9 | .902 | 3 | 8 | 860.1-0720-022A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.8 | 3.063 | 41 | 1.614 | 1.3 | .052 |
| 7.50 | .295 | 38.8 | 1.528 | 5 | 8 | 860.1-0750-038A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 89.7 | 3.532 | 53 | 2.087 | 1.3 | .051 |
| 7.70 | .303 | 24.5 | .965 | 3 | 8 | 860.1-0770-024A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.4 | .055 |
| 7.80 | .307 | 24.8 | .976 | 3 | 8 | 860.1-0780-024A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 77.7 | 3.059 | 41 | 1.614 | 1.4 | .056 |
| 8.00 | .315 | 25.5 | 1.004 | 3 | 8 | 860.1-0800-025A0-GM | ★ | ☆ | ★ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 89.6 | 3.528 | 41 | 1.614 | 1.5 | .057 |
| 8.00 | .315 | 38.4 | 1.512 | 5 | 8 | 860.1-0800-038A0-GM | ★ | | ★ | ☆ | ☆ | 8.0 | .315 | 91 | 3.583 | 77.6 | 3.055 | 53 | 2.087 | 1.4 | .055 |
| 8.10 | .319 | 25.8 | 1.016 | 3 | 10 | 860.1-0810-025A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 118.6 | 4.669 | 47 | 1.850 | 1.5 | .058 |
| 8.20 | .323 | 26.1 | 1.028 | 3 | 10 | 860.1-0820-026A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.6 | 3.449 | 47 | 1.850 | 1.5 | .059 |
| 8.30 | .327 | 26.4 | 1.039 | 3 | 10 | 860.1-0830-026A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.6 | 3.449 | 47 | 1.850 | 1.5 | .059 |
| 8.30 | .327 | 43.0 | 1.693 | 5 | 10 | 860.1-0830-043A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 101.6 | 4.000 | 61 | 2.402 | 1.4 | .055 |
| 8.40 | .331 | 26.7 | 1.051 | 3 | 10 | 860.1-0840-026A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.6 | 3.449 | 47 | 1.850 | 1.5 | .060 |
| 8.50 | .335 | 27.0 | 1.063 | 3 | 10 | 860.1-0850-027A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.5 | .061 |
| 8.50 | .335 | 44.0 | 1.732 | 5 | 10 | 860.1-0850-044A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 101.5 | 3.996 | 61 | 2.402 | 1.5 | .061 |
| 8.60 | .339 | 27.4 | 1.079 | 3 | 10 | 860.1-0860-027A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 101.5 | 3.996 | 47 | 1.850 | 1.6 | .062 |
| 8.60 | .339 | 44.6 | 1.756 | 5 | 10 | 860.1-0860-044A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 87.5 | 3.445 | 61 | 2.402 | 1.6 | .062 |
| 8.70 | .343 | 27.7 | 1.091 | 3 | 10 | 860.1-0870-027A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 118.5 | 4.665 | 47 | 1.850 | 1.6 | .062 |
| 8.70 | .343 | 45.0 | 1.772 | 5 | 10 | 860.1-0870-044A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 87.5 | 3.445 | 61 | 2.402 | 1.6 | .062 |
| 8.80 | .346 | 28.0 | 1.102 | 3 | 10 | 860.1-0880-028A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 101.5 | 3.996 | 47 | 1.850 | 1.6 | .063 |
| 8.80 | .346 | 44.9 | 1.768 | 5 | 10 | 860.1-0880-044A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 87.5 | 3.445 | 61 | 2.402 | 1.6 | .063 |
| 9.00 | .354 | 28.6 | 1.126 | 3 | 10 | 860.1-0900-028A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.5 | 3.445 | 47 | 1.850 | 1.6 | .064 |
| 9.00 | .354 | 44.7 | 1.760 | 5 | 10 | 860.1-0900-044A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 101.5 | 3.996 | 61 | 2.402 | 1.6 | .064 |
| 9.30 | .366 | 29.6 | 1.165 | 3 | 10 | 860.1-0930-029A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.4 | 3.441 | 47 | 1.850 | 1.7 | .067 |
| 9.50 | .374 | 30.2 | 1.189 | 3 | 10 | 860.1-0950-030A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 101.4 | 3.992 | 47 | 1.850 | 1.7 | .068 |
| 9.50 | .374 | 44.3 | 1.744 | 5 | 10 | 860.1-0950-044A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 87.4 | 3.441 | 61 | 2.402 | 1.7 | .068 |
| 9.80 | .386 | 30.0 | 1.181 | 3 | 10 | 860.1-0980-030A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.3 | 3.437 | 47 | 1.850 | 1.8 | .070 |
| 10.00 | .394 | 29.9 | 1.177 | 3 | 10 | 860.1-1000-029A0-GM | ★ | ☆ | ★ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.3 | 3.437 | 47 | 1.850 | 1.8 | .072 |
| 10.00 | .394 | 43.9 | 1.728 | 5 | 10 | 860.1-1000-043A0-GM | ★ | | ★ | ☆ | ☆ | 10.0 | .394 | 103 | 4.055 | 101.3 | 3.988 | 61 | 2.402 | 1.8 | .072 |
| 10.20 | .402 | 32.5 | 1.280 | 3 | 12 | 860.1-1020-032A0-GM | ★ | ☆ | ★ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 116.3 | 4.579 | 55 | 2.165 | 1.9 | .073 |
| 10.20 | .402 | 52.9 | 2.083 | 5 | 12 | 860.1-1020-052A0-GM | ★ | | ★ | ☆ | ☆ | 12.0 | .472 | 118 | 4.646 | 100.3 | 3.949 | 71 | 2.795 | 1.9 | .073 |
| 10.30 | .406 | 52.9 | 2.083 | 5 | 12 | 860.1-1030-052A0-GM | ★ | | ★ | ☆ | ☆ | 12.0 | .472 | 118 | 4.646 | 100.2 | 3.945 | 71 | 2.795 | 1.9 | .074 |
| 10.40 | .409 | 33.1 | 1.303 | 3 | 12 | 860.1-1040-033A0-GM | ★ | ☆ | ★ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 116.2 | 4.575 | 55 | 2.165 | 1.9 | .075 |
| 10.40 | .409 | 52.8 | 2.079 | 5 | 12 | 860.1-1040-052A0-GM | ★ | | ★ | ☆ | ☆ | 12.0 | .472 | 118 | 4.646 | 100.2 | 3.945 | 71 | 2.795 | 1.9 | .075 |
| 10.50 | .413 | 33.4 | 1.315 | 3 | 12 | 860.1-1050-033A0-GM | ★ | ☆ | ★ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.2 | 3.945 | 55 | 2.165 | 1.9 | .075 |
| 10.50 | .413 | 52.7 | 2.075 | 5 | 12 | 860.1-1050-052A0-GM | ★ | | ★ | ☆ | ☆ | 12.0 | .472 | 118 | 4.646 | 116.2 | 4.575 | 71 | 2.795 | 1.9 | .075 |
| 10.80 | .425 | 52.5 | 2.067 | 5 | 12 | 860.1-1080-052A0-GM | ★ | | ★ | ☆ | ☆ | 12.0 | .472 | 118 | 4.646 | 116.1 | 4.571 | 71 | 2.795 | 2.0 | .077 |
| 11.00 | .433 | 35.0 | 1.378 | 3 | 12 | 860.1-1100-035A0-GM | ★ | ☆ | ★ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 116.1 | 4.571 | 55 | 2.165 | 2.0 | .079 |
| 11.00 | .433 | 52.3 | 2.059 | 5 | 12 | 860.1-1100-052A0-GM | ★ | | ★ | ☆ | ☆ | 12.0 | .472 | 118 | 4.646 | 149.1 | 5.870 | 71 | 2.795 | 2.0 | .079 |
| 12.00 | .472 | 35.6 | 1.402 | 3 | 12 | 860.1-1200-035A0-GM | ★ | ☆ | ★ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 99.9 | 3.933 | 55 | 2.165 | 2.2 | .086 |
| 12.00 | .472 | 51.6 | 2.032 | 5 | 12 | 860.1-1200-051A0-GM | ★ | | ★ | ☆ | ☆ | 12.0 | .472 | 118 | 4.646 | 115.9 | 4.563 | 71 | 2.795 | 2.2 | .086 |
| 12.50 | .492 | 39.4 | 1.551 | 3 | 14 | 860.1-1250-039A0-GM | ★ | ☆ | ★ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.9 | 4.130 | 60 | 2.362 | 2.3 | .090 |
| 12.60 | .496 | 39.3 | 1.547 | 3 | 14 | 860.1-1260-039A0-GM | ★ | ☆ | ★ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.8 | 4.126 | 60 | 2.362 | 2.3 | .090 |
| 13.00 | .512 | 39.0 | 1.535 | 3 | 14 | 860.1-1300-038A0-GM | ★ | ☆ | ★ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 104.8 | 4.126 | 60 | 2.362 | 2.4 | .093 |
| 14.00 | .551 | 38.2 | 1.504 | 3 | 14 | 860.1-1400-038A0-GM | ★ | ☆ | ★ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 121.6 | 4.787 | 60 | 2.362 | 2.5 | .100 |
| 14.00 | .551 | 55.2 | 2.173 | 3 | 14 | 860.1-1400-055A0-GM | ★ | | ★ | ☆ | ☆ | 14.0 | .551 | 124 | 4.882 | 104.6 | 4.118 | 77 | 3.032 | 2.5 | .100 |

C30 G2 G5 G6



SANDVIK Coromant

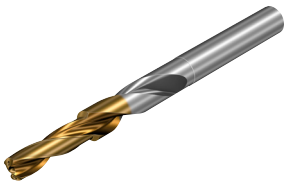
ITA

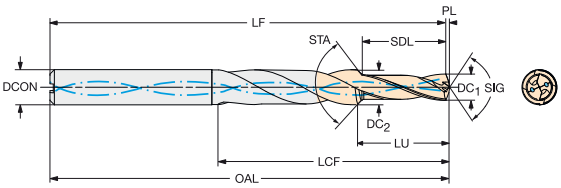
# CoroDrill® 860, punta in metallo duro integrale

**Per componenti multimateriale**

**Adduzione interna di refrigerante**

TCHA H9
SIG 140°






## Punta per smussi e gradini

Dimensioni in mm e pollici

| DC1 | DC1" | DC2 | DC2" | SDL | SDL" | STA | LU | LU" | CZCMS | Codice di ordinazione | P X1BM | M X1BM | K X1BM | N X1BM | S X1BM | H X1BM | DCONMS | DCONMS" | OAL | OAL" | LF | LF" | LCF | LCF" | PL | PL" |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3.35 | .132 | 4.50 | .177 | 10.10 | .398 | 90° | 11.3 | .445 | 6 | 860.2-0335-011A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 61.4 | 2.417 | 19 | .748 | 0.6 | .024 |
| 3.40 | .134 | 4.60 | .181 | 10.20 | .402 | 90° | 11.4 | .449 | 6 | 860.2-0340-011A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.4 | 2.575 | 19 | .748 | 0.6 | .024 |
| 4.25 | .167 | 5.70 | .224 | 12.80 | .504 | 90° | 14.3 | .563 | 6 | 860.2-0425-014A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 23 | .906 | 0.7 | .028 |
| 4.30 | .169 | 5.80 | .228 | 13.00 | .512 | 90° | 14.5 | .571 | 6 | 860.2-0430-014A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.3 | 2.571 | 23 | .906 | 0.7 | .028 |
| 4.65 | .183 | 5.90 | .232 | 14.00 | .551 | 90° | 15.5 | .610 | 6 | 860.2-0465-015A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 6.0 | .236 | 66 | 2.598 | 65.2 | 2.567 | 23 | .906 | 0.8 | .031 |
| 5.00 | .197 | 6.80 | .268 | 15.00 | .591 | 90° | 16.8 | .661 | 8 | 860.2-0500-016A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 78.2 | 3.079 | 28 | 1.102 | 0.8 | .031 |
| 5.10 | .201 | 6.90 | .272 | 15.30 | .602 | 90° | 17.1 | .673 | 8 | 860.2-0510-017A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 78.1 | 3.075 | 28 | 1.102 | 0.9 | .035 |
| 5.50 | .217 | 7.40 | .291 | 16.60 | .654 | 90° | 18.6 | .732 | 8 | 860.2-0550-018A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 78.1 | 3.075 | 28 | 1.102 | 0.9 | .035 |
| 5.55 | .219 | 7.50 | .295 | 16.70 | .657 | 90° | 18.7 | .736 | 8 | 860.2-0555-018A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 8.0 | .315 | 79 | 3.110 | 78.1 | 3.075 | 28 | 1.102 | 0.9 | .035 |
| 6.60 | .260 | 8.90 | .350 | 19.90 | .783 | 90° | 22.3 | .878 | 10 | 860.2-0660-022A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.9 | 3.461 | 37 | 1.457 | 1.1 | .043 |
| 6.75 | .266 | 9.10 | .358 | 20.30 | .799 | 90° | 22.7 | .894 | 10 | 860.2-0675-022A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.8 | 3.457 | 37 | 1.457 | 1.2 | .047 |
| 6.85 | .270 | 9.20 | .362 | 20.60 | .811 | 90° | 23.0 | .906 | 10 | 860.2-0685-023A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.8 | 3.457 | 37 | 1.457 | 1.2 | .047 |
| 6.90 | .272 | 9.30 | .366 | 20.70 | .815 | 90° | 23.2 | .913 | 10 | 860.2-0690-023A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.8 | 3.457 | 37 | 1.457 | 1.2 | .047 |
| 7.00 | .276 | 9.50 | .374 | 21.10 | .831 | 90° | 23.6 | .929 | 10 | 860.2-0700-023A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.8 | 3.457 | 37 | 1.457 | 1.2 | .047 |
| 7.40 | .291 | 9.80 | .386 | 22.20 | .874 | 90° | 24.7 | .972 | 10 | 860.2-0740-024A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 10.0 | .394 | 89 | 3.504 | 87.7 | 3.453 | 37 | 1.457 | 1.3 | .051 |
| 8.00 | .315 | 10.80 | .425 | 24.00 | .945 | 90° | 26.9 | 1.059 | 12 | 860.2-0800-026A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.6 | 3.961 | 42 | 1.654 | 1.4 | .055 |
| 8.50 | .335 | 11.50 | .453 | 25.50 | 1.004 | 90° | 28.5 | 1.122 | 12 | 860.2-0850-028A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.5 | 3.957 | 42 | 1.654 | 1.5 | .059 |
| 8.60 | .339 | 11.60 | .457 | 25.80 | 1.016 | 90° | 28.9 | 1.138 | 12 | 860.2-0860-028A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.5 | 3.957 | 42 | 1.654 | 1.5 | .059 |
| 8.70 | .343 | 11.70 | .461 | 26.10 | 1.028 | 90° | 29.2 | 1.150 | 12 | 860.2-0870-029A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.5 | 3.957 | 42 | 1.654 | 1.5 | .059 |
| 9.00 | .354 | 11.80 | .465 | 27.00 | 1.063 | 90° | 30.0 | 1.181 | 12 | 860.2-0900-030A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 12.0 | .472 | 102 | 4.016 | 100.5 | 3.957 | 42 | 1.654 | 1.5 | .059 |
| 10.25 | .404 | 13.80 | .543 | 30.80 | 1.213 | 90° | 34.4 | 1.354 | 14 | 860.2-1025-034A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 105.2 | 4.142 | 52 | 2.047 | 1.8 | .071 |
| 10.30 | .406 | 13.80 | .543 | 31.00 | 1.220 | 90° | 34.6 | 1.362 | 14 | 860.2-1030-034A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 105.2 | 4.142 | 52 | 2.047 | 1.8 | .071 |
| 10.40 | .409 | 13.80 | .543 | 31.20 | 1.228 | 90° | 34.8 | 1.370 | 14 | 860.2-1040-034A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 105.2 | 4.142 | 52 | 2.047 | 1.8 | .071 |
| 10.50 | .413 | 13.80 | .543 | 31.60 | 1.244 | 90° | 35.2 | 1.386 | 14 | 860.2-1050-035A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 14.0 | .551 | 107 | 4.213 | 105.2 | 4.142 | 52 | 2.047 | 1.8 | .071 |
| 12.00 | .472 | 15.80 | .622 | 36.00 | 1.417 | 90° | 40.1 | 1.579 | 16 | 860.2-1200-040A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 16.0 | .630 | 115 | 4.528 | 112.9 | 4.445 | 59 | 2.323 | 2.1 | .083 |
| 14.00 | .551 | 18.90 | .744 | 42.10 | 1.657 | 90° | 47.1 | 1.854 | 20 | 860.2-1400-047A1-GM | ★ | ☆ | ★ | ☆ | ☆ | ★ | 20.0 | .787 | 131 | 5.157 | 128.6 | 5.063 | 78 | 3.071 | 2.4 | .094 |

C30 G2 G5 G6

# CoroDrill® DS20

**4-5xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD Min. | Consigliata | Max. | Diametro punta | Lunghezza della punta 4xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza della punta 5xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| P | | | | | | | | | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro |
| | P1.0.Z.AN | Acciaio non legato C=0.05-0.10% | 110 | 4324 | 230 | 340 | 400 | 15.00-18.00 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | 0.04-0.1 | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | 0.04-0.09 |
| | | | | 4334 | 210 | 285 | 325 | 18.01-22.00 | 0.04-0.09 | **0.04-0.09** | 0.04-0.09 | - | 0.04-0.11 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | 0.04-0.1 |
| | | | | 4344 | 190 | 225 | 245 | 22.01-27.00 | 0.04-0.1 | **0.04-0.1** | 0.04-0.1 | - | 0.04-0.12 | 0.04-0.09 | **0.04-0.09** | 0.04-0.09 | - | 0.04-0.11 |
| | | | | | | | | 27.01-33.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.13 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.12 |
| | | | | | | | | 33.01-40.00 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.16 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.14 |
| | | | | | | | | 40.01-52.00 | 0.06-0.12 | **0.06-0.12** | 0.06-0.12 | - | 0.06-0.16 | 0.06-0.11 | **0.06-0.11** | 0.06-0.11 | - | 0.06-0.14 |
| | | | | | | | | 52.01-65.00 | 0.06-0.12 | **0.06-0.12** | 0.06-0.12 | - | 0.06-0.16 | 0.06-0.11 | **0.06-0.11** | 0.06-0.11 | - | 0.06-0.14 |
| | P1.1.Z.AN | Acciaio non legato C=0.05-0.25% | 125 | 4324 | 230 | 320 | 370 | 15.00-18.00 | 0.04-0.1 | **0.04-0.1** | 0.04-0.1 | - | 0.04-0.1 | 0.04-0.09 | **0.04-0.09** | 0.04-0.09 | - | 0.04-0.09 |
| | | | | 4334 | 200 | 270 | 305 | 18.01-22.00 | 0.04-0.11 | **0.04-0.11** | 0.04-0.11 | - | 0.04-0.11 | 0.04-0.1 | **0.04-0.1** | 0.04-0.1 | - | 0.04-0.1 |
| | | | | 4344 | 170 | 210 | 235 | 22.01-27.00 | 0.04-0.12 | **0.04-0.12** | 0.04-0.12 | - | 0.04-0.12 | 0.04-0.11 | **0.04-0.11** | 0.04-0.11 | - | 0.04-0.11 |
| | | | | | | | | 27.01-33.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.13 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.12 |
| | | | | | | | | 33.01-40.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.16 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.14 |
| | | | | | | | | 40.01-52.00 | 0.06-0.14 | **0.06-0.14** | 0.06-0.14 | - | 0.06-0.16 | 0.06-0.13 | **0.06-0.13** | 0.06-0.13 | - | 0.06-0.14 |
| | | | | | | | | 52.01-65.00 | 0.06-0.14 | **0.06-0.14** | 0.06-0.14 | - | 0.06-0.16 | 0.06-0.13 | **0.06-0.13** | 0.06-0.13 | - | 0.06-0.14 |
| | P1.2.Z.AN | Acciaio non legato C=0.25-0.55% | 190 | 4324 | 190 | 265 | 305 | 15.00-18.00 | - | 0.05-0.12 | 0.06-0.14 | **0.06-0.16** | - | - | 0.05-0.1 | 0.06-0.12 | **0.06-0.14** | - |
| | | | | 4334 | 155 | 215 | 250 | 18.01-22.00 | - | 0.05-0.14 | 0.06-0.16 | **0.06-0.18** | - | - | 0.05-0.12 | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4344 | 120 | 165 | 190 | 22.01-27.00 | - | 0.05-0.18 | 0.06-0.2 | **0.06-0.22** | - | - | 0.05-0.15 | 0.06-0.17 | **0.06-0.19** | - |
| | | | | | | | | 27.01-33.00 | - | 0.07-0.22 | 0.08-0.24 | **0.08-0.26** | - | - | 0.07-0.19 | 0.08-0.2 | **0.08-0.22** | - |
| | | | | | | | | 33.01-40.00 | - | 0.07-0.24 | 0.08-0.26 | **0.08-0.28** | - | - | 0.07-0.2 | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 40.01-52.00 | - | 0.09-0.24 | 0.1-0.26 | **0.1-0.28** | - | - | 0.09-0.2 | 0.1-0.22 | **0.1-0.24** | - |
| | | | | | | | | 52.01-65.00 | - | 0.09-0.24 | 0.1-0.26 | **0.1-0.28** | - | - | 0.09-0.2 | 0.1-0.22 | **0.1-0.24** | - |
| | P1.3.Z.AN | Acciaio non legato C=0.55-0.80% | 190 | 4324 | 170 | 250 | 290 | 15.00-18.00 | - | 0.05-0.12 | 0.06-0.14 | **0.06-0.16** | - | - | 0.05-0.1 | 0.06-0.12 | **0.06-0.14** | - |
| | | | | 4334 | 140 | 205 | 240 | 18.01-22.00 | - | 0.05-0.14 | 0.06-0.16 | **0.06-0.18** | - | - | 0.05-0.12 | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4344 | 105 | 155 | 185 | 22.01-27.00 | - | 0.05-0.18 | 0.06-0.2 | **0.06-0.22** | - | - | 0.05-0.15 | 0.06-0.17 | **0.06-0.19** | - |
| | | | | | | | | 27.01-33.00 | - | 0.07-0.22 | 0.08-0.24 | **0.08-0.26** | - | - | 0.07-0.19 | 0.08-0.2 | **0.08-0.22** | - |
| | | | | | | | | 33.01-40.00 | - | 0.07-0.24 | 0.08-0.26 | **0.08-0.28** | - | - | 0.07-0.2 | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 40.01-52.00 | - | 0.09-0.24 | 0.1-0.26 | **0.1-0.28** | - | - | 0.09-0.2 | 0.1-0.22 | **0.1-0.24** | - |
| | | | | | | | | 52.01-65.00 | - | 0.09-0.24 | 0.1-0.26 | **0.1-0.28** | - | - | 0.09-0.2 | 0.1-0.22 | **0.1-0.24** | - |
| | P1.5.C.UT | Acciaio non legato Fuso - non trattato | 150 | 4324 | 140 | 260 | 325 | 15.00-18.00 | - | 0.04-0.12 | 0.04-0.12 | **0.04-0.12** | - | - | 0.04-0.1 | 0.04-0.1 | **0.04-0.1** | - |
| | | | | 4334 | 135 | 220 | 265 | 18.01-22.00 | - | 0.04-0.13 | 0.04-0.13 | **0.04-0.13** | - | - | 0.04-0.11 | 0.04-0.11 | **0.04-0.11** | - |
| | | | | 4344 | 125 | 175 | 200 | 22.01-27.00 | - | 0.04-0.14 | 0.04-0.14 | **0.04-0.14** | - | - | 0.04-0.12 | 0.04-0.12 | **0.04-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | 0.05-0.15 | 0.05-0.15 | **0.05-0.15** | - | - | 0.05-0.13 | 0.05-0.13 | **0.05-0.13** | - |
| | | | | | | | | 33.01-40.00 | - | 0.05-0.16 | 0.05-0.16 | **0.05-0.16** | - | - | 0.05-0.14 | 0.05-0.14 | **0.05-0.14** | - |
| | | | | | | | | 40.01-52.00 | - | 0.06-0.16 | 0.06-0.16 | **0.06-0.16** | - | - | 0.06-0.14 | 0.06-0.14 | **0.06-0.14** | - |
| | | | | | | | | 52.01-65.00 | - | 0.06-0.16 | 0.06-0.16 | **0.06-0.16** | - | - | 0.06-0.14 | 0.06-0.14 | **0.06-0.14** | - |
| | P2.1.Z.AN | Acciaio debolmente legato Ricotto | 175 | 4324 | 180 | 260 | 305 | 15.00-18.00 | - | - | 0.06-0.14 | **0.06-0.16** | - | - | - | 0.06-0.12 | **0.06-0.14** | - |
| | | | | 4334 | 150 | 215 | 250 | 18.01-22.00 | - | - | 0.06-0.16 | **0.06-0.18** | - | - | - | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4344 | 115 | 165 | 190 | 22.01-27.00 | - | - | 0.06-0.2 | **0.06-0.22** | - | - | - | 0.06-0.17 | **0.06-0.19** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | **0.08-0.26** | - | - | - | 0.08-0.2 | **0.08-0.22** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | **0.08-0.28** | - | - | - | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | P2.2.Z.AN | Acciaio debolmente legato Ricotto | 240 | 4324 | 180 | 250 | 290 | 15.00-18.00 | - | - | 0.06-0.14 | **0.06-0.16** | - | - | - | 0.06-0.12 | **0.06-0.14** | - |
| | | | | 4334 | 150 | 200 | 225 | 18.01-22.00 | - | - | 0.06-0.16 | **0.06-0.18** | - | - | - | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4344 | 115 | 175 | 205 | 22.01-27.00 | - | - | 0.06-0.2 | **0.06-0.22** | - | - | - | 0.06-0.17 | **0.06-0.19** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | **0.08-0.26** | - | - | - | 0.08-0.2 | **0.08-0.22** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | **0.08-0.28** | - | - | - | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | P2.5.Z.HT | Acciaio debolmente legato Temprato | 330 | 4324 | 90 | 190 | 245 | 15.00-18.00 | - | - | 0.06-0.14 | **0.06-0.16** | - | - | - | 0.06-0.12 | **0.06-0.14** | - |
| | | | | 4334 | 85 | 155 | 195 | 18.01-22.00 | - | - | 0.06-0.16 | **0.06-0.18** | - | - | - | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4344 | 75 | 125 | 150 | 22.01-27.00 | - | - | 0.06-0.2 | **0.06-0.22** | - | - | - | 0.06-0.17 | **0.06-0.19** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | **0.08-0.26** | - | - | - | 0.08-0.2 | **0.08-0.22** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | **0.08-0.28** | - | - | - | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | P2.6.C.UT | Acciaio debolmente legato Fuso - non trattato | 200 | 4324 | 110 | 210 | 265 | 15.00-18.00 | - | - | 0.06-0.16 | **0.06-0.18** | - | - | - | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4334 | 105 | 175 | 210 | 18.01-22.00 | - | - | 0.06-0.18 | **0.06-0.2** | - | - | - | 0.06-0.15 | **0.06-0.17** | - |
| | | | | 4344 | 100 | 140 | 160 | 22.01-27.00 | - | - | 0.06-0.22 | **0.06-0.24** | - | - | - | 0.06-0.19 | **0.06-0.2** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.26 | **0.08-0.28** | - | - | - | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.28 | **0.08-0.3** | - | - | - | 0.08-0.24 | **0.08-0.26** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.28 | **0.1-0.3** | - | - | - | 0.1-0.24 | **0.1-0.26** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.28 | **0.1-0.3** | - | - | - | 0.1-0.24 | **0.1-0.26** | - |
| | P3.0.Z.AN | Acciaio fortemente legato Ricotto | 200 | 4324 | 160 | 245 | 290 | 15.00-18.00 | - | - | 0.06-0.14 | **0.06-0.16** | - | - | - | 0.06-0.12 | **0.06-0.14** | - |
| | | | | 4334 | 130 | 200 | 240 | 18.01-22.00 | - | - | 0.06-0.16 | **0.06-0.18** | - | - | - | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4344 | 100 | 150 | 180 | 22.01-27.00 | - | - | 0.06-0.2 | **0.06-0.22** | - | - | - | 0.06-0.17 | **0.06-0.19** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | **0.08-0.26** | - | - | - | 0.08-0.2 | **0.08-0.22** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | **0.08-0.28** | - | - | - | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |



SANDVIK Coromant

ITA

# CoroDrill® DS20

**4-5xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD | | | Diametro punta | Lunghezza della punta 4xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza della punta 5xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| P | P3.0.Z.HT | Acciaio fortemente legato Temprato | 380 | 4324 | 80 | 165 | 210 | 15.00-18.00 | - | - | 0.06-0.14 | **0.06-0.16** | - | - | - | 0.06-0.12 | **0.06-0.14** | - |
| | | | | 4334 | 75 | 140 | 175 | 18.01-22.00 | - | - | 0.06-0.16 | **0.06-0.18** | - | - | - | 0.06-0.14 | **0.06-0.15** | - |
| | | | | 4344 | 70 | 110 | 130 | 22.01-27.00 | - | - | 0.06-0.2 | **0.06-0.22** | - | - | - | 0.06-0.17 | **0.06-0.19** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | **0.08-0.26** | - | - | - | 0.08-0.2 | **0.08-0.22** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | **0.08-0.28** | - | - | - | 0.08-0.22 | **0.08-0.24** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.26 | **0.1-0.28** | - | - | - | 0.1-0.22 | **0.1-0.24** | - |
| | P5.0.Z.AN | Acciaio inossidabile ferritico/martensitico Ricotto | 200 | 4334 | 115 | 185 | 225 | 15.00-18.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 |
| | | | | 4344 | 115 | 155 | 175 | 18.01-22.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 |
| | | | | 2044 | 115 | 150 | 165 | 22.01-27.00 | 0.05-0.15 | **0.05-0.15** | 0.05-0.15 | - | 0.05-0.14 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 |
| | | | | | | | | 27.01-33.00 | 0.07-0.16 | **0.07-0.16** | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.13 |
| | | | | | | | | 33.01-40.00 | 0.07-0.18 | **0.07-0.18** | 0.07-0.18 | - | 0.07-0.16 | 0.07-0.15 | **0.07-0.15** | 0.07-0.15 | - | 0.07-0.14 |
| | | | | | | | | 40.01-52.00 | 0.09-0.18 | **0.09-0.18** | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | **0.09-0.15** | 0.09-0.15 | - | 0.09-0.14 |
| | | | | | | | | 52.01-65.00 | 0.09-0.18 | **0.09-0.18** | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | **0.09-0.15** | 0.09-0.15 | - | 0.09-0.14 |
| | P5.0.Z.HT | Acciaio inossidabile ferritico/martensitico Temprato | 330 | 4334 | 75 | 135 | 170 | 15.00-18.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 |
| | | | | 4344 | 70 | 115 | 140 | 18.01-22.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 |
| | | | | 2044 | 70 | 115 | 140 | 22.01-27.00 | 0.05-0.15 | **0.05-0.15** | 0.05-0.15 | - | 0.05-0.14 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 |
| | | | | | | | | 27.01-33.00 | 0.07-0.16 | **0.07-0.16** | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.13 |
| | | | | | | | | 33.01-40.00 | 0.07-0.18 | **0.07-0.18** | 0.07-0.18 | - | 0.07-0.16 | 0.07-0.15 | **0.07-0.15** | 0.07-0.15 | - | 0.07-0.14 |
| | | | | | | | | 40.01-52.00 | 0.09-0.18 | **0.09-0.18** | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | **0.09-0.15** | 0.09-0.15 | - | 0.09-0.14 |
| | | | | | | | | 52.01-65.00 | 0.09-0.18 | **0.09-0.18** | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | **0.09-0.15** | 0.09-0.15 | - | 0.09-0.14 |
| M | M1.0.Z.AQ | Acciaio inossidabile austenitico Ricotto/bonificato | 200 | 4334 | 115 | 185 | 225 | 15.00-18.00 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 |
| | | | | 4344 | 115 | 165 | 190 | 18.01-22.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 |
| | | | | 2044 | 115 | 155 | 180 | 22.01-27.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 |
| | | | | | | | | 27.01-33.00 | 0.07-0.15 | **0.07-0.15** | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.13 |
| | | | | | | | | 33.01-40.00 | 0.07-0.16 | **0.07-0.16** | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.14 |
| | | | | | | | | 40.01-52.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | | | | | | | | 52.01-65.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | M1.1.Z.AQ | Acciaio inossidabile austenitico A lavorabilità migliorata | 200 | 4334 | 115 | 195 | 240 | 15.00-18.00 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 |
| | | | | 4344 | 115 | 175 | 210 | 18.01-22.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 |
| | | | | 2044 | 115 | 170 | 200 | 22.01-27.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 |
| | | | | | | | | 27.01-33.00 | 0.07-0.15 | **0.07-0.15** | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.13 |
| | | | | | | | | 33.01-40.00 | 0.07-0.16 | **0.07-0.16** | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.14 |
| | | | | | | | | 40.01-52.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | | | | | | | | 52.01-65.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | M2.0.Z.AQ | Acciaio inossidabile superaustenitico Ricotto/bonificato | 200 | 4334 | 80 | 125 | 150 | 15.00-18.00 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 |
| | | | | 4344 | 80 | 110 | 125 | 18.01-22.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 |
| | | | | 2044 | 80 | 110 | 125 | 22.01-27.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 |
| | | | | | | | | 27.01-33.00 | 0.07-0.15 | **0.07-0.15** | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.13 |
| | | | | | | | | 33.01-40.00 | 0.07-0.16 | **0.07-0.16** | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.14 |
| | | | | | | | | 40.01-52.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | | | | | | | | 52.01-65.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | M3.1.Z.AQ | Acciaio inossidabile duplex >60% ferrite (N<0.10%) | 230 | 4334 | 85 | 125 | 145 | 15.00-18.00 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 |
| | | | | 4344 | 85 | 115 | 130 | 18.01-22.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 |
| | | | | 2044 | 85 | 110 | 125 | 22.01-27.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 |
| | | | | | | | | 27.01-33.00 | 0.07-0.15 | **0.07-0.15** | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.13 |
| | | | | | | | | 33.01-40.00 | 0.07-0.16 | **0.07-0.16** | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.14 |
| | | | | | | | | 40.01-52.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | | | | | | | | 52.01-65.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | M3.2.Z.AQ | Acciaio inossidabile duplex <Ferrite al 60% (N>0.10%) | 260 | 4334 | 75 | 105 | 120 | 15.00-18.00 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 |
| | | | | 4344 | 75 | 100 | 115 | 18.01-22.00 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | 0.05-0.11 |
| | | | | 2044 | 75 | 100 | 115 | 22.01-27.00 | 0.05-0.14 | **0.05-0.14** | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | **0.05-0.13** | 0.05-0.13 | - | 0.05-0.12 |
| | | | | | | | | 27.01-33.00 | 0.07-0.15 | **0.07-0.15** | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.13 |
| | | | | | | | | 33.01-40.00 | 0.07-0.16 | **0.07-0.16** | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | **0.07-0.14** | 0.07-0.14 | - | 0.07-0.14 |
| | | | | | | | | 40.01-52.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| | | | | | | | | 52.01-65.00 | 0.09-0.16 | **0.09-0.16** | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | **0.09-0.14** | 0.09-0.14 | - | 0.09-0.14 |
| S | S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS | Superleghe resistenti al calore Base Ni | 350 | 4334 | 20 | 40 | 50 | 15.00-18.00 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | - | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | - |
| | | | | 4344 | 20 | 40 | 50 | 18.01-22.00 | 0.04-0.09 | **0.04-0.09** | 0.04-0.09 | - | - | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | - |
| | | | | 2044 | 20 | 40 | 50 | 22.01-27.00 | 0.04-0.1 | **0.04-0.1** | 0.04-0.1 | - | - | 0.04-0.09 | **0.04-0.09** | 0.04-0.09 | - | - |
| | | | | | | | | 27.01-33.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | - | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | - |
| | | | | | | | | 33.01-40.00 | 0.05-0.12 | **0.05-0.12** | 0.05-0.12 | - | - | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | - |
| | | | | | | | | 40.01-52.00 | 0.06-0.12 | **0.06-0.12** | 0.06-0.12 | - | - | 0.06-0.11 | **0.06-0.11** | 0.06-0.11 | - | - |
| | | | | | | | | 52.01-65.00 | 0.06-0.12 | **0.06-0.12** | 0.06-0.12 | - | - | 0.06-0.11 | **0.06-0.11** | 0.06-0.11 | - | - |
| | S4.2.Z.AN S4.3.Z.AG | Superleghe resistenti al calore Base Ti | 330 | H13A | 40 | 90 | 120 | 15.00-18.00 | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - |
| | | | | 4344 | 40 | 90 | 120 | 18.01-22.00 | **0.06-0.15** | 0.06-0.15 | 0.06-0.15 | - | - | **0.06-0.13** | 0.06-0.13 | 0.06-0.13 | - | - |
| | | | | 2044 | 40 | 90 | 120 | 22.01-27.00 | **0.06-0.16** | 0.06-0.16 | 0.06-0.16 | - | - | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.17** | 0.08-0.17 | 0.08-0.17 | - | - | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.18** | 0.08-0.18 | 0.08-0.18 | - | - | **0.08-0.15** | 0.08-0.15 | 0.08-0.15 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.18** | 0.1-0.18 | 0.1-0.18 | - | - | **0.1-0.15** | 0.1-0.15 | 0.1-0.15 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.18** | 0.1-0.18 | 0.1-0.18 | - | - | **0.1-0.15** | 0.1-0.15 | 0.1-0.15 | - | - |

# CoroDrill® DS20

**4-5xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD | | | Diametro punta | Lunghezza della punta 4xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza della punta 5xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| K | K1.1.C.NS | Ghisa malleabile Bassa resistenza | 200 | 4324 | 140 | 210 | 245 | 15.00-18.00 | - | 0.08-0.15 | 0.08-0.15 | **0.08-0.2** | - | - | 0.08-0.13 | 0.08-0.13 | **0.08-0.17** | - |
| | | | | 4334 | 110 | 170 | 200 | 18.01-22.00 | - | 0.08-0.18 | 0.08-0.18 | **0.08-0.23** | - | - | 0.08-0.15 | 0.08-0.15 | **0.08-0.2** | - |
| | | | | 4344 | 180 | 165 | 155 | 22.01-27.00 | - | 0.08-0.21 | 0.08-0.21 | **0.08-0.26** | - | - | 0.08-0.18 | 0.08-0.18 | **0.08-0.22** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.24 | 0.1-0.24 | **0.1-0.29** | - | - | 0.1-0.2 | 0.1-0.2 | **0.1-0.25** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.27 | 0.1-0.27 | **0.1-0.32** | - | - | 0.1-0.23 | 0.1-0.23 | **0.1-0.27** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.27 | 0.12-0.27 | **0.12-0.32** | - | - | 0.12-0.23 | 0.12-0.23 | **0.12-0.27** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.27 | 0.12-0.27 | **0.12-0.32** | - | - | 0.12-0.23 | 0.12-0.23 | **0.12-0.27** | - |
| | K2.1.C.UT | Ghisa grigia Bassa resistenza | 180 | 4324 | 210 | 285 | 325 | 15.00-18.00 | - | 0.08-0.15 | 0.08-0.15 | **0.08-0.2** | - | - | 0.08-0.13 | 0.08-0.13 | **0.08-0.17** | - |
| | | | | 4334 | 170 | 235 | 270 | 18.01-22.00 | - | 0.08-0.18 | 0.08-0.18 | **0.08-0.23** | - | - | 0.08-0.15 | 0.08-0.15 | **0.08-0.2** | - |
| | | | | 4344 | 130 | 180 | 205 | 22.01-27.00 | - | 0.08-0.21 | 0.08-0.21 | **0.08-0.26** | - | - | 0.08-0.18 | 0.08-0.18 | **0.08-0.22** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.24 | 0.1-0.24 | **0.1-0.29** | - | - | 0.1-0.2 | 0.1-0.2 | **0.1-0.25** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.27 | 0.1-0.27 | **0.1-0.32** | - | - | 0.1-0.23 | 0.1-0.23 | **0.1-0.27** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.27 | 0.12-0.27 | **0.12-0.32** | - | - | 0.12-0.23 | 0.12-0.23 | **0.12-0.27** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.27 | 0.12-0.27 | **0.12-0.32** | - | - | 0.12-0.23 | 0.12-0.23 | **0.12-0.27** | - |
| | K2.2.C.UT | Ghisa grigia Alta resistenza | 245 | 4324 | 125 | 205 | 245 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | **0.08-0.18** | - | - | 0.08-0.11 | 0.08-0.11 | **0.08-0.15** | - |
| | | | | 4334 | 100 | 160 | 195 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.21** | - | - | 0.08-0.14 | 0.08-0.14 | **0.08-0.18** | - |
| | | | | 4344 | 75 | 125 | 150 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | **0.08-0.24** | - | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.2** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | **0.1-0.27** | - | - | 0.1-0.19 | 0.1-0.19 | **0.1-0.23** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | **0.1-0.3** | - | - | 0.1-0.21 | 0.1-0.21 | **0.1-0.26** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| | K3.1.C.UT | Ghisa nodulare Ferritica | 155 | 4324 | 125 | 190 | 225 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | **0.08-0.18** | - | - | 0.08-0.11 | 0.08-0.11 | **0.08-0.15** | - |
| | | | | 4334 | 100 | 155 | 185 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.21** | - | - | 0.08-0.14 | 0.08-0.14 | **0.08-0.18** | - |
| | | | | 4344 | 80 | 120 | 145 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | **0.08-0.24** | - | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.2** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | **0.1-0.27** | - | - | 0.1-0.19 | 0.1-0.19 | **0.1-0.23** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | **0.1-0.3** | - | - | 0.1-0.21 | 0.1-0.21 | **0.1-0.26** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| | K3.3.C.UT | Ghisa nodulare Perlitica | 265 | 4324 | 110 | 175 | 210 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | **0.08-0.18** | - | - | 0.08-0.11 | 0.08-0.11 | **0.08-0.15** | - |
| | | | | 4334 | 90 | 145 | 175 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.21** | - | - | 0.08-0.14 | 0.08-0.14 | **0.08-0.18** | - |
| | | | | 4344 | 70 | 110 | 130 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | **0.08-0.24** | - | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.2** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | **0.1-0.27** | - | - | 0.1-0.19 | 0.1-0.19 | **0.1-0.23** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | **0.1-0.3** | - | - | 0.1-0.21 | 0.1-0.21 | **0.1-0.26** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| | K4.2.C.UT | Ghisa a grafite compatta (CGI) Elevata resistenza alla trazione (Perlite>90%) | 230 | 4324 | 130 | 210 | 250 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | **0.08-0.18** | - | - | 0.08-0.11 | 0.08-0.11 | **0.08-0.15** | - |
| | | | | 4334 | 110 | 170 | 200 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.21** | - | - | 0.08-0.14 | 0.08-0.14 | **0.08-0.18** | - |
| | | | | 4344 | 85 | 125 | 150 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | **0.08-0.24** | - | - | 0.08-0.16 | 0.08-0.16 | **0.08-0.2** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | **0.1-0.27** | - | - | 0.1-0.19 | 0.1-0.19 | **0.1-0.23** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | **0.1-0.3** | - | - | 0.1-0.21 | 0.1-0.21 | **0.1-0.26** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | **0.12-0.3** | - | - | 0.12-0.21 | 0.12-0.21 | **0.12-0.26** | - |
| H | H1.3.Z.HA | Acciai extra duri Temprato | 60 (HRC) | 4324 | 30 | 65 | 85 | 15.00-18.00 | - | 0.06-0.13 | **0.06-0.13** | 0.06-0.13 | - | - | 0.06-0.11 | **0.06-0.11** | 0.06-0.11 | - |
| | | | | 4334 | 30 | 65 | 85 | 18.01-22.00 | - | 0.06-0.14 | **0.06-0.14** | 0.06-0.14 | - | - | 0.06-0.12 | **0.06-0.12** | 0.06-0.12 | - |
| | | | | 4344 | 30 | 65 | 85 | 22.01-27.00 | - | 0.06-0.15 | **0.06-0.15** | 0.06-0.15 | - | - | 0.06-0.13 | **0.06-0.13** | 0.06-0.13 | - |
| | | | | | | | | 27.01-33.00 | - | 0.08-0.16 | **0.08-0.16** | 0.08-0.16 | - | - | 0.08-0.14 | **0.08-0.14** | 0.08-0.14 | - |
| | | | | | | | | 33.01-40.00 | - | 0.08-0.18 | **0.08-0.18** | 0.08-0.18 | - | - | 0.08-0.15 | **0.08-0.15** | 0.08-0.15 | - |
| | | | | | | | | 40.01-52.00 | - | 0.1-0.18 | **0.1-0.18** | 0.1-0.18 | - | - | 0.1-0.15 | **0.1-0.15** | 0.1-0.15 | - |
| | | | | | | | | 52.01-65.00 | - | 0.1-0.18 | **0.1-0.18** | 0.1-0.18 | - | - | 0.1-0.15 | **0.1-0.15** | 0.1-0.15 | - |

ITA

# CoroDrill® DS20

**4-5xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD | | | Diametro punta | Lunghezza della punta 4xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza della punta 5xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| N | N1.2.Z.AG | Leghe a base di alluminio | 100 | H13A | 300 | 365 | 400 | 15.00-18.00 | **0.06-0.16** | 0.06-0.16 | 0.06-0.16 | - | - | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - |
| | | Leghe AlSi, Si ≤ 1% | | 4344 | 300 | 365 | 400 | 18.01-22.00 | **0.06-0.18** | 0.06-0.18 | 0.06-0.18 | - | - | **0.06-0.15** | 0.06-0.15 | 0.06-0.15 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.2** | 0.06-0.2 | 0.06-0.2 | - | - | **0.06-0.17** | 0.06-0.17 | 0.06-0.17 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.22** | 0.08-0.22 | 0.08-0.22 | - | - | **0.08-0.19** | 0.08-0.19 | 0.08-0.19 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.25** | 0.08-0.25 | 0.08-0.25 | - | - | **0.08-0.21** | 0.08-0.21 | 0.08-0.21 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.25** | 0.1-0.25 | 0.1-0.25 | - | - | **0.1-0.21** | 0.1-0.21 | 0.1-0.21 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.25** | 0.1-0.25 | 0.1-0.25 | - | - | **0.1-0.21** | 0.1-0.21 | 0.1-0.21 | - | - |
| | N1.3.C.UT | Leghe a base di alluminio | 75 | H13A | 250 | 350 | 400 | 15.00-18.00 | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - |
| | | Leghe fuse AlSi (1% < Si < 13%) | | 4344 | 250 | 350 | 400 | 18.01-22.00 | **0.06-0.16** | 0.06-0.16 | 0.06-0.16 | - | - | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.18** | 0.06-0.18 | 0.06-0.18 | - | - | **0.06-0.15** | 0.06-0.15 | 0.06-0.15 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.2** | 0.08-0.2 | 0.08-0.2 | - | - | **0.08-0.17** | 0.08-0.17 | 0.08-0.17 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.22** | 0.08-0.22 | 0.08-0.22 | - | - | **0.08-0.19** | 0.08-0.19 | 0.08-0.19 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.22** | 0.1-0.22 | 0.1-0.22 | - | - | **0.1-0.19** | 0.1-0.19 | 0.1-0.19 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.22** | 0.1-0.22 | 0.1-0.22 | - | - | **0.1-0.19** | 0.1-0.19 | 0.1-0.19 | - | - |
| | N1.3.C.AG | Leghe a base di alluminio | 90 | H13A | 250 | 315 | 350 | 15.00-18.00 | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - |
| | | AlSi cast and aged alloys (1%< Si <13%) | | 4344 | 250 | 315 | 350 | 18.01-22.00 | **0.06-0.16** | 0.06-0.16 | 0.06-0.16 | - | - | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.18** | 0.06-0.18 | 0.06-0.18 | - | - | **0.06-0.15** | 0.06-0.15 | 0.06-0.15 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.2** | 0.08-0.2 | 0.08-0.2 | - | - | **0.08-0.17** | 0.08-0.17 | 0.08-0.17 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.22** | 0.08-0.22 | 0.08-0.22 | - | - | **0.08-0.19** | 0.08-0.19 | 0.08-0.19 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.22** | 0.1-0.22 | 0.1-0.22 | - | - | **0.1-0.19** | 0.1-0.19 | 0.1-0.19 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.22** | 0.1-0.22 | 0.1-0.22 | - | - | **0.1-0.19** | 0.1-0.19 | 0.1-0.19 | - | - |
| | N3.3.U.UT | Leghe a base di rame | 110 | H13A | 250 | 350 | 400 | 15.00-18.00 | **0.06-0.16** | 0.06-0.16 | 0.06-0.16 | - | - | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - |
| | | Leghe a base di rame a lavorabilità migliorata | | 4344 | 250 | 350 | 400 | 18.01-22.00 | **0.06-0.18** | 0.06-0.18 | 0.06-0.18 | - | - | **0.06-0.15** | 0.06-0.15 | 0.06-0.15 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.2** | 0.06-0.2 | 0.06-0.2 | - | - | **0.06-0.17** | 0.06-0.17 | 0.06-0.17 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.22** | 0.08-0.22 | 0.08-0.22 | - | - | **0.08-0.19** | 0.08-0.19 | 0.08-0.19 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.25** | 0.08-0.25 | 0.08-0.25 | - | - | **0.08-0.21** | 0.08-0.21 | 0.08-0.21 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.25** | 0.1-0.25 | 0.1-0.25 | - | - | **0.1-0.21** | 0.1-0.21 | 0.1-0.21 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.25** | 0.1-0.25 | 0.1-0.25 | - | - | **0.1-0.21** | 0.1-0.21 | 0.1-0.21 | - | - |
| | N3.2.C.UT | Leghe a base di rame | 90 | H13A | 180 | 220 | 240 | 15.00-18.00 | **0.06-0.16** | 0.06-0.16 | 0.06-0.16 | - | - | **0.06-0.14** | 0.06-0.14 | 0.06-0.14 | - | - |
| | | Bronzi e ottoni al piombo (Pb<1%) | | 4344 | 180 | 220 | 240 | 18.01-22.00 | **0.06-0.18** | 0.06-0.18 | 0.06-0.18 | - | - | **0.06-0.15** | 0.06-0.15 | 0.06-0.15 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.2** | 0.06-0.2 | 0.06-0.2 | - | - | **0.06-0.17** | 0.06-0.17 | 0.06-0.17 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.22** | 0.08-0.22 | 0.08-0.22 | - | - | **0.08-0.19** | 0.08-0.19 | 0.08-0.19 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.25** | 0.08-0.25 | 0.08-0.25 | - | - | **0.08-0.21** | 0.08-0.21 | 0.08-0.21 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.25** | 0.1-0.25 | 0.1-0.25 | - | - | **0.1-0.21** | 0.1-0.21 | 0.1-0.21 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.25** | 0.1-0.25 | 0.1-0.25 | - | - | **0.1-0.21** | 0.1-0.21 | 0.1-0.21 | - | - |

# CoroDrill® DS20

**6-7xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 6-7xD Min. | Consigliata | Max. | Diametro punta | Lunghezza punta 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza punta 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| | | | | | | | | | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro | $f_n$ mm/giro |
| P | P1.0.Z.AN | Acciaio non legato C=0.05-0.10% | 110 | 4324 | 230 | 305 | 360 | 15.00-18.00 | 0.04-0.06 | **0.04-0.06** | 0.04-0.06 | - | 0.04-0.08 | 0.04-0.05 | **0.04-0.05** | 0.04-0.05 | - | 0.04-0.07 |
| | | | | 4334 | 210 | 255 | 295 | 18.01-22.00 | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | 0.04-0.09 | 0.04-0.06 | **0.04-0.06** | 0.04-0.06 | - | 0.04-0.07 |
| | | | | 4344 | 190 | 205 | 220 | 22.01-27.00 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | 0.04-0.1 | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | 0.04-0.08 |
| | | | | | | | | 27.01-33.00 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.1 | 0.05-0.07 | **0.05-0.07** | 0.05-0.07 | - | 0.05-0.08 |
| | | | | | | | | 33.01-40.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.13 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.1 |
| | | | | | | | | 40.01-52.00 | 0.06-0.1 | **0.06-0.1** | 0.06-0.1 | - | 0.06-0.13 | 0.06-0.08 | **0.06-0.08** | 0.06-0.08 | - | 0.06-0.1 |
| | | | | | | | | 52.01-65.00 | 0.06-0.1 | **0.06-0.1** | 0.06-0.1 | - | 0.06-0.13 | 0.06-0.08 | **0.06-0.08** | 0.06-0.08 | - | 0.06-0.1 |
| | P1.1.Z.AN | Acciaio non legato C=0.05-0.25% | 125 | 4324 | 230 | 290 | 335 | 15.00-18.00 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | 0.04-0.08 | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | 0.04-0.07 |
| | | | | 4334 | 200 | 245 | 275 | 18.01-22.00 | 0.04-0.09 | **0.04-0.09** | 0.04-0.09 | - | 0.04-0.09 | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | 0.04-0.07 |
| | | | | 4344 | 170 | 190 | 210 | 22.01-27.00 | 0.04-0.1 | **0.04-0.1** | 0.04-0.1 | - | 0.04-0.1 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | 0.04-0.08 |
| | | | | | | | | 27.01-33.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | | | | | 33.01-40.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.13 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.1 |
| | | | | | | | | 40.01-52.00 | 0.06-0.11 | **0.06-0.11** | 0.06-0.11 | - | 0.06-0.13 | 0.06-0.09 | **0.06-0.09** | 0.06-0.09 | - | 0.06-0.1 |
| | | | | | | | | 52.01-65.00 | 0.06-0.11 | **0.06-0.11** | 0.06-0.11 | - | 0.06-0.13 | 0.06-0.09 | **0.06-0.09** | 0.06-0.09 | - | 0.06-0.1 |
| | P1.2.Z.AN | Acciaio non legato C=0.25-0.55% | 190 | 4324 | 190 | 240 | 275 | 15.00-18.00 | - | 0.05-0.08 | 0.06-0.09 | **0.06-0.1** | - | - | 0.05-0.07 | 0.06-0.08 | **0.06-0.09** | - |
| | | | | 4334 | 155 | 195 | 225 | 18.01-22.00 | - | 0.05-0.09 | 0.06-0.1 | **0.06-0.12** | - | - | 0.05-0.08 | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4344 | 120 | 150 | 170 | 22.01-27.00 | - | 0.05-0.12 | 0.06-0.13 | **0.06-0.14** | - | - | 0.05-0.1 | 0.06-0.11 | **0.06-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | 0.07-0.14 | 0.08-0.16 | **0.08-0.17** | - | - | 0.07-0.12 | 0.08-0.13 | **0.08-0.14** | - |
| | | | | | | | | 33.01-40.00 | - | 0.07-0.16 | 0.08-0.17 | **0.08-0.18** | - | - | 0.07-0.13 | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 40.01-52.00 | - | 0.09-0.16 | 0.1-0.17 | **0.1-0.18** | - | - | 0.09-0.13 | 0.1-0.14 | **0.1-0.15** | - |
| | | | | | | | | 52.01-65.00 | - | 0.09-0.16 | 0.1-0.17 | **0.1-0.18** | - | - | 0.09-0.13 | 0.1-0.14 | **0.1-0.15** | - |
| | P1.3.Z.AN | Acciaio non legato C=0.55-0.80% | 190 | 4324 | 170 | 225 | 260 | 15.00-18.00 | - | 0.05-0.08 | 0.06-0.09 | **0.06-0.1** | - | - | 0.05-0.07 | 0.06-0.08 | **0.06-0.09** | - |
| | | | | 4334 | 140 | 185 | 215 | 18.01-22.00 | - | 0.05-0.09 | 0.06-0.1 | **0.06-0.12** | - | - | 0.05-0.08 | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4344 | 105 | 140 | 165 | 22.01-27.00 | - | 0.05-0.12 | 0.06-0.13 | **0.06-0.14** | - | - | 0.05-0.1 | 0.06-0.11 | **0.06-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | 0.07-0.14 | 0.08-0.16 | **0.08-0.17** | - | - | 0.07-0.12 | 0.08-0.13 | **0.08-0.14** | - |
| | | | | | | | | 33.01-40.00 | - | 0.07-0.16 | 0.08-0.17 | **0.08-0.18** | - | - | 0.07-0.13 | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 40.01-52.00 | - | 0.09-0.16 | 0.1-0.17 | **0.1-0.18** | - | - | 0.09-0.13 | 0.1-0.14 | **0.1-0.15** | - |
| | | | | | | | | 52.01-65.00 | - | 0.09-0.16 | 0.1-0.17 | **0.1-0.18** | - | - | 0.09-0.13 | 0.1-0.14 | **0.1-0.15** | - |
| | P1.5.C.UT | Acciaio non legato Fuso - non trattato | 150 | 4324 | 140 | 235 | 295 | 15.00-18.00 | - | 0.04-0.08 | 0.04-0.08 | **0.04-0.08** | - | - | 0.04-0.07 | 0.04-0.07 | **0.04-0.07** | - |
| | | | | 4334 | 135 | 200 | 240 | 18.01-22.00 | - | 0.04-0.08 | 0.04-0.08 | **0.04-0.08** | - | - | 0.04-0.07 | 0.04-0.07 | **0.04-0.07** | - |
| | | | | 4344 | 125 | 160 | 180 | 22.01-27.00 | - | 0.04-0.09 | 0.04-0.09 | **0.04-0.09** | - | - | 0.04-0.08 | 0.04-0.08 | **0.04-0.08** | - |
| | | | | | | | | 27.01-33.00 | - | 0.05-0.1 | 0.05-0.1 | **0.05-0.1** | - | - | 0.05-0.08 | 0.05-0.08 | **0.05-0.08** | - |
| | | | | | | | | 33.01-40.00 | - | 0.05-0.1 | 0.05-0.1 | **0.05-0.1** | - | - | 0.05-0.09 | 0.05-0.09 | **0.05-0.09** | - |
| | | | | | | | | 40.01-52.00 | - | 0.06-0.1 | 0.06-0.1 | **0.06-0.1** | - | - | 0.06-0.09 | 0.06-0.09 | **0.06-0.09** | - |
| | | | | | | | | 52.01-65.00 | - | 0.06-0.1 | 0.06-0.1 | **0.06-0.1** | - | - | 0.06-0.09 | 0.06-0.09 | **0.06-0.09** | - |
| | P2.1.Z.AN | Acciaio debolmente legato Ricotto | 175 | 4324 | 180 | 235 | 275 | 15.00-18.00 | - | - | 0.06-0.09 | **0.06-0.1** | - | - | - | 0.06-0.08 | **0.06-0.09** | - |
| | | | | 4334 | 150 | 195 | 225 | 18.01-22.00 | - | - | 0.06-0.1 | **0.06-0.12** | - | - | - | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4344 | 115 | 150 | 170 | 22.01-27.00 | - | - | 0.06-0.13 | **0.06-0.14** | - | - | - | 0.06-0.11 | **0.06-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | **0.08-0.17** | - | - | - | 0.08-0.13 | **0.08-0.14** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | **0.08-0.18** | - | - | - | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | P2.2.Z.AN | Acciaio debolmente legato Ricotto | 240 | 4324 | 180 | 225 | 260 | 15.00-18.00 | - | - | 0.06-0.09 | **0.06-0.1** | - | - | - | 0.06-0.08 | **0.06-0.09** | - |
| | | | | 4334 | 150 | 180 | 205 | 18.01-22.00 | - | - | 0.06-0.1 | **0.06-0.12** | - | - | - | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4344 | 115 | 160 | 185 | 22.01-27.00 | - | - | 0.06-0.13 | **0.06-0.14** | - | - | - | 0.06-0.11 | **0.06-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | **0.08-0.17** | - | - | - | 0.08-0.13 | **0.08-0.14** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | **0.08-0.18** | - | - | - | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | P2.5.Z.HT | Acciaio debolmente legato Temprato | 330 | 4324 | 90 | 170 | 220 | 15.00-18.00 | - | - | 0.06-0.09 | **0.06-0.1** | - | - | - | 0.06-0.08 | **0.06-0.09** | - |
| | | | | 4334 | 85 | 140 | 175 | 18.01-22.00 | - | - | 0.06-0.1 | **0.06-0.12** | - | - | - | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4344 | 75 | 115 | 135 | 22.01-27.00 | - | - | 0.06-0.13 | **0.06-0.14** | - | - | - | 0.06-0.11 | **0.06-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | **0.08-0.17** | - | - | - | 0.08-0.13 | **0.08-0.14** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | **0.08-0.18** | - | - | - | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | P2.6.C.UT | Acciaio debolmente legato Fuso - non trattato | 200 | 4324 | 110 | 190 | 240 | 15.00-18.00 | - | - | 0.06-0.1 | **0.06-0.12** | - | - | - | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4334 | 105 | 160 | 190 | 18.01-22.00 | - | - | 0.06-0.12 | **0.06-0.13** | - | - | - | 0.06-0.1 | **0.06-0.11** | - |
| | | | | 4344 | 100 | 125 | 145 | 22.01-27.00 | - | - | 0.06-0.14 | **0.06-0.16** | - | - | - | 0.06-0.12 | **0.06-0.13** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.17 | **0.08-0.18** | - | - | - | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.18 | **0.08-0.2** | - | - | - | 0.08-0.15 | **0.08-0.17** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.18 | **0.1-0.2** | - | - | - | 0.1-0.15 | **0.1-0.17** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.18 | **0.1-0.2** | - | - | - | 0.1-0.15 | **0.1-0.17** | - |
| | P3.0.Z.AN | Acciaio fortemente legato Ricotto | 200 | 4324 | 160 | 220 | 260 | 15.00-18.00 | - | - | 0.06-0.09 | **0.06-0.1** | - | - | - | 0.06-0.08 | **0.06-0.09** | - |
| | | | | 4334 | 130 | 180 | 215 | 18.01-22.00 | - | - | 0.06-0.1 | **0.06-0.12** | - | - | - | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4344 | 100 | 135 | 160 | 22.01-27.00 | - | - | 0.06-0.13 | **0.06-0.14** | - | - | - | 0.06-0.11 | **0.06-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | **0.08-0.17** | - | - | - | 0.08-0.13 | **0.08-0.14** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | **0.08-0.18** | - | - | - | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |



SANDVIK Coromant

ITA

# CoroDrill® DS20

**6-7xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 6-7xD | | | Diametro punta | Lunghezza punta 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza punta 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| P | P3.0.Z.HT | Acciaio fortemente legato Temprato | 380 | 4324 | 80 | 150 | 190 | 15.00-18.00 | - | - | 0.06-0.09 | **0.06-0.1** | - | - | - | 0.06-0.08 | **0.06-0.09** | - |
| | | | | 4334 | 75 | 125 | 160 | 18.01-22.00 | - | - | 0.06-0.1 | **0.06-0.12** | - | - | - | 0.06-0.09 | **0.06-0.1** | - |
| | | | | 4344 | 70 | 100 | 115 | 22.01-27.00 | - | - | 0.06-0.13 | **0.06-0.14** | - | - | - | 0.06-0.11 | **0.06-0.12** | - |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | **0.08-0.17** | - | - | - | 0.08-0.13 | **0.08-0.14** | - |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | **0.08-0.18** | - | - | - | 0.08-0.14 | **0.08-0.15** | - |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | | | | | | | | 52.01-65.00 | - | - | 0.1-0.17 | **0.1-0.18** | - | - | - | 0.1-0.14 | **0.1-0.15** | - |
| | P5.0.Z.AN | Acciaio inossidabile ferritico/martensitico Ricotto | 200 | 4334 | 115 | 165 | 205 | 15.00-18.00 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 | 0.05-0.07 | **0.05-0.07** | 0.05-0.07 | - | 0.05-0.07 |
| | | | | 4344 | 115 | 140 | 160 | 18.01-22.00 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.08 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 2044 | 115 | 135 | 150 | 22.01-27.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | | | | | 27.01-33.00 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.09 | **0.07-0.09** | 0.07-0.09 | - | 0.07-0.08 |
| | | | | | | | | 33.01-40.00 | 0.07-0.12 | **0.07-0.12** | 0.07-0.12 | - | 0.07-0.1 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.09 |
| | | | | | | | | 40.01-52.00 | 0.09-0.12 | **0.09-0.12** | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.09 |
| | | | | | | | | 52.01-65.00 | 0.09-0.12 | **0.09-0.12** | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.09 |
| | P5.0.Z.HT | Acciaio inossidabile ferritico/martensitico Temprato | 330 | 4334 | 75 | 120 | 155 | 15.00-18.00 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 | 0.05-0.07 | **0.05-0.07** | 0.05-0.07 | - | 0.05-0.07 |
| | | | | 4344 | 70 | 105 | 125 | 18.01-22.00 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.08 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 2044 | 70 | 105 | 125 | 22.01-27.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | | | | | 27.01-33.00 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.09 | **0.07-0.09** | 0.07-0.09 | - | 0.07-0.08 |
| | | | | | | | | 33.01-40.00 | 0.07-0.12 | **0.07-0.12** | 0.07-0.12 | - | 0.07-0.1 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.09 |
| | | | | | | | | 40.01-52.00 | 0.09-0.12 | **0.09-0.12** | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.09 |
| | | | | | | | | 52.01-65.00 | 0.09-0.12 | **0.09-0.12** | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.09 |
| M | M1.0.Z.AQ | Acciaio inossidabile austenitico Ricotto/bonificato | 200 | 4334 | 115 | 165 | 205 | 15.00-18.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 115 | 150 | 170 | 18.01-22.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 115 | 140 | 160 | 22.01-27.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.08 |
| | | | | | | | | 27.01-33.00 | 0.07-0.12 | **0.07-0.12** | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.09 |
| | | | | | | | | 33.01-40.00 | 0.07-0.13 | **0.07-0.13** | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.1 |
| | | | | | | | | 40.01-52.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | | | | | | | | 52.01-65.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | M1.1.Z.AQ | Acciaio inossidabile austenitico A lavorabilità migliorata | 200 | 4334 | 115 | 175 | 215 | 15.00-18.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 115 | 160 | 190 | 18.01-22.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 115 | 155 | 180 | 22.01-27.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.08 |
| | | | | | | | | 27.01-33.00 | 0.07-0.12 | **0.07-0.12** | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.09 |
| | | | | | | | | 33.01-40.00 | 0.07-0.13 | **0.07-0.13** | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.1 |
| | | | | | | | | 40.01-52.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | | | | | | | | 52.01-65.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | M2.0.Z.AQ | Acciaio inossidabile superaustenitico Ricotto/bonificato | 200 | 4334 | 80 | 115 | 135 | 15.00-18.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 80 | 100 | 115 | 18.01-22.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 80 | 100 | 115 | 22.01-27.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.08 |
| | | | | | | | | 27.01-33.00 | 0.07-0.12 | **0.07-0.12** | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.09 |
| | | | | | | | | 33.01-40.00 | 0.07-0.13 | **0.07-0.13** | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.1 |
| | | | | | | | | 40.01-52.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | | | | | | | | 52.01-65.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | M3.1.Z.AQ | Acciaio inossidabile duplex >60% ferrite (N<0.10%) | 230 | 4334 | 85 | 115 | 130 | 15.00-18.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 85 | 105 | 115 | 18.01-22.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 85 | 100 | 115 | 22.01-27.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.08 |
| | | | | | | | | 27.01-33.00 | 0.07-0.12 | **0.07-0.12** | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.09 |
| | | | | | | | | 33.01-40.00 | 0.07-0.13 | **0.07-0.13** | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.1 |
| | | | | | | | | 40.01-52.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | | | | | | | | 52.01-65.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | M3.2.Z.AQ | Acciaio inossidabile duplex <Ferrite al 60% (N>0.10%) | 260 | 4334 | 75 | 95 | 110 | 15.00-18.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 75 | 90 | 105 | 18.01-22.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 75 | 90 | 105 | 22.01-27.00 | 0.05-0.11 | **0.05-0.11** | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | 0.05-0.08 |
| | | | | | | | | 27.01-33.00 | 0.07-0.12 | **0.07-0.12** | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.09 |
| | | | | | | | | 33.01-40.00 | 0.07-0.13 | **0.07-0.13** | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | **0.07-0.1** | 0.07-0.1 | - | 0.07-0.1 |
| | | | | | | | | 40.01-52.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| | | | | | | | | 52.01-65.00 | 0.09-0.13 | **0.09-0.13** | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | **0.09-0.1** | 0.09-0.1 | - | 0.09-0.1 |
| S | S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS | Superleghe resistenti al calore Base Ni | 350 | 4334 | 20 | 35 | 45 | 15.00-18.00 | 0.04-0.06 | **0.04-0.06** | 0.04-0.06 | - | - | 0.04-0.05 | **0.04-0.05** | 0.04-0.05 | - | - |
| | | | | 4344 | 20 | 35 | 45 | 18.01-22.00 | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | - | 0.04-0.06 | **0.04-0.06** | 0.04-0.06 | - | - |
| | | | | 2044 | 20 | 35 | 45 | 22.01-27.00 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | - | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | - |
| | | | | | | | | 27.01-33.00 | 0.05-0.09 | **0.05-0.09** | 0.05-0.09 | - | - | 0.05-0.07 | **0.05-0.07** | 0.05-0.07 | - | - |
| | | | | | | | | 33.01-40.00 | 0.05-0.1 | **0.05-0.1** | 0.05-0.1 | - | - | 0.05-0.08 | **0.05-0.08** | 0.05-0.08 | - | - |
| | | | | | | | | 40.01-52.00 | 0.06-0.1 | **0.06-0.1** | 0.06-0.1 | - | - | 0.06-0.08 | **0.06-0.08** | 0.06-0.08 | - | - |
| | | | | | | | | 52.01-65.00 | 0.06-0.1 | **0.06-0.1** | 0.06-0.1 | - | - | 0.06-0.08 | **0.06-0.08** | 0.06-0.08 | - | - |
| | S4.2.Z.AN S4.3.Z.AG | Superleghe resistenti al calore Base Ti | 330 | H13A | 40 | 80 | 110 | 15.00-18.00 | **0.06-0.11** | 0.06-0.11 | 0.06-0.11 | - | - | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - |
| | | | | 4344 | 40 | 80 | 110 | 18.01-22.00 | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | 2044 | 40 | 80 | 110 | 22.01-27.00 | 0.06-0.13 | 0.06-0.13 | 0.06-0.13 | - | - | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - | **0.08-0.11** | 0.08-0.11 | 0.08-0.11 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - | **0.08-0.12** | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - | **0.1-0.12** | 0.1-0.12 | 0.1-0.12 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - | **0.1-0.12** | 0.1-0.12 | 0.1-0.12 | - | - |

L'avanzamento in entrata dovrebbe equivalere al 75% della velocità di avanzamento consigliata. L'avanzamento in uscita dovrebbe essere di 0.05 mm/giro.

# CoroDrill® DS20

**6-7xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 6-7xD | | | Diametro punta | Lunghezza punta 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza punta 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| K | K1.1.C.NS | Ghisa malleabile Bassa resistenza | 200 | 4324 | 140 | 190 | 220 | 15.00-18.00 | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - | - | 0.08-0.08 | 0.08-0.08 | **0.08-0.11** | - |
| | | | | 4334 | 110 | 155 | 180 | 18.01-22.00 | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.15** | - | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - |
| | | | | 4344 | 180 | 150 | 140 | 22.01-27.00 | - | 0.08-0.14 | 0.08-0.14 | **0.08-0.17** | - | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.14** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.16 | 0.1-0.16 | **0.1-0.19** | - | - | 0.1-0.13 | 0.1-0.13 | **0.1-0.16** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.18 | 0.1-0.18 | **0.1-0.21** | - | - | 0.1-0.15 | 0.1-0.15 | **0.1-0.18** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.18 | 0.12-0.18 | **0.12-0.21** | - | - | 0.12-0.15 | 0.12-0.15 | **0.12-0.18** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.18 | 0.12-0.18 | **0.12-0.21** | - | - | 0.12-0.15 | 0.12-0.15 | **0.12-0.18** | - |
| | K2.1.C.UT | Ghisa grigia Bassa resistenza | 180 | 4324 | 210 | 255 | 295 | 15.00-18.00 | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - | - | 0.08-0.08 | 0.08-0.08 | **0.08-0.11** | - |
| | | | | 4334 | 170 | 210 | 245 | 18.01-22.00 | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.15** | - | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - |
| | | | | 4344 | 130 | 160 | 185 | 22.01-27.00 | - | 0.08-0.14 | 0.08-0.14 | **0.08-0.17** | - | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.14** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.16 | 0.1-0.16 | **0.1-0.19** | - | - | 0.1-0.13 | 0.1-0.13 | **0.1-0.16** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.18 | 0.1-0.18 | **0.1-0.21** | - | - | 0.1-0.15 | 0.1-0.15 | **0.1-0.18** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.18 | 0.12-0.18 | **0.12-0.21** | - | - | 0.12-0.15 | 0.12-0.15 | **0.12-0.18** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.18 | 0.12-0.18 | **0.12-0.21** | - | - | 0.12-0.15 | 0.12-0.15 | **0.12-0.18** | - |
| | K2.2.C.UT | Ghisa grigia Alta resistenza | 245 | 4324 | 125 | 185 | 220 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | **0.08-0.12** | - | - | 0.08-0.07 | 0.08-0.07 | **0.08-0.1** | - |
| | | | | 4334 | 100 | 145 | 175 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.14** | - | - | 0.08-0.09 | 0.08-0.09 | **0.08-0.12** | - |
| | | | | 4344 | 75 | 115 | 135 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.16** | - | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.18** | - | - | 0.1-0.12 | 0.1-0.12 | **0.1-0.15** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | **0.1-0.2** | - | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.17** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| | K3.1.C.UT | Ghisa nodulare Ferritica | 155 | 4324 | 125 | 170 | 205 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | **0.08-0.12** | - | - | 0.08-0.07 | 0.08-0.07 | **0.08-0.1** | - |
| | | | | 4334 | 100 | 140 | 165 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.14** | - | - | 0.08-0.09 | 0.08-0.09 | **0.08-0.12** | - |
| | | | | 4344 | 80 | 110 | 130 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.16** | - | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.18** | - | - | 0.1-0.12 | 0.1-0.12 | **0.1-0.15** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | **0.1-0.2** | - | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.17** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| | K3.3.C.UT | Ghisa nodulare Perlitica | 265 | 4324 | 110 | 160 | 190 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | **0.08-0.12** | - | - | 0.08-0.07 | 0.08-0.07 | **0.08-0.1** | - |
| | | | | 4334 | 90 | 130 | 160 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.14** | - | - | 0.08-0.09 | 0.08-0.09 | **0.08-0.12** | - |
| | | | | 4344 | 70 | 100 | 115 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.16** | - | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.18** | - | - | 0.1-0.12 | 0.1-0.12 | **0.1-0.15** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | **0.1-0.2** | - | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.17** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| | K4.2.C.UT | Ghisa a grafite compatta (CGI) Elevata resistenza alla trazione (Perlite>90%) | 230 | 4324 | 130 | 190 | 225 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | **0.08-0.12** | - | - | 0.08-0.07 | 0.08-0.07 | **0.08-0.1** | - |
| | | | | 4334 | 110 | 155 | 180 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.14** | - | - | 0.08-0.09 | 0.08-0.09 | **0.08-0.12** | - |
| | | | | 4344 | 85 | 115 | 135 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.16** | - | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.13** | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.18** | - | - | 0.1-0.12 | 0.1-0.12 | **0.1-0.15** | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | **0.1-0.2** | - | - | 0.1-0.14 | 0.1-0.14 | **0.1-0.17** | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| | | | | | | | | 52.01-65.00 | - | 0.12-0.16 | 0.12-0.16 | **0.12-0.2** | - | - | 0.12-0.14 | 0.12-0.14 | **0.12-0.17** | - |
| H | H1.3.Z.HA | Acciai extra duri Temprato | 60 (HRC) | 4324 | 30 | 60 | 75 | 15.00-18.00 | - | 0.06-0.08 | 0.06-0.08 | **0.06-0.08** | - | - | 0.06-0.07 | 0.06-0.07 | **0.06-0.07** | - |
| | | | | 4334 | 30 | 60 | 75 | 18.01-22.00 | - | 0.06-0.09 | 0.06-0.09 | **0.06-0.09** | - | - | 0.06-0.08 | 0.06-0.08 | **0.06-0.08** | - |
| | | | | 4344 | 30 | 60 | 75 | 22.01-27.00 | - | 0.06-0.1 | 0.06-0.1 | **0.06-0.1** | - | - | 0.06-0.08 | 0.06-0.08 | **0.06-0.08** | - |
| | | | | | | | | 27.01-33.00 | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.1** | - | - | 0.08-0.09 | 0.08-0.09 | **0.08-0.09** | - |
| | | | | | | | | 33.01-40.00 | - | 0.08-0.12 | 0.08-0.12 | **0.08-0.12** | - | - | 0.08-0.1 | 0.08-0.1 | **0.08-0.1** | - |
| | | | | | | | | 40.01-52.00 | - | 0.1-0.12 | 0.1-0.12 | **0.1-0.12** | - | - | 0.1-0.1 | 0.1-0.1 | **0.1-0.1** | - |
| | | | | | | | | 52.01-65.00 | - | 0.1-0.12 | 0.1-0.12 | **0.1-0.12** | - | - | 0.1-0.1 | 0.1-0.1 | **0.1-0.1** | - |

ITA

# CoroDrill® DS20

**6-7xD**

**Valori in millimetri**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 6-7xD | | | Diametro punta | Lunghezza punta 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza punta 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | | | | | |
| N | N1.2.Z.AG | Leghe a base di alluminio | 100 | H13A | 300 | 330 | 360 | 15.00-18.00 | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - |
| | | Leghe AlSi, Si ≤ 1% | | 4344 | 300 | 330 | 360 | 18.01-22.00 | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.13** | 0.06-0.13 | 0.06-0.13 | - | - | **0.06-0.11** | 0.06-0.11 | 0.06-0.11 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - | **0.08-0.12** | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.16** | 0.08-0.16 | 0.08-0.16 | - | - | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.16** | 0.1-0.16 | 0.1-0.16 | - | - | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.16** | 0.1-0.16 | 0.1-0.16 | - | - | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - |
| | N1.3.C.UT | Leghe a base di alluminio | 75 | H13A | 250 | 315 | 360 | 15.00-18.00 | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - | **0.06-0.08** | 0.06-0.08 | 0.06-0.08 | - | - |
| | | Leghe fuse AlSi (1% < Si < 13%) | | 4344 | 250 | 315 | 360 | 18.01-22.00 | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.13** | 0.08-0.13 | 0.08-0.13 | - | - | **0.08-0.11** | 0.08-0.11 | 0.08-0.11 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - | **0.08-0.12** | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - | **0.1-0.12** | 0.1-0.12 | 0.1-0.12 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - | **0.1-0.12** | 0.1-0.12 | 0.1-0.12 | - | - |
| | N1.3.C.AG | Leghe a base di alluminio | 90 | H13A | 250 | 285 | 315 | 15.00-18.00 | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - | **0.06-0.08** | 0.06-0.08 | 0.06-0.08 | - | - |
| | | AlSi cast and aged alloys (1%< Si <13%) | | 4344 | 250 | 285 | 315 | 18.01-22.00 | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.13** | 0.08-0.13 | 0.08-0.13 | - | - | **0.08-0.11** | 0.08-0.11 | 0.08-0.11 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - | **0.08-0.12** | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - | **0.1-0.12** | 0.1-0.12 | 0.1-0.12 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - | **0.1-0.12** | 0.1-0.12 | 0.1-0.12 | - | - |
| | N3.3.U.UT | Leghe a base di rame | 110 | H13A | 250 | 315 | 360 | 15.00-18.00 | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - |
| | | Leghe a base di rame a lavorabilità migliorata | | 4344 | 250 | 315 | 360 | 18.01-22.00 | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.13** | 0.06-0.13 | 0.06-0.13 | - | - | **0.06-0.11** | 0.06-0.11 | 0.06-0.11 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - | **0.08-0.12** | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.16** | 0.08-0.16 | 0.08-0.16 | - | - | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.16** | 0.1-0.16 | 0.1-0.16 | - | - | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.16** | 0.1-0.16 | 0.1-0.16 | - | - | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - |
| | N3.2.C.UT | Leghe a base di rame | 90 | H13A | 180 | 200 | 215 | 15.00-18.00 | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - | **0.06-0.09** | 0.06-0.09 | 0.06-0.09 | - | - |
| | | Bronzi e ottoni al piombo (Pb<1%) | | 4344 | 180 | 200 | 215 | 18.01-22.00 | **0.06-0.12** | 0.06-0.12 | 0.06-0.12 | - | - | **0.06-0.1** | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 22.01-27.00 | **0.06-0.13** | 0.06-0.13 | 0.06-0.13 | - | - | **0.06-0.11** | 0.06-0.11 | 0.06-0.11 | - | - |
| | | | | | | | | 27.01-33.00 | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - | **0.08-0.12** | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 33.01-40.00 | **0.08-0.16** | 0.08-0.16 | 0.08-0.16 | - | - | **0.08-0.14** | 0.08-0.14 | 0.08-0.14 | - | - |
| | | | | | | | | 40.01-52.00 | **0.1-0.16** | 0.1-0.16 | 0.1-0.16 | - | - | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - |
| | | | | | | | | 52.01-65.00 | **0.1-0.16** | 0.1-0.16 | 0.1-0.16 | - | - | **0.1-0.14** | 0.1-0.14 | 0.1-0.14 | - | - |

L'avanzamento in entrata dovrebbe equivalere al 75% della velocità di avanzamento consigliata. L'avanzamento in uscita dovrebbe essere di 0.05 mm/giro.

# CoroDrill® DS20

**4-5xD**

**Valori in pollici**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD Min. | Rec. | Max. | Attacco cilindrico | Lunghezza della punta 4xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza della punta 5xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
| | | | | | | | | | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro | $f_n$ poll./giro |
| P | P1.0.Z.AN | Acciaio non legato C=0.05-0.10% | 110 | 4324 | 755 | 1115 | 1310 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.004 |
| | | | | 4334 | 690 | 935 | 1065 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.004 |
| | | | | 4344 | 625 | 740 | 805 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 1.063-1.299 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.005 |
| | | | | | | | | 1.299-1.575 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.006 |
| | | | | | | | | 1.575-2.047 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.006 |
| | | | | | | | | 2.047-2.559 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.006 |
| | P1.1.Z.AN | Acciaio non legato C=0.05-0.25% | 125 | 4324 | 755 | 1055 | 1215 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4334 | 655 | 880 | 1000 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 560 | 695 | 770 | 0.866-1.063 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 1.063-1.299 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.299-1.575 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 |
| | | | | | | | | 1.575-2.047 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 |
| | | | | | | | | 2.047-2.559 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 |
| | P1.2.Z.AN | Acciaio non legato C=0.25-0.55% | 190 | 4324 | 625 | 870 | 1000 | 0.591-0.709 | - | 0.002-0.005 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | 4334 | 510 | 710 | 820 | 0.709-0.866 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.007** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 395 | 545 | 625 | 0.866-1.063 | - | 0.002-0.007 | 0.002-0.008 | **0.002-0.009** | - | - | 0.002-0.006 | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.009 | 0.003-0.009 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.009 | 0.003-0.01 | **0.003-0.011** | - | - | 0.003-0.008 | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | P1.3.Z.AN | Acciaio non legato C=0.55-0.80% | 190 | 4324 | 560 | 815 | 950 | 0.591-0.709 | - | 0.002-0.005 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | 4334 | 460 | 670 | 785 | 0.709-0.866 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.007** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 345 | 515 | 605 | 0.866-1.063 | - | 0.002-0.007 | 0.002-0.008 | **0.002-0.009** | - | - | 0.002-0.006 | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.009 | 0.003-0.009 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.009 | 0.003-0.01 | **0.003-0.011** | - | - | 0.003-0.008 | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | P1.5.C.UT | Acciaio non legato Fuso - non trattato | 150 | 4324 | 460 | 855 | 1065 | 0.591-0.709 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - |
| | | | | 4334 | 445 | 720 | 870 | 0.709-0.866 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - |
| | | | | 4344 | 410 | 570 | 655 | 0.866-1.063 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.299-1.575 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.575-2.047 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 2.047-2.559 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | P2.1.Z.AN | Acciaio debolmente legato Ricotto | 175 | 4324 | 590 | 855 | 1000 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | | | 4334 | 490 | 705 | 820 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 375 | 540 | 625 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P2.2.Z.AN | Acciaio debolmente legato Ricotto | 240 | 4324 | 590 | 825 | 950 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | | | 4334 | 490 | 655 | 740 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 375 | 565 | 670 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | 0.003-0.009 | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P2.5.Z.HT | Acciaio debolmente legato Temprato | 330 | 4324 | 295 | 625 | 805 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | | | 4334 | 280 | 515 | 640 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 245 | 405 | 490 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P2.6.C.UT | Acciaio debolmente legato Fuso - non trattato | 200 | 4324 | 360 | 690 | 870 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4334 | 345 | 570 | 690 | 0.709-0.866 | - | - | 0.002-0.007 | **0.002-0.008** | - | - | - | 0.002-0.006 | **0.002-0.007** | - |
| | | | | 4344 | 330 | 455 | 525 | 0.866-1.063 | - | - | 0.002-0.009 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.011 | **0.003-0.012** | - | - | - | 0.003-0.009 | **0.003-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.011 | **0.004-0.012** | - | - | - | 0.004-0.009 | **0.004-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.011 | **0.004-0.012** | - | - | - | 0.004-0.009 | **0.004-0.01** | - |
| | P3.0.Z.AN | Acciaio fortemente legato Ricotto | 200 | 4324 | 525 | 800 | 950 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | | | 4334 | 425 | 660 | 785 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 330 | 500 | 590 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |



SANDVIK Coromant

ITA

# CoroDrill® DS20

## 4-5xD

### Valori in pollici

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD | | | Attacco cilindrico | Lunghezza della punta 4xD<br>Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Lunghezza della punta 5xD<br>Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | -S5W | -L5W | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W |
| P | P3.0.Z.HT | Acciaio fortemente legato Temprato | 380 | 4324 | 260 | 540 | 690 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | | | 4334 | 245 | 460 | 575 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 230 | 355 | 425 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P5.0.Z.AN | Acciaio inossidabile ferritico/martensitico Ricotto | 200 | 4334 | 375 | 610 | 740 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 375 | 505 | 575 | 0.709-0.866 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 375 | 480 | 540 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.007 | **0.003-0.007** | 0.003-0.007 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | P5.0.Z.HT | Acciaio inossidabile ferritico/martensitico Temprato | 330 | 4334 | 245 | 450 | 560 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 230 | 380 | 460 | 0.709-0.866 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 230 | 380 | 460 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.007 | **0.003-0.007** | 0.003-0.007 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| M | M1.0.Z.AQ | Acciaio inossidabile austenitico Ricotto/bonificato | 200 | 4334 | 375 | 610 | 740 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 375 | 540 | 625 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 375 | 515 | 590 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M1.1.Z.AQ | Acciaio inossidabile austenitico A lavorabilità migliorata | 200 | 4334 | 375 | 640 | 785 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 375 | 580 | 690 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 375 | 555 | 655 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M2.0.Z.AQ | Acciaio inossidabile superaustenitico (Ni>20%) Ricotto/bonificato | 200 | 4334 | 260 | 410 | 490 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 260 | 360 | 410 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 260 | 360 | 410 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M3.1.Z.AQ | Acciaio inossidabile duplex >60% ferrite (N<0.10%) | 230 | 4334 | 280 | 405 | 475 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 280 | 375 | 425 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 280 | 365 | 410 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M3.2.Z.AQ | Acciaio inossidabile duplex >60% ferrite (N<0.10%) | 260 | 4334 | 245 | 345 | 395 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 245 | 330 | 375 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 245 | 330 | 375 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| S | S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS | Superleghe resistenti al calore Base Ni | 350 | 4334 | 65 | 130 | 165 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | 4344 | 65 | 130 | 165 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | 2044 | 65 | 130 | 165 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 1.575-2.047 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 2.047-2.559 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | S4.2.Z.AN S4.3.Z.AG | Superleghe resistenti al calore Base Ti | 330 | H13A | 130 | 300 | 395 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | 4344 | 130 | 300 | 395 | 0.709-0.866 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | 2044 | 130 | 300 | 395 | 0.866-1.063 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - |

# CoroDrill® DS20

**4-5xD**

**Valori in pollici**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD | | | Attacco cilindrico | Lunghezza della punta 4xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza della punta 5xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
| K | K1.1.C.NS | Ghisa malleabile Bassa resistenza | 200 | 4324 | 460 | 685 | 805 | 0.591-0.709 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4334 | 360 | 550 | 655 | 0.709-0.866 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | 4344 | 590 | 540 | 510 | 0.866-1.063 | - | 0.003-0.008 | 0.003-0.008 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.011 | 0.004-0.011 | **0.004-0.013** | - | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | K2.1.C.UT | Ghisa grigia Bassa resistenza | 180 | 4324 | 690 | 935 | 1065 | 0.591-0.709 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4334 | 560 | 770 | 885 | 0.709-0.866 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | 4344 | 425 | 585 | 670 | 0.866-1.063 | - | 0.003-0.008 | 0.003-0.008 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.011 | 0.004-0.011 | **0.004-0.013** | - | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | K2.2.C.UT | Ghisa grigia Alta resistenza | 245 | 4324 | 410 | 665 | 805 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | | | 4334 | 330 | 530 | 640 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 245 | 405 | 490 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | K3.1.C.UT | Ghisa nodulare Ferritica | 155 | 4324 | 410 | 625 | 740 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | | | 4334 | 330 | 510 | 605 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 260 | 400 | 475 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | K3.3.C.UT | Ghisa nodulare Ferritica | 265 | 4324 | 360 | 575 | 690 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | | | 4334 | 295 | 475 | 575 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 230 | 355 | 425 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | K4.2.C.UT | Ghisa a grafite compatta (CGI) Alta resistenza | 230 | 4324 | 425 | 680 | 820 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | | | 4334 | 360 | 550 | 655 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 280 | 415 | 490 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| H | H1.3.Z.HA | Acciaio molto duro Temprato | 60 (HRC) | 4324 | 100 | 215 | 280 | 0.591-0.709 | - | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - |
| | | | | 4334 | 100 | 215 | 280 | 0.709-0.866 | - | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | - | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - |
| | | | | 4344 | 100 | 215 | 280 | 0.866-1.063 | - | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | - | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | - | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.007 | **0.003-0.007** | 0.003-0.007 | - | - | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | - | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | - | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - |

ITA

# CoroDrill® DS20

**4-5xD**

**Valori in pollici**

| ISO | Codice MC | Materiale | HB | Qualità | Velocità di taglio consigliate 4-5xD | | | Attacco cilindrico | Lunghezza della punta 4xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza della punta 5xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
| N | N1.2.Z.AG | Leghe a base di alluminio | 100 | H13A | 985 | 1195 | 1310 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | Leghe AlSi, Si ≤ 1% | | 4344 | 985 | 1195 | 1310 | 0.709-0.866 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.008** | 0.002-0.008 | 0.002-0.008 | - | - | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.01** | 0.003-0.01 | 0.003-0.01 | - | - | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | N1.3.C.UT | Leghe a base di alluminio | 75 | H13A | 820 | 1140 | 1310 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | Leghe AlSi, Si ≤ 1% | | 4344 | 820 | 1140 | 1310 | 0.709-0.866 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | N1.3.C.AG | Leghe a base di alluminio | 90 | H13A | 820 | 1035 | 1150 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | AlSi cast and aged alloys (1%< Si <13%) | | 4344 | 820 | 1035 | 1150 | 0.709-0.866 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | N3.3.U.UT | Leghe a base di rame | 110 | H13A | 820 | 1140 | 1310 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | Leghe a base di rame a lavorabilità migliorata | | 4344 | 820 | 1140 | 1310 | 0.709-0.866 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.008** | 0.002-0.008 | 0.002-0.008 | - | - | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.01** | 0.003-0.01 | 0.003-0.01 | - | - | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | N3.2.C.UT | Leghe a base di rame | 90 | H13A | 590 | 715 | 785 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | Bronzi e ottoni al piombo (Pb ≤ 1%) | | 4344 | 590 | 715 | 785 | 0.709-0.866 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.008** | 0.002-0.008 | 0.002-0.008 | - | - | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.01** | 0.003-0.01 | 0.003-0.01 | - | - | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |

# CoroDrill® DS20

**6-7xD**

**Valori in pollici**

| ISO | Codice MC | Materiale | HB | Qualità | Dati di taglio consigliati 6-7xD Min. | Consigliata | Max. | Attacco cilindrico | Lunghezza punta 6xD -S5W fn inch/rev | -L5W fn inch/rev | -L6W fn inch/rev | -M7W fn inch/rev | -H5W fn inch/rev | Lunghezza punta 7xD -S5W fn inch/rev | -L5W fn inch/rev | -L6W fn inch/rev | -M7W fn inch/rev | -H5W fn inch/rev |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
| P | P1.0.Z.AN | Acciaio non legato C=0.05-0.10% | 110 | 4324 | 755 | 1005 | 1180 | 0.591-0.709 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.002** | 0.002-0.002 | 0.002-0.002 | - | 0.002-0.003 |
| | | | | 4334 | 690 | 840 | 960 | 0.709-0.866 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.002** | 0.002-0.002 | 0.002-0.002 | - | 0.002-0.003 |
| | | | | 4344 | 625 | 665 | 725 | 0.866-1.063 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.299-1.575 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 |
| | | | | | | | | 1.575-2.047 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 |
| | | | | | | | | 2.047-2.559 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 |
| | P1.1.Z.AN | Acciaio non legato C=0.05-0.25% | 125 | 4324 | 755 | 950 | 1095 | 0.591-0.709 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4334 | 655 | 790 | 900 | 0.709-0.866 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 560 | 625 | 695 | 0.866-1.063 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.299-1.575 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 1.575-2.047 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 2.047-2.559 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 |
| | P1.2.Z.AN | Acciaio non legato C=0.25-0.55% | 190 | 4324 | 625 | 785 | 900 | 0.591-0.709 | - | 0.002-0.003 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 510 | 640 | 740 | 0.709-0.866 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 395 | 490 | 565 | 0.866-1.063 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.006 | 0.003-0.006 | 0.003-0.007 | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.006 | 0.003-0.007 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | P1.3.Z.AN | Acciaio non legato C=0.55-0.80% | 190 | 4324 | 560 | 735 | 855 | 0.591-0.709 | - | 0.002-0.003 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 460 | 605 | 705 | 0.709-0.866 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 345 | 465 | 545 | 0.866-1.063 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.006 | 0.003-0.007 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | P1.5.C.UT | Acciaio non legato Fuso - non trattato | 150 | 4324 | 460 | 770 | 960 | 0.591-0.709 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 445 | 650 | 785 | 0.709-0.866 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4344 | 410 | 515 | 590 | 0.866-1.063 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 1.063-1.299 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 1.299-1.575 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 1.575-2.047 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 2.047-2.559 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | P2.1.Z.AN | Acciaio debolmente legato Ricotto | 175 | 4324 | 590 | 770 | 900 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 490 | 635 | 740 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 375 | 485 | 565 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P2.2.Z.AN | Acciaio debolmente legato Ricotto | 240 | 4324 | 590 | 745 | 855 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 490 | 590 | 665 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 375 | 510 | 605 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P2.5.Z.HT | Acciaio debolmente legato Temprato | 330 | 4324 | 295 | 565 | 725 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 280 | 465 | 575 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 245 | 365 | 440 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | 0.003-0.007 | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P2.6.C.UT | Acciaio debolmente legato Fuso - non trattato | 200 | 4324 | 360 | 620 | 785 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4334 | 345 | 515 | 620 | 0.709-0.866 | - | - | 0.002-0.005 | **0.002-0.005** | - | - | - | 0.002-0.004 | **0.002-0.004** | - |
| | | | | 4344 | 330 | 410 | 475 | 0.866-1.063 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.008** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.008** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.008** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P3.0.Z.AN | Acciaio fortemente legato Ricotto | 200 | 4324 | 525 | 720 | 855 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 425 | 595 | 705 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 330 | 450 | 530 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | 0.003-0.006 | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |

ITA

# CoroDrill® DS20

## 6-7xD

### Valori in pollici

| ISO | Codice MC | Materiale | HB | Qualità | Dati di taglio consigliati 6-7xD | | | Attacco cilindrico | Lunghezza punta 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza punta 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
| P | P3.0.Z.HT | Acciaio fortemente legato Temprato | 380 | 4324 | 260 | 485 | 620 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 245 | 415 | 520 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 230 | 320 | 385 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P5.0.Z.AN | Acciaio inossidabile ferritico/martensitico Ricotto | 200 | 4334 | 375 | 550 | 665 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 375 | 455 | 520 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 375 | 430 | 485 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 | 0.003-0.003 | **0.003-0.003** | 0.003-0.003 | - | 0.003-0.003 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.003 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | P5.0.Z.HT | Acciaio inossidabile ferritico/martensitico Temprato | 330 | 4334 | 245 | 405 | 505 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 230 | 340 | 415 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 230 | 340 | 415 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 | 0.003-0.003 | **0.003-0.003** | 0.003-0.003 | - | 0.003-0.003 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.003 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | M1.0.Z.AQ | Acciaio inossidabile austenitico Ricotto/bonificato | 200 | 4334 | 375 | 550 | 665 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 375 | 485 | 565 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 375 | 465 | 530 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| M | M1.1.Z.AQ | Acciaio inossidabile austenitico A lavorabilità migliorata | 200 | 4334 | 375 | 575 | 705 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 375 | 520 | 620 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 375 | 500 | 590 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | M2.0.Z.AQ | Acciaio inossidabile superaustenitico (Ni>20%) Ricotto/bonificato | 200 | 4334 | 260 | 370 | 440 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 260 | 325 | 370 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 260 | 325 | 370 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | M3.1.Z.AQ | Acciaio inossidabile duplex >60% ferrite (N<0.10%) | 230 | 4334 | 280 | 365 | 430 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 280 | 340 | 385 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 280 | 330 | 370 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | M3.2.Z.AQ | Acciaio inossidabile duplex >60% ferrite (N<0.10%) | 260 | 4334 | 245 | 310 | 355 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 245 | 295 | 340 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 245 | 295 | 340 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| S | S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS | Superleghe resistenti al calore Base Ni | 350 | 4334 | 65 | 115 | 150 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.002 | **0.002-0.002** | 0.002-0.002 | - | - |
| | | | | 4344 | 65 | 115 | 150 | 0.709-0.866 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.002 | **0.002-0.002** | 0.002-0.002 | - | - |
| | | | | 2044 | 65 | 115 | 150 | 0.866-1.063 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 1.063-1.299 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 1.299-1.575 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 1.575-2.047 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 2.047-2.559 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | S4.2.Z.AN S4.3.Z.AG | Superleghe resistenti al calore Base Ti | 330 | H13A | 130 | 270 | 355 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | 4344 | 130 | 270 | 355 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | 2044 | 130 | 270 | 355 | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - | **0.003-0.004** | 0.003-0.004 | 0.003-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |

L'avanzamento in entrata dovrebbe equivalere al 75% della velocità di avanzamento consigliata. L'avanzamento in uscita dovrebbe essere di 0.05 mm/giro.

# CoroDrill® DS20

**6-7xD**

**Valori in pollici**

| ISO | Codice MC | Materiale | HB | Qualità | Dati di taglio consigliati 6-7xD | | | Attacco cilindrico | Lunghezza punta 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza punta 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
| K | K1.1.C.NS | Ghisa malleabile | 200 | 4324 | 460 | 615 | 725 | 0.591-0.709 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Bassa resistenza | | 4334 | 360 | 495 | 590 | 0.709-0.866 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | 4344 | 590 | 485 | 460 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.008** | - | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | K2.1.C.UT | Ghisa grigia | 180 | 4324 | 690 | 840 | 960 | 0.591-0.709 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Bassa resistenza | | 4334 | 560 | 695 | 795 | 0.709-0.866 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | 4344 | 425 | 525 | 605 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.008** | - | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | K2.2.C.UT | Ghisa grigia | 245 | 4324 | 410 | 600 | 725 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Alta resistenza | | 4334 | 330 | 475 | 575 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 245 | 365 | 440 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | K3.1.C.UT | Ghisa nodulare | 155 | 4324 | 410 | 565 | 665 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Ferritica | | 4334 | 330 | 460 | 545 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 260 | 360 | 430 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | K3.3.C.UT | Ghisa nodulare | 265 | 4324 | 360 | 520 | 620 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Ferritica | | 4334 | 295 | 430 | 520 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 230 | 320 | 385 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | K4.2.C.UT | Ghisa a grafite compatta (CGI) | 230 | 4324 | 425 | 610 | 740 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Alta resistenza | | 4334 | 360 | 495 | 590 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 280 | 375 | 440 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| H | H1.3.Z.HA | Acciaio molto duro | 60 (HRC) | 4324 | 100 | 195 | 250 | 0.591-0.709 | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - |
| | | Temprato | | 4334 | 100 | 195 | 250 | 0.709-0.866 | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - |
| | | | | 4344 | 100 | 195 | 250 | 0.866-1.063 | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | - | 0.003-0.003 | **0.003-0.003** | 0.003-0.003 | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | - | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | - | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | - | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - |

ITA

# CoroDrill® DS20

**6-7xD**

**Valori in pollici**

| ISO | Codice MC | Materiale | HB | Qualità | Dati di taglio consigliati 6-7xD | | | Attacco cilindrico | Lunghezza punta 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Lunghezza punta 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | | Valore iniziale raccomandato a metà del campo di avanzamento | | | | |
| N | N1.2.Z.AG | Leghe a base di alluminio | 100 | H13A | 985 | 1075 | 1180 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | Leghe AlSi, Si ≤ 1% | | 4344 | 985 | 1075 | 1180 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N1.3.C.UT | Leghe a base di alluminio | 75 | H13A | 820 | 1025 | 1180 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | Leghe AlSi, Si ≤ 1% | | 4344 | 820 | 1025 | 1180 | 0.709-0.866 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - | **0.003-0.004** | 0.003-0.004 | 0.003-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N1.3.C.AG | Leghe a base di alluminio | 90 | H13A | 820 | 930 | 1035 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | AlSi cast and aged alloys (1%< Si <13%) | | 4344 | 820 | 930 | 1035 | 0.709-0.866 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - | **0.003-0.004** | 0.003-0.004 | 0.003-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N3.3.U.UT | Leghe a base di rame | 110 | H13A | 820 | 1025 | 1180 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | Leghe a base di rame a lavorabilità migliorata | | 4344 | 820 | 1025 | 1180 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N3.2.C.UT | Leghe a base di rame | 90 | H13A | 590 | 645 | 705 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | Bronzi e ottoni al piombo (Pb ≤ 1%) | | 4344 | 590 | 645 | 705 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |

L'avanzamento in entrata dovrebbe equivalere al 75% della velocità di avanzamento consigliata. L'avanzamento in uscita dovrebbe essere di 0.05 mm/giro.

# CoroDrill® 860-GM



## Valori in millimetri

| ISO | Mc No. | Materiale | Durezza Brinell HB | Vel. di taglio, $v_c$ (m/min) |
|---|---|---|---|---|
| P | | **Acciaio non legato** | | (min-iniziale-max) |
| | P1.1.Z.AN | C = 0.05-0.10% | 125 | 120-145-170 |
| | P1.1.Z.AN | C = 0.1-0.25% | 125 | 120-145-170 |
| | P1.2.Z.AN | C = 0.25-0.55% | 150 | 100-125-150 |
| | P1.3.Z.AN | C = 0.55-0.80% | 170 | 100-125-150 |
| | | **Acciaio ad alto tenore di carbonio** | | |
| | P1.3.Z.AN | Acciaio per utensili al carbonio | 210 | 100-125-150 |
| | | **Acciaio debolmente legato** | | |
| | P2.1.Z.AN | Non trattato | 175 | 100-125-150 |
| | P2.5.Z.HT.1 | Bonificato | 275 | 80-100-120 |
| | P2.5.Z.HT.2 | Bonificato | 350 | 60-80-100 |
| | | **Acciaio fortemente legato** | | |
| | P3.0.Z.AN | Ricotto | 200 | 64-77-90 |
| | P3.0.Z.HT.1 | Acciaio per utensili bonificato | 300 | 64-77-90 |
| | | **Getti di acciaio** | | |
| | P1.5.C.UT | Acciaio non legato | 150 | 64-77-90 |
| | P2.6.C.UT | Debolmente legato (elementi legati < 5%) | 200 | 64-77-90 |

## Valori in pollici

| ISO | Mc No. | Materiale | Durezza Brinell HB | Velocità di taglio ($V_c$), piedi/min |
|---|---|---|---|---|
| P | | **Acciaio non legato** | | (min-iniziale-max) |
| | P1.1.Z.AN | C = 0.05-0.10% | 125 | 393 - 475 - 557 |
| | P1.1.Z.AN | C = 0.1-0.25% | 125 | 393 - 475 - 557 |
| | P1.2.Z.AN | C = 0.25-0.55% | 150 | 328 - 410 - 492 |
| | P1.3.Z.AN | C = 0.55-0.80% | 170 | 328 - 410 - 492 |
| | | **Acciaio ad alto tenore di carbonio** | | |
| | P1.3.Z.AN | Acciaio per utensili al carbonio | 210 | 328 - 410 - 492 |
| | | **Acciaio debolmente legato** | | |
| | P2.1.Z.AN | Non trattato | 175 | 328 - 410 - 492 |
| | P2.5.Z.HT.1 | Bonificato | 275 | 262 - 328 - 393 |
| | P2.5.Z.HT.2 | Bonificato | 350 | 196 - 262 - 328 |
| | | **Acciaio fortemente legato** | | |
| | P3.0.Z.AN | Ricotto | 200 | 209 - 252 - 295 |
| | P3.0.Z.HT.1 | Acciaio per utensili bonificato | 300 | 209 - 252 - 295 |
| | | **Getti di acciaio** | | |
| | P1.5.C.UT | Acciaio non legato | 150 | 209 - 252 - 295 |
| | P2.6.C.UT | Debolmente legato (elementi legati < 5%) | 200 | 209 - 252 - 295 |

## Valori in millimetri

| ISO | Codice MC | Materiale | Durezza Brinell HB | Vel. di taglio, $v_c$ (m/min) |
|---|---|---|---|---|
| M | | **Acciaio inossidabile** | | (min-iniziale-max) |
| | M1.0.Z.AQ | Austenitico | 200 | 30-38-46 |
| | M2.0.Z.AQ | Ni>20% superaustenitico | 200 | 28-36-44 |
| | M3.1.Z.AQ | Duplex (austenitico/ferritico) | 230 | 28-35-42 |
| | M3.2.Z.AQ | Duplex (austenitico/ferritico) | 260 | 26-31-35 |
| | M1.0.C.UT | Austenitico | 200 | 28-36-44 |
| | M2.0.C.AQ | Ni>20% superaustenitico | 200 | 28-36-44 |
| | M3.1.C.AQ | Ferritica | 230 | 24-30-36 |

## Valori in pollici

| ISO | Codice MC | Materiale | Durezza Brinell HB | Velocità di taglio ($V_c$), piedi/min |
|---|---|---|---|---|
| M | | **Acciaio inossidabile** | | (min-iniziale-max) |
| | M1.0.Z.AQ | Austenitico | 200 | 98-125-151 |
| | M2.0.Z.AQ | Ni>20% superaustenitico | 200 | 92-118-144 |
| | M3.1.Z.AQ | Duplex (austenitico/ferritico) | 230 | 92-115-138 |
| | M3.2.Z.AQ | Duplex (austenitico/ferritico) | 260 | 85-102-115 |
| | M1.0.C.UT | Austenitico | 200 | 92-118-144 |
| | M2.0.C.AQ | Ni>20% superaustenitico | 200 | 92-118-144 |
| | M3.1.C.AQ | Ferritica | 230 | 79-98-118 |

# CoroDrill® 860-GM

### Valori in millimetri

| Diametro della punta, mm | | | | | | | |
|---|---|---|---|---|---|---|---|
| 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
| Avanzamento ($f_n$) mm/giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.09-0.12 | 0.08-0.11-0.14 | 0.10-0.14-0.18 | 0.12-0.17-0.23 | 0.14-0.21-0.28 | 0.17-0.24-0.31 | 0.20-0.27-0.34 | 0.23-0.30-0.37 |
| 0.06-0.09-0.12 | 0.08-0.11-0.14 | 0.10-0.14-0.18 | 0.12-0.17-0.23 | 0.14-0.21-0.28 | 0.17-0.24-0.31 | 0.20-0.27-0.34 | 0.23-0.30-0.37 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.09-0.12 | 0.08-0.11-0.14 | 0.10-0.14-0.18 | 0.12-0.17-0.23 | 0.14-0.21-0.28 | 0.17-0.24-0.31 | 0.20-0.27-0.34 | 0.23-0.30-0.37 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |
| 0.06-0.10-0.14 | 0.10-0.16-0.22 | 0.15-0.20-0.25 | 0.16-0.22-0.28 | 0.20-0.25-0.30 | 0.20-0.26-0.34 | 0.24-0.30-0.38 | 0.26-0.34-0.40 |

### Valori in pollici

| Diametro punta, pollici | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0.1181 | 0.1575 | 0.2362 | 0.315 | 0.3937 | 0.4724 | 0.6299 | 0.7874 |
| Avanzamento ($f_n$), poll./giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0090-.0118-.0145 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0090-.0118-.0145 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0090-.0118-.0145 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0090-.0118-.0145 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0090-.0118-.0145 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0090-.0118-.0145 |
| .0023-.0035-.0047 | .0031-.0043-.0055 | .0039-.0055-.0070 | .0047-.0066-.0090 | .0055-.0082-.0110 | .0066-.0094-.0122 | .0078-.0106-.0133 | .0090-.0118-.0145 |
| .0023-.0035-.0047 | .0031-.0043-.0055 | .0039-.0055-.0070 | .0047-.0066-.0090 | .0055-.0082-.0110 | .0066-.0094-.0122 | .0078-.0106-.0133 | .0090-.0118-.0145 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0102-.0133-.0157 |
| .0023-.0035-.0047 | .0031-.0043-.0055 | .0039-.0055-.0070 | .0047-.0066-.0090 | .0055-.0082-.0110 | .0066-.0094-.0122 | .0078-.0106-.0133 | .0090-.0118-.0145 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0102-.0133-.0157 |
| .0023-.0039-.0055 | .0039-.0062-.0086 | .0059-.0078-.0098 | .0062-.0086-.0110 | .0078-.0098-.0118 | .0078-.0102-.0133 | .0094-.0118-.0149 | .0102-.0133-.0157 |

### Valori in millimetri

| Diametro della punta, mm | | | | | | | |
|---|---|---|---|---|---|---|---|
| 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
| Avanzamento ($f_n$) mm/giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.11-0.15-0.17 | 0.18-0.20-0.22 | 0.24-0.28-0.32 | 0.24-0.28-0.32 | 0.28-0.32-0.36 | 0.30-0.34-0.38 |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.13-0.15-0.17 | 0.18-0.20-0.22 | 0.24-0.28-0.32 | 0.24-0.28-0.32 | 0.28-0.32-0.36 | 0.30-0.34-0.38 |
| 0.06-0.07-0.09 | 0.06-0.08-0.10 | 0.09-0.11-0.13 | 0.11-0.14-0.17 | 0.14-0.17-0.20 | 0.16-0.20-0.24 | 0.21-0.23-0.25 | 0.22-0.24-0.26 |
| 0.06-0.07-0.09 | 0.06-0.08-0.10 | 0.09-0.11-0.13 | 0.11-0.14-0.17 | 0.14-0.17-0.20 | 0.16-0.20-0.24 | 0.21-0.23-0.25 | 0.22-0.24-0.26 |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.13-0.15-0.17 | 0.18-0.20-0.22 | 0.24-0.28-0.32 | 0.24-0.28-0.32 | 0.28-0.32-0.36 | 0.30-0.34-0.38 |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.13-0.15-0.17 | 0.18-0.20-0.22 | 0.24-0.28-0.32 | 0.24-0.28-0.32 | 0.28-0.32-0.36 | 0.30-0.34-0.38 |
| 0.05-0.07-0.09 | 0.06-0.08-0.10 | 0.09-0.11-0.13 | 0.11-0.14-0.17 | 0.14-0.17-0.20 | 0.16-0.20-0.24 | 0.21-0.23-0.25 | 0.22-0.24-0.26 |

### Valori in pollici

| Diametro punta, pollici | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0.1181 | 0.1575 | 0.2362 | 0.315 | 0.3937 | 0.4724 | 0.6299 | 0.7874 |
| Avanzamento $f_n$, pollici/giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| .0031-.0039-.0047 | .0039-.0047-.0055 | .0043-.0059-.0067 | .0071-.0079-.0087 | .0094-.0110-.0126 | .0094-.0110-.0126 | .0110-.0126-.0142 | .0118-.0134-.0150 |
| .0031-.0039-.0047 | .0039-.0047-.0055 | .0051-.0059-.0067 | .0071-.0079-.0087 | .0094-0.011-.0126 | .0094-.0110-.0126 | .0110-.0126-.0142 | .0118-.0134-.0150 |
| .0024-.0028-.0035 | .0024-.0031-.0039 | .0035-.0043-.0051 | .0043-.0055-.0067 | .0055-.0067-.0079 | .0063-.0079-.0094 | .0083-.0091-.0098 | .0087-.0094-.0102 |
| .0024-.0028-.0035 | .0024-.0031-.0039 | .0035-.0043-.0051 | .0043-.0055-.0067 | .0055-.0067-.0079 | .0063-.0079-.0094 | .0083-.0091-.0098 | .0087-.0094-.0102 |
| .0031-.0039-.0047 | .0039-.0047-.0055 | .0051-.0059-.0067 | .0071-.0079-.0087 | .0094-.0110-.0126 | .0094-.0110-.0126 | .0110-.0126-.0142 | .0118-.0134-.0150 |
| .0031-.0039-.0047 | .0039-.0047-.0055 | .0051-.0059-.0067 | .0071-.0079-.0087 | .0094-.0110-.0126 | .0094-.0110-.0126 | .0110-.0126-.0142 | .0118-.0134-.0150 |
| .0020-.0028-.0035 | .0024-.0031-.0039 | .0035-.0043-.0051 | .0043-.0055-.0067 | .0055-.0067-.0079 | .0063-.0079-.0094 | .0083-.0091-.0098 | .0087-.0094-.0102 |

# CoroDrill® 860-GM

### Valori in millimetri

| ISO | Codice MC | Materiale | Durezza Brinell HB | Vel. di taglio, $v_c$ (m/min) |
|---|---|---|---|---|
| K | | **Ghisa malleabile** | | (min-iniziale-max) |
| | K1.1.C.NS | Ferritica Perlitica | 200 | 80-100-120 |
| | | **Ghisa grigia** | | |
| | K2.1.C.UT | Bassa resistenza | 180 | 100-120-140 |
| | K2.2.C.UT | Alta resistenza | 245 | 80-100-120 |
| | K2.3.C.UT | Alta resistenza | 175 | 100-120-140 |
| | | **Ghisa nodulare** | | |
| | K3.1.C.UT | Ferritica | 155 | 100-120-140 |
| | K3.2.C.UT | Perlitica | 215 | 80-100-120 |
| | K3.3.C.UT | Perlitica | 265 | 100-120-140 |
| | K3.5.C.UT | Perlitica | 190 | 100-120-140 |
| | K5.1.C.UT | ADI | 300 | 60-80-100 |

### Valori in pollici

| ISO | Codice MC | Materiale | Durezza Brinell HB | Velocità di taglio ($V_c$), piedi/min |
|---|---|---|---|---|
| K | | **Ghisa malleabile** | | (min-iniziale-max) |
| | K1.1.C.NS | Ferritica Perlitica | 200 | 262-328-393 |
| | | **Ghisa grigia** | | |
| | K2.1.C.UT | Bassa resistenza | 180 | 328-393-459 |
| | K2.2.C.UT | Alta resistenza | 245 | 262-328-393 |
| | K2.3.C.UT | Alta resistenza | 175 | 328-393-459 |
| | | **Ghisa nodulare** | | |
| | K3.1.C.UT | Ferritica | 155 | 328-393-459 |
| | K3.2.C.UT | Perlitica | 215 | 262-328-393 |
| | K3.3.C.UT | Perlitica | 265 | 328-393-459 |
| | K3.5.C.UT | Perlitica | 190 | 328-393-459 |
| | K5.1.C.UT | ADI | 300 | 196-262-328 |

### Valori in millimetri

| ISO | Codice MC | Materiale | Durezza Brinell HB | Vel. di taglio, $v_c$ (m/min) |
|---|---|---|---|---|
| S | | **Superleghe resistenti al calore – Base nichel** | | (min-iniziale-max) |
| | S2.0.Z.AN | Ricotte o solubilizzate | 250 | 15-20-25 |
| | S2.0.Z.AG | Invecchiate o solubilizzate ed invecchiate | 350 | 10-15-20 |
| | S2.0.C.NS | Fuse o fuse e invecchiate | 320 | 10-15-20 |
| | | **Leghe di titanio** | | |
| | S4.1.Z.UT | Austenitico | 200 | 40-50-60 |
| | S4.2.Z.AN | Ricotto | 180 | 40-50-60 |
| | S4.3.Z.AG | Leghe invecchiate | 245 | 30-40-50 |

### Valori in pollici

| ISO | Codice MC | Materiale | Durezza Brinell HB | Velocità di taglio ($V_c$), piedi/min |
|---|---|---|---|---|
| S | | **Superleghe resistenti al calore – Base nichel** | | (min-iniziale-max) |
| | S2.0.Z.AN | Ricotte o solubilizzate | 250 | 49-65-82 |
| | S2.0.Z.AG | Invecchiate o solubilizzate ed invecchiate | 350 | 32-49-65 |
| | S2.0.C.NS | Fuse o fuse e invecchiate | 320 | 32-49-65 |
| | | **Leghe di titanio** | | |
| | S4.1.Z.UT | Austenitico | 200 | 131-164-196 |
| | S4.2.Z.AN | Ricotto | 180 | 131-164-196 |
| | S4.3.Z.AG | Leghe invecchiate | 245 | 98-131-164 |

# CoroDrill® 860-GM

### Valori in millimetri

| Diametro della punta, mm | | | | | | | |
|---|---|---|---|---|---|---|---|
| 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
| Avanzamento ($f_n$) mm/giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.12-0.16-0.18 | 0.16-0.20-0.24 | 0.20-0.25-0.30 | 0.22-0.28-0.33 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |
| 0.10-0.15-0.20 | 0.14-0.18-0.23 | 0.16-0.22-0.27 | 0.20-0.26-0.312 | 0.26-0.33-0.40 | 0.30-0.38-0.45 | 0.34-0.43-0.51 | 0.36-0.45-0.54 |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.12-0.16-0.18 | 0.16-0.20-0.24 | 0.20-0.25-0.30 | 0.22-0.28-0.33 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |
| 0.10-0.15-0.20 | 0.14-0.18-0.23 | 0.16-0.22-0.27 | 0.20-0.26-0.31 | 0.26-0.33-0.40 | 0.30-0.38-0.45 | 0.34-0.43-0.51 | 0.36-0.45-0.54 |
| 0.10-0.13-0.15 | 0.12-0.15-0.18 | 0.16-0.20-0.24 | 0.20-0.26-0.31 | 0.26-0.33-0.40 | 0.30-0.38-0.45 | 0.34-0.43-0.51 | 0.36-0.45-0.54 |
| 0.08-0.12-0.16 | 0.12-0.15-0.18 | 0.14-0.18-0.20 | 0.18-0.23-0.28 | 0.20-0.27-0.34 | 0.24-0.30-0.36 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |
| 0.08-0.12-0.16 | 0.12-0.15-0.18 | 0.14-0.18-0.20 | 0.18-0.23-0.28 | 0.20-0.27-0.34 | 0.24-0.30-0.36 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |
| 0.10-0.13-0.15 | 0.12-0.15-0.18 | 0.16-0.20-0.24 | 0.20-0.26-0.31 | 0.26-0.33-0.40 | 0.30-0.38-0.45 | 0.34-0.43-0.51 | 0.36-0.45-0.54 |
| 0.08-0.12-0.16 | 0.12-0.15-0.18 | 0.14-0.18-0.20 | 0.18-0.23-0.28 | 0.20-0.27-0.34 | 0.24-0.30-0.36 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |

### Valori in pollici

| Diametro punta, pollici | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0.1181 | 0.1575 | 0.2362 | 0.315 | 0.3937 | 0.4724 | 0.6299 | 0.7874 |
| Avanzamento ($f_n$), poll./giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| .0031-.0039-.0047 | .0039-.0047-.0055 | .0047-.0062-.0071 | .0062-.0078-.0094 | .0078-.0098-.0118 | .0086-.0110-.0129 | .0098-.0125-.0149 | .0160-.0133-.0157 |
| .0039-.0059-.0078 | .0055-.0070-.0090 | .0062-.0086-.0106 | .0078-.0102-.0122 | .0102-.0129-.0157 | .0118-.0149-.0177 | .0133-.0169-.0200 | .0141-.0177-.0213 |
| .0031-.0039-.0047 | .0039-.0047-.0055 | .0047-.0062-.0071 | .0062-.0078-.0094 | .0078-.0098-.0118 | .0086-.0110-.0129 | .0098-.0125-.0149 | .0160-.0133-.0157 |
| .0039-.0059-.0078 | .0055-.0070-.0090 | .0062-.0086-.0106 | .0078-.0102-.0122 | .0102-.0129-.0157 | .0118-.0149-.0177 | .0133-.0169-.0200 | .0141-.0177-.0213 |
| .0039-.0051-.0059 | .0047-.0059-.0070 | 0062-.0078-.0094 | .0078-.0102-.0122 | .0102-.0129-.0157 | .0118-.0149-.0177 | .0133-.0169-.0200 | .0141-.0177-.0213 |
| .0031-.0047-.0062 | .0047-.0059-.0070 | .0055-.0070-.0078 | .0070-.0090-.0110 | .0078-.0106-.0133 | .0094-.0128-.0141 | .0098-.0125-.0149 | .0160-.0133-.0157 |
| .0031-.0047-.0062 | .0047-.0059-.0070 | .0055-.0070-.0078 | .0070-.0090-.0110 | .0078-.0106-.0133 | .0094-.0128-.0141 | .0098-.0125-.0149 | .0160-.0133-.0157 |
| .0039-.0051-.0059 | .0047-.0059-.0070 | 0062-.0078-.0094 | .0078-.0102-.0122 | .0102-.0129-.0157 | .0118-.0149-.0177 | .0133-.0169-.0200 | .0141-.0177-.0213 |
| .0031-.0047-.0062 | .0047-.0059-.0070 | .0055-.0070-.0078 | .0070-.0090-.0110 | .0078-.0106-.0133 | .0094-.0128-.0141 | .0098-.0125-.0149 | .0160-.0133-.0157 |

### Valori in millimetri

| Diametro della punta, mm | | | | | | | |
|---|---|---|---|---|---|---|---|
| 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
| Avanzamento ($f_n$) mm/giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.08-0.10-0.12 | 0.08-0.10-0.12 | 0.10-0.12-0.15 | 0.10-0.12-0.15 | 0.10-0.12-0.15 |
| 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.08-0.10-0.12 | 0.08-0.10-0.12 | 0.10-0.12-0.15 | 0.10-0.12-0.15 | 0.10-0.12-0.15 |
| 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.08-0.10-0.12 | 0.08-0.10-0.12 | 0.10-0.12-0.15 | 0.10-0.12-0.15 | 0.10-0.12-0.15 |
| 0.06-0.08-0.12 | 0.06-0.08-0.12 | 0.06-0.08-0.12 | 0.08-0.12-0.16 | 0.10-0.14-0.16 | 0.12-0.16-0.20 | 0.16-0.20-0.24 | 0.20-0.25-0.30 |
| 0.06-0.08-0.12 | 0.06-0.08-0.12 | 0.06-0.08-0.12 | 0.08-0.12-0.16 | 0.10-0.14-0.16 | 0.12-0.16-0.20 | 0.16-0.20-0.24 | 0.20-0.25-0.30 |
| 0.06-0.08-0.12 | 0.06-0.08-0.12 | 0.06-0.08-0.12 | 0.08-0.12-0.16 | 0.10-0.14-0.16 | 0.12-0.16-0.20 | 0.16-0.20-0.24 | 0.20-0.25-0.30 |

### Valori in pollici

| Diametro punta, pollici | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0.1181 | 0.1575 | 0.2362 | 0.315 | 0.3937 | 0.4724 | 0.6299 | 0.7874 |
| Avanzamento ($f_n$), poll./giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0039-.0047 | .0039-.0047-.0059 | .0039-.0047-.0059 | .0039-.0047-.0059 |
| .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0039-.0047 | .0039-.0047-.0059 | .0039-.0047-.0059 | .0039-.0047-.0059 |
| .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0039-.0047 | .0039-.0047-.0059 | .0039-.0047-.0059 | .0039-.0047-.0059 |
| .0023-.0031-.0051 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0047-.0062 | .0039-.0055-.0062 | .0047-.0062-.0078 | .0062-.0078-.0094 | .0078-.0098-.0118 |
| .0023-.0031-.0051 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0047-.0062 | .0039-.0055-.0062 | .0047-.0062-.0078 | .0062-.0078-.0094 | .0078-.0098-.0118 |
| .0023-.0031-.0051 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0047-.0062 | .0039-.0055-.0062 | .0047-.0062-.0078 | .0062-.0078-.0094 | .0078-.0098-.0118 |

# CoroDrill® 860-GM

### Valori in millimetri

| ISO | Codice MC | Materiale | Durezza Brinell HB | Vel. di taglio, $v_c$ (m/min) |
|---|---|---|---|---|
| N | | **Leghe a base di alluminio** | | (min-iniziale-max) |
| | N1.2.Z.UT | Commercialmente puro | 60 | 170-225-280 |
| | N1.2.Z.AG | **Leghe AlSi, Si ≤ 1%** | 100 | 170-225-280 |
| | N1.3.C.UT | Fuse, non invecchiate | 75 | 170-225-280 |
| | N1.3.C.AG | Fuse o fuse e invecchiate | 90 | 160-200-240 |
| | N1.4.C.NS | Leghe fuse AlSi, Si ≥ 13% | 130 | 120-150-180 |
| | | **Leghe a base di rame** | | |
| | N3.3.U.UT | Leghe a lavorabilità migliorata (Pb > 1%) | 110 | 110-140-170 |
| | N3.1.U.UT | Leghe di rame senza piombo (incl. rame elettrolitico) | 100 | 100-125-150 |

### Valori in pollici

| ISO | Codice MC | Materiale | Durezza Brinell HB | Velocità di taglio ($V_c$), piedi/min |
|---|---|---|---|---|
| N | | **Leghe a base di alluminio** | | (min-iniziale-max) |
| | N1.2.Z.UT | Commercialmente puro | 60 | 557-738-918 |
| | N1.2.Z.AG | **Leghe AlSi, Si ≤ 1%** | 100 | 557-738-918 |
| | N1.3.C.UT | Fuse, non invecchiate | 75 | 557-738-918 |
| | N1.3.C.AG | Fuse o fuse e invecchiate | 90 | 524-656-787 |
| | N1.4.C.NS | Leghe fuse AlSi, Si ≥ 13% | 130 | 393-492-590 |
| | | **Leghe a base di rame** | | |
| | N3.3.U.UT | Leghe a lavorabilità migliorata (Pb > 1%) | 110 | 360-459-557 |
| | N3.1.U.UT | Leghe di rame senza piombo (incl. rame elettrolitico) | 100 | 328-410-492 |

### Valori in millimetri

| ISO | Codice MC | Materiale | Durezza Brinell HB | Vel. di taglio, $v_c$ (m/min) |
|---|---|---|---|---|
| H | | **Acciaio molto duro** | | (min-iniziale-max) |
| | H1.3.Z.HA | Bonificato | 47-60 HRC | 15-20-25 |
| | H1.3.Z.HA | | 47-60 HRC | 15-20-25 |
| | H1.1.Z.HA | Bonificato | 50 HRC | 15-20-25 |
| | H2.0.C.UT.4 | Ghisa fusa in conchiglia | 64HRC | 12-15-18 |

### Valori in pollici

| ISO | Codice MC | Materiale | Durezza Brinell HB | Velocità di taglio ($V_c$), piedi/min |
|---|---|---|---|---|
| H | | **Acciaio molto duro** | | (min-iniziale-max) |
| | H1.3.Z.HA | Bonificato | 47-60 HRC | 49-65-82 |
| | H1.3.Z.HA | | 47-60 HRC | 49-65-82 |
| | H1.1.Z.HA | Bonificato | 50 HRC | 49-65-82 |
| | H2.0.C.UT.4 | Ghisa fusa in conchiglia | 64HRC | 39-49-59 |

# CoroDrill® 860-GM

### Valori in millimetri

| Diametro della punta, mm | | | | | | | |
|---|---|---|---|---|---|---|---|
| 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
| Avanzamento ($f_n$) mm/giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| 0.10-0.13-0.15 | 0.12-0.15-0.18 | 0.16-0.20-0.24 | 0.20-0.26-0.30 | 0.26-0.33-0.39 | 0.22-0.28-0.33 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |
| 0.10-0.13-0.15 | 0.12-0.15-0.18 | 0.16-0.20-0.24 | 0.20-0.26-0.30 | 0.26-0.33-0.39 | 0.22-0.28-0.33 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |
| 0.10-0.13-0.15 | 0.12-0.15-0.18 | 0.16-0.20-0.24 | 0.20-0.26-0.31 | 0.26-0.33-0.40 | 0.30-0.38-0.45 | 0.34-0.43-0.51 | 0.36-0.45-0.54 |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.12-0.16-0.18 | 0.16-0.20-0.24 | 0.20-0.25-0.30 | 0.22-0.28-0.33 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |
| 0.10-0.13-0.15 | 0.10-0.12-0.14 | 0.16-0.20-0.24 | 0.20-0.26-0.31 | 0.26-0.33-0.40 | 0.30-0.38-0.45 | 0.34-0.43-0.51 | 0.36-0.45-0.54 |
| 0.10-0.13-0.15 | 0.12-0.15-0.18 | 0.16-0.20-0.24 | 0.20-0.26-0.31 | 0.26-0.33-0.40 | 0.30-0.38-0.45 | 0.34-0.43-0.51 | 0.36-0.45-0.54 |
| 0.08-0.10-0.12 | 0.10-0.12-0.14 | 0.12-0.16-0.18 | 0.16-0.20-0.24 | 0.20-0.25-0.30 | 0.22-0.28-0.33 | 0.25-0.32-0.38 | 0.27-0.34-0.40 |

### Valori in pollici

| Diametro punta, pollici | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0.1181 | 0.1575 | 0.2362 | 0.315 | 0.3937 | 0.4724 | 0.6299 | 0.7874 |
| Avanzamento ($f_n$), poll./giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| .0039-.0051-.0060 | .0047-.0059-.0070 | .0062-.0078-.0094 | .0078-.0102-.0122 | .0102-.0129-.0153 | .0086-.0110-.0129 | .0098-.0125-.0149 | .0106-.0133-.0157 |
| .0039-.0051-.0060 | .0047-.0059-.0070 | .0062-.0078-.0094 | .0078-.0102-.0122 | .0102-.0129-.0153 | .0086-.0110-.0129 | .0098-.0125-.0149 | .0106-.0133-.0157 |
| .0039-.0051-.0060 | .0047-.0059-.0070 | .0062-.0078-.0094 | .0078-.0102-.0122 | .0102-.0129-.0167 | .0118-.0149-.0178 | .0134-.0169-.0201 | .0141-.0177-.0212 |
| .0031-.0039-.0048 | .0039-.0047-.0055 | .0047-.0062-.0070 | .0062-.0078-.0094 | .0078-.0098-.0118 | .0086-.0110-.0129 | .0098-.0125-.0149 | .0106-.0133-.0157 |
| .0039-.0051-.0060 | .0047-.0059-.0070 | .0062-.0078-.0094 | .0078-.0102-.0122 | .0102-.0129-.0167 | .0118-.0149-.0178 | .0134-.0169-.0201 | .0141-.0177-.0212 |
| .0039-.0051-.0060 | .0047-.0059-.0070 | .0062-.0078-.0094 | .0078-.0102-.0122 | .0102-.0129-.0167 | .0118-.0149-.0178 | .0134-.0169-.0201 | .0141-.0177-.0212 |
| .0031-.0039-.0048 | .0039-.0047-.0055 | .0047-.0062-.0070 | .0062-.0078-.0094 | .0078-.0098-.0118 | .0086-.0110-.0129 | .0098-.0125-.0149 | .0106-.0133-.0157 |

### Valori in millimetri

| Diametro della punta, mm | | | | | | | |
|---|---|---|---|---|---|---|---|
| 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
| Avanzamento ($f_n$) mm/giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.08-0.10-0.12 | 0.10-0.12-0.15 | 0.12-0.15-0.18 | 0.12-0.15-0.18 | 0.12-0.15-0.18 |
| 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.08-0.10-0.12 | 0.10-0.11-0.13 | 0.10-0.11-0.13 | 0.12-0.13-0.15 | 0.12-0.13-0.15 |
| 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.08-0.10-0.12 | 0.10-0.12-0.15 | 0.12-0.15-0.18 | 0.12-0.15-0.18 | 0.12-0.15-0.18 |
| 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.06-0.08-0.10 | 0.08-0.10-0.12 | 0.10-0.11-0.13 | 0.10-0.11-0.13 | 0.12-0.13-0.15 | 0.12-0.13-0.15 |

### Valori in pollici

| Diametro punta, pollici | | | | | | | |
|---|---|---|---|---|---|---|---|
| 0.1181 | 0.1575 | 0.2362 | 0.315 | 0.3937 | 0.4724 | 0.6299 | 0.7874 |
| Avanzamento ($f_n$), poll./giro | | | | | | | |
| (min-iniziale-max) | | | | | | | |
| .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0039-.0047 | .0039-.0047-.0059 | .0047-.0059-.0070 | .0047-.0059-.0070 | .0047-.0059-.0070 |
| .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0039-.0047 | .0039-.0043-.0051 | .0039-.0043-.0051 | .0047-.0051-.0059 | .0047-.0051-.0059 |
| .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0039-.0047 | .0039-.0047-.0059 | .0047-.0059-.0070 | .0047-.0059-.0070 | .0047-.0059-.0070 |
| .0023-.0031-.0039 | .0023-.0031-.0039 | .0023-.0031-.0039 | .0031-.0039-.0047 | .0039-.0043-.0051 | .0039-.0043-.0051 | .0047-.0051-.0059 | .0047-.0051-.0059 |

# Selezione dei dati di taglio

Formazione ed evacuazione truciolo sono problemi critici nella foratura e dipendono dal materiale del pezzo, dalla scelta della punta/geometria di inserto, dalla pressione e dal volume del refrigerante e dai dati di taglio. L'intasamento da truciolo può provocare il movimento radiale della punta e incidere, di conseguenza, su qualità del foro, durata e affidabilità della punta e rischio di rottura della punta o dell'inserto.

La formazione dei trucioli è accettabile quando i trucioli possono essere evacuati dalla punta senza ostacoli. Il modo migliore per individuarlo è ascoltare il tipo di rumore. Un suono costante significa che l'evacuazione truciolo è buona, mentre un rumore interrotto denota intasamento da truciolo. Controllare il monitor della forza di avanzamento o della potenza. In presenza di irregolarità, la ragione può essere l'intasamento da truciolo. Osservare i trucioli: se sono lunghi e piegati anziché arrotolati, si è verificato un intasamento. Osservare il foro: in presenza di intasamento da truciolo, la superficie sarà irregolare

**Effetti della velocità di taglio – $v_c$**

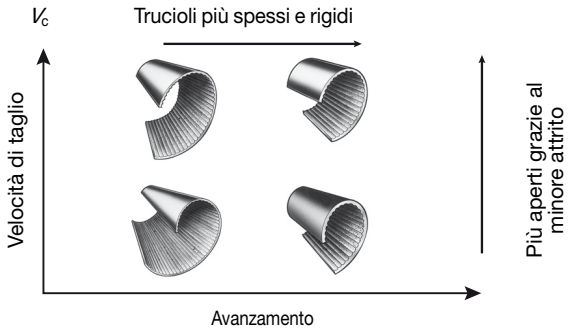
**Velocità di taglio troppo elevata:**
Rapida usura sul fianco
Deformazione plastica
Scarsa qualità e scorretta tolleranza del foro

**Velocità di taglio troppo ridotta:**
Tagliente di riporto
Inadeguata evacuazione truciolo
Tempi di taglio più lunghi

**Effetti dell'avanzamento – $f_n$**

**Alta velocità di avanzamento:**
Più difficile controllo truciolo
Tempo di taglio inferiore
Minore usura dell'utensile ma maggior rischio di rottura della punta
Ridotta qualità del foro

**Velocità di avanzamento bassa:**
Preferibile per i materiali a truciolo lungo
Maggiore qualità
Usura accelerata degli utensili
Tempi di taglio più lunghi




## Come ottenere una buona qualità del foro

**Evacuazione del truciolo**
Verificare che l'evacuazione truciolo sia soddisfacente. L'intasamento da truciolo influisce su qualità del foro e affidabilità/durata utensile. La geometria di punta/inserto e i dati di taglio sono cruciali.

**Stabilità, setup dell'utensile**
Utilizzare la punta più corta possibile. Utilizzare un portautensili rigido e preciso, con runout minimo. Verificare che il mandrino della macchina sia in buone condizioni e correttamente allineato. Verificare che il componente sia saldamente fissato e stabile. Stabilire le velocità di avanzamento corrette per le superfici irregolari o angolari e per i fori incrociati.

**Durata tagliente**
Controllare l'usura dell'inserto e stabilire un programma predeterminato di durata utensile. Il modo più efficace di supervisionare la foratura consiste nell'utilizzare un sensore per il monitoraggio della forza di avanzamento.

**Manutenzione**
Cambiare regolarmente la vite di bloccaggio dell'inserto. Pulire la sede della cuspide prima di cambiare l'inserto e utilizzare una chiave torsiometrica. Non superare l'usura massima consentita prima di riaffilare le punte in metallo duro integrale.

**Foratura profonda con CoroDrill® DS20**
Se nella realizzazione di fori 6-7xD con CoroDrill DS20 occorre la migliore qualità del foro possibile, è importante utilizzare una velocità di avanzamento ridotta in entrata (primi 1-2 mm) (.039-.787 poll.) e in uscita (ultimi 5 mm) (.197 poll.).

# Barenatura

## Sgrossatura

CoroBore® BR30 D2

## Barenatura di precisione

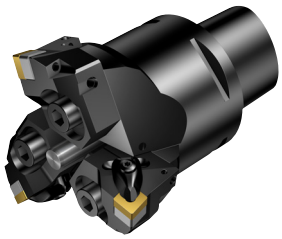
CoroBore® 826 XL D3-D8

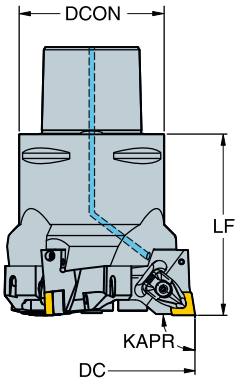
Per informazioni sulla gamma completa, visitare il sito www.sandvik.coromant.com/it

# CoroBore® BR30, bareno di sgrossatura a tre taglienti

**Coromant Capto® - adduzione interna di refrigerante**

KAPR 90°






CNMM
CNMG
CNMA, CNGA

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Codice di ordinazione | $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | Dimensioni in mm e pollici | | | | | | | |
| 106.00 | 122.00 | 12 | 1/2 | C8 | 3 | **BR30-122CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.190 | 3 | CNMG 12 04 08 |
| 4.173 | 4.803 | | | | | | 3.150 | .315 | 3.937 | 1015 | | | |
| 121.00 | 137.00 | 12 | 1/2 | C8 | 3 | **BR30-137CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.340 | 3 | CNMG 12 04 08 |
| 4.764 | 5.394 | | | | | | 3.150 | .315 | 3.937 | 1015 | | | |
| 136.00 | 152.00 | 12 | 1/2 | C8 | 3 | **BR30-152CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.820 | 3 | CNMG 12 04 08 |
| 5.354 | 5.984 | | | | | | 3.150 | .315 | 3.937 | 1015 | | | |
| 151.00 | 167.00 | 12 | 1/2 | C8 | 3 | **BR30-167CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.970 | 3 | CNMG 12 04 08 |
| 5.945 | 6.575 | | | | | | 3.150 | .315 | 3.937 | 1015 | | | |

Per componenti, accessori e parti di ricambio degli utensili per barenatura, visitare il sito www.sandvik.coromant.com/it
Per gli inserti, consultare il catalogo "Utensili di tornitura"

ISO 13399 G2

CNSC CXSC G5



SANDVIK Coromant

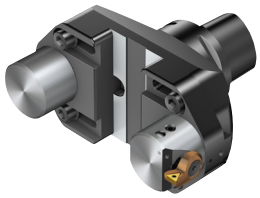
ITA

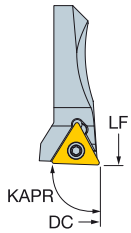
# CoroBore® 826 XL, bareno microregistrabile

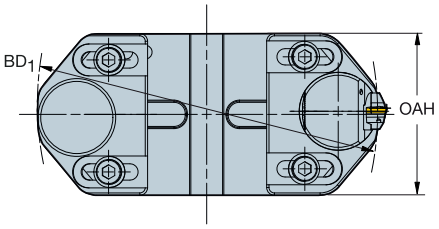
**Coromant Capto® - adduzione di refrigerante ad alta precisione**

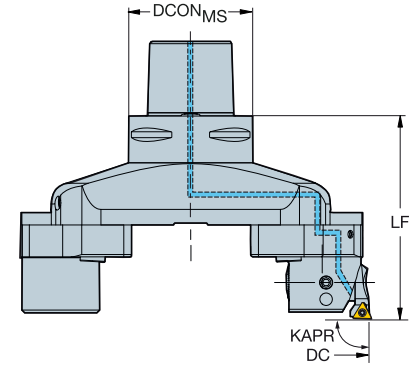
KAPR
STDNO

92°
ISO26623-1





TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Codice di ordinazione | Dimensioni in mm e pollici $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 154.35 | 207.65 | 11 | 1/4 | C6 | 3 | **826-207TC11-C6HP** | 63.00 | 26.65 | 125.00 | 104.00 | 145.00 | 70 | 3.560 | 1 | TCMT 11 03 04 |
| 6.077 | 8.175 | | | | | | 2.480 | 1.049 | 4.921 | 4.094 | 5.709 | 1015 | | | |
| 154.35 | 207.65 | 11 | 1/4 | C8 | 3 | **826-207TC11-C8HP** | 80.00 | 26.65 | 137.00 | 104.00 | 145.00 | 70 | 6.430 | 1 | TCMT 11 03 04 |
| 6.077 | 8.175 | | | | | | 3.150 | 1.049 | 5.394 | 4.094 | 5.709 | 1015 | | | |
| 204.35 | 257.65 | 11 | 1/4 | C6 | 3 | **826-257TC11-C6HP** | 63.00 | 26.65 | 125.00 | 104.00 | 195.00 | 70 | 3.880 | 1 | TCMT 11 03 04 |
| 8.045 | 10.144 | | | | | | 2.480 | 1.049 | 4.921 | 4.094 | 7.677 | 1015 | | | |
| 204.35 | 257.65 | 11 | 1/4 | C8 | 3 | **826-257TC11-C8HP** | 80.00 | 26.65 | 137.00 | 104.00 | 195.00 | 70 | 7.630 | 1 | TCMT 11 03 04 |
| 8.045 | 10.144 | | | | | | 3.150 | 1.049 | 5.394 | 4.094 | 7.677 | 1015 | | | |
| 254.35 | 307.65 | 11 | 1/4 | C6 | 3 | **826-307TC11-C6HP** | 63.00 | 26.65 | 125.00 | 104.00 | 245.00 | 70 | 4.240 | 1 | TCMT 11 03 04 |
| 10.014 | 12.112 | | | | | | 2.480 | 1.049 | 4.921 | 4.094 | 9.646 | 1015 | | | |
| 254.35 | 307.65 | 11 | 1/4 | C8 | 3 | **826-307TC11-C8HP** | 80.00 | 26.65 | 137.00 | 104.00 | 245.00 | 70 | 8.720 | 1 | TCMT 11 03 04 |
| 10.014 | 12.112 | | | | | | 3.150 | 1.049 | 5.394 | 4.094 | 9.646 | 1015 | | | |

I diametri sono validi per la barenatura frontale.

La barenatura in tirata non è consigliata con CoroBore® 826

Per componenti, accessori e parti di ricambio degli utensili per barenatura, visitare il sito www.sandvik.coromant.com/it

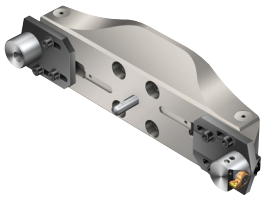
Per gli inserti, consultare il catalogo "Utensili di tornitura"

ISO 13399 G2

CNSC CXSC G5

# CoroBore® 826 XL, bareno microregistrabile

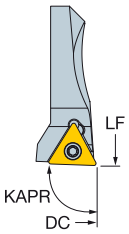
**Arbor - Adduzione di refrigerante ad alta precisione**

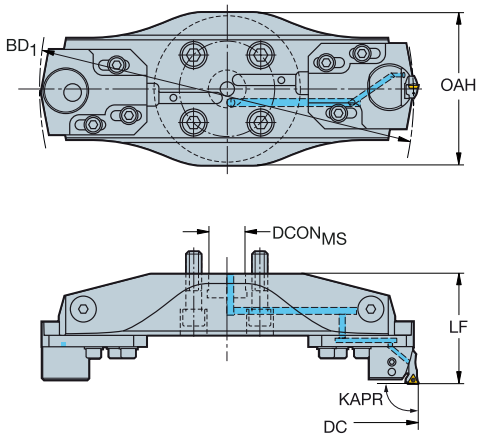


TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Codice di ordinazione | Dimensioni in mm e pollici $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 304.35 | 387.65 | 11 | 1/4 | 40X | 1 | **826-387TC11HP** | 40.00 | 41.65 | 121.00 | 164.00 | 295.00 | 70 | 8.870 | 1 | TCMT 11 03 04 |
| 11.982 | 15.262 | | | | | | 1.575 | 1.640 | 4.764 | 6.457 | 11.614 | 1015 | | | |
| 384.35 | 467.65 | 11 | 1/4 | 40X | 1 | **826-467TC11HP** | 40.00 | 41.65 | 126.00 | 164.00 | 375.00 | 70 | 10.400 | 1 | TCMT 11 03 04 |
| 15.132 | 18.411 | | | | | | 1.575 | 1.640 | 4.961 | 6.457 | 14.764 | 1015 | | | |
| 464.35 | 547.65 | 11 | 1/4 | 40X | 1 | **826-547TC11HP** | 40.00 | 41.65 | 131.00 | 164.00 | 455.00 | 70 | 12.340 | 1 | TCMT 11 03 04 |
| 18.282 | 21.561 | | | | | | 1.575 | 1.640 | 5.157 | 6.457 | 17.913 | 1015 | | | |

I diametri sono validi per la barenatura frontale.
La barenatura in tirata non è consigliata con CoroBore® 826
Utilizzare solo con gli attacchi 40X CoroBore XL. Da ordinare separatamente. Vedere il catalogo "Utensili rotanti"
In caso di flangia diretta al mandrino utilizzare una spina di centraggio, vedere il catalogo "Utensili rotanti"

Per componenti, accessori e parti di ricambio degli utensili per barenatura, visitare il sito www.sandvik.coromant.com/it
Per gli inserti, consultare il catalogo "Utensili di tornitura"

ISO 13399 G2
CNSC CXSC G5

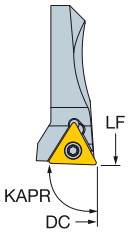
ITA

# CoroBore® 826 XL, bareno microregistrabile

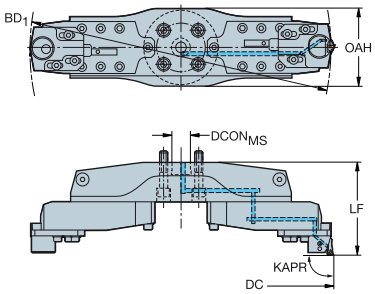
**Arbor - Adduzione di refrigerante ad alta precisione**

**Con estensione ponte**

KAPR




92°



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DCN | DCX | ↔ | IC | $CZC_{MS}$ | CNSC | Codice di ordinazione | Dimensioni in mm e pollici $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 544.35 | 787.65 | 11 | 1/4 | 40X | 1 | **826-787TC11HP** | 40.00 | 121.65 | 205.00 | 164.00 | 535.00 | 70 | 24.430 | 1 | TCMT 11 03 04 |
| *21.431* | *31.010* | | | | | | *1.575* | *4.789* | *8.071* | *6.457* | *21.063* | *1015* | | | |
| 784.35 | 1027.65 | 11 | 1/4 | 40X | 1 | **826-1027TC11HP** | 40.00 | 121.65 | 225.00 | 164.00 | 775.00 | 70 | 35.060 | 1 | TCMT 11 03 04 |
| *30.880* | *40.459* | | | | | | *1.575* | *4.789* | *8.858* | *6.457* | *30.512* | *1015* | | | |
| 1024.35 | 1267.65 | 11 | 1/4 | 40X | 1 | **826-1267TC11HP** | 40.00 | 121.65 | 225.00 | 164.00 | 1015.00 | 70 | 44.110 | 1 | TCMT 11 03 04 |
| *40.329* | *49.908* | | | | | | *1.575* | *4.789* | *8.858* | *6.457* | *39.961* | *1015* | | | |

I diametri sono validi per la barenatura frontale.

La barenatura in tirata non è consigliata con CoroBore® 826

Utilizzare solo con gli attacchi 40X CoroBore XL. Da ordinare separatamente. Vedere il catalogo "Utensili rotanti"

In caso di flangia diretta al mandrino utilizzare una spina di centraggio, vedere il catalogo "Utensili rotanti"

Per componenti, accessori e parti di ricambio degli utensili per barenatura, visitare il sito www.sandvik.coromant.com/it

Per gli inserti, consultare il catalogo "Utensili di tornitura"

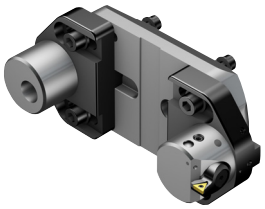
ISO 13399 G2

CNSC CXSC G5

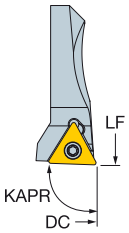
# CoroBore® 826 XL, bareno microregistrabile

**Arbor - Adduzione di refrigerante ad alta precisione**

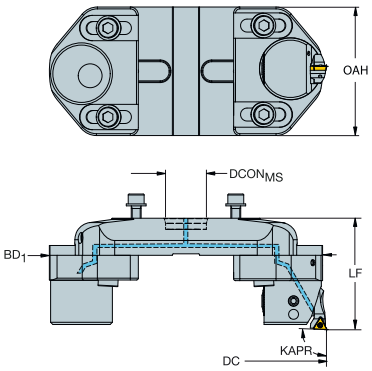
**Specifiche per barenatura Silent Tools**



KAPR




92°




TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Codice di ordinazione | Dimensioni in mm e pollici $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 154.35 | 207.65 | 11 | 1/4 | 33 | 1 | **826D-207TC11HP** | 33.00 | 26.65 | 97.00 | 104.00 | 145.00 | 70 | 2.770 | 1 | TCMT 11 03 04 |
| *6.077* | *8.175* | | | | | | *1.299* | *1.049* | *3.819* | *4.094* | *5.709* | *1015* | | | |
| 204.35 | 257.65 | 11 | 1/4 | 33 | 1 | **826D-257TC11HP** | 33.00 | 26.65 | 97.00 | 104.00 | 195.00 | 70 | 3.110 | 1 | TCMT 11 03 04 |
| *8.045* | *10.144* | | | | | | *1.299* | *1.049* | *3.819* | *4.094* | *7.677* | *1015* | | | |
| 254.35 | 307.65 | 11 | 1/4 | 33 | 1 | **826D-307TC11HP** | 33.00 | 26.65 | 97.00 | 104.00 | 245.00 | 70 | 3.470 | 1 | TCMT 11 03 04 |
| *10.014* | *12.112* | | | | | | *1.299* | *1.049* | *3.819* | *4.094* | *9.646* | *1015* | | | |

I diametri sono validi per la barenatura frontale.

La barenatura in tirata non è consigliata con CoroBore® 826

Questi assiemi leggeri sono concepiti specificamente per essere utilizzati con gli adattatori antivibranti per barenatura. Gli adattatori antivibranti sono venduti separatamente, vedere il catalogo "Utensili rotanti"

Per componenti, accessori e parti di ricambio degli utensili per barenatura, visitare il sito www.sandvik.coromant.com/it

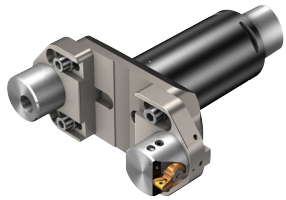
Per gli inserti, consultare il catalogo "Utensili di tornitura"

G2 G5

ITA

# CoroBore® 826 XL, bareno microregistrabile leggero

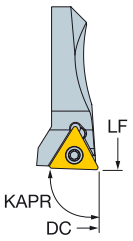
**Coromant Capto® - adduzione di refrigerante ad alta precisione**



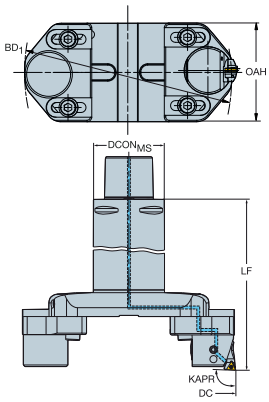
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Codice di ordinazione | Dimensioni in mm e pollici $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 154.35 | 207.65 | 11 | 1/4 | C8 | 3 | **826L-207TC11-C8HP** | 80.00 | 26.65 | 237.00 | 104.00 | 145.00 | 70 | 6.300 | 1 | TCMT 11 03 04 |
| *6.077* | *8.175* | | | | | | *3.150* | *1.049* | *9.331* | *4.094* | *5.709* | *1015* | | | |
| 204.35 | 257.65 | 11 | 1/4 | C8 | 3 | **826L-257TC11-C8HP** | 80.00 | 26.65 | 237.00 | 104.00 | 195.00 | 70 | 6.660 | 1 | TCMT 11 03 04 |
| *8.045* | *10.144* | | | | | | *3.150* | *1.049* | *9.331* | *4.094* | *7.677* | *1015* | | | |
| 254.35 | 307.65 | 11 | 1/4 | C8 | 3 | **826L-307TC11-C8HP** | 80.00 | 26.65 | 237.00 | 104.00 | 245.00 | 70 | 7.030 | 1 | TCMT 11 03 04 |
| *10.014* | *12.112* | | | | | | *3.150* | *1.049* | *9.331* | *4.094* | *9.646* | *1015* | | | |

La barenatura in tirata non è consigliata con CoroBore® 826

I diametri sono validi per la barenatura frontale.

Per componenti, accessori e parti di ricambio degli utensili per barenatura, visitare il sito www.sandvik.coromant.com/it

Per gli inserti, consultare il catalogo "Utensili di tornitura"

G2

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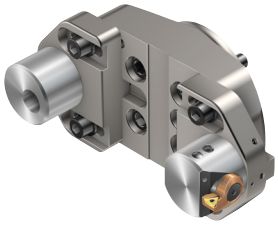
# CoroBore® 826 XL, bareno microregistrabile leggero

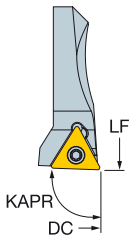
**Arbor - Adduzione di refrigerante ad alta precisione**



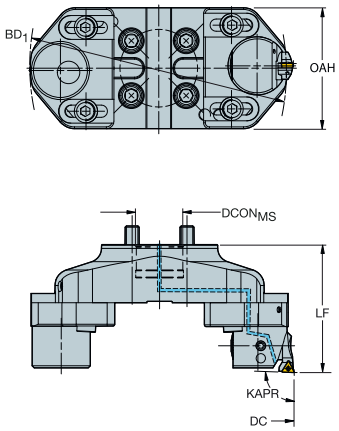
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| | | | | | | | Dimensioni in mm e pollici | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DCN | DCX | ↔ | ↔IC | $CZC_{MS}$ | CNSC | **Codice di ordinazione** | $DCON_{MS}$ | ISO | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
| 154.35 | 207.65 | 11 | 1/4 | 40S | 1 | **826L-207TC11HP** | 40.00 | C | 26.65 | 117.00 | 104.00 | 145.00 | 70 | 3.310 | 1 | TCMT 11 03 04 |
| *6.077* | *8.175* | | | | | | *1.575* | | *1.049* | *4.606* | *4.094* | *5.709* | *1015* | | | |
| 204.35 | 257.65 | 11 | 1/4 | 40S | 1 | **826L-257TC11HP** | 40.00 | C | 26.65 | 117.00 | 104.00 | 195.00 | 70 | 3.650 | 1 | TCMT 11 03 04 |
| *8.045* | *10.144* | | | | | | *1.575* | | *1.049* | *4.606* | *4.094* | *7.677* | *1015* | | | |
| 254.35 | 307.65 | 11 | 1/4 | 40S | 1 | **826L-307TC11HP** | 40.00 | C | 26.65 | 117.00 | 104.00 | 245.00 | 70 | 4.320 | 1 | TCMT 11 03 04 |
| *10.014* | *12.112* | | | | | | *1.575* | | *1.049* | *4.606* | *4.094* | *9.646* | *1015* | | | |

Da utilizzare con attacchi per spianatura 40S, ad es. C8-391.05-40 060M. Da ordinare separatamente.
La barenatura in tirata non è consigliata con CoroBore® 826
I diametri sono validi per la barenatura frontale.

Per componenti, accessori e parti di ricambio degli utensili per barenatura, visitare il sito www.sandvik.coromant.com/it
Per gli inserti, consultare il catalogo "Utensili di tornitura"

G2 G5

# Adattatori per utensili rotanti

## Adattatori


Coromant Capto® E2-E3

HSK E4-E5

BIG-PLUS ISO E6

BIG-PLUS MAS-BT E7-E8

Big Plus Cat V E9

ISO 7388-1 E10

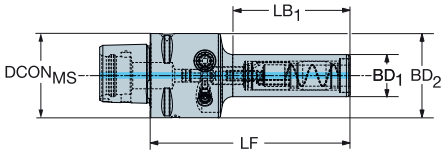
MAS-BT E11-E12

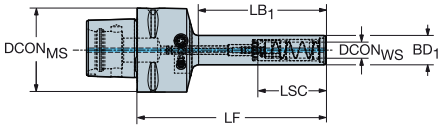
CAT-V E13

# Coromant Capto® per CoroChuck™ 930

**Versione a stilo**

DSGN 2 5




Dimensioni in mm e pollici

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Codice di ordinazione | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C4 | 8 | 3 | 1 | 2 | **930-C4-P-08-085** | 40.0 | 8.0 | 37 | 85.0 | 45.8 | 85.0 | | 17.5 | 40.0 | | 80 | 8.0 | 0.45 | 39000 |
| | | | | | | 1.575 | .315 | 1.457 | 3.346 | 1.803 | 3.346 | | .689 | 1.575 | | 1160 | | | |
| | 10 | 3 | 1 | 2 | **930-C4-P-10-095** | 40.0 | 10.0 | 41 | 95.0 | 55.8 | 95.0 | | 20.0 | 40.0 | | 80 | 8.0 | 0.50 | 39000 |
| | | | | | | 1.575 | .394 | 1.614 | 3.740 | 2.197 | 3.740 | | .787 | 1.575 | | 1160 | | | |
| | 10 | 3 | 1 | 2 | **930-C4-P-10-135** | 40.0 | 10.0 | 41 | 135.0 | 95.8 | 135.0 | | 20.0 | 40.0 | | 80 | 8.0 | 0.59 | 39000 |
| | | | | | | 1.575 | .394 | 1.614 | 5.315 | 3.772 | 5.315 | | .787 | 1.575 | | 1160 | | | |
| C5 | 8 | 3 | 1 | 5 | **930-C5-P-08-088** | 50.0 | 8.0 | 37 | 88.0 | 45.8 | 64.9 | 88.0 | 17.5 | 40.0 | 50.0 | 80 | 8.0 | 0.65 | 28000 |
| | | | | | | 1.969 | .315 | 1.457 | 3.465 | 1.803 | 2.555 | 3.465 | .689 | 1.575 | 1.969 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C5-P-10-098** | 50.0 | 10.0 | 41 | 98.0 | 55.8 | 74.9 | 98.0 | 20.0 | 40.0 | 50.0 | 80 | 8.0 | 0.70 | 28000 |
| | | | | | | 1.969 | .394 | 1.614 | 3.858 | 2.197 | 2.949 | 3.858 | .787 | 1.575 | 1.969 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C5-P-10-138** | 50.0 | 10.0 | 41 | 138.0 | 95.8 | 114.9 | 138.0 | 20.0 | 40.0 | 50.0 | 80 | 8.0 | 0.80 | 28000 |
| | | | | | | 1.969 | .394 | 1.614 | 5.433 | 3.772 | 4.524 | 5.433 | .787 | 1.575 | 1.969 | 1160 | | | |
| C6 | 8 | 3 | 1 | 5 | **930-C6-P-08-091** | 63.0 | 8.0 | 37 | 91.0 | 45.8 | 64.9 | 91.0 | 17.5 | 40.0 | 63.0 | 80 | 8.0 | 1.00 | 20000 |
| | | | | | | 2.480 | .315 | 1.457 | 3.583 | 1.803 | 2.555 | 3.583 | .689 | 1.575 | 2.480 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C6-P-10-102** | 63.0 | 10.0 | 41 | 102.0 | 55.8 | 75.0 | 102.0 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 1.07 | 20000 |
| | | | | | | 2.480 | .394 | 1.614 | 4.016 | 2.197 | 2.953 | 4.016 | .787 | 1.575 | 2.480 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C6-P-10-142** | 63.0 | 10.0 | 41 | 142.0 | 95.8 | 115.0 | 142.0 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 1.16 | 20000 |
| | | | | | | 2.480 | .394 | 1.614 | 5.591 | 3.772 | 4.528 | 5.591 | .787 | 1.575 | 2.480 | 1160 | | | |

Per le parti di ricambio, visitate il sito www.sandvik.coromant.com/it

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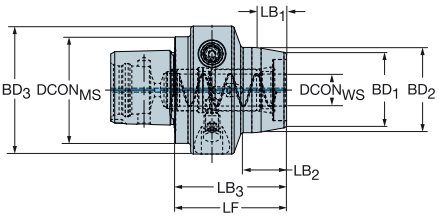
ITA

# Coromant Capto® per CoroChuck™ 930

**Per portautensili rotanti**

**Solo bloccaggio a segmenti e cambio utensili manuale**




Dimensioni in mm e pollici

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Codice di ordinazione | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C3 | 6 | 3 | 1 | **930-C3-T-06-036** | 32.0 | 6.0 | 37 | 36.0 | 9.3 | 12.8 | 22.0 | 26.0 | 42.0 | 12° | 80 | 8.0 | 0.26 | 10000 |
| | | | | | 1.260 | .236 | 1.457 | 1.417 | .366 | .504 | .866 | 1.024 | 1.654 | | 1160 | | | |
| | 8 | 3 | 1 | **930-C3-T-08-036** | 32.0 | 8.0 | 37 | 36.0 | 9.3 | 12.8 | 24.0 | 28.0 | 44.0 | 12° | 80 | 8.0 | 0.28 | 10000 |
| | | | | | 1.260 | .315 | 1.457 | 1.417 | .366 | .504 | .945 | 1.102 | 1.732 | | 1160 | | | |
| | 10 | 3 | 1 | **930-C3-T-10-038** | 32.0 | 10.0 | 41 | 38.0 | 11.3 | 14.8 | 26.0 | 30.0 | 46.0 | 10° | 80 | 8.0 | 0.31 | 10000 |
| | | | | | 1.260 | .394 | 1.614 | 1.496 | .445 | .583 | 1.024 | 1.181 | 1.811 | | 1160 | | | |
| C4 | 6 | 3 | 1 | **930-C4-T-06-036** | 40.0 | 6.0 | 37 | 36.0 | 9.3 | 12.8 | 22.0 | 26.0 | 42.0 | 12° | 80 | 8.0 | 0.33 | 10000 |
| | | | | | 1.575 | .236 | 1.457 | 1.417 | .366 | .504 | .866 | 1.024 | 1.654 | | 1160 | | | |
| | 8 | 3 | 1 | **930-C4-T-08-036** | 40.0 | 8.0 | 37 | 36.0 | 9.3 | 12.8 | 24.0 | 28.0 | 44.0 | 12° | 80 | 8.0 | 0.34 | 10000 |
| | | | | | 1.575 | .315 | 1.457 | 1.417 | .366 | .504 | .945 | 1.102 | 1.732 | | 1160 | | | |
| | 10 | 3 | 1 | **930-C4-T-10-038** | 40.0 | 10.0 | 41 | 38.0 | 11.3 | 14.8 | 26.0 | 30.0 | 46.0 | 10° | 80 | 8.0 | 0.37 | 10000 |
| | | | | | 1.575 | .394 | 1.614 | 1.496 | .445 | .583 | 1.024 | 1.181 | 1.811 | | 1160 | | | |
| C5 | 6 | 3 | 1 | **930-C5-T-06-036** | 50.0 | 6.0 | 37 | 36.0 | 9.3 | 12.8 | 22.0 | 26.0 | 50.0 | 12° | 80 | 8.0 | 0.49 | 10000 |
| | | | | | 1.969 | .236 | 1.457 | 1.417 | .366 | .504 | .866 | 1.024 | 1.969 | | 1160 | | | |
| | 8 | 3 | 1 | **930-C5-T-08-036** | 50.0 | 8.0 | 37 | 36.0 | 9.3 | 12.8 | 24.0 | 28.0 | 50.0 | 12° | 80 | 8.0 | 0.50 | 10000 |
| | | | | | 1.969 | .315 | 1.457 | 1.417 | .366 | .504 | .945 | 1.102 | 1.969 | | 1160 | | | |
| | 10 | 3 | 1 | **930-C5-T-10-038** | 50.0 | 10.0 | 41 | 38.0 | 11.3 | 14.8 | 26.0 | 30.0 | 50.0 | 10° | 80 | 8.0 | 0.51 | 10000 |
| | | | | | 1.969 | .394 | 1.614 | 1.496 | .445 | .583 | 1.024 | 1.181 | 1.969 | | 1160 | | | |

Per le parti di ricambio, visitate il sito www.sandvik.coromant.com/it

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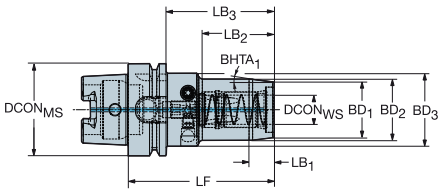
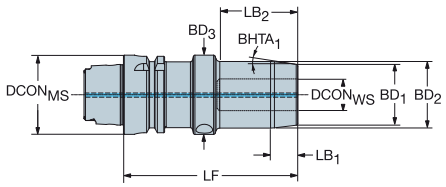
# HSK per CoroChuck™ 930

**Versione sottile**

**Interfaccia lato macchina HSK A/C**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Codice di ordinazione | DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BD$_4$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 6 | 1 | 1 | **930-HA04-S-06-070** | 40.0 | 6.0 | 37 | 70.0 | 11.3 | 33.2 | 50.0 | 22.0 | 26.0 | 32.0 | 40.0 | 10° | 80 | 8.0 | 0.40 | 30000 |
| | | | | | 1.575 | .236 | 1.457 | 2.756 | .445 | 1.307 | 1.969 | .866 | 1.024 | 1.260 | 1.575 | | 1160 | | | |
| | 8 | 1 | 1 | **930-HA04-S-08-070** | 40.0 | 8.0 | 37 | 70.0 | 11.3 | 35.3 | 50.0 | 24.0 | 28.0 | 32.0 | 40.0 | 10° | 80 | 8.0 | 0.42 | 30000 |
| | | | | | 1.575 | .315 | 1.457 | 2.756 | .445 | 1.390 | 1.969 | .945 | 1.102 | 1.260 | 1.575 | | 1160 | | | |
| | 10 | 1 | 1 | **930-HA04-S-10-075** | 40.0 | 10.0 | 41 | 75.0 | 11.3 | 39.6 | 55.0 | 26.0 | 30.0 | 32.0 | 40.0 | 10° | 80 | 8.0 | 0.46 | 30000 |
| | | | | | 1.575 | .394 | 1.614 | 2.953 | .445 | 1.559 | 2.165 | 1.024 | 1.181 | 1.260 | 1.575 | | 1160 | | | |
| | 12 | 1 | 1 | **930-HA04-S-12-080** | 40.0 | 12.0 | 46 | 80.0 | 11.3 | 41.0 | 60.0 | 28.0 | 32.0 | 33.5 | 40.0 | 10° | 80 | 8.0 | 0.51 | 30000 |
| | | | | | 1.575 | .472 | 1.811 | 3.150 | .445 | 1.614 | 2.362 | 1.102 | 1.260 | 1.319 | 1.575 | | 1160 | | | |
| 50.0 | 6 | 1 | 1 | **930-HA05-S-06-074** | 50.0 | 6.0 | 37 | 74.0 | 11.3 | 30.2 | 48.0 | 22.0 | 26.0 | 40.0 | 50.0 | 10° | 80 | 8.0 | 0.64 | 25000 |
| | | | | | 1.969 | .236 | 1.457 | 2.913 | .445 | 1.189 | 1.890 | .866 | 1.024 | 1.575 | 1.969 | | 1160 | | | |
| | 8 | 1 | 1 | **930-HA05-S-08-074** | 50.0 | 8.0 | 37 | 74.0 | 11.3 | 30.2 | 48.0 | 24.0 | 28.0 | 40.0 | 50.0 | 10° | 80 | 8.0 | 0.65 | 25000 |
| | | | | | 1.969 | .315 | 1.457 | 2.913 | .445 | 1.189 | 1.890 | .945 | 1.102 | 1.575 | 1.969 | | 1160 | | | |
| | 10 | 1 | 1 | **930-HA05-S-10-080** | 50.0 | 10.0 | 41 | 80.0 | 11.3 | 34.2 | 54.0 | 26.0 | 30.0 | 40.0 | 50.0 | 10° | 80 | 8.0 | 0.71 | 25000 |
| | | | | | 1.969 | .394 | 1.614 | 3.150 | .445 | 1.346 | 2.126 | 1.024 | 1.181 | 1.575 | 1.969 | | 1160 | | | |
| | 12 | 1 | 1 | **930-HA05-S-12-085** | 50.0 | 12.0 | 46 | 85.0 | 11.3 | 38.2 | 59.0 | 28.0 | 32.0 | 40.0 | 50.0 | 10° | 80 | 8.0 | 0.75 | 25000 |
| | | | | | 1.969 | .472 | 1.811 | 3.346 | .445 | 1.504 | 2.323 | 1.102 | 1.260 | 1.575 | 1.969 | | 1160 | | | |




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Codice di ordinazione | DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 20 | 1 | 1 | **930-HA05-S-20-090** | 50.0 | 20.0 | 51 | 90.0 | 16.0 | 64.0 | 37.6 | 41.5 | 7° | 80 | 8.0 | 0.89 | 25000 |
| | | | | | 1.969 | .787 | 2.008 | 3.543 | .630 | 2.520 | 1.480 | 1.634 | | 1160 | | | |

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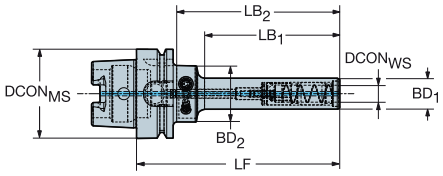
ITA

# HSK per CoroChuck™ 930

**Versione a stilo**

**Interfaccia lato macchina HSK A/C**




| | | | | | Dimensioni in mm e pollici | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Codice di ordinazione** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
| 63.0 | 8 | 1 | 1 | **930-HA06-P-08-094** | 63.0 | 8.0 | 37 | 94.0 | 45.8 | 65.5 | 17.5 | 40.0 | 80 | 8.0 | 0.87 | 20000 |
| | | | | | 2.480 | .315 | 1.457 | 3.701 | 1.803 | 2.579 | .689 | 1.575 | 1160 | | | |
| | 10 | 1 | 1 | **930-HA06-P-10-104** | 63.0 | 10.0 | 41 | 104.0 | 55.8 | 75.5 | 20.0 | 40.0 | 80 | 8.0 | 0.91 | 20000 |
| | | | | | 2.480 | .394 | 1.614 | 4.094 | 2.197 | 2.972 | .787 | 1.575 | 1160 | | | |
| | 10 | 1 | 1 | **930-HA06-P-10-144** | 63.0 | 10.0 | 41 | 144.0 | 95.8 | 115.5 | 20.0 | 40.0 | 80 | 8.0 | 1.01 | 20000 |
| | | | | | 2.480 | .394 | 1.614 | 5.669 | 3.772 | 4.547 | .787 | 1.575 | 1160 | | | |

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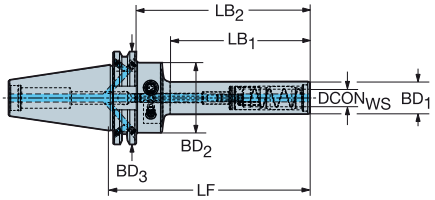
# BIG-PLUS ISO per CoroChuck™ 930

**Interfaccia lato macchina compatibile con ISO 7388-1 e DIN 69871-ADB**




**Versione a stilo**

| | | | | | Dimensioni in mm e pollici | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Codice di ordinazione** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 8 | 7 | 1 | **930-IB40-P-08-088** | 8.0 | M16 | 37 | 88.0 | 45.8 | 66.5 | 17.5 | 40.0 | 63.5 | 80 | 8.0 | 1.06 | 18000 |
| | | | | | .315 | | 1.457 | 3.465 | 1.803 | 2.618 | .689 | 1.575 | 2.500 | 1160 | | | |
| | 10 | 7 | 1 | **930-IB40-P-10-098** | 10.0 | M16 | 41 | 98.0 | 55.8 | 76.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.10 | 18000 |
| | | | | | .394 | | 1.614 | 3.858 | 2.197 | 3.012 | .787 | 1.575 | 2.500 | 1160 | | | |
| | 10 | 7 | 1 | **930-IB40-P-10-138** | 10.0 | M16 | 41 | 138.0 | 95.8 | 116.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.20 | 18000 |
| | | | | | .394 | | 1.614 | 5.433 | 3.772 | 4.587 | .787 | 1.575 | 2.500 | 1160 | | | |

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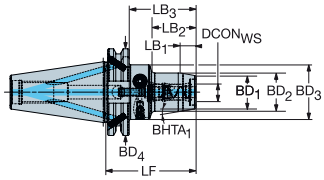
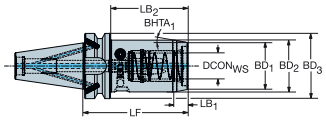
ITA

# BIG-PLUS MAS-BT per CoroChuck™ 930

**Interfaccia lato macchina compatibile con MAS-BT 403 e JIS B 6339**

DSGN 10 6




**Versione sottile**

Dimensioni in mm e pollici

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Codice di ordinazione | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $LB_4$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 6 | 1 | 1 | 6 | 930-BB30-S-06-048 | 6.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 22.0 | 26.0 | 46.0 | | 12° | 80 | 8.0 | 0.56 | 25000 |
| | | | | | | .236 | | 1.457 | 1.890 | .366 | .504 | 1.890 | | .866 | 1.024 | 1.811 | | | 1160 | | | |
| | 8 | 1 | 1 | 6 | 930-BB30-S-08-048 | 8.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 24.0 | 28.0 | 46.0 | | 12° | 80 | 8.0 | 0.57 | 25000 |
| | | | | | | .315 | | 1.457 | 1.890 | .366 | .504 | 1.890 | | .945 | 1.102 | 1.811 | | | 1160 | | | |
| | 10 | 1 | 1 | 6 | 930-BB30-S-10-048 | 10.0 | M12 | 41 | 48.0 | 9.3 | 13.8 | 48.0 | | 26.0 | 30.0 | 46.0 | | 12° | 80 | 8.0 | 0.56 | 25000 |
| | | | | | | .394 | | 1.614 | 1.890 | .366 | .543 | 1.890 | | 1.024 | 1.181 | 1.811 | | | 1160 | | | |
| | 12 | 1 | 1 | 10 | 930-BB30-S-12-082 | 12.0 | M12 | 46 | 82.0 | 11.3 | 38.2 | 60.0 | 82.0 | 28.0 | 32.0 | 40.0 | 46 | 10° | 80 | 8.0 | 0.76 | 25000 |
| | | | | | | .472 | | 1.811 | 3.228 | .445 | 1.504 | 2.362 | 3.228 | 1.102 | 1.260 | 1.575 | 1.811 | | 1160 | | | |
| | 20 | 1 | 1 | 6 | 930-BB30-S-20-088 | 20.0 | M12 | 51 | 88.0 | 16.0 | 66.0 | 88.0 | | 38.0 | 42.0 | 46.0 | | 7° | 80 | 8.0 | 0.94 | 25000 |
| | | | | | | .787 | | 2.008 | 3.465 | .630 | 2.598 | 3.465 | | 1.496 | 1.654 | 1.811 | | | 1160 | | | |

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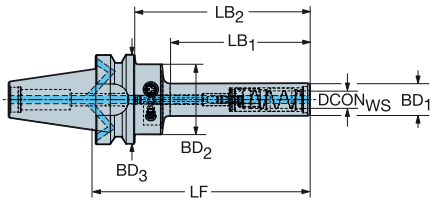
# BIG-PLUS MAS-BT per CoroChuck™ 930

**Interfaccia lato macchina compatibile con MAS-BT 403 e JIS B 6339**




**Versione a stilo**

| | | | | | Dimensioni in mm e pollici | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Codice di ordinazione** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | | | | RPMX |
| 30.0 | 8 | 1 | 1 | **930-BB30-P-08-088** | 8.0 | M12 | 37 | 88.0 | 45.8 | 66.0 | 17.5 | 40.0 | 46.0 | 80 | 8.0 | 0.60 | 25000 |
| | | | | | .315 | | 1.457 | 3.465 | 1.803 | 2.598 | .689 | 1.575 | 1.811 | 1160 | | | |
| | 10 | 1 | 1 | **930-BB30-P-10-098** | 10.0 | M12 | 41 | 98.0 | 55.8 | 76.0 | 20.0 | 40.0 | 46.0 | 80 | 8.0 | 0.64 | 25000 |
| | | | | | .394 | | 1.614 | 3.858 | 2.197 | 2.992 | .787 | 1.575 | 1.811 | 1160 | | | |
| | 10 | 1 | 1 | **930-BB30-P-10-138** | 10.0 | M12 | 41 | 138.0 | 95.8 | 116.0 | 20.0 | 40.0 | 46.0 | 80 | 8.0 | 0.74 | 25000 |
| | | | | | .394 | | 1.614 | 5.433 | 3.772 | 4.567 | .787 | 1.575 | 1.811 | 1160 | | | |
| 40.0 | 8 | 7 | 1 | **930-BB40-P-08-095** | 8.0 | M16 | 37 | 95.0 | 45.8 | 65.5 | 17.5 | 40.0 | 63.0 | 80 | 8.0 | 1.21 | 18000 |
| | | | | | .315 | | 1.457 | 3.740 | 1.803 | 2.579 | .689 | 1.575 | 2.480 | 1160 | | | |
| | 10 | 7 | 1 | **930-BB40-P-10-105** | 10.0 | M16 | 41 | 105.0 | 55.8 | 75.5 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 1.25 | 18000 |
| | | | | | .394 | | 1.614 | 4.134 | 2.197 | 2.972 | .787 | 1.575 | 2.480 | 1160 | | | |
| | 10 | 7 | 1 | **930-BB40-P-10-145** | 10.0 | M16 | 41 | 145.0 | 95.8 | 115.5 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 1.35 | 18000 |
| | | | | | .394 | | 1.614 | 5.709 | 3.772 | 4.547 | .787 | 1.575 | 2.480 | 1160 | | | |

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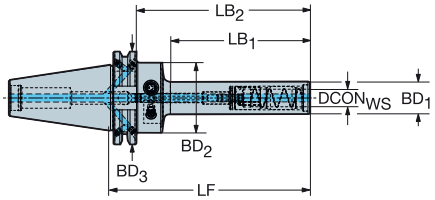
ITA

# BIG-PLUS CAT-V per CoroChuck™ 930

**Interfaccia lato macchina compatibile con ASME B5.50-2009**

**Versione a stilo**




**Foro in mm**

| | | | | | Dimensioni in mm e pollici | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Codice di ordinazione** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 8 | 7 | 1 | **930-VB40-P-08-088** | 8.0 | 5/8"-11 | 37 | 88.0 | 45.8 | 66.5 | 17.5 | 40.0 | 63.5 | 80 | 8.0 | 1.07 | 18000 |
| | | | | | *.315* | | *1.457* | *3.465* | *1.803* | *2.618* | *.689* | *1.575* | *2.500* | *1160* | | | |
| | 10 | 7 | 1 | **930-VB40-P-10-098** | 10.0 | 5/8"-11 | 41 | 98.0 | 55.8 | 76.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.11 | 18000 |
| | | | | | *.394* | | *1.614* | *3.858* | *2.197* | *3.012* | *.787* | *1.575* | *2.500* | *1160* | | | |
| | 10 | 7 | 1 | **930-VB40-P-10-138** | 10.0 | 5/8"-11 | 41 | 138.0 | 95.8 | 116.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.21 | 18000 |
| | | | | | *.394* | | *1.614* | *5.433* | *3.772* | *4.587* | *.787* | *1.575* | *2.500* | *1160* | | | |

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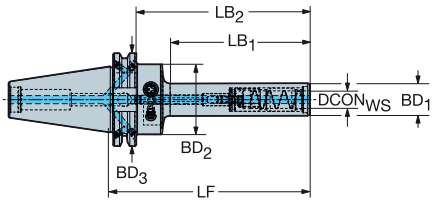
# ISO 7388-1 per CoroChuck™ 930

**Interfaccia lato macchina compatibile con DIN 69871-ADB**




**Versione a stilo**

Dimensioni in mm e pollici

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Codice di ordinazione | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 8 | 7 | 1 | **930-I40-P-08-088** | 8.0 | M16 | 37 | 88.0 | 45.8 | 66.5 | 17.5 | 40.0 | 63.5 | 80 | 8.0 | 1.04 | 18000 |
| | | | | | .315 | | 1.457 | 3.465 | 1.803 | 2.618 | .689 | 1.575 | 2.500 | 1160 | | | |
| | 10 | 7 | 1 | **930-I40-P-10-098** | 10.0 | M16 | 41 | 98.0 | 55.8 | 76.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.09 | 18000 |
| | | | | | .394 | | 1.614 | 3.858 | 2.197 | 3.012 | .787 | 1.575 | 2.500 | 1160 | | | |
| | 10 | 7 | 1 | **930-I40-P-10-138** | 10.0 | M16 | 41 | 138.0 | 95.8 | 116.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.18 | 18000 |
| | | | | | .394 | | 1.614 | 5.433 | 3.772 | 4.587 | .787 | 1.575 | 2.500 | 1160 | | | |

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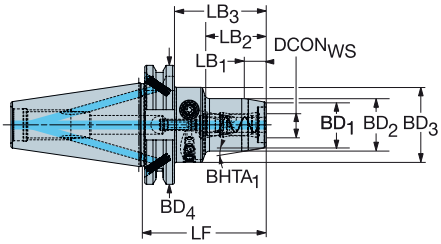
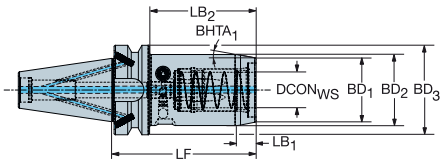
ITA

# MAS-BT 403 per CoroChuck™ 930

**Interfaccia lato macchina compatibile con JIS B 6339**

DSGN 10 6




**Versione sottile**

| | | | | | | Dimensioni in mm e pollici | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Codice di ordinazione** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $LB_4$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 30.0 | 6 | 1 | 1 | 6 | **930-B30-S-06-048** | 6.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 22.0 | 26.0 | 46.0 | | 12° | 80 | 8.0 | 0.55 | 25000 |
| | | | | | | .236 | | 1.457 | 1.890 | .366 | .504 | 1.890 | | .866 | 1.024 | 1.811 | | | 1160 | | | |
| | 8 | 1 | 1 | 6 | **930-B30-S-08-048** | 8.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 24.0 | 28.0 | 46.0 | | 12° | 80 | 8.0 | 0.56 | 25000 |
| | | | | | | .315 | | 1.457 | 1.890 | .366 | .504 | 1.890 | | .945 | 1.102 | 1.811 | | | 1160 | | | |
| | 10 | 1 | 1 | 6 | **930-B30-S-10-048** | 10.0 | M12 | 41 | 48.0 | 9.3 | 13.8 | 48.0 | | 26.0 | 30.0 | 46.0 | | 12° | 80 | 8.0 | 0.55 | 25000 |
| | | | | | | .394 | | 1.614 | 1.890 | .366 | .543 | 1.890 | | 1.024 | 1.181 | 1.811 | | | 1160 | | | |
| | 12 | 1 | 1 | 10 | **930-B30-S-12-082** | 12.0 | M12 | 46 | 82.0 | 11.3 | 38.2 | 60.0 | 82.0 | 28.0 | 32.0 | 40.0 | 46 | 10° | 80 | 8.0 | 0.75 | 25000 |
| | | | | | | .472 | | 1.811 | 3.228 | .445 | 1.504 | 2.362 | 3.228 | 1.102 | 1.260 | 1.575 | 1.811 | | 1160 | | | |
| | 20 | 1 | 1 | 6 | **930-B30-S-20-088** | 20.0 | M12 | 51 | 88.0 | 16.0 | 66.0 | 88.0 | | 38.0 | 42.0 | 46.0 | | 7° | 80 | 8.0 | 0.93 | 25000 |
| | | | | | | .787 | | 2.008 | 3.465 | .630 | 2.598 | 3.465 | | 1.496 | 1.654 | 1.811 | | | 1160 | | | |

Per le parti di ricambio, visitate il sito www.sandvik.coromant.com/it

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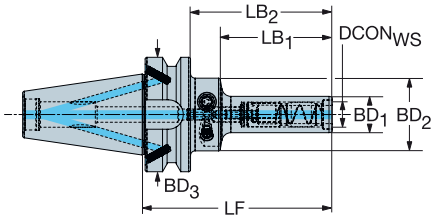
# MAS-BT 403 per CoroChuck™ 930

**Interfaccia lato macchina compatibile con JIS B 6339**

**Versione a stilo**




Dimensioni in mm e pollici

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Codice di ordinazione | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 8 | 1 | 1 | 930-B30-P-08-088 | 8.0 | M12 | 37 | 88.0 | 45.8 | 66.0 | 17.5 | 40.0 | 46.0 | 80 | 8.0 | 0.59 | 25000 |
| | | | | | .315 | | 1.457 | 3.465 | 1.803 | 2.598 | .689 | 1.575 | 1.811 | 1160 | | | |
| | 10 | 1 | 1 | 930-B30-P-10-098 | 10.0 | M12 | 41 | 98.0 | 55.8 | 76.0 | 20.0 | 40.0 | 46.0 | 80 | 8.0 | 0.63 | 25000 |
| | | | | | .394 | | 1.614 | 3.858 | 2.197 | 2.992 | .787 | 1.575 | 1.811 | 1160 | | | |
| | 10 | 1 | 1 | 930-B30-P-10-138 | 10.0 | M12 | 41 | 138.0 | 95.8 | 116.0 | 20.0 | 40.0 | 46.0 | 80 | 8.0 | 0.73 | 25000 |
| | | | | | .394 | | 1.614 | 5.433 | 3.772 | 4.567 | .787 | 1.575 | 1.811 | 1160 | | | |
| 40.0 | 8 | 7 | 1 | 930-B40-P-08-095 | 8.0 | M16 | 37 | 95.0 | 45.8 | 65.5 | 17.5 | 40.0 | 63.0 | 80 | 8.0 | 1.20 | 18000 |
| | | | | | .315 | | 1.457 | 3.740 | 1.803 | 2.579 | .689 | 1.575 | 2.480 | 1160 | | | |
| | 10 | 7 | 1 | 930-B40-P-10-105 | 10.0 | M16 | 41 | 105.0 | 55.8 | 75.5 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 1.24 | 18000 |
| | | | | | .394 | | 1.614 | 4.134 | 2.197 | 2.972 | .787 | 1.575 | 2.480 | 1160 | | | |
| | 10 | 7 | 1 | 930-B40-P-10-145 | 10.0 | M16 | 41 | 145.0 | 95.8 | 115.5 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 1.34 | 18000 |
| | | | | | .394 | | 1.614 | 5.709 | 3.772 | 4.547 | .787 | 1.575 | 2.480 | 1160 | | | |

Per le parti di ricambio, visitate il sito www.sandvik.coromant.com/it

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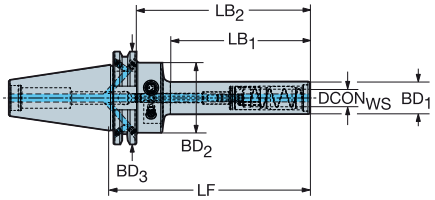
ITA

# CAT-V per CoroChuck™ 930

**Versione a stilo**

**Interfaccia lato macchina ASME B5.50-2009**




Dimensioni in mm e pollici

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Codice di ordinazione | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 8 | 7 | 1 | **930-V40-P-08-088** | 8.0 | 5/8"-11 | 37 | 88.0 | 45.8 | 66.5 | 17.5 | 40.0 | 63.5 | 80 | 8.0 | 1.05 | 18000 |
| | | | | | .315 | | 1.457 | 3.465 | 1.803 | 2.618 | .689 | 1.575 | 2.500 | 1160 | | | |
| | 10 | 7 | 1 | **930-V40-P-10-098** | 10.0 | 5/8"-11 | 41 | 98.0 | 55.8 | 76.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.09 | 18000 |
| | | | | | .394 | | 1.614 | 3.858 | 2.197 | 3.012 | .787 | 1.575 | 2.500 | 1160 | | | |
| | 10 | 7 | 1 | **930-V40-P-10-138** | 10.0 | 5/8"-11 | 41 | 138.0 | 95.8 | 116.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.19 | 18000 |
| | | | | | .394 | | 1.614 | 5.433 | 3.772 | 4.587 | .787 | 1.575 | 2.500 | 1160 | | | |

Per le parti di ricambio, visitate il sito www.sandvik.coromant.com/it

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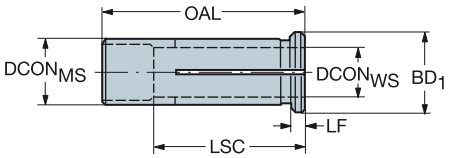
# Manicotti cilindrici

**Adduzione di refrigerante di precisione**




**Versione in pollici**

| | | | | | Dimensioni, pollici | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Codice di ordinazione** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | OAL | LF | PSI | LBS |
| 12 | 1/8 | 1 | 4 | **A393.CF-12 02 40** | .472 | .125 | 1.574 | 1.732 | .157 | 1160 | .079 |
| | 3/16 | 1 | 4 | **A393.CF-12 03 40** | .472 | .187 | 1.574 | 1.732 | .157 | 1160 | .066 |

Per gli estrattori per pinze cilindriche, vedere il catalogo "Utensili rotanti"

G2

G5

# Informazioni generali


ISO 13399 G2

Informazioni sull'adduzione di refrigerante G5

Ricondizionamento G6

Informazioni per la sicurezza G7

Concetto di Riciclo Coromant (CRC) G8

**ISO 13399 è uno standard internazionale che semplifica lo scambio dei dati per gli utensili da taglio. Esiste una leggera differenza nei parametri e nelle descrizioni di ogni utensile.**

Per la prima volta, c'è un modo standardizzato per descrivere i dati dei prodotti per quanto riguarda gli utensili da taglio disponibili. Quando tutti gli utensili nell'industria manifatturiera condividono gli stessi parametri e definizioni, la comunicazione delle relative informazioni tra i vari sistemi software diventa molto semplice.

B

**Che cosa significa per voi?**

Fondamentalmente, ciò significa che i vostri sistemi possono parlare con i nostri, perché tutti parlano la stessa lingua. Scaricate i dati dei prodotti dal nostro sito web e inseriteli direttamente nel vostro software CAD/CAM per assemblare gli utensili che si utilizzano in produzione. Non c'è bisogno di cercare informazioni nei cataloghi e interpretare i dati da un sistema all'altro. Immaginate quanto tempo questo sistema vi farà risparmiare!

C

| Acronimo | Significato |
|---|---|
| ADJLN | Limite di regolazione minimo |
| ADJLX | Massimo limite di regolazione |
| ADJRG | Gamma di regolazione |
| ALP | Angolo di spoglia inferiore assiale |
| AN | Angolo di spoglia inferiore principale |
| ANN | Angolo di spoglia inferiore secondario |
| APMX | Profondità di taglio massima |
| APMX_EFW | Profondità di taglio massima - avanzamento finale |
| APMX_FFW | Profondità di taglio massima - avanzamento laterale |
| AZ | Profondità di tuffo massima |
| B | Larghezza dello stelo |
| BAWS | Angolo del corpo lato pezzo |
| BAMS | Angolo del corpo lato macchina |
| BBD | Bilanciato in fase di progettazione |
| BBR | Bilanciato mediante prova rotazionale |
| BCH | Lunghezza dello smusso angolare |
| BD | Diametro del corpo |
| BHTA | Angolo semiconico del corpo |
| BN | Larghezza del petto |
| BS | Lunghezza del tagliente raschiante |
| BSG | Gruppo standard di base |
| BSR | Raggio del tagliente raschiante |
| CBMD | Costruttore rompitrucioli |
| CDX | Profondità di taglio massima |
| CEMR | Raggio principale del tagliente |
| CF | Smusso di invito |
| CHBA | Angolo dello smusso del corpo |
| CHBL | Lunghezza dello smusso del corpo |
| CHW | Larghezza dello smusso angolare |
| CICT | Numero di articoli da taglio |
| $CICT_{BALL}$ | Numero di articoli da taglio - inserto a testa sferica |
| $CICT_{E}$ | Numero di articoli da taglio - posizione finale |
| $CICT_{P}$ | Numero di articoli da taglio - posizione periferica |
| $CICT_{S}$ | Numero di articoli da taglio - posizione laterale |
| $CICT_{SP}$ | Numero di articoli da taglio - Inserto di "guardia" |
| $CICT_{T}$ | Numero di articoli da taglio - totale |
| CND | Diametro ingresso refrigerante |
| CNSC | Codice tipo con ingresso refrigerante |
| CNT | Misura della filettatura all'ingresso refrigerante |
| COATING | Rivestimento |
| CP | Pressione massima refrigerante |
| CRKS | Misura della filettatura della bussola di arresto del collegamento |
| CRNT | Misura della filettatura dell'ingresso radiale del refrigerante |
| CTPT | Tipo di operazione |
| CUTDIA | Diametro massimo di troncatura del pezzo |
| CW | Larghezza di taglio |
| CWN | Larghezza di taglio minima |
| CWTOLL | Tolleranza inferiore larghezza di taglio |
| CWTOLU | Tolleranza superiore larghezza di taglio |
| CWX | Larghezza di taglio massima |
| CXSC | Codice tipo di uscita refrigerante |
| CZC | Codice misura di connessione |
| $CZC_{MS}$ | Codice misura collegamento lato macchina |
| $CZC_{WS}$ | Codice misura collegamento lato pezzo |
| D1 | Diametro del foro di fissaggio |
| DAH | Diametro del foro di accesso |
| DAXIN | Diametro minimo interno della scanalatura assiale |
| DAXN | Diametro minimo esterno della scanalatura assiale |

D

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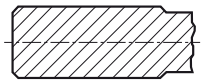
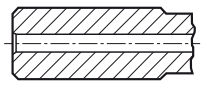
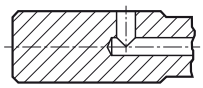
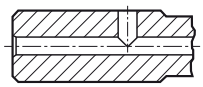
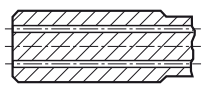
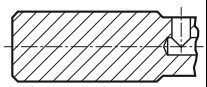
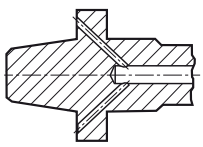
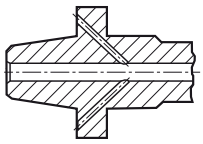
| | |
|---|---|
| DAXX | Diametro massimo esterno della scanalatura assiale |
| DBC | Diametro del cerchio fori per bulloni |
| DC | Diametro di taglio |
| DCB | Diametro del foro di collegamento |
| DCBN | Diametro minimo interno di collegamento |
| DCBX | Diametro massimo interno di collegamento |
| DCF | Diametro di taglio al contatto della faccia |
| DCIN | Diametro di taglio interno |
| DCN | Diametro di taglio minimo |
| DCON | Diametro di collegamento |
| $DCON_{MS}$ | Diametro di collegamento, lato macchina |
| $DCON_{WS}$ | Diametro di collegamento, lato pezzo |
| $DCONN_{WS}$ | Diametro di collegamento minimo, lato pezzo |
| $DCONX_{WS}$ | Diametro di collegamento massimo, lato pezzo |
| DCPS | Chip dati diam. 10x4.5 accordi ISO69873 |
| $DCSF_{MS}$ | Diametro superficie di contatto lato macchina |
| $DCSF_{WS}$ | Diametro superficie di contatto lato pezzo |
| DCX | Diametro di taglio massimo |
| DHUB | Diametro del punzone |
| DIX | Diametro massimo di interferenza con il dispositivo di cambio utensili |
| DMIN | Diametro minimo del foro |
| DMM | Diametro stelo |
| DN | Diametro dello stelo scaricato |
| DRVCT | Numero dispositivi di trascinamento |
| DSGN | Versione |
| EPSR | Angolo incluso dell'inserto |
| FHA | Angolo d'elica |
| FLGT | Spessore della flangia |
| FTDZ | Per dimensione diametro di filettatura |
| GB | Angolo del petto |
| H | Altezza dello stelo |
| HA | Altezza teorica della filettatura |
| HB | Differenza altezza della filettatura |
| HBH | Altezza offset del fondo della testina |
| HC | Altezza effettiva della filettatura |
| HF | Altezza funzionale |
| HRY | Punto più basso dal piano di riferimento |
| HSUP | Altezza del supporto |
| HTB | Altezza del corpo |
| HTH | Altezza |
| IC | Diametro del cerchio inscritto |
| INSL | Lunghezza inserto |
| INSUC | Codice di utilizzo dell'inserto |
| IZC | Codice dimensione inserto |
| KAPR | Angolo del tagliente utensile |
| KAPR_EFW | Angolo del tagliente utensile - avanzamento finale |
| KCH | Smusso angolare |
| KRINS | Angolo d'attacco principale |
| KWW | Larghezza sede chiavetta |
| L | Lunghezza del tagliente |
| LAMS | Angolo di inclinazione |
| LB | Lunghezza del corpo |
| LCF | Lunghezza curvatura truciolo |
| LCOX | Lunghezza massima di troncatura |
| LE | Lunghezza effettiva del tagliente |
| LF | Lunghezza funzionale |
| LFN | Lunghezza funzionale minima |
| LH | Lunghezza della testina |
| LPR | Lunghezza sporgente |
| LS | Lunghezza stelo |
| LSC | Lunghezza di bloccaggio |
| LSCN | Lunghezza minima di bloccaggio |
| LSCS | Distanza all'inizio del bloccaggio |
| LSCX | Lunghezza massima di bloccaggio |
| LSD | Lunghezza stelo "inerte" |
| LU | Lunghezza utilizzabile (max. raccomandata) |
| LU_BFW | Lunghezza utile - sfacciatura in tirata |
| LUX | Massima lunghezza utilizzabile |
| MHD | Distanza del foro di montaggio |
| MIID | Identificazione inserto campione |
| $MIID_E$ | Identificazione inserto campione - posizione finale |
| $MIID_S$ | Identificazione inserto campione - posizione laterale |
| $MIID_C$ | Identificazione inserto campione - posizione centrale |
| $MIID_P$ | Identificazione inserto campione - posizione periferica |
| $MIID_I$ | Identificazione inserto campione - posizione intermedia |
| MMCC | Codice per coppia preimpostata |
| MMCX | Coppia di taglio max. |
| NOF | Numero di scanalature |
| NT | Numero di denti |
| OAH | Altezza globale |
| OAL | Lunghezza globale |
| OAW | Larghezza globale |
| OH | Sporgenza raccomandata |
| OHN | Sporgenza minima |

| | |
|---|---|
| OHX | Sporgenza massima |
| ORDCODE | Codice di ordinazione |
| PCL | Lunghezza cilindrica periferica |
| PDX | Distanza profilo EX |
| PDY | Distanza profilo EY |
| PHD | Diametro del preforo |
| PHDX | Diametro massimo del preforo |
| PL | Lunghezza della punta |
| PNA | Angolo incluso del profilo |
| PRFRAD | Raggio del profilo |
| PRSPC | Specifica del profilo |
| PSIR | Angolo di attacco dell'utensile |
| PSIRL | Angolo del tagliente principale sinistro |
| PSIRR | Angolo del tagliente principale destro |
| PSW | Larghezza scanalatura prelavorata |
| RADH | Altezza radiale del corpo |
| RADW | Larghezza radiale del corpo |
| RAR | Angolo di spoglia inferiore di destra |
| RE | Raggio di punta |
| REEQ | Raggio di punta equivalente |
| REL | Raggio di punta, sinistro |
| RER | Raggio di punta, destro |
| RETOLL | Tolleranza inferiore raggio di punta |
| RETOLU | Tolleranza superiore raggio di punta |
| RGL | Lunghezza di riaffilatura |
| RMPX | Massimo angolo di penetrazione |
| RPMX | Velocità rotazionale massima |
| S | Spessore dell'inserto |
| SDL | Lunghezza diametro a gradini |
| SIG | Angolo di punta |
| SPTL | Linea di divisione |
| SSC | Codice misura sede inserto |
| $SSC_E$ | Codice misura sede inserto - posizione finale |
| $SSC_P$ | Codice misura sede inserto - posizione periferica |
| $SSC_S$ | Codice misura sede inserto - posizione laterale |
| STA | Angolo incluso del gradino |
| STDNO | Numero standard |
| SUBSTRATE | Substrato |
| TCDC | Classe di tolleranza diametro di taglio |
| TCDCON | Tolleranza sul diametro di collegamento |
| TCDMM | Tolleranza diametro stelo |
| TCHA | Tolleranza ottenibile del foro |
| TCHAL | Tolleranza inferiore del foro ottenibile |
| TCHAU | Tolleranza superiore del foro ottenibile |
| TCT | Classe di tolleranza utensile |
| TCTR | Classe di tolleranza filettatura |
| TD | Diametro della filettatura |
| TDZ | Misura del diametro della filettatura |
| TFLA | Lunghezza flottante del maschio in avanti |
| TFLB | Lunghezza flottante del maschio indietro |
| TG | Gradiente conico |
| THBTP | Proprietà conicità posteriore della filettatura |
| THCA | Angolo di correzione elica della filettatura |
| THCHT | Tipo smusso della filettatura |
| THFT | Tipo forma della filettatura |
| THFTS | Serie standard forma filettatura |
| THL | Lunghezza filettatura |
| THUB | Spessore mozzo |
| TP | Passo filettatura |
| TPI | Filetti per pollice |
| TPIN | Filetti per pollice minimi |
| TPIX | Filetti per pollice massimi |
| TPN | Passo minimo di filettatura |
| TPT | Tipo profilo della filettatura |
| TPX | Passo massimo di filettatura |
| TRMAX | Gamma di maschiatura max |
| TQ | Coppia |
| TSYC | Codice tipo di utensile |
| TTP | Tipo di filettatura |
| ULDR | Rapporto lunghezza-diametro utilizzabile |
| VCX | Velocità di taglio massima |
| W1 | Larghezza inserto |
| WB | Larghezza del corpo |
| WF | Larghezza funzionale |
| WFCIRP | Larghezza al punto di riferimento dell'articolo da taglio |
| WSC | Larghezza di bloccaggio |
| WT | Peso dell'articolo |
| ZADJ | Numero di inserti regolabili |
| ZEFF | Numero di taglienti effettivi sulla faccia |
| ZEFP | Numero di taglienti periferici effettivi (ZEFP) |
| ZWX | Numero massimo di inserti raschianti |

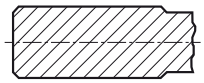
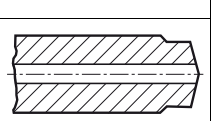
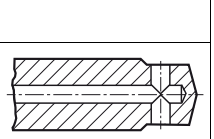
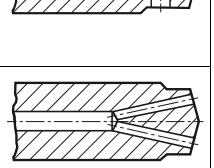
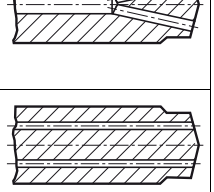
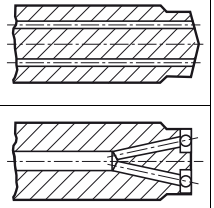
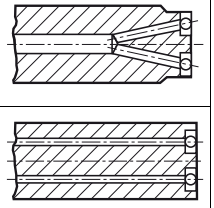
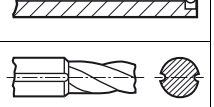
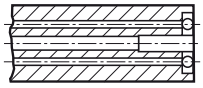
## CNSC

**Codice tipo con ingresso refrigerante**

| Codice | Descrizione | Immagine |
|---|---|---|
| 0 | Senza refrigerante |  |
| 1 | Entrata assiale concentrica |  |
| 2 | Entrata radiale |  |
| 3 | Entrata assiale concentrica e radiale |  |
| 4 | Entrata assiale concentrica su cerchio |  |
| 5 | Entrata radiale prima dell'adattatore |  |
| 6 | Decentrata su flangia |  |
| 7 | Decentrata su flangia e assiale |  |
| 8 | Decentrata sulle scanalature dello stelo | |

## CXSC

**Codice tipo di uscita refrigerante**

| Codice | Descrizione | Immagine |
|---|---|---|
| 0 | Senza uscita refrigerante |  |
| 1 | Uscita assiale concentrica |  |
| 2 | Uscita radiale |  |
| 3 | Uscita assiale inclinata |  |
| 4 | Assiale concentrica su cerchio |  |
| 5 | Uscita assiale inclinata con ugello, regolabile |  |
| 6 | Uscita decentrata con ugello, regolabile |  |
| 7 | Decentrata sulle scanalature dello stelo |  |
| 8 | Assiale o decentrata con ugello, regolabile |  |

# Ricondizionamento

Offriamo di più del tradizionale servizio di “riaffilatura”. Con il nostro servizio di ricondizionamento, garantiamo le stesse prestazioni iniziali, per ridurre il costo per applicazione.

## La nostra offerta

100%

**Affidabilità**
I nostri specialisti sono a vostra disposizione per offrirvi supporto e know-how.

x3

**Prestazioni originali**
La qualità dell'utensile originale è garantita - fino a tre volte.

50%

**Risparmi**
Con il ricondizionamento, è possibile ridurre il costo degli utensili fino al 50%.

## Prodotti coperti dal servizio

**Foratura**

**Fresatura**

**Alesatura**

Come indicato dal simbolo del ricondizionamento sulle pagine dedicate alle famiglie di prodotti.

## Informazioni aggiuntive

**Contenitore per il ricondizionamento**
Il contenitore può essere ordinato in due misure -
- Piccolo (300 x 200 x 138 mm)
Numero articolo: 6949557

- Medio (400 x 300 x 138 mm)
Numero articolo: 6949558

Tutti i tipi di utensili Sandvik Coromant possono essere spediti nello stesso contenitore.

**Servizio di ricondizionamento**
- Prima del ricondizionamento, gli utensili vengono ispezionati per determinare se possono essere ricondizionati. Gli utensili non ricondizionabili verranno restituiti

- Ogni intervento di ricondizionamento viene registrato attraverso una marcatura laser sullo stelo dell'utensile

- Gli utensili vengono restituiti nella confezione originale

**Che succede ai vostri utensili?**
- - Ripristino completo della geometria

- Riduzione della lunghezza della punta

- Riduzione del diametro e della lunghezza delle frese a candela (il diametro minimo è di circa 0.9xDc)

- Mantenimento della tolleranza sul diametro degli alesatori

**Per i prezzi, contattate il vostro Tecnico di Vendita Sandvik Coromant di riferimento.**

# Informazioni per la sicurezza in relazione all’affilatura del metallo duro

## Composizione del materiale

La maggior parte dei prodotti di metallo duro contengono carburo di tungsteno e cobalto. Altre sostanze possono essere: carburo di titanio, carburo di tantalio, carburo di niobio, carburo di cromo, carburo di molibdeno o carburo di vanadio. Alcune qualità contengono carbonitruro di titanio e/o nichel.

## Rischi di esposizione

L’affilatura o il “riscaldamento” di un semilavorato o di un prodotto di metallo duro produce polvere o esalazioni di sostanze pericolose che possono essere inalate, ingerite, oppure venire a contatto con l'epidermide o gli occhi.

## Tossicità acuta

La polvere è tossica per inalazione. L’inalazione può causare irritazioni e infiammazioni alle vie respiratorie. Una tossicità acuta per inalazione, notevolmente più elevata del solo cobalto, è stata riportata durante l’inalazione contemporanea di cobalto e carburo di tungsteno.
Il contatto con la pelle può causare irritazioni e rash cutanei. In persone particolarmente sensibili possono manifestarsi reazioni allergiche.

## Tossicità cronica

Ripetute inalazioni di gas contenenti cobalto possono causare occlusioni alle vie respiratorie. L’inalazione prolungata di concentrazioni maggiori può causare fibrosi o cancro ai polmoni. Studi epidemiologici segnalano che, in passato, i lavoratori esposti ad elevate concentrazioni di carburo di tungsteno/cobalto correvano un rischio maggiore di sviluppare cancro al polmone.
Il cobalto ed il nichel sono due potenti sensibilizzatori della pelle. Contatti ripetuti o prolungati possono causare irritazione e sensibilizzazione.

## Segnalazioni di rischio

Tossico: pericolo di gravi danni alla salute in caso di esposizione prolungata per inalazione.
Tossico per inalazione.
Evidenza limitata di un effetto cancerogeno.
Può provocare sensibilizzazione per inalazione e a contatto con l’epidermide.

## Misure preventive

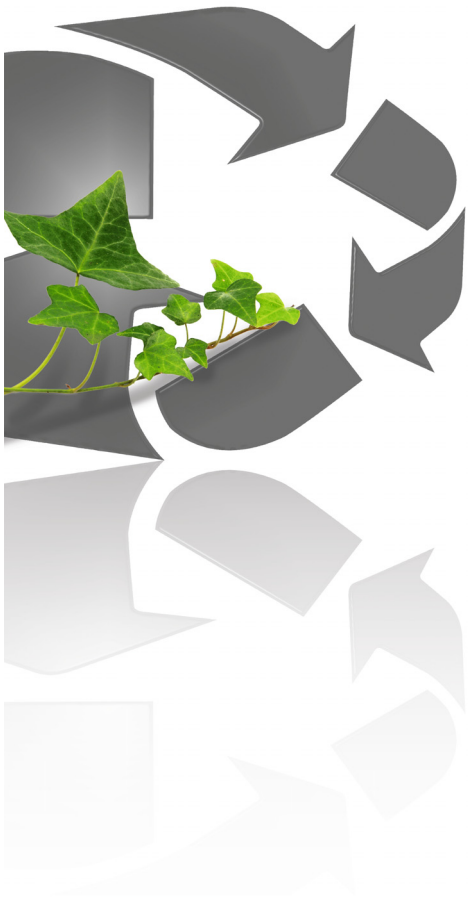
Evitare la formazione e l'inalazione di polvere. Usare un impianto di ventilazione che sia adatto a limitare l'esposizione al personale ben al di sotto dei limiti consentiti a livello nazionale.
Se l’impianto di ventilazione non è disponibile o adeguato, usare respiratori approvati, a livello nazionale, per lo scopo.
Indossare occhiali di protezione o occhiali con schermi laterali, quando è necessario.
Evitare il contatto ripetuto con l'epidermide. Indossare guanti adatti. Lavarsi accuratamente dopo la manipolazione.
Usare vestiario di protezione adatto. Usare indumenti lavabili e riutilizzabili, se richiesto.-
Non mangiare, bere o fumare nell’area di lavoro. Lavarsi accuratamente prima di mangiare, bere o fumare.

# Per il rispetto dell'ambiente!

## Informatevi subito sul Sistema di Riciclo Coromant (CRC)!

B

Il Sistema di Riciclo Coromant (CRC) è un servizio completo che Sandvik Coromant offre a tutti i suoi clienti per la raccolta degli inserti di metallo duro usurati e degli utensili integrali di metallo duro.
In considerazione del crescente consumo di materie prime "non rinnovabili", la gestione economica delle risorse in via di estinzione diventa un dovere di tutti i produttori.
Sandvik Coromant svolge la sua parte offrendo la possibilità di raccogliere inserti di metallo duro e utensili integrali di metallo duro usurati e di riciclarli nel rispetto dell'ambiente.



C

**I vantaggi del Sistema di Riciclo Coromant (CRC) sono:**

- Sistema di riciclo su scala mondiale, certificato secondo ISO e OHAS.
- Senza intermediari.
- Semplice procedura di raccolta e trasporto.
- Meno rifiuti, minore contaminazione dell'ambiente.
- Migliore utilizzazione delle risorse.
- Raccolta di inserti anche di altri fabbricanti.

D

E

Contattare Sandvik Italia, Divisione Coromant, telefonicamente al numero 02/30.705.1 o via fax al numero 02/30705.580, oppure il nostro Tecnico di Vendita o Rivenditore Autorizzato di zona, per richiedere ulteriori informazioni ed ordinare i contenitori per la raccolta (ogni contenitore contiene fino a 20 Kg.)

F

| | Codici di ordinazione |
|---|---|
| Contenitore per la raccolta: | 91617 |
| Cassetta di trasporto (in legno compensato) per utensili di metallo duro integrali: | 92994 |
| Contenitore di raccolta inserti (in legno compensato): | 92995 |

G