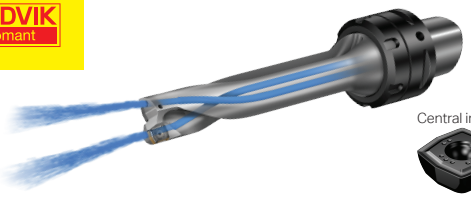
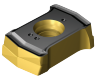
CoroDrill® DS20



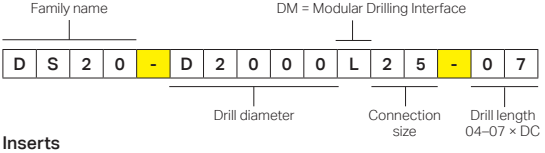
Central insert

Peripheral insert

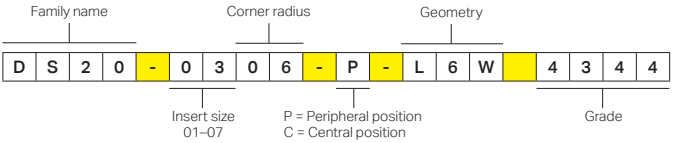


Drill bodies

Connection type
L = ISO9766 shank
LX = ISO9766 shank (inch)
DM = Modular Drilling Interface



Inserts



Insert and grade recommendations

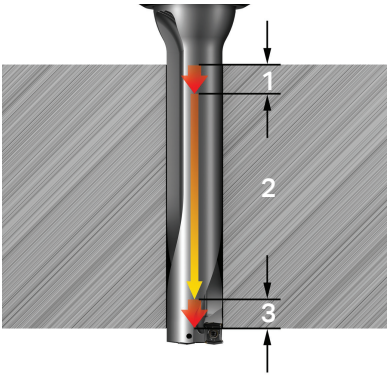
Material		First choice	
		Central insert	Peripheral insert
Low-carbon steel, P1	P	P1.1–1.2: -L5 1344 P1.3–1.5: -M7 1344	P1.1: -H5W 4334 P1.2: -L5W 4334 P1.3–1.5: -M7W 4334
Low-alloy steel, P2	P	-M7 1344	-M7W 4334
Stainless steel	M	-L5 1144	-H5W 2044
Cast iron	K	-M7 1344	-M7W 4334
Non-ferrous material	N	-L5 H13A	-S5W H13A
HRSA	S	-L5 1344	-L6W 4344 (Inconel) -S5W 4344 (Titanium)
Hardened steels	H	-L5 1344	-L6W 4344

Geometry description

Geometry	Description
- M7W	- Low to high feed - Strong reinforced edge - Good chip control in high feed
- L6W	- Low to medium feed - Low cutting force - Multi-purpose geometry with good chip control in most materials
- L5W	- Low to medium feed - Low cutting force - Good chip control in long chipping materials
- S5W	- Low feed - Sharp and extremely low cutting force
- H5W	- Low to medium feed - Negative T-land for hard to break materials - Expect slightly increased cutting forces

Use CoroPlus® Tool Guide for cutting data recommendations and details specific for your application
www.coroguide.com

Drilling strategy for deep holes



- Apply soft entries and exits to maintain the hole tolerance (recommendations can be found in CoroPlus® Tool Guide):

1. f_n at hole entry: f_n × 75%. Length of entry: 1 mm (0.039 inch)
2. f_n at continuous drilling: recommendations from CoroPlus® Tool Guide
3. f_n at hole exit: 0.05 mm/rev (0.002 in/rev) or even lower if high demands on hole quality Length of exit: 3–5 mm (0.118–0.196 inch)

   No v_c change in the different sections of the hole.

Caution!
When drilling through-holes a disc will be produced as the drill breaks through. This disc is often ejected at high speed from between the jaws of the chuck and could inflict damage or injury. To prevent this, the chuck should be enclosed with an adequate guard.

Varning!
Vid borrning av genomgående hål bildas en ändbricka när borren bryter igenom. Denna ändbricka kastas ofta med hög hastighet ut ur chucken, vilket kan förorsaka skador. För att förhindra detta bör chucken förses med en lämplig
skyddskåpa.

Warnung!
Bei der Herstellung von Durchgangsbohrungen mit nicht rotierendem Bohrer entsteht beim Austritt des Bohrers aus dem Werkstück eine Scheibe, die oft mit hoher Geschwindigkeit aus dem Spannfutter geschleudert wird und Schäden und Verletzungen verursachen kann. Um dies zu verhindern, muss das Spannfutter mit einer Schutzabdeckung versehen sein.

Attention!
Le perçage de trous débouchants entraîne la formation d'un disque, souvent éjecté à grande vitesse à travers les mors du mandrin, qui risque d'occasionner blessures ou dommages. Pour y remédier, prévoyez une protection adéquate autour du mandrin.

¡ Precaución !
Cuando se taladran agujeros pasantes se produce un disco cuando la broca termina el agujero. Frecuentemente, este disco es lanzado a gran velocidad por las garras del plato, pudiendo producir daños o accidentes. Para evitar que esto se produzca, el plato debe ir encerrado en una protección adecuada.

Attenzione!
Quando si eseguono fori passanti, l'uscita della punta produce un disco all'estremità posteriore del pezzo. Questo disco viene spesso espulso ad elevata velocità dalle ganasce del mandrino autocentrante, con il rischio di ferire l'operatore. Per evitare danni, si consiglia di montare un'adeguata protezione sul mandrino.

Head office:
AB Sandvik Coromant
SE-811 81 Sandviken, Sweden
www.sandvik.coromant.com
E-mail: info.coromant@sandvik.com

92062

2019.04, Rev 2021.11