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CORODRILL 860 GM OVERVIEW

CoroDrill® 860 with -GM geometry is a high-performance drilling solution for short holes, primarily in steel, stainless steel, cast iron and hardened materials. It also performs competitively in HRSA and non-ferrous materials.

The drill offers robust process security, high hole integrity and excellent tool life, making it ideal for automotive and general engineering applications. The performance of the drill also makes it suitable in applications within the aerospace and oil and gas industries where hole quality and process security are critical.

- Standard diameter range 3–16 mm (0.118–0.629 inch)
- Drill depth 3–8 × drill diameter
- Single- and two-diameter tools as standard
- Body tolerance m7
- Achievable hole tolerance H6–H8

BENEFITS

- Optimized for drilling a wide range of materials and applications across all industry sectors
- Offers excellent stability, machining security and improved tool life
Polished flutes provide better chip evacuation and help reduce heat buildup in the tool
- Robust design and excellent dimensional accuracy significantly improve finished hole tolerance and quality
- With one drill for all materials, stock holding can be reduced and greater machine flexibility is offered, leading to reduced set-up time

ADVANCED GEOMETRY

- Corner reinforcement for increased corner strength and reduction in exit burring
- Optimized double margin for increased stability and improved hole quality
- New point-thinning type for reduced cutting forces and excellent hole accuracy
- New point geometry results in refined clearance angles, improved surface quality and stable wear progression
- Edge preparation for increased cutting edge strength and removal of micro defects

APPLICATION

- CoroDrill® 860 with -GM geometry can be applied in many applications and components across multiple industries
- Perfect for ISO P, K, M and H materials in the general engineering and automotive industries
- Typical components are valve bodies, blocks, casings, flanges and manifolds



RECOMMENDED SPEEDS AND FEEDS

Material		HB	SFM (min-start-max)	Drill diameter, inch (0.2362) Feed/Rev. (min-start-max)	Drill diameter, inch (0.315) Feed/Rev. (min-start-max)
ISO P	Low Alloy	175	328 - 410 - 492	.0059-.0078-.0098	.0062-.0086-.0110
ISO P	High Alloy	300	209 - 252 - 295	.0039-.0055-.0070	.0047-.0066-.0090
ISO M	Stainless	200	98-125-151	.0043-.0059-.0067	.0071-.0079-.0087
ISO M	Duplex SS	260	85-102-115	.0035-.0043-.0051	.0043-.0055-.0067
ISO K	Cast Iron	245	262-328-393	.0047-.0062-.0071	.0062-.0078-.0094
ISO S	Titanium	180	131-164-196	.0023-.0031-.0039	.0031-.0047-.0062
ISO S	HRSA	350	32-49-65	.0023-.0031-.0039	.0023-.0031-.0039
ISO N	Aluminum	60	557-738-918	.0062-.0078-.0094	.0078-.0102-.0122
ISO H	Extra Hard Steel	47-60 HRC*	49-65-82	.0023-.0031-.0039	.0031-.0039-.0047

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