

**SANDVIK**  
Coromant

# CoroDrill® DS20

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# The CoroDrill® DS20: 4–7 × DC insert drill offering reliability, predictability and outstanding penetration rates.

## OVERVIEW

- Diameter range: 15–27 mm (0.591–1.06 inch) and 33.01–40 mm (1.30–1.57 inch)
- Depth capacity: 4–7×DC
- Hole tolerance: H12–H13
- Compatible with both non-rotating and rotating setups
- Can be used for drilling with radial offset, deburring and back boring

## MODULAR DRILLING INTERFACE COUPLING

MDI is a stable and high-precision drilling interface. The modular coupling between drill and adapter allows you to use one size for several drill diameters, leading to less tool inventory and lower costs.

Four locating pins allow for high torque transmission and provide an exact cutting edge position and quick and easy set-up.

With two different diameters on shank and adapter, double centering with high fitting accuracy is possible. Combined with flange and surface contact between the drill body and nut, increased stability, good run-out precision and optimal repeatability can be achieved.



## GEOMETRY AND GRADE SELECTION

	ISO area	First Choice		Complementary Choice	
		Central Insert	Peripheral Insert	Central Insert	Peripheral Insert
Low-carbon steel	ISO P	-L5 1344	-L5W 4334	-L5 1344	-L5W 4324 -L5W 4344 -H5W 4344
Low-alloy steel	ISO P	-M7 1344	-M7W 4334	-M7 1344	-M7W 4324 -M7W 4344
Stainless steel	ISO M	-L5 1144	-L5W 2044	-L5 1144	-L5W 4344 -H5W 4344 -H5W 2044
Cast iron	ISO K	-M7 1344	-M7W 4334	-M7 1344	-M7W 4324 -M7W 4344
Non-ferrous material	ISO N	-L5 H13A	-S5W H13A	-L5 1344	-L5W 4344
HRSA	ISO S	-L5 1344	-L6W 4344 (Inconel) -S5W 4344 (Titanium)	-L5 H13A	-L5W H13A -S5W H13A
Hardened steels	ISO H	-L5 1344	-L6W 4344	-M7 1344	-M7W 4344

## RECOMMENDED SPEED AND FEED

Material		SFM	Feed/Rev.
Low Alloy	ISO P	610	0.004
High Alloy	ISO P	560	0.0041
Stainless	ISO M	490	0.0035
Duplex SS	ISO M	350	0.0035

Material		SFM	Feed/Rev.
Titanium	ISO K	160	0.0028
Inconel	ISO N	130	0.0028
Aluminum	ISO S	1125	0.005
Cast Iron	ISO H	510	0.005