



- Quick quotation
- Easy to order
- Competitive delivery

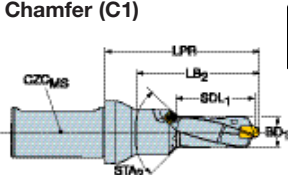
Even more possibilities thanks to tailored design!

If you do not find what you need in our comprehensive standard programme, choose the tool shape you require and we will tailor it for you to *your* dimensions.

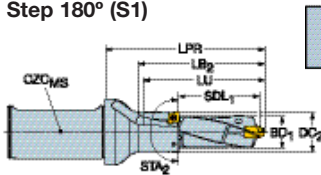
CoroDrill® 870 Step and chamfer

Type of drill

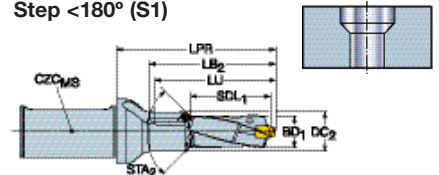
Chamfer (C1)



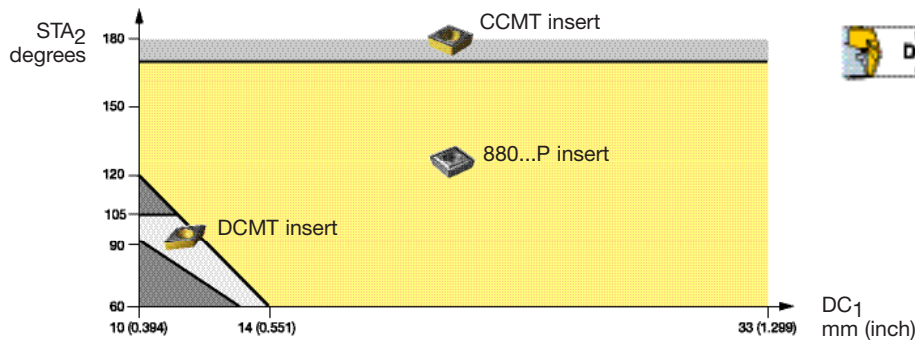
Step 180° (S1)



Step <180° (S1)



Type of step or chamfer insert



Sizes of standard drill tip interface

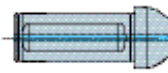
Tip Interface size	DC ₁ min (mm)	DC ₁ max (mm)
6	10.00	10.49
7	10.50	10.99
8	11.00	11.49
9	11.50	11.99
10	12.00	12.49
11	12.50	12.99
12	13.00	13.49
13	13.50	13.99
14	14.00	14.99
15	15.00	15.99
16	16.00	16.99
17	17.00	17.99
18	18.00	18.99
19	19.00	19.99
20	20.00	20.99
21	21.00	21.99
22	22.00	22.99
23	23.00	23.99
24	24.00	24.99
25	25.00	25.99
26	26.00	26.99
27	27.00	27.99
28	28.00	28.99
29	29.00	29.99
30	30.00	30.99
31	31.00	33.00

Couplings

Drill bodies for drill tip diameter	Coupling type	
	① ②	① ②
	Coupling size CZC _{MS}	
DC mm	metric	inch
10.00-13.99	16, 20, 25	.625, .75, 1.0
14.00-15.99	16, 20, 25, 32	.625, .75, 1.0, 1.25
16.00-19.99	20, 25, 32	.75, 1.0, 1.25
20.00-24.99	25, 32	1.0, 1.25
25.00-48.5	32, 40	1.25, 1.5

① Cylindrical with flat (with flange)

(acc. to ISO 9766)



② Cylindrical (with flange)

(Same length as ISO 9766)



*For chamfer drills DC₁ influences the size of shank.
For step drills DC₂ influences the size of shank

Options

Note Drill tips to be ordered separately.

Note For specific details regarding the options, contact your Sandvik Coromant sales representative.

Type of drill	S1 = step drill, C1 = chamfer drill
DC ₁	Drill tip diameter – 10.00–33.00 mm
MIID	Master drill tip identification
Optimized drill body diameter	Drill body diameter (BD ₁) optimized (largest possible) for chosen drill tip diameter
STA ₂	Step included angle, step 60–180 degrees, chamfer 60–150 degrees depending on other parameters
DC ₂ *	Cutting diameter on step – 15–48.5 mm depending on other parameters
SDL ₁	Length to step or chamfer – 20 mm–5 x DC ₁ depending on other parameters
CICT	Number of inserts on step or chamfer – 1 or 2
LU*	Usable length – max SDL ₁ + 2 x DC ₁ , depending on other parameters
LB ₂	Drill body length – max 8 x DC ₁ , depending on other parameters

Coupling type	Cylindrical with flat, acc. to ISO 9766 (with flange) – CYPFF Cylindrical, same length as ISO 9766 (with flange) – CYLFA
Coupling unit	M = metric U = inch
CZC _{MS}	Coupling size – see above table
LPR	Protruding length – depending on other parameters

*Parameter only valid for step drill





CoroDrill® 870 Step and chamfer

Inquiry/ordering No.

Customer	Customer No. (Coromant internal)	Date
Street	Telephone	Customer attention
Post Code/City/State	Telefax	Issuer
Quantity	Customer denomination	

Your value/
Your choice

State only your options deviating from the above standard

Type of drill	S1 = step drill, C1 = chamfer drill	<input type="text"/>
DC₁	Drill tip diameter – 10.00–33.00 mm	<input type="text"/>
MIID	Master drill tip identification	<input type="text"/>
Optimized drill body diameter	Drill body diameter (BD ₁) optimized (largest possible) for chosen drill tip diameter	<input type="text"/>
STA₂	Step included angle, step 60–180 degrees , chamfer 60–150 degrees , depending on other parameters	<input type="text"/>
DC₂*	Cutting diameter on step – 15–48,5 mm depending on other parameters	<input type="text"/>
SDL₁	Length to step or chamfer – 20 mm–5 x DC₁ , depending on other parameters	<input type="text"/>
CICT	Number of inserts on step or chamfer – 1 or 2	<input type="text"/>
LU*	Usable length – max SDL₁ + 2 x DC₁ depending on other parameters	<input type="text"/>
LB₂	Drill body length – max 8 x DC₁ , depending on other parameters	<input type="text"/>
Coupling type	Cylindrical with flat, acc. to ISO 9766 (with flange) – CYLPFF Cylindrical, same length as ISO 9766 (with flange) – CYLFA	<input type="text"/>
Coupling unit	M = metric U = inch	<input type="text"/>
CZCMS	Coupling size – see table on previous page	<input type="text"/>
LPR	Protruding length – depending on other parameters	<input type="text"/>

*Parameter only valid for step drill



The value/choice must be given

If no value/choice is specified, it will be recommended by the system