SANDVIK
Coromant

2020.2

Suplemento

– A LOS CATÁLOGOS DE HERRAMIENTAS
PARA TORNEADO Y ROTATIVAS

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Taladrado C
Mandrinado D
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CoroTurn® TR

Plaquitas A3

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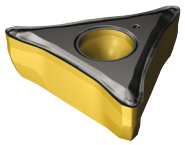
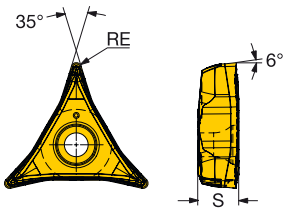
Para ver la gama completa, consulte www.sandvik.coromant.com/es

Plaquita CoroTurn® Prime para torneado

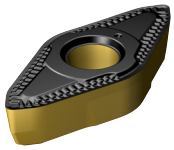
Plaquita tipo A

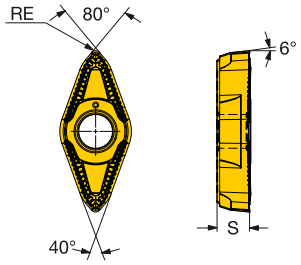




		SSC	S	REEQ	RE	CÓDIGO ISO	P 4415	P 4425
Acabado	L5	CP-A	6.00	0.4	0.40	CP-A1104-L5	★	☆
			.236	.016	.016			
			6.00	0.8	0.79	CP-A1108-L5	★	☆
			.236	.031	.031			
	L5W	CP-A	6.00	0.8	0.80	CP-A1108-L5W	★	☆
			.236	.031	.031			
	L3	CP-A	6.00		0.79	CP-A1108-L3	★	☆
			.236		.031			
	L3WX	CP-A	6.00	0.8	0.80	CP-A1108-L3WX	★	☆
			.236	.031	.031			

Plaquita tipo B





		SSC	S	REEQ	RE	CÓDIGO ISO	P 4425
Acabado	L4	CP-B	5.00	0.8	0.80	CP-B1108-L4	★
			.197	.031	.031		
	L4W	CP-B	5.00	0.8	0.80	CP-B1108-L4W	★
			.197	.031	.031		
Medio	M5	CP-B	5.00	0.8	0.80	CP-B1108-M5	★
			.197	.031	.031		
	M5W	CP-B	5.00	0.8	0.80	CP-B1108-M5W	★
			.197	.031	.031		
	H3W	CP-B	5.00	0.8	0.80	CP-B1108-H3W	★
			.197	.031	.031		
	H3	CP-B	5.00	0.8	0.80	CP-B1108-H3	★
			.197	.031	.031		

SSC = Debe corresponderse con el SSC del portaherramientas.

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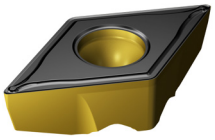
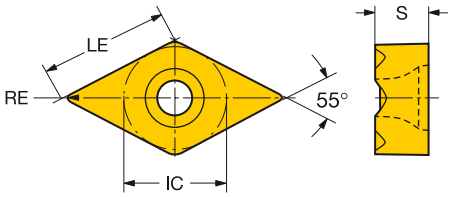
Plaquita CoroTurn® TR para torneado

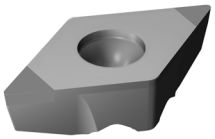
Plaquita tipo D (Rómbica de 55°)

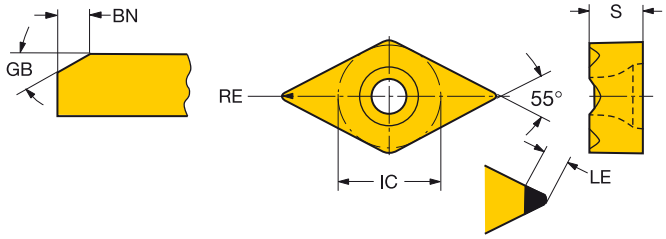




			LE	S	RE	CÓDIGO ISO	P 4415	P 4425
Acabado	F	13	12.6	5.53	0.40	TR-DC1304-F	★	☆
			.496	*.218*	*.016*			
			12.2	5.53	0.79	TR-DC1308-F	★	☆
			.480	*.218*	*.031*			
Medio	M	13	12.2	5.53	0.79	TR-DC1308-M	☆	★
			.480	*.218*	*.031*			
			11.8	5.53	1.19	TR-DC1312-M	☆	★
			.465	*.218*	*.047*			

Materiales de corte avanzados





			LE	S	RE	CÓDIGO ISO	S 7014
Acabado	EF	13	3.0	5.53	0.79	TR-DC1308EF	★
			.118	*.218*	*.031*		
			2.6	5.53	1.19	TR-DC1312EF	★
			.104	*.218*	*.047*		

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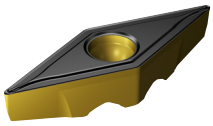
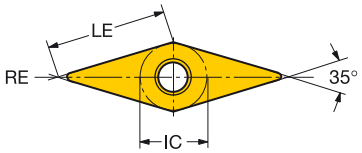
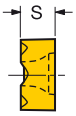
Plaquita CoroTurn® TR para torneado

Plaquita tipo V (Rómbica de 35°)

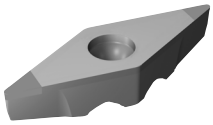


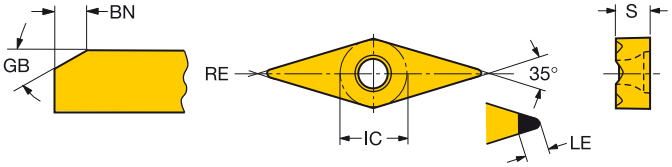




			LE	S	RE	CÓDIGO ISO	P 4415	P 4425
Acabado	F	13	12.6	4.53	0.40	TR-VB1304-F	★	☆
			.496	*.178*	*.016*			
			12.2	4.53	0.79	TR-VB1308-F	★	☆
			.480	*.178*	*.031*			
			11.8	4.53	1.19	TR-VB1312-F	★	☆
			.465	*.178*	*.047*			

Materiales de corte avanzados





			LE	S	RE	CÓDIGO ISO	S 7014
Acabado	EF	13	3.0	4.53	0.79	TR-VB1308EF	★
			.118	*.178*	*.031*		
			2.1	4.53	1.19	TR-VB1312EF	★
			.084	*.178*	*.047*		

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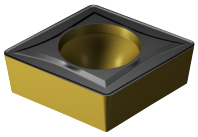
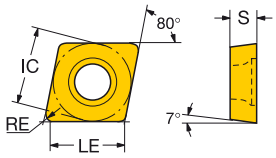
Plaquita CoroTurn® 107 para torneado

Plaquita tipo C (Rómbica de 80°)





		IC	LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Acabado	WF	06	1/4	6.0	2.38	0.40	CCMT 06 02 04-WF	★	☆	CCMT 2(1.5)1-WF
				.238	.094	.016				
				5.6	2.38	0.79	CCMT 06 02 08-WF	★	☆	CCMT 2(1.5)2-WF
				.222	.094	.031				
		09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-WF	★	☆	CCMT 3(2.5)1-WF
				.365	.156	.016				
				8.9	3.97	0.79	CCMT 09 T3 08-WF	★	☆	CCMT 3(2.5)2-WF
				.349	.156	.031				
	PF	06	1/4	6.2	2.38	0.20	CCMT 06 02 02-PF		★	CCMT 2(1.5)0-PF
				.246	.094	.008				
				6.0	2.38	0.40	CCMT 06 02 04-PF	★		CCMT 2(1.5)1-PF
				.238	.094	.016				
		09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-PF	★	☆	CCMT 3(2.5)1-PF
				.365	.156	.016				
				8.9	3.97	0.79	CCMT 09 T3 08-PF	★	☆	CCMT 3(2.5)2-PF
				.349	.156	.031				
		12	1/2	12.5	4.76	0.40	CCMT 12 04 04-PF	★	☆	CCMT 431-PF
				.492	.188	.016				
	UF	06	1/4	6.0	2.38	0.40	CCMT 06 02 04-UF	★	☆	CCMT 2(1.5)1-UF
				.238	.094	.016				
		09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-UF	★	☆	CCMT 3(2.5)1-UF
				.365	.156	.016				
Medio	WM	06	1/4	5.6	2.38	0.79	CCMT 06 02 08-WM	☆	★	CCMT 2(1.5)2-WM
				.222	.094	.031				
		09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-WM	☆	★	CCMT 3(2.5)1-WM
				.365	.156	.016				
				8.9	3.97	0.79	CCMT 09 T3 08-WM	☆	★	CCMT 3(2.5)2-WM
				.349	.156	.031				
		12	1/2	12.5	4.76	0.40	CCMT 12 04 04-WM	☆	★	CCMT 431-WM
				.492	.188	.016				
				12.1	4.76	0.79	CCMT 12 04 08-WM	☆	★	CCMT 432-WM
				.476	.188	.031				
	PM	06	1/4	6.0	2.38	0.40	CCMT 06 02 04-PM	☆	★	CCMT 2(1.5)1-PM
				.238	.094	.016				
				5.6	2.38	0.79	CCMT 06 02 08-PM	☆	★	CCMT 2(1.5)2-PM
				.222	.094	.031				
		09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-PM	☆	★	CCMT 3(2.5)1-PM
				.365	.156	.016				
				8.9	3.97	0.79	CCMT 09 T3 08-PM	☆	★	CCMT 3(2.5)2-PM
				.349	.156	.031				
		12	1/2	12.5	4.76	0.40	CCMT 12 04 04-PM	☆	★	CCMT 431-PM
				.492	.188	.016				
				12.1	4.76	0.79	CCMT 12 04 08-PM	☆	★	CCMT 432-PM
				.476	.188	.031				
				11.7	4.76	1.19	CCMT 12 04 12-PM	☆	★	CCMT 433-PM
				.460	.188	.047				
	UM	06	1/4	6.0	2.38	0.40	CCMT 06 02 04-UM	☆	★	CCMT 2(1.5)1-UM
				.238	.094	.016				
		09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-UM	☆	★	CCMT 3(2.5)1-UM
				.365	.156	.016				
				8.9	3.97	0.79	CCMT 09 T3 08-UM	☆	★	CCMT 3(2.5)2-UM
				.349	.156	.031				
		12	1/2	12.1	4.76	0.79	CCMT 12 04 08-UM	☆	★	CCMT 432-UM
				.476	.188	.031				

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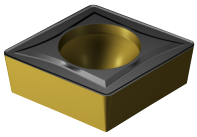
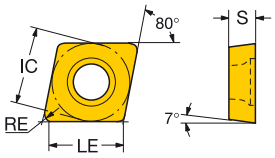
Plaquita CoroTurn® 107 para torneado

Plaquita tipo C (Rómbica de 80°)





		IC	LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Desbaste	PR	06	5.6	2.38	0.79	CCMT 06 02 08-PR	☆	★	CCMT 2(1.5)2-PR
		1/4	*.222*	*.094*	*.031*				
		09	8.9	3.97	0.79	CCMT 09 T3 08-PR	☆	★	CCMT 3(2.5)2-PR
		3/8	*.349*	*.156*	*.031*				
			8.5	3.97	1.19	CCMT 09 T3 12-PR	☆	★	CCMT 3(2.5)3-PR
			.334	*.156*	*.047*				
		12	12.1	4.76	0.79	CCMT 12 04 08-PR	☆	★	CCMT 432-PR
		1/2	*.476*	*.188*	*.031*				
			11.7	4.76	1.19	CCMT 12 04 12-PR	☆	★	CCMT 433-PR
			.460	*.188*	*.047*				
	UR	09	9.3	3.97	0.40	CCMT 09 T3 04-UR	☆	★	CCMT 3(2.5)1-UR
		3/8	*.365*	*.156*	*.016*				
			8.9	3.97	0.79	CCMT 09 T3 08-UR	☆	★	CCMT 3(2.5)2-UR
			.349	*.156*	*.031*				
		12	12.1	4.76	0.79	CCMT 12 04 08-UR	☆	★	CCMT 432-UR
		1/2	*.476*	*.188*	*.031*				

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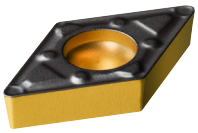
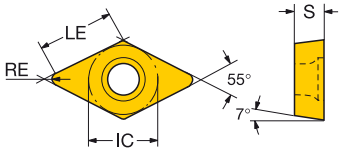
Plaquita CoroTurn® 107 para torneado

Plaquita tipo D (Rómbica de 55°)



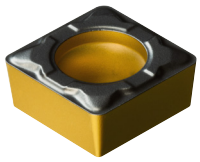


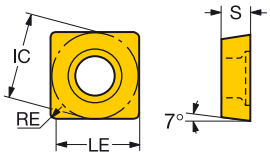
		IC	LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Acabado	WF	07	1/4	7.4	2.38	0.40	DCMX 07 02 04-WF	★	☆	DCMX 2(1.5)1-WF
				.289	.094	.016				
				7.0	2.38	0.79	DCMX 07 02 08-WF	★	☆	DCMX 2(1.5)2-WF
				.274	.094	.031				
		11	3/8	11.2	3.97	0.40	DCMX 11 T3 04-WF	★	☆	DCMX 3(2.5)1-WF
				.442	.156	.016				
				10.8	3.97	0.79	DCMX 11 T3 08-WF	★	☆	DCMX 3(2.5)2-WF
				.426	.156	.031				
	PF	07	1/4	7.4	2.38	0.40	DCMT 07 02 04-PF	★	☆	DCMT 2(1.5)1-PF
				.289	.094	.016				
		11	3/8	11.2	3.97	0.40	DCMT 11 T3 04-PF	★	☆	DCMT 3(2.5)1-PF
				.442	.156	.016				
				10.8	3.97	0.79	DCMT 11 T3 08-PF	★	☆	DCMT 3(2.5)2-PF
				.426	.156	.031				
	UF	07	1/4	7.4	2.38	0.40	DCMT 07 02 04-UF	★	☆	DCMT 2(1.5)1-UF
				.289	.094	.016				
		11	3/8	11.2	3.97	0.40	DCMT 11 T3 04-UF	★	☆	DCMT 3(2.5)1-UF
				.442	.156	.016				
				10.8	3.97	0.79	DCMT 11 T3 08-UF	★	☆	DCMT 3(2.5)2-UF
				.426	.156	.031				
Medio	WM	11	3/8	11.2	3.97	0.40	DCMX 11 T3 04-WM	☆	★	DCMX 3(2.5)1-WM
				.442	.156	.016				
				10.8	3.97	0.79	DCMX 11 T3 08-WM	☆	★	DCMX 3(2.5)2-WM
				.426	.156	.031				
	PM	07	1/4	7.4	2.38	0.40	DCMT 07 02 04-PM	☆	★	DCMT 2(1.5)1-PM
				.289	.094	.016				
				7.0	2.38	0.79	DCMT 07 02 08-PM	☆	★	DCMT 2(1.5)2-PM
				.274	.094	.031				
		11	3/8	11.2	3.97	0.40	DCMT 11 T3 04-PM	☆	★	DCMT 3(2.5)1-PM
				.442	.156	.016				
				10.8	3.97	0.79	DCMT 11 T3 08-PM	☆	★	DCMT 3(2.5)2-PM
				.426	.156	.031				
				10.4	3.97	1.19	DCMT 11 T3 12-PM	☆	★	DCMT 3(2.5)3-PM
				.411	.156	.047				
	UM	07	1/4	7.4	2.38	0.40	DCMT 07 02 04-UM	☆	★	DCMT 2(1.5)1-UM
				.289	.094	.016				
				7.0	2.38	0.79	DCMT 07 02 08-UM	☆	★	DCMT 2(1.5)2-UM
				.274	.094	.031				
		11	3/8	11.2	3.97	0.40	DCMT 11 T3 04-UM	☆	★	DCMT 3(2.5)1-UM
				.442	.156	.016				
				10.8	3.97	0.79	DCMT 11 T3 08-UM	☆	★	DCMT 3(2.5)2-UM
				.426	.156	.031				
Desbaste	PR	11	3/8	10.8	3.97	0.79	DCMT 11 T3 08-PR	☆	★	DCMT 3(2.5)2-PR
				.426	.156	.031				
				10.4	3.97	1.19	DCMT 11 T3 12-PR	☆	★	DCMT 3(2.5)3-PR
				.411	.156	.047				
	UR	11	3/8	11.2	3.97	0.40	DCMT 11 T3 04-UR	☆	★	DCMT 3(2.5)1-UR
				.442	.156	.016				
				10.8	3.97	0.79	DCMT 11 T3 08-UR	☆	★	DCMT 3(2.5)2-UR
				.426	.156	.031				
				10.4	3.97	1.19	DCMT 11 T3 12-UR	☆	★	DCMT 3(2.5)3-UR
				.411	.156	.047				

A26 F2

Plaquita CoroTurn® 107 para torneado

Plaquita tipo S (Cuadrada)





		IC	LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Acabado	PF	09	9.1	3.97	0.40	SCMT 09 T3 04-PF	★	☆	SCMT 3(2.5)1-PF
			.359	*.156*	*.016*				
			8.7	3.97	0.79	SCMT 09 T3 08-PF	★	☆	SCMT 3(2.5)2-PF
			.344	*.156*	*.031*				
	UF	09	8.7	3.97	0.79	SCMT 09 T3 08-UF	★	☆	SCMT 3(2.5)2-UF
			.344	*.156*	*.031*				
Medio	PM	09	9.1	3.97	0.40	SCMT 09 T3 04-PM	☆	★	SCMT 3(2.5)1-PM
			.359	*.156*	*.016*				
			8.7	3.97	0.79	SCMT 09 T3 08-PM	☆	★	SCMT 3(2.5)2-PM
			.344	*.156*	*.031*				
		12	12.3	4.76	0.40	SCMT 12 04 04-PM	☆	★	SCMT 431-PM
			.484	*.188*	*.016*				
			11.9	4.76	0.79	SCMT 12 04 08-PM	☆	★	SCMT 432-PM
			.469	*.188*	*.031*				
			11.5	4.76	1.19	SCMT 12 04 12-PM	☆	★	SCMT 433-PM
			.453	*.188*	*.047*				
	UM	09	8.7	3.97	0.79	SCMT 09 T3 08-UM	☆	★	SCMT 3(2.5)2-UM
			.344	*.156*	*.031*				
		12	11.9	4.76	0.79	SCMT 12 04 08-UM	☆	★	SCMT 432-UM
			.469	*.188*	*.031*				
			11.5	4.76	1.19	SCMT 12 04 12-UM	☆	★	SCMT 433-UM
			.453	*.188*	*.047*				
Desbaste	PR	09	8.7	3.97	0.79	SCMT 09 T3 08-PR	☆	★	SCMT 3(2.5)2-PR
			.344	*.156*	*.031*				
			8.3	3.97	1.19	SCMT 09 T3 12-PR	☆	★	SCMT 3(2.5)3-PR
			.328	*.156*	*.047*				
		12	11.9	4.76	0.79	SCMT 12 04 08-PR	☆	★	SCMT 432-PR
			.469	*.188*	*.031*				
			11.5	4.76	1.19	SCMT 12 04 12-PR	☆	★	SCMT 433-PR
			.453	*.188*	*.047*				
	UR	09	8.7	3.97	0.79	SCMT 09 T3 08-UR	☆	★	SCMT 3(2.5)2-UR
			.344	*.156*	*.031*				
		12	11.9	4.76	0.79	SCMT 12 04 08-UR		★	SCMT 432-UR
			.469	*.188*	*.031*				

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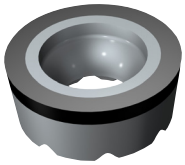
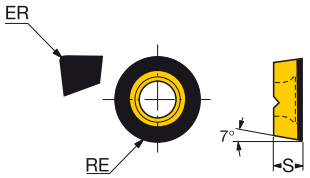
Plaquita CoroTurn® 107 para torneado

Plaquita tipo R (Redonda)

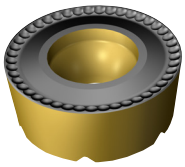
Plaquitas redondas con asiento estriado

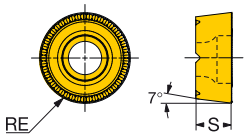




Versión métrica

		S	RE	CÓDIGO ISO	S 7014
Medio	ED	3.18	4.00	RCGW0803MTED	★
		3.97	5.00	RCGW10T3MTED	★
		4.76	6.00	RCGW1204MUED	★





Versión métrica

		S	RE	CÓDIGO ISO	P 4425	M 1105	M 2220	S 1105
Acabado	L3	3.18	4.00	RCMT 08 03 MP-L3	★	☆	★	★
		3.97	5.00	RCMT 10 T3 MP-L3	★	☆	★	★
		4.76	6.00	RCMT 12 04 MP-L3	★	☆	★	★
		6.35	8.00	RCMT 16 06 MP-L3	★	☆	★	★
Medio	M3	3.18	4.00	RCMT 08 03 MP-M3	★	☆	★	★
		3.97	5.00	RCMT 10 T3 MP-M3	★	☆	★	★
		4.76	6.00	RCMT 12 04 MP-M3	★	☆	★	★
		6.35	8.00	RCMT 16 06 MP-M3	★	☆	★	★
Desbaste	H7	3.18	4.00	RCMT 08 03 MP-H7	★	☆	★	★
		3.97	5.00	RCMT 10 T3 MP-H7	★	☆	★	★
		4.76	6.00	RCMT 12 04 MP-H7	★	☆	★	★
		6.35	8.00	RCMT 16 06 MP-H7	★	☆	★	★

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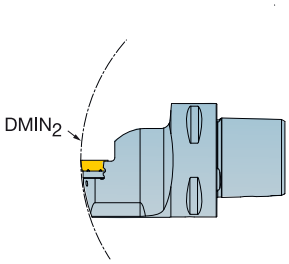
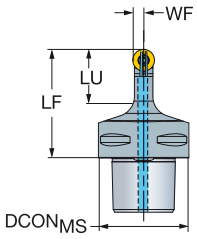
Unidad de corte CoroTurn® 107 para torneado

Diseño de sujeción por tornillo: para plaquitas con asiento estriado

Coromant Capto® - Suministro de refrigerante interior





RCMT..MP/MT/MU

								Dimensiones, mm, pulg.							
	IC	CZC_{MS}	$DMIN_2$	LU	RMPX	CNSC	Código de pedido	$DCON_{MS}$	WB	LF	WF	BAR PSI	NM	KG	MIID
08	.315	C5	165.0	28.0	90°	3	C5-SRDCN-00060-08XC	50	6.8	60.0	4.0	150	1.4	0.53	RCMT 08 03 MP
			6.496	*1.102*				*1.969*	*.268*	*2.362*	*.157*	*2175*			
		C6	190.0	32.0	90°	3	C6-SRDCN-00065-08XC	63	6.8	65.0	4.0	150	1.4	0.89	RCMT 08 03 MP
			7.480	*1.260*				*2.480*	*.268*	*2.559*	*.157*	*2175*			
10	.394	C5	165.0	30.0	90°	3	C5-SRDCN-00060-10XC	50	8.4	60.0	5.0	150	3.0	0.53	RCMT 10 T3 MP
			6.496	*1.181*				*1.969*	*.331*	*2.362*	*.197*	*2175*			
		C6	190.0	34.0	90°	3	C6-SRDCN-00065-10XC	63	8.4	65.0	5.0	150	3.0	0.89	RCMT 10 T3 MP
			7.480	*1.339*				*2.480*	*.331*	*2.559*	*.197*	*2175*			
12	.472	C5	165.0	30.0	90°	3	C5-SRDCN-00060-12XC	50	10.2	60.0	6.0	150	3.0	0.54	RCMT 12 04 MP
			6.496	*1.181*				*1.969*	*.402*	*2.362*	*.236*	*2175*			
		C6	190.0	34.0	90°	3	C6-SRDCN-00065-12XC	63	10.2	65.0	6.0	150	3.0	0.91	RCMT 12 04 MP
			7.480	*1.339*				*2.480*	*.402*	*2.559*	*.236*	*2175*			
16	.630	C5	165.0	30.0	90°	3	C5-SRDCN-00060-16XC	50	13.6	60.0	8.0	150	6.4	0.57	RCMT 16 06 MP
			6.496	*1.181*				*1.969*	*.535*	*2.362*	*.315*	*2175*			
		C6	190.0	34.0	90°	3	C6-SRDCN-00065-16XC	63	13.6	65.0	8.0	150	6.4	0.94	RCMT 16 06 MP
			7.480	*1.339*				*2.480*	*.535*	*2.559*	*.315*	*2175*			

N - Neutro

			Piezas de repuesto			
	IC	CZC_{MS}	Tornillo de plaquita	Placa de apoyo	Tornillo de la placa de apoyo	Boquilla
08	.315	C5-C6	5513 020-04			5691 026-23
10	.394	C5-C6	5513 020-09			5691 026-13
12	.472	C5-C6	5513 020-01	5322 160-01 E7F3	5512 090-01	5691 026-13
16	.630	C5-C6	5513 020-26	5322 160-02 E7F3	5512 090-06	5691 026-03

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

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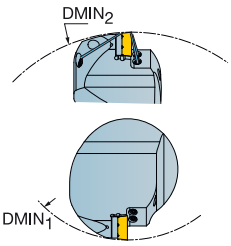
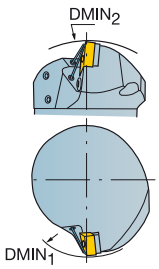
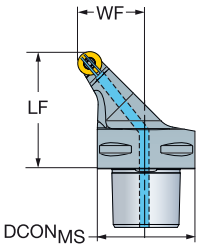
Unidad de corte CoroTurn® 107 para torneado

Diseño de sujeción por tornillo: para plaquitas con asiento estriado

Coromant Capto® - Suministro de refrigerante interior







RCMT..MP/MT/MU

			Dimensiones, mm, pulg.										
	IC	CZC_{MS}	$DMIN_1$	$DMIN_2$	RMPX	CNSC	Código de pedido	$DCON_{MS}$	LF	WF	BAR PSI	NM	KG	MIID
08	.315	C5	150.0	165.0	45°	3	C5-SRSCR/L-35060-08XC	50	60.0	35.0	150	1.4	0.61	RCMT 08 03 MP
			5.906	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	150.0	190.0	45°	3	C6-SRSCR/L-45065-08XC	63	65.0	45.0	150	1.4	1.17	RCMT 08 03 MP
			5.906	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			
10	.394	C5	150.0	165.0	45°	3	C5-SRSCR/L-35060-10XC	50	60.0	35.0	150	3.0	0.62	RCMT 10 T3 MP
			5.906	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	150.0	190.0	45°	3	C6-SRSCR/L-45065-10XC	63	65.0	45.0	150	3.0	1.17	RCMT 10 T3 MP
			5.906	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			
12	.472	C5	150.0	165.0	45°	3	C5-SRSCR/L-35060-12XC	50	60.0	35.0	150	3.0	0.63	RCMT 12 04 MP
			5.906	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	150.0	190.0	45°	3	C6-SRSCR/L-45065-12XC	63	65.0	45.0	150	3.0	1.18	RCMT 12 04 MP
			5.906	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			
16	.630	C5	150.0	165.0	45°	3	C5-SRSCR/L-35060-16XC	50	60.0	35.0	150	6.4	0.64	RCMT 16 06 MP
			5.906	*6.496*				*1.969*	*2.362*	*1.378*	*2175*			
		C6	150.0	190.0	45°	3	C6-SRSCR/L-45065-16XC	63	65.0	45.0	150	6.4	1.18	RCMT 16 06 MP
			5.906	*7.480*				*2.480*	*2.559*	*1.772*	*2175*			

R = A Derecha, L = A Izquierda

			Piezas de repuesto				
	IC	CZC_{MS}	Tornillo de plaquita	Placa de apoyo		Tornillo de la placa de apoyo	Boquilla
08	.315	C5-C6	5513 020-04				5691 026-23
10	.394	C5-C6	5513 020-09				5691 026-13
12	.472	C5-C6	5513 020-01	5322 160-01	E7F3	5512 090-01	5691 026-03
16	.630	C5-C6	5513 020-26	5322 160-02	E7F3	5512 090-06	5691 026-03

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

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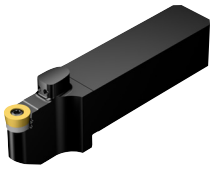
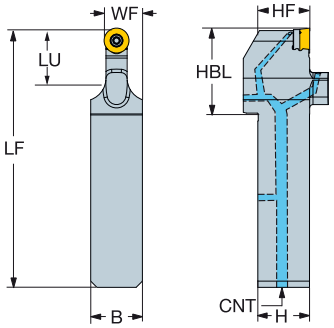
Mango de herramienta CoroTurn® 107 QS para torneado

Diseño de sujeción por tornillo: para plaquitas con asiento estriado

Suministro de refrigerante de precisión



RCMT..MP/MT/MU



Versión métrica

							Dimensiones, mm								BAR	NM	KG	
	CZC_{MS}	LU	RMPX	OHX	CNSC	Código de pedido	B	H	WB	HBL	LF	WF	HF	CNT				MIID
08	20 x 20	20.0	90°	56.0	3	QS-SRDCN-202020-08XC	20.0	20.0	6.8	36.0	105.0	14.0	20.0	G 1/8-28	150	1.4	0.25	RCMT 08 03 MP
	25 x 25	20.0	90°	61.0	3	QS-SRDCN-252520-08XC	25.0	25.0	6.8	36.0	120.0	16.5	25.0	G 1/8-28	150	1.4	0.46	RCMT 08 03 MP
	25 x 25	40.0	90°	81.0	3	QS-SRDCN-252540-08XC	25.0	25.0	6.8	56.0	140.0	16.5	25.0	G 1/8-28	150	1.4	0.50	RCMT 08 03 MP
10	20 x 20	25.0	90°	60.0	3	QS-SRDCN-202025-10XC	20.0	20.0	8.4	40.0	109.0	15.0	20.0	G 1/8-28	150	3.0	0.27	RCMT 10 T3 MP
	25 x 25	25.0	90°	65.0	3	QS-SRDCN-252525-10XC	25.0	25.0	8.4	40.0	124.0	17.5	25.0	G 1/8-28	150	3.0	0.48	RCMT 10 T3 MP
	25 x 25	40.0	90°	80.0	3	QS-SRDCN-252540-10XC	25.0	25.0	8.4	55.0	139.0	17.5	25.0	G 1/8-28	150	3.0	0.52	RCMT 10 T3 MP
12	20 x 20	25.0	90°	58.0	3	QS-SRDCN-202025-12XC	20.0	20.0	10.2	38.0	107.0	16.0	20.0	G 1/8-28	150	3.0	0.27	RCMT 12 04 MP
	25 x 25	28.0	90°	66.0	3	QS-SRDCN-252528-12XC	25.0	25.0	10.2	41.0	125.0	18.5	25.0	G 1/8-28	150	3.0	0.49	RCMT 12 04 MP
	25 x 25	40.0	90°	78.0	3	QS-SRDCN-252540-12XC	25.0	25.0	10.2	53.0	137.0	20.5	25.0	G 1/8-28	150	3.0	0.52	RCMT 12 04 MP
16	25 x 25	35.0	90°	70.0	3	QS-SRDCN-252535-16XC	25.0	25.0	13.6	45.0	129.0	20.5	25.0	G 1/8-28	150	6.4	0.50	RCMT 16 06 MP

Versión en pulgadas

							Dimensiones, pulg.								PSI	FT/LBS	LBS	
IC	CZC_{MS}	LU	RMPX	OHX	CNSC	Código de pedido	B	H	WB	HBL	LF	WF	HF	CNT				MIID
.315	3/4 x 3/4	1.000	90°	2.125	3	QS-SRDCN-12-20-08XC	.750	.750	.268	1.375	4.092	.531	.750	G 1/8-28	2175	1.0	0.494	RCMT 08 03 MP
	1 x 1	.750	90°	2.375	3	QS-SRDCN-16-20-08XC	1.000	1.000	.268	1.375	4.682	.656	1.000	G 1/8-28	2175	1.0	1.045	RCMT 08 03 MP
	1 x 1	1.500	90°	3.125	3	QS-SRDCN-16-40-08XC	1.000	1.000	.268	2.125	5.432	.656	1.000	G 1/8-28	2175	1.0	1.120	RCMT 08 03 MP
.394	3/4 x 3/4	1.000	90°	2.375	3	QS-SRDCN-12-25-10XC	.750	.750	.331	1.625	4.342	.570	.750	G 1/8-28	2175	2.2	0.545	RCMT 10 T3 MP
	1 x 1	1.000	90°	2.625	3	QS-SRDCN-16-25-10XC	1.000	1.000	.331	1.625	4.932	.695	1.000	G 1/8-28	2175	2.2	1.111	RCMT 10 T3 MP
	1 x 1	1.500	90°	3.125	3	QS-SRDCN-16-40-10XC	1.000	1.000	.331	2.125	5.432	.695	1.000	G 1/8-28	2175	2.2	1.175	RCMT 10 T3 MP
.472	3/4 x 3/4	1.000	90°	2.250	3	QS-SRDCN-12-25-12XC	.750	.750	.402	1.500	4.217	.610	.750	G 1/8-28	2175	2.2	0.529	RCMT 12 04 MP
	1 x 1	1.125	90°	2.625	3	QS-SRDCN-16-28-12XC	1.000	1.000	.402	1.625	4.932	.735	1.000	G 1/8-28	2175	2.2	1.102	RCMT 12 04 MP
	1 x 1	1.500	90°	3.125	3	QS-SRDCN-16-40-12XC	1.000	1.000	.402	2.125	5.432	.735	1.000	G 1/8-28	2175	2.2	1.206	RCMT 12 04 MP
.630	1 x 1	1.375	90°	2.750	3	QS-SRDCN-16-35-16XC	1.000	1.000	.535	1.750	5.057	.813	1.000	G 1/8-28	2175	4.7	1.124	RCMT 16 06 MP

R = A Derecha, L = A Izquierda

			Piezas de repuesto						
	IC	CZC_{MS}	Tornillo de plaquita	Placa de apoyo	Tornillo de la placa de apoyo	Boquilla	Tornillo	Tornillo	Tornillo
08	.315	20 x 20-25 x 25	5513 020-04			5691 026-23	5512 104-01	3214 012-01	3214 013-01
10	.394	20 x 20-25 x 25	5513 020-09			5691 026-13	5512 104-01	3214 012-01	3214 013-01
12	.472	20 x 20-25 x 25	5513 020-01	5322 160-01 E7F3	5512 090-01	5691 026-13	5512 104-01	3214 012-01	3214 013-01
16	.630	25 x 25	5513 020-26	5322 160-02 E7F3	5512 090-06	5691 026-03	5512 104-01	3214 012-01	3214 013-01

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

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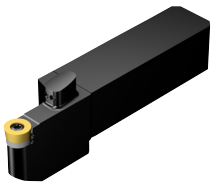
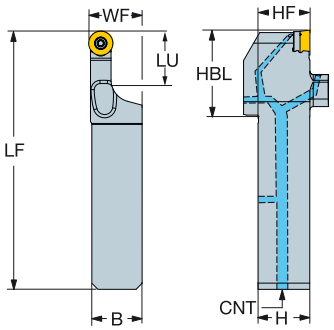
Mango de herramienta CoroTurn® 107 QS para torneado

Diseño de sujeción por tornillo: para plaquitas con asiento estriado

Suministro de refrigerante de precisión



RCMT..MP/MT/MU



Versión métrica

							Dimensiones, mm											
	CZC_{MS}	LU	RMPX	OHX	CNSC	**Código de pedido**	B	H	WB	HBL	LF	WF	HF	CNT	BAR	NM	KG	MIID
08	20 x 20	20.0	90°	59.0	3	**QS-SRDCR/L-202020-08XC**	20.0	20.0	6.8	39.0	108.0	21.0	20.0	G 1/8-28	150	1.4	0.26	RCMT 08 03 MP
	25 x 25	20.0	90°	64.0	3	**QS-SRDCR/L-252520-08XC**	25.0	25.0	6.8	39.0	123.0	26.0	25.0	G 1/8-28	150	1.4	0.47	RCMT 08 03 MP
10	20 x 20	25.0	90°	63.0	3	**QS-SRDCR/L-202025-10XC**	20.0	20.0	8.4	43.0	112.0	21.5	20.0	G 1/8-28	150	3.0	0.28	RCMT 10 T3 MP
	25 x 25	25.0	90°	68.0	3	**QS-SRDCR/L-252525-10XC**	25.0	25.0	8.4	43.0	127.0	26.5	25.0	G 1/8-28	150	3.0	0.49	RCMT 10 T3 MP
12	20 x 20	25.0	90°	60.0	3	**QS-SRDCR/L-202025-12XC**	20.0	20.0	10.2	40.0	109.0	21.5	20.0	G 1/8-28	150	3.0	0.27	RCMT 12 04 MP
	25 x 25	28.0	90°	69.0	3	**QS-SRDCR/L-252528-12XC**	25.0	25.0	10.2	44.0	128.0	26.5	25.0	G 1/8-28	150	3.0	0.50	RCMT 12 04 MP
16	25 x 25	35.0	90°	71.0	3	**QS-SRDCR/L-252535-16XC**	25.0	25.0	13.6	46.0	130.0	26.5	25.0	G 1/8-28	150	6.4	0.50	RCMT 16 06 MP

Versión en pulgadas

							Dimensiones, pulg.											
IC	CZC_{MS}	LU	RMPX	OHX	CNSC	**Código de pedido**	B	H	WB	HBL	LF	WF	HF	CNT	PSI	FT/LBS	LBS	MIID
.315	3/4 x 3/4	.750	90°	2.250	3	**QS-SRDCR/L-12-20-08XC**	.750	.750	.268	1.500	4.217	.781	.750	G 1/8-28	2175	1.0	0.509	RCMT 08 03 MP
	1 x 1	.750	90°	2.500	3	**QS-SRDCR/L-16-20-08XC**	1.000	1.000	.268	1.500	4.807	1.031	1.000	G 1/8-28	2175	1.0	1.067	RCMT 08 03 MP
.394	3/4 x 3/4	1.000	90°	2.500	3	**QS-SRDCR/L-12-25-10XC**	.750	.750	.331	1.750	4.467	.813	.750	G 1/8-28	2175	2.2	0.564	RCMT 10 T3 MP
	1 x 1	1.000	90°	2.750	3	**QS-SRDCR/L-16-25-10XC**	1.000	1.000	.331	1.750	5.057	1.063	1.000	G 1/8-28	2175	2.2	1.140	RCMT 10 T3 MP
.472	3/4 x 3/4	1.000	90°	2.375	3	**QS-SRDCR/L-12-25-12XC**	.750	.750	.402	1.625	4.342	.813	.750	G 1/8-28	2175	2.2	0.551	RCMT 12 04 MP
	1 x 1	1.125	90°	2.750	3	**QS-SRDCR/L-16-28-12XC**	1.000	1.000	.402	1.750	5.057	1.063	1.000	G 1/8-28	2175	2.2	1.133	RCMT 12 04 MP
.630	1 x 1	1.375	90°	2.875	3	**QS-SRDCR/L-16-35-16XC**	1.000	1.000	.535	1.875	5.182	1.063	1.000	G 1/8-28	2175	4.7	1.155	RCMT 16 06 MP

R = A Derecha, L = A Izquierda

			Piezas de repuesto						
	IC	CZC_{MS}	Tornillo de plaquita	Placa de apoyo	Tornillo de la placa de apoyo	Boquilla	Tornillo	Tornillo	Tornillo
08	.315	20 x 20-25 x 25	5513 020-04			5691 026-23	5512 104-01	3214 012-01	3214 013-01
10	.394	20 x 20-25 x 25	5513 020-09			5691 026-13	5512 104-01	3214 012-01	3214 013-01
12	.472	20 x 20-25 x 25	5513 020-01	5322 160-01 E7F3	5512 090-01	5691 026-13	5512 104-01	3214 012-01	3214 013-01
16	.630	25 x 25	5513 020-26	5322 160-02 E7F3	5512 090-06	5691 026-03	5512 104-01	3214 012-01	3214 013-01

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

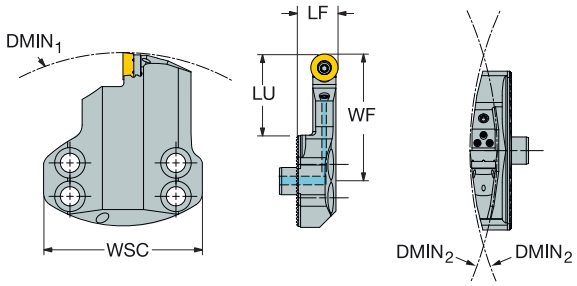
A9 F2 F5

Cabeza CoroTurn® 107 para torneado

Diseño de sujeción por tornillo: para plaquitas con asiento estriado

CoroTurn® SL70: suministro de refrigerante de precisión

RCMT..MP/MT/MU



IC		CZC_{MS}	$DMIN_1$	$DMIN_2$	LU	RMPX	CNSC	Código de pedido	Dimensiones, mm, pulg. WB	LF	WF	WSC	BAR PSI	NM	KG	MIID
10	.394	70	120.0	250.0	35.0	90°	1	**SL70-SRDCR/L-35-10XC**	8.4	17.0	56.0	70.0	70	3.0	0.27	RCMT 10 T3 MP
			4.724	*9.843*	*1.378*				*.331*	*.669*	*2.205*	*2.756*	*1015*			
12	.472	70	120.0	300.0	35.0	90°	1	**SL70-SRDCR/L-35-12XC**	10.2	18.0	56.0	70.0	70	3.0	0.30	RCMT 12 04 MP
			4.724	*11.811*	*1.378*				*.402*	*.709*	*2.205*	*2.756*	*1015*			
		70	120.0	260.0	50.0	90°	1	**SL70-SRDCR/L-50-12XC**	10.2	18.0	71.0	70.0	70	3.0	0.35	RCMT 12 04 MP
			4.724	*10.236*	*1.969*				*.402*	*.709*	*2.795*	*2.756*	*1015*			
		70	120.0	260.0	75.0	90°	1	**SL70-SRDCR/L-75-12XC**	10.2	18.0	96.0	70.0	70	3.0	0.44	RCMT 12 04 MP
			4.724	*10.236*	*2.953*				*.402*	*.709*	*3.780*	*2.756*	*1015*			

R = A Derecha, L = A Izquierda

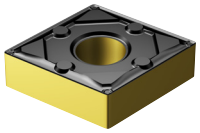
			Piezas de repuesto				
IC		CZC_{MS}	Tornillo de plaquita	Placa de apoyo	Tornillo de la placa de apoyo	Boquilla	Pivote de posicionado
10	.394	70	5513 020-09			5691 026-13	5552 058-04
12	.472	70	5513 020-01	5322 160-01 E7F3	5512 090-01	5691 026-13	5552 058-04

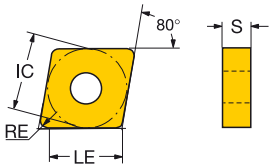
Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

A9 F2 F5

Plaquita T-Max® P para torneado

Plaquita tipo C (Rómbica de 80°)





		IC		LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Acabado	WF	12	1/2	12.5	4.76	0.40	CNMG 12 04 04-WF	★	☆	CNMG 431-WF
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-WF	★	☆	CNMG 432-WF
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-WF	★	☆	CNMG 433-WF
				.460	.188	.047				
	PF	09	3/8	9.3	3.18	0.40	CNMG 09 03 04-PF	★	☆	CNMG 321-PF
				.365	.125	.016				
				8.9	3.18	0.79	CNMG 09 03 08-PF	★	☆	CNMG 322-PF
				.349	.125	.031				
		12	1/2	12.5	4.76	0.40	CNMG 12 04 04-PF	★	☆	CNMG 431-PF
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-PF	★	☆	CNMG 432-PF
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-PF	★	☆	CNMG 433-PF
				.460	.188	.047				
	LC	12	1/2	12.5	4.76	0.40	CNMG 12 04 04-LC	★	☆	CNMG 431-LC
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-LC	★	☆	CNMG 432-LC
				.476	.188	.031				
	WL	12	1/2	12.5	4.76	0.40	CNMG 12 04 04-WL	★	☆	CNMG 431-WL
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-WL	★	☆	CNMG 432-WL
				.476	.188	.031				
	XF	12	1/2	12.5	4.76	0.40	CNMG 12 04 04-XF	★	☆	CNMG 431-XF
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-XF	★	☆	CNMG 432-XF
				.476	.188	.031				
Medio	WM	12	1/2	12.1	4.76	0.79	CNMG 12 04 08-WM	☆	★	CNMG 432-WM
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-WM	☆	★	CNMG 433-WM
				.460	.188	.047				
		16	5/8	14.9	6.35	1.19	CNMG 16 06 12-WM	☆	★	CNMG 543-WM
				.587	.250	.047				
	WMX	12	1/2	12.1	4.76	0.79	CNMG 12 04 08-WMX	☆	★	CNMG 432-WMX
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-WMX	☆	★	CNMG 433-WMX
				.460	.188	.047				
		16	5/8	15.3	6.35	0.79	CNMG 16 06 08-WMX	☆	★	CNMG 542-WMX
				.603	.250	.031				
				14.9	6.35	1.19	CNMG 16 06 12-WMX	☆	★	CNMG 543-WMX
				.587	.250	.047				

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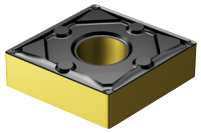
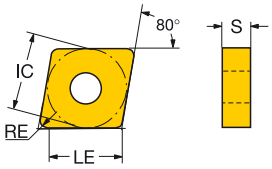
Plaquita T-Max® P para torneado

Plaquita tipo C (Rómbica de 80°)





		IC	LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Medium	PM	09	3/8	9.3	3.18	0.40	CNMG 09 03 04-PM	☆	★	CNMG 321-PM
				.365	.125	.016				
				8.9	3.18	0.79	CNMG 09 03 08-PM	☆	★	CNMG 322-PM
				.349	.125	.031				
		12	1/2	12.5	4.76	0.40	CNMG 12 04 04-PM	☆	★	CNMG 431-PM
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-PM	☆	★	CNMG 432-PM
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-PM	☆	★	CNMG 433-PM
				.460	.188	.047				
				11.3	4.76	1.59	CNMG 12 04 16-PM	☆	★	CNMG 434-PM
				.445	.188	.063				
		16	5/8	15.3	6.35	0.79	CNMG 16 06 08-PM	☆	★	CNMG 542-PM
				.603	.250	.031				
				14.9	6.35	1.19	CNMG 16 06 12-PM	☆	★	CNMG 543-PM
				.587	.250	.047				
				14.5	6.35	1.59	CNMG 16 06 16-PM	☆	★	CNMG 544-PM
				.572	.250	.063				
		19	3/4	18.5	6.35	0.79	CNMG 19 06 08-PM	☆	★	CNMG 642-PM
				.730	.250	.031				
				18.1	6.35	1.19	CNMG 19 06 12-PM	☆	★	CNMG 643-PM
				.714	.250	.047				
				17.7	6.35	1.59	CNMG 19 06 16-PM	☆	★	CNMG 644-PM
				.699	.250	.063				
	QM	09	3/8	9.3	3.18	0.40	CNMG 09 03 04-QM	☆	★	CNMG 321-QM
				.365	.125	.016				
				8.9	3.18	0.79	CNMG 09 03 08-QM	☆	★	CNMG 322-QM
				.349	.125	.031				
		12	1/2	12.5	4.76	0.40	CNMG 12 04 04-QM	☆	★	CNMG 431-QM
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-QM	☆	★	CNMG 432-QM
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-QM	☆	★	CNMG 433-QM
				.460	.188	.047				
				11.3	4.76	1.59	CNMG 12 04 16-QM	☆	★	CNMG 434-QM
				.445	.188	.063				
		16	5/8	15.7	6.35	0.40	CNMG 16 06 04-QM	☆	★	CNMG 541-QM
				.619	.250	.016				
				15.3	6.35	0.79	CNMG 16 06 08-QM	☆	★	CNMG 542-QM
				.603	.250	.031				
				14.9	6.35	1.19	CNMG 16 06 12-QM	☆	★	CNMG 543-QM
				.587	.250	.047				
				14.5	6.35	1.59	CNMG 16 06 16-QM	☆	★	CNMG 544-QM
				.572	.250	.063				
		19	3/4	18.5	6.35	0.79	CNMG 19 06 08-QM	☆	★	CNMG 642-QM
				.730	.250	.031				
				18.1	6.35	1.19	CNMG 19 06 12-QM	☆	★	CNMG 643-QM
				.714	.250	.047				
				17.7	6.35	1.59	CNMG 19 06 16-QM	☆	★	CNMG 644-QM
				.699	.250	.063				
	XM	12	1/2	12.5	4.76	0.40	CNMG 12 04 04-XM		★	CNMG 431-XM
				.492	.188	.016				
				12.1	4.76	0.79	CNMG 12 04 08-XM	☆	★	CNMG 432-XM
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-XM	☆	★	CNMG 433-XM
				.460	.188	.047				

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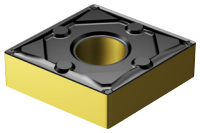
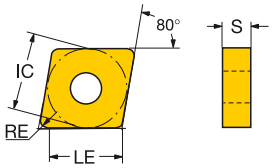
Plaquita T-Max® P para torneado

Plaquita tipo C (Rómbica de 80°)





								P		
			IC	LE	S	RE	CÓDIGO ISO	4415	4425	CÓDIGO ANSI
Desbaste	PR	12	1/2	12.1	4.76	0.79	CNMG 12 04 08-PR	☆	★	CNMG 432-PR
				.476	.188	.031				
				11.7	4.76	1.19	CNMG 12 04 12-PR	☆	★	CNMG 433-PR
				.460	.188	.047				
				11.3	4.76	1.59	CNMG 12 04 16-PR	☆	★	CNMG 434-PR
				.445	.188	.063				
		16	5/8	14.9	6.35	1.19	CNMG 16 06 12-PR	☆	★	CNMG 543-PR
				.587	.250	.047				
				14.5	6.35	1.59	CNMG 16 06 16-PR	☆	★	CNMG 544-PR
				.572	.250	.063				
				13.7	6.35	2.38	CNMG 16 06 24-PR	☆	★	CNMG 546-PR
				.540	.250	.094				
		19	3/4	18.5	6.35	0.79	CNMG 19 06 08-PR	☆	★	CNMG 642-PR
				.730	.250	.031				
				18.1	6.35	1.19	CNMG 19 06 12-PR	☆	★	CNMG 643-PR
				.714	.250	.047				
				17.7	6.35	1.59	CNMG 19 06 16-PR	☆	★	CNMG 644-PR
				.699	.250	.063				
				16.9	6.35	2.38	CNMG 19 06 24-PR	☆	★	CNMG 646-PR
				.667	.250	.094				
		12	1/2	12.1	4.76	0.79	CNMM 12 04 08-PR	☆	★	CNMM 432-PR
				.476	.188	.031				
				11.7	4.76	1.19	CNMM 12 04 12-PR	☆	★	CNMM 433-PR
				.460	.188	.047				
				11.3	4.76	1.59	CNMM 12 04 16-PR	☆	★	CNMM 434-PR
				.445	.188	.063				
		16	5/8	15.3	6.35	0.79	CNMM 16 06 08-PR	☆	★	CNMM 542-PR
				.603	.250	.031				
				14.9	6.35	1.19	CNMM 16 06 12-PR	☆	★	CNMM 543-PR
				.587	.250	.047				
				14.5	6.35	1.59	CNMM 16 06 16-PR	☆	★	CNMM 544-PR
				.572	.250	.063				
		19	3/4	18.1	6.35	1.19	CNMM 19 06 12-PR	☆	★	CNMM 643-PR
				.714	.250	.047				
				17.7	6.35	1.59	CNMM 19 06 16-PR	☆	★	CNMM 644-PR
				.699	.250	.063				
				16.9	6.35	2.38	CNMM 19 06 24-PR	☆	★	CNMM 646-PR
				.667	.250	.094				
	QR	12	1/2	12.1	4.76	0.79	CNMM 12 04 08-QR	☆	★	CNMM 432-QR
				.476	.188	.031				
				11.7	4.76	1.19	CNMM 12 04 12-QR	☆	★	CNMM 433-QR
				.460	.188	.047				
				11.3	4.76	1.59	CNMM 12 04 16-QR	☆	★	CNMM 434-QR
				.445	.188	.063				
		16	5/8	14.9	6.35	1.19	CNMM 16 06 12-QR	☆	★	CNMM 543-QR
				.587	.250	.047				
				14.5	6.35	1.59	CNMM 16 06 16-QR	☆	★	CNMM 544-QR
				.572	.250	.063				
				13.7	6.35	2.38	CNMM 16 06 24-QR	☆	★	CNMM 546-QR
				.540	.250	.094				
		19	3/4	18.1	6.35	1.19	CNMM 19 06 12-QR	☆	★	CNMM 643-QR
				.714	.250	.047				
				17.7	6.35	1.59	CNMM 19 06 16-QR	☆	★	CNMM 644-QR
				.699	.250	.063				
				16.9	6.35	2.38	CNMM 19 06 24-QR	☆	★	CNMM 646-QR
				.667	.250	.094				

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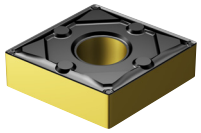
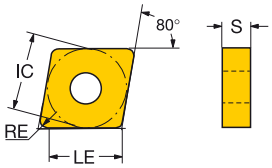
Plaquita T-Max® P para torneado

Plaquita tipo C (Rómbica de 80°)





								P		
			IC	LE	S	RE	CÓDIGO ISO	4415	4425	CÓDIGO ANSI
Roughing	XMR	12	1/2	12.1	4.76	0.79	CNMG 12 04 08-XMR	☆	★	CNMG 432-XMR
				.476	*.188*	*.031*				
				11.7	4.76	1.19	CNMG 12 04 12-XMR	☆	★	CNMG 433-XMR
				.460	*.188*	*.047*				
				11.3	4.76	1.59	CNMG 12 04 16-XMR	★		CNMG 434-XMR
				.445	*.188*	*.063*				

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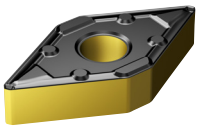
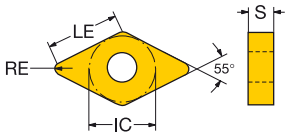
Plaquita T-Max® P para torneado

Plaquita tipo D (Rómbica de 55°)





								P		
			IC	LE	S	RE	CÓDIGO ISO	4415	4425	CÓDIGO ANSI
Acabado	WF	11	3/8	11.2	4.76	0.40	DNMX 11 04 04-WF	★	☆	DNMX 331-WF
				.442	.188	.016				
				10.8	4.76	0.79	DNMX 11 04 08-WF	★	☆	DNMX 332-WF
				.426	.188	.031				
		15	1/2	15.1	4.76	0.40	DNMX 15 04 04-WF	★	☆	DNMX 431-WF
				.595	.188	.016				
				14.7	4.76	0.79	DNMX 15 04 08-WF	★	☆	DNMX 432-WF
				.579	.188	.031				
				15.1	6.35	0.40	DNMX 15 06 04-WF	★	☆	DNMX 441-WF
				.595	.250	.016				
				14.7	6.35	0.79	DNMX 15 06 08-WF	★	☆	DNMX 442-WF
				.579	.250	.031				
				14.3	6.35	1.19	DNMX 15 06 12-WF	★	☆	DNMX 443-WF
				.563	.250	.047				
	PF	11	3/8	11.2	4.76	0.40	DNMG 11 04 04-PF	★	☆	DNMG 331-PF
				.442	.188	.016				
				10.8	4.76	0.79	DNMG 11 04 08-PF	★	☆	DNMG 332-PF
				.426	.188	.031				
				10.4	4.76	1.19	DNMG 11 04 12-PF	★	☆	DNMG 333-PF
				.411	.188	.047				
		15	1/2	15.1	4.76	0.40	DNMG 15 04 04-PF	★	☆	DNMG 431-PF
				.595	.188	.016				
				14.7	4.76	0.79	DNMG 15 04 08-PF	★	☆	DNMG 432-PF
				.579	.188	.031				
				14.3	4.76	1.19	DNMG 15 04 12-PF	★	☆	DNMG 433-PF
				.563	.188	.047				
				15.1	6.35	0.40	DNMG 15 06 04-PF	★	☆	DNMG 441-PF
				.595	.250	.016				
				14.7	6.35	0.79	DNMG 15 06 08-PF	★	☆	DNMG 442-PF
				.579	.250	.031				
				14.3	6.35	1.19	DNMG 15 06 12-PF	★	☆	DNMG 443-PF
				.563	.250	.047				
	LC	11	3/8	10.8	4.76	0.79	DNMG 11 04 08-LC	★	☆	DNMG 332-LC
				.426	.188	.031				
		15	1/2	15.1	4.76	0.40	DNMG 15 04 04-LC	★	☆	DNMG 431-LC
				.595	.188	.016				
				14.7	4.76	0.79	DNMG 15 04 08-LC	★	☆	DNMG 432-LC
				.579	.188	.031				
				14.7	6.35	0.79	DNMG 15 06 08-LC	★	☆	DNMG 442-LC
				.579	.250	.031				
	K	15	1/2	15.1	6.35	0.40	DNMG 15 06 04R/L-K	★	☆	DNMG 441L-K
				.595	.250	.016				
				14.7	6.35	0.79	DNMG 15 06 08R/L-K	★	☆	DNMG 442L-K
				.579	.250	.031				
	XF	15	1/2	14.7	6.35	0.79	DNMG 15 06 08-XF	★		DNMG 442-XF
				.579	.250	.031				

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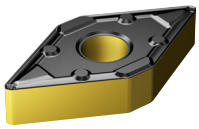
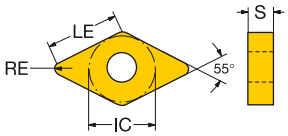
Plaquita T-Max® P para torneado

Plaquita tipo D (Rómbica de 55°)





				LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Medio	WM	11	3/8	10.8	4.76	0.79	DNMX 11 04 08-WM	☆	★	DNMX 332-WM
				.426	.188	.031				
				10.4	4.76	1.19	DNMX 11 04 12-WM	☆	★	DNMX 333-WM
				.411	.188	.047				
		15	1/2	14.7	4.76	0.79	DNMX 15 04 08-WM	☆	★	DNMX 432-WM
				.579	.188	.031				
				14.7	6.35	0.79	DNMX 15 06 08-WM	☆	★	DNMX 442-WM
				.579	.250	.031				
				14.3	6.35	1.19	DNMX 15 06 12-WM	☆	★	DNMX 443-WM
				.563	.250	.047				
				13.9	6.35	1.59	DNMX 15 06 16-WM	☆	★	DNMX 444-WM
				.547	.250	.063				
	WMX	15	1/2	14.7	4.76	0.79	DNMX 15 04 08-WMX	☆	★	DNMX 432-WMX
				.579	.188	.031				
				14.3	4.76	1.19	DNMX 15 04 12-WMX	☆	★	DNMX 433-WMX
				.563	.188	.047				
				14.7	6.35	0.79	DNMX 15 06 08-WMX	☆	★	DNMX 442-WMX
				.579	.250	.031				
				14.3	6.35	1.19	DNMX 15 06 12-WMX	☆	★	DNMX 443-WMX
				.563	.250	.047				
				13.9	6.35	1.59	DNMX 15 06 16-WMX	☆	★	DNMX 444-WMX
				.547	.250	.063				
	PM	11	3/8	11.2	4.76	0.40	DNMG 11 04 04-PM	☆	★	DNMG 331-PM
				.442	.188	.016				
				10.8	4.76	0.79	DNMG 11 04 08-PM	☆	★	DNMG 332-PM
				.426	.188	.031				
				10.4	4.76	1.19	DNMG 11 04 12-PM	☆	★	DNMG 333-PM
				.411	.188	.047				
		15	1/2	15.1	4.76	0.40	DNMG 15 04 04-PM	☆	★	DNMG 431-PM
				.595	.188	.016				
				14.7	4.76	0.79	DNMG 15 04 08-PM	☆	★	DNMG 432-PM
				.579	.188	.031				
				14.3	4.76	1.19	DNMG 15 04 12-PM	☆	★	DNMG 433-PM
				.563	.188	.047				
				15.1	6.35	0.40	DNMG 15 06 04-PM	☆	★	DNMG 441-PM
				.595	.250	.016				
				14.7	6.35	0.79	DNMG 15 06 08-PM	☆	★	DNMG 442-PM
				.579	.250	.031				
				14.3	6.35	1.19	DNMG 15 06 12-PM	☆	★	DNMG 443-PM
				.563	.250	.047				
				13.9	6.35	1.59	DNMG 15 06 16-PM	☆	★	DNMG 444-PM
				.547	.250	.063				
	QM	11	3/8	10.4	4.76	1.19	DNMG 11 04 12-QM	☆	★	DNMG 333-QM
				.411	.188	.047				
		15	1/2	14.7	4.76	0.79	DNMG 15 04 08-QM	☆	★	DNMG 432-QM
				.579	.188	.031				
				14.3	4.76	1.19	DNMG 15 04 12-QM	☆	★	DNMG 433-QM
				.563	.188	.047				
				15.1	6.35	0.40	DNMG 15 06 04-QM	☆	★	DNMG 441-QM
				.595	.250	.016				
				14.7	6.35	0.79	DNMG 15 06 08-QM	☆	★	DNMG 442-QM
				.579	.250	.031				
				14.3	6.35	1.19	DNMG 15 06 12-QM	☆	★	DNMG 443-QM
				.563	.250	.047				
				13.9	6.35	1.59	DNMG 15 06 16-QM	☆	★	DNMG 444-QM
				.547	.250	.063				
	XM	15	1/2	14.7	6.35	0.79	DNMG 15 06 08-XM	☆	★	DNMG 442-XM
				.579	.250	.031				
				14.3	6.35	1.19	DNMG 15 06 12-XM	☆	★	DNMG 443-XM
				.563	.250	.047				

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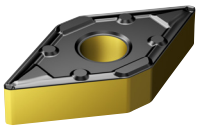
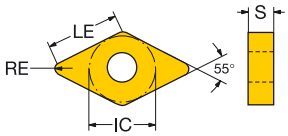
SPA

Plaquita T-Max® P para torneado

Plaquita tipo D (Rómbica de 55°)





								P		
			IC	LE	S	RE	CÓDIGO ISO	4415	4425	CÓDIGO ANSI
Desbaste	XMR	15	1/2	14.3	6.35	1.19	DNMG 15 06 12-XMR	☆	★	DNMG 443-XMR
				.563	.250	.047				
	PR	15	1/2	14.7	4.76	0.79	DNMG 15 04 08-PR	☆	★	DNMG 432-PR
				.579	.188	.031				
				14.3	4.76	1.19	DNMG 15 04 12-PR	☆	★	DNMG 433-PR
				.563	.188	.047				
				13.9	4.76	1.59	DNMG 15 04 16-PR	☆	★	DNMG 434-PR
				.547	.188	.063				
				14.7	6.35	0.79	DNMG 15 06 08-PR	☆	★	DNMG 442-PR
				.579	.250	.031				
				14.3	6.35	1.19	DNMG 15 06 12-PR	☆	★	DNMG 443-PR
				.563	.250	.047				
				13.9	6.35	1.59	DNMG 15 06 16-PR	☆	★	DNMG 444-PR
				.547	.250	.063				
		19	5/8	18.6	6.35	0.79	DNMG 19 06 08-PR	☆	★	DNMG 542-PR
				.731	.250	.031				
		15	1/2	14.7	6.35	0.79	DNMM 15 06 08-PR	☆	★	DNMM 442-PR
				.579	.250	.031				
				14.3	6.35	1.19	DNMM 15 06 12-PR	☆	★	DNMM 443-PR
				.563	.250	.047				
				13.9	6.35	1.59	DNMM 15 06 16-PR	☆	★	DNMM 444-PR
				.547	.250	.063				
	QR	15	1/2	14.7	6.35	0.79	DNMM 15 06 08-QR	☆	★	DNMM 442-QR
				.579	.250	.031				
				14.3	6.35	1.19	DNMM 15 06 12-QR	☆	★	DNMM 443-QR
				.563	.250	.047				

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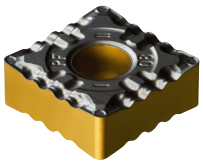
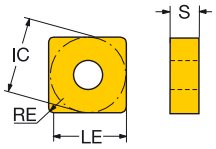
Plaquita T-Max® P para torneado

Plaquita tipo S (Cuadrada)





		IC	LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Acabado	PF	12 1/2	11.9	4.76	0.79	SNMG 12 04 08-PF	★	☆	SNMG 432-PF
			.469	.188	.031				
			11.5	4.76	1.19	SNMG 12 04 12-PF	★	☆	SNMG 433-PF
			.453	.188	.047				
Medio	PM	09 3/8	9.1	3.18	0.40	SNMG 09 03 04-PM	☆	★	SNMG 321-PM
			.359	.125	.016				
			8.7	3.18	0.79	SNMG 09 03 08-PM	☆	★	SNMG 322-PM
			.344	.125	.031				
		12 1/2	12.3	4.76	0.40	SNMG 12 04 04-PM	☆	★	SNMG 431-PM
			.484	.188	.016				
			11.9	4.76	0.79	SNMG 12 04 08-PM	☆	★	SNMG 432-PM
			.469	.188	.031				
			11.5	4.76	1.19	SNMG 12 04 12-PM	☆	★	SNMG 433-PM
			.453	.188	.047				
			11.1	4.76	1.59	SNMG 12 04 16-PM	☆	★	SNMG 434-PM
			.437	.188	.063				
		15 5/8	14.7	6.35	1.19	SNMG 15 06 12-PM	☆	★	SNMG 543-PM
			.578	.250	.047				
			14.3	6.35	1.59	SNMG 15 06 16-PM		★	SNMG 544-PM
			.562	.250	.063				
	QM	09 3/8	8.7	3.18	0.79	SNMG 09 03 08-QM	☆	★	SNMG 322-QM
			.344	.125	.031				
		12 1/2	11.9	4.76	0.79	SNMG 12 04 08-QM	☆	★	SNMG 432-QM
			.469	.188	.031				
			11.5	4.76	1.19	SNMG 12 04 12-QM	☆	★	SNMG 433-QM
			.453	.188	.047				
Desbaste	PR	12 1/2	11.9	4.76	0.79	SNMG 12 04 08-PR	☆	★	SNMG 432-PR
			.469	.188	.031				
			11.5	4.76	1.19	SNMG 12 04 12-PR	☆	★	SNMG 433-PR
			.453	.188	.047				
			11.1	4.76	1.59	SNMG 12 04 16-PR	☆	★	SNMG 434-PR
			.437	.188	.063				
		15 5/8	15.1	6.35	0.79	SNMG 15 06 08-PR	☆	★	SNMG 542-PR
			.594	.250	.031				
			14.7	6.35	1.19	SNMG 15 06 12-PR	☆	★	SNMG 543-PR
			.578	.250	.047				
			14.3	6.35	1.59	SNMG 15 06 16-PR	☆	★	SNMG 544-PR
			.562	.250	.063				
			13.5	6.35	2.38	SNMG 15 06 24-PR	☆	★	SNMG 546-PR
			.531	.250	.094				
		12 1/2	11.9	4.76	0.79	SNMM 12 04 08-PR	☆	★	SNMM 432-PR
			.469	.188	.031				
			11.5	4.76	1.19	SNMM 12 04 12-PR	☆	★	SNMM 433-PR
			.453	.188	.047				
		15 5/8	14.7	6.35	1.19	SNMM 15 06 12-PR	☆	★	SNMM 543-PR
			.578	.250	.047				
			14.3	6.35	1.59	SNMM 15 06 16-PR	☆	★	SNMM 544-PR
			.562	.250	.063				
		19 3/4	17.9	6.35	1.19	SNMM 19 06 12-PR	☆	★	SNMM 643-PR
			.703	.250	.047				
			17.5	6.35	1.59	SNMM 19 06 16-PR	☆	★	SNMM 644-PR
			.687	.250	.063				
			16.7	6.35	2.38	SNMM 19 06 24-PR	☆	★	SNMM 646-PR
			.656	.250	.094				
	QR	19 3/4	17.9	6.35	1.19	SNMM 19 06 12-QR	☆	★	SNMM 643-QR
			.703	.250	.047				
			17.5	6.35	1.59	SNMM 19 06 16-QR	☆	★	SNMM 644-QR
			.687	.250	.063				

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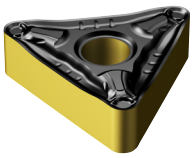
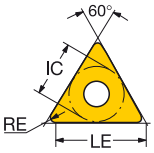
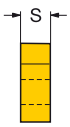
Plaquita T-Max® P para torneado

Plaquita tipo T (Triangular)







		IC		LE	S	RE	CÓDIGO ISO	P 4415	P 4425	CÓDIGO ANSI
Medio	PM	16	3/8	16.1	4.76	0.40	TNMG 16 04 04-PM	☆	★	TNMG 331-PM
				.634	*.188*	*.016*				
				15.7	4.76	0.79	TNMG 16 04 08-PM	☆	★	TNMG 332-PM
				.618	*.188*	*.031*				
				15.3	4.76	1.19	TNMG 16 04 12-PM	☆	★	TNMG 333-PM
				.602	*.188*	*.047*				
Desbaste	PR	16	3/8	15.7	4.76	0.79	TNMG 16 04 08-PR	☆	★	TNMG 332-PR
				.618	*.188*	*.031*				
				15.3	4.76	1.19	TNMG 16 04 12-PR	☆	★	TNMG 333-PR
				.602	*.188*	*.047*				

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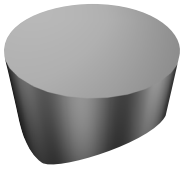
Plaquita T-Max® para torneado

Plaquita tipo R (Redonda)

TSYC



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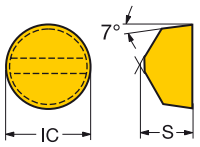
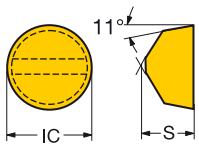


RPGX..E

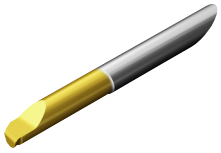


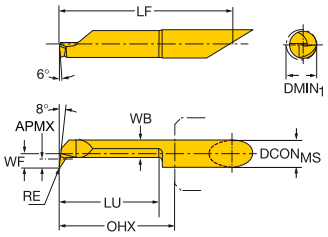
Versión métrica

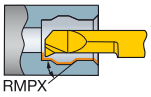
			S	RE	CÓDIGO ISO	S 7014
Medio	E	06	6.35	3.18	RCGX060600E	★
			4.76	3.18	RPGX060400E	★
		09	7.94	4.76	RCGX090700E	★
			7.94	4.76	RPGX090700E	★

A26 F2

Herramienta de metal duro CoroTurn® XS para torneado





	CZC$_{MS}$	DMIN$_1$	LU	OHX	RE	APMX	Código de pedido	P 1125	M 1125	N 1125	S 1125	Dimensiones, mm DCON$_{MS}$	WB	LF	WF	RMPX
	4	2.7	10.0	13.0	0.05	0.2	CXS-04T098-05-2710R	☆	★	☆	★	4	2.1	27.3	1.2	17°
	4	2.7	10.0	13.0	0.15	0.2	CXS-04T098-15-2710R	☆	★	☆	★	4	2.1	27.3	1.2	17°
	4	2.7	15.0	18.0	0.15	0.2	CXS-04T098-15-2715R	☆	★	☆	★	4	2.1	32.3	1.2	17°
	4	3.2	15.0	18.0	0.05	0.2	CXS-04T098-05-3215R	☆	★	☆	★	4	2.6	32.3	1.5	17°
	4	3.2	10.0	13.0	0.15	0.2	CXS-04T098-15-3210R	☆	★	☆	★	4	2.6	27.3	1.5	17°
	4	3.2	15.0	18.0	0.15	0.2	CXS-04T098-15-3215R	☆	★	☆	★	4	2.6	32.3	1.5	17°
	4	3.2	20.0	23.0	0.15	0.2	CXS-04T098-15-3220R	☆	★	☆	★	4	2.6	37.3	1.5	17°
	4	4.2	15.0	18.0	0.05	0.3	CXS-04T098-05-4215R	☆	★	☆	★	4	3.5	32.3	2.0	17°
	4	4.2	10.0	13.0	0.15	0.3	CXS-04T098-15-4210R	☆	★	☆	★	4	3.5	27.3	2.0	17°
	4	4.2	15.0	18.0	0.15	0.3	CXS-04T098-15-4215R	☆	★	☆	★	4	3.5	32.3	2.0	17°
	4	4.2	20.0	23.0	0.15	0.3	CXS-04T098-15-4220R	☆	★	☆	★	4	3.5	37.3	2.0	17°
	4	4.2	25.0	28.0	0.15	0.3	CXS-04T098-15-4225R	☆	★	☆	★	4	3.5	42.3	2.0	17°
	5	5.2	20.0	23.0	0.05	0.5	CXS-05T098-05-5220R	☆	★	☆	★	5	4.3	42.3	2.5	17°
	5	5.2	10.0	13.0	0.20	0.5	CXS-05T098-20-5210R	☆	★	☆	★	5	4.3	32.3	2.5	17°
	5	5.2	20.0	23.0	0.20	0.5	CXS-05T098-20-5220R	☆	★	☆	★	5	4.3	42.3	2.5	17°
	5	5.2	25.0	28.0	0.20	0.5	CXS-05T098-20-5225R	☆	★	☆	★	5	4.3	47.3	2.5	17°
	5	5.2	30.0	33.0	0.20	0.5	CXS-05T098-20-5230R	☆	★	☆	★	5	4.3	52.3	2.5	17°
	6	6.2	15.0	18.0	0.20	0.5	CXS-06T098-20-6215R	☆	★	☆	★	6	5.3	37.3	3.0	17°
	6	6.2	20.0	23.0	0.20	0.5	CXS-06T098-20-6220R	☆	★	☆	★	6	5.3	42.3	3.0	17°
	6	6.2	25.0	28.0	0.20	0.5	CXS-06T098-20-6225R	☆	★	☆	★	6	5.3	47.3	3.0	17°
	6	6.2	30.0	33.0	0.20	0.5	CXS-06T098-20-6230R	☆	★	☆	★	6	5.3	52.3	3.0	17°
	6	6.2	40.0	43.0	0.20	0.5	CXS-06T098-20-6240R	☆	★	☆	★	6	5.3	62.3	3.0	17°
	7	7.2	25.0	28.0	0.20	0.5	CXS-07T098-20-7225R	☆	★	☆	★	7	6.3	47.3	3.5	17°
	7	7.2	30.0	33.0	0.20	0.5	CXS-07T098-20-7230R	☆	★	☆	★	7	6.3	52.3	3.5	17°
	7	7.2	50.0	53.0	0.20	0.5	CXS-07T098-20-7250R	☆	★	☆	★	7	6.3	72.3	3.5	17°

RMPX

CZC$_{MS}$ debe corresponderse con CZC$_{WS}$ en el adaptador.

R = A Derecha, L = A Izquierda

F2

Recomendaciones de velocidad de corte, valores métricos

Las recomendaciones son válidas si se utiliza refrigerante.

ISO P		Acero	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE	
					GC4415	GC4425
					h_{ex}, mm ≈ avance f_n, mm/r	
	N.º				0.1-0.4-0.8	0.1-0.4-0.8
Núm. MC	CMC	Material	N/mm²	HB	Velocidad de corte (V_c), m/min	
		Acero no aleado				
P1.1.Z.AN	01.1	C = 0.1–0.25%	1500	125	560-400-290	500-340-240
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	190	565-345-230	550-300-185
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	190	455-325-240	395-265-190
		Acero de baja aleación				
		(elementos de aleación ≤5%)				
P2.1.Z.AN	02.1	No templado	1700	175	440-315-240	430-305-230
P2.5.Z.HT	02.2	Endurecido y templado	1850	330	310-200-145	275-180-135
		Acero de alta aleación				
		(elementos de aleación >5%)				
P3.0.Z.AN	03.11	Recocido	1950	200	410-270-200	300-205-150
P3.0.Z.HT	03.21	Acero de herram. templado	3000	380	170-110-80	115-80-65
		Acero fundido				
P1.5.C.UT	06.1	No aleado	1550	150	410-295-230	365-270-195
P2.6.C.UT	06.2	De baja aleación (elementos de aleación ≤5%)	1600	200	265-185-145	250-170-120
P3.0.C.UT	06.3	Alta aleación (elementos de aleación >5%)	2050	200	235-160-120	215-145-105

ISO M		Acero inoxidable	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE	
					GC1105	GC2220
					h_{ex}, mm ≈ avance f_n, mm/r	
	N.º				0.1-0.3-0.5	0.2-0.4-0.6
Núm. MC	CMC	Material	N/mm²	HB	Velocidad de corte (V_c), m/min	
		Austenítico				
		Barras/forjadas				
M1.0.Z.AQ	05.21	Austenítico	1800	200	215-140-105	225-165-125
M1.0.Z.PH	05.22	Templado PH	2850	300	245-160-110	100-70-55
M2.0.Z.AQ	05.23	Super austenítico	2250	200	250-165-115	130-100-75
		Austenítico-ferrítico (Dúplex)				
		Barras/forjadas				
M3.1.Z.AQ	05.51	No soldable ≥ 0,05% C	2000	230	315-205-145	190-150-110
M3.2.Z.AQ	05.52	Soldable < 0,05% C	2450	260	280-185-130	150-120-90
		Austenítico				
		Fundición				
M1.0.C.UT	15.21	Austenítico	1700	200	-	200-155-115
M2.0.C.AQ	15.23	Super austenítico	2150	200	-	130-90-65
		Austenítico-ferrítico (Dúplex)				
		Fundición				
M3.1.C.AQ	15.51	No soldable ≥ 0,05% C	1800	230	-	150-120-90
M3.2.C.AQ	15.52	Soldable < 0,05% C	2250	260	-	125-105-80

ISO S		Material termo-resistente	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE	
					GC1105	CB7014
					h_{ex}, mm ≈ avance f_n, mm/r	
	N.º				0.1-0.3-0.5	0.05-0.15-0.25
Núm. MC	CMC	Material	N/mm²	HB	Velocidad de corte (V_c), m/min	
		Superaleaciones termorresistentes				
		Base de hierro				
S1.0.U.AN	20.11	Recocidas o tratadas en solución	2400	200	150-100-70	-
S1.0.U.AG	20.12	Envejecidas o tratadas en solución y envejecidas	2500	280	120-80-60	-
		Base de níquel				
S2.0.Z.AN	20.21	Recocidas o tratadas en solución	2650	250	90-55-30	320-280-250
S2.0.Z.AG	20.22	Envejecidas o tratadas en solución y envejecidas	2900	350	80-50-27	280-245-220
S2.0.C.NS	20.24	Fundición, o fundición y envejecido	3000	320	70-45-24	200-155-130
		Base de cobalto				
S3.0.Z.AN	20.31	Recocidas o tratadas en solución	2700	200	90-60-30	250-190-160
S3.0.Z.AG	20.32	Tratadas en solución y envejecidas	3000	300	80-50-27	250-190-160
S3.0.C.NS	20.33	Fundición, o fundición y envejecido	3100	320	70-45-24	200-155-130

SPA

Recomendaciones de velocidad de corte, valores en pulgadas

Las recomendaciones son válidas si se utiliza refrigerante.

ISO P		Acero	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE	
					GC4415	GC4425
					h_{ex}, pulg. ≈ avance, f_n pulg./rev.	
	N.º				.004-.016-.031	.004-.016-.031
Núm. MC	CMC	Material	lbs/pulg.²	HB	Velocidad de corte (v_c), pies/min	
		Acero no aleado				
P1.1.Z.AN	01.1	C = 0.1–0.25%	216,500	125	1840-1310-950	1640-1115-790
P1.2.Z.AN	01.2	C = 0.25–0.55%	233,000	190	1855-1130-755	1805-985-610
P1.3.Z.AN	01.3	C = 0.55–0.80%	247,000	190	1495-1065-780	1295-870-625
		Acero de baja aleación				
		(elementos de aleación ≤5%)				
P2.1.Z.AN	02.1	No templado	249,500	175	1445-1035-790	1410-1000-755
P2.5.Z.HT	02.2	Endurecido y templado	268,000	330	1020-655-475	900-590-445
		Acero de alta aleación				
		(elementos de aleación >5%)				
P3.0.Z.AN	03.11	Recocido	282,000	200	1345-885-655	985-675-490
P3.0.Z.HT	03.21	Acero de herram. templado	435,500	380	560-360-260	380-260-215
		Acero fundido				
P1.5.C.UT	06.1	No aleado	225,000	150	1345-970-755	1200-885-640
P2.6.C.UT	06.2	De baja aleación (elementos de aleación ≤5%)	230,500	200	870-610-475	820-560-395
P3.0.C.UT	06.3	Alta aleación (elementos de aleación >5%)	300,500	200	770-525-395	705-475-345

ISO M		Acero inoxidable	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE	
					GC1105	GC2220
					h_{ex}, pulg. ≈ avance, f_n pulg./rev.	
	N.º				.004-.012-.020	.008-.016-.024
Núm. MC	CMC	Material	lbs/pulg.²	HB	Velocidad de corte (v_c), pies/min	
		Austenítico				
		Barras/forjadas				
M1.0.Z.AQ	05.21	Austenítico	259,000	200	705-460-345	740-540-400
M1.0.Z.PH	05.22	Templado PH	414,000	300	805-525-360	330-235-175
M2.0.Z.AQ	05.23	Super austenítico	328,000	200	820-540-380	425-325-245
		Austenítico-ferrítico (Dúplex)				
		Barras/forjadas				
M3.1.Z.AQ	05.51	No soldable ≥ 0,05% C	286,500	230	1035-675-475	620-485-355
M3.2.Z.AQ	05.52	Soldable < 0,05% C	356,500	260	920-610-430	490-390-290
		Austenítico				
		Fundición				
M1.0.C.UT	15.21	Austenítico	248,000	200	-	660-500-370
M2.0.C.AQ	15.23	Super austenítico	310,500	200	-	425-290-210
		Austenítico-ferrítico (Dúplex)				
		Fundición				
M3.1.C.AQ	15.51	No soldable ≥ 0,05% C	258,000	230	-	490-390-290
M3.2.C.AQ	15.52	Soldable < 0,05% C	326,000	260	-	410-340-260

ISO S		Material termo-resistente	Fuerza de corte específica k_{c1}	Dureza Brinell	<<<< RESISTENCIA AL DESGASTE	
					GC1105	CB7014
					h_{ex}, pulg. ≈ avance, f_n pulg./rev.	
	N.º				.004-.012-.020	.002-.006-.010
Núm. MC	CMC	Material	lbs/pulg.²	HB	Velocidad de corte (v_c), pies/min	
		Superaleaciones termorresistentes				
		Base de hierro				
S1.0.U.AN	20.11	Recocidas o tratadas en solución	348,000	200	490-325-225	-
S1.0.U.AG	20.12	Envejecidas o tratadas en solución y envejecidas	359,000	280	390-260-195	-
		Base de níquel				
S2.0.Z.AN	20.21	Recocidas o tratadas en solución	383,000	250	295-185-95	1050-920-820
S2.0.Z.AG	20.22	Envejecidas o tratadas en solución y envejecidas	420,500	350	265-165-85	920-805-720
S2.0.C.NS	20.24	Fundición, o fundición y envejecido	436,500	320	235-150-75	655-510-430
		Base de cobalto				
S3.0.Z.AN	20.31	Recocidas o tratadas en solución	391,500	200	295-185-95	820-625-525
S3.0.Z.AG	20.32	Tratadas en solución y envejecidas	432,000	300	265-165-85	820-625-525
S3.0.C.NS	20.33	Fundición, o fundición y envejecido	450,500	320	235-150-75	655-510-430

Fresado

Herramientas de fresado de alto avance

CoroMill® 415 B2

Herramientas de fresado de disco

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado B3-B6
Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado inverso B7-B11

Herramientas de fresado enterizas optimizadas

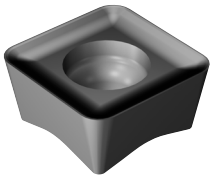
Fresa de ranurar de metal duro enteriza CoroMill® Plura para mecanizado en plunge B12-B13
Fresa de ranurar enteriza de metal duro CoroMill® Plura para fresado lateral de alto avance B14-B15
Fresa de ranurar de metal duro enteriza CoroMill® para fresado estable en múltiples operaciones B16-B18

Datos de corte

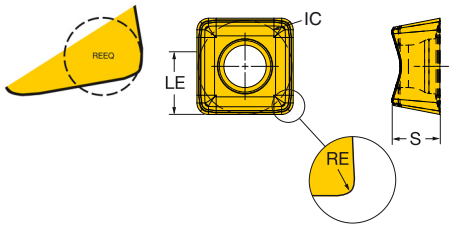
B19-B21

Para ver la gama completa, consulte www.sandvik.coromant.com/es

Plaquita CoroMill® 415 para fresado



KRINS 15°



		RE	Código de pedido	P	M			S		Dimensiones, mm					
				1040	1040	S30T	S40T	S30T	S40T	IC	LE	S	BS	BSR	REEQ
M30	05	1.20	415N-05 02 12E-M30	☆	★	☆	☆	★	☆	5.0	3.0	2.21	0.0	1.2	2.00
	07	2.00	415N-07 03 20E-M30	☆	★	☆	☆	★	☆	7.0	3.0	3.07	0.0	1.2	2.80

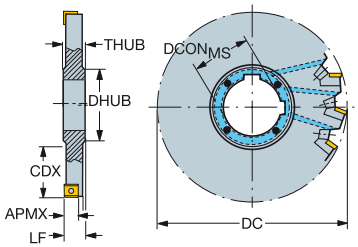
ISO 13399

SPA

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado

Árbol con chavetero - Suministro de refrigerante interior

KAPR 90°



N331.1A

Versión métrica

								Dimensiones, mm										
DC	CDX		CZC_{MS}	APMX	CNSC		**Código de pedido**	$DCON_{MS}$	LF	DRVCT	DHUB	THUB	BAR	NM	KG	RPMX	CICT	MIID
80	19.5	08	27	7.6	1	6	**R331.52C-080S27EM**	27.0	13.00	1	39.0	16.0	80	1.4	0.23	18100	6	N331.1A-08
100	25.5	08	32	7.6	1	8	**R331.52C-100S32EM**	32.0	13.00	1	47.0	16.0	80	1.4	0.37	15900	8	N331.1A-08
125	34.0	08	40	7.6	1	10	**R331.52C-125S40EM**	40.0	13.00	2	55.0	16.0	80	1.4	0.60	14100	10	N331.1A-08
160	51.5	08	40	7.6	1	12	**R331.52C-160S40EM**	40.0	13.00	1	55.0	16.0	80	1.4	1.10	12400	12	N331.1A-08
80	19.5	08	27	7.6	1	6	**R331.52C-080S27FM**	27.0	14.00	1	39.0	16.0	80	1.4	0.27	18100	6	N331.1A-08
100	25.5	08	32	7.6	1	8	**R331.52C-100S32FM**	32.0	14.00	1	47.0	16.0	80	1.4	0.44	15900	8	N331.1A-08
125	34.0	08	40	7.6	1	10	**R331.52C-125S40FM**	40.0	14.00	2	55.0	16.0	80	1.4	0.72	14100	10	N331.1A-08
160	51.5	08	40	7.6	1	12	**R331.52C-160S40FM**	40.0	14.00	1	55.0	16.0	80	1.4	1.33	12400	12	N331.1A-08
100	25.5	11	32	10.6	1	6	**R331.52C-100S32KM**	32.0	16.75	2	47.0	18.5	80	3.0	0.54	14000	6	N331.1A-11
125	34.0	11	40	10.6	1	8	**R331.52C-125S40KM**	40.0	16.75	1	55.0	18.5	80	3.0	0.88	12400	8	N331.1A-11
160	51.5	11	40	10.6	1	10	**R331.52C-160S40KM**	40.0	16.75	2	55.0	18.5	80	3.0	1.62	10800	10	N331.1A-11

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
R331.52C-125S40EM	5513 020-24	5431 105-01	339-831
R331.52C-125S40FM	5513 020-24	5431 105-02	339-831
R331.52C-080S27EM	5513 020-24	5431 105-01	339-831
R331.52C-080S27FM	5513 020-24	5431 105-02	339-831
R331.52C-100S32EM	5513 020-24	5431 105-01	339-831
R331.52C-100S32FM	5513 020-24	5431 105-02	339-831
R331.52C-160S40EM	5513 020-24	5431 105-01	339-831
R331.52C-160S40FM	5513 020-24	5431 105-02	339-831
R331.52C-100S32KM	5513 020-29	5431 105-04	5516 010-02
R331.52C-160S40KM	5513 020-29	5431 105-04	339-831
R331.52C-125S40KM	5513 020-29	5431 105-04	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

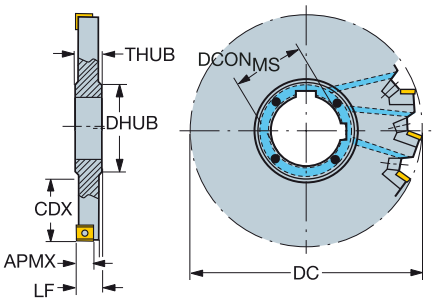
F2 F5

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado

Árbol con chavetero - Suministro de refrigerante interior

KAPR 90°

N331.1A



Versión en pulgadas

DC	CDX		CZC$_{MS}$	APMX	CNSC		Código de pedido	Dimensiones, pulg. DCON$_{MS}$	LF	DRVCT	DHUB	THUB	PSI	FT/LBS	LBS	RPMX	CICT	MIID
3.150	.768	08	1	.299	1	6	R331.52C-080T25FM	1.000	.551	1	1.535	.630	1160	1.0	0.56	18100	6	N331.1A-08
4.000	1.043	08	1 1/4	.299	1	8	R331.52C-101T32FM	1.250	.551	1	1.811	.630	1160	1.0	0.94	15900	8	N331.1A-08
5.000	1.437	08	1 1/2	.299	1	10	R331.52C-127T38FM	1.500	.551	2	2.047	.630	1160	1.0	1.59	14100	10	N331.1A-08
6.000	1.929	08	1 1/2	.299	1	12	R331.52C-152T38FM	1.500	.551	1	2.047	.728	1160	1.0	2.51	12400	12	N331.1A-08
5.000	1.437	11	1 1/2	.417	1	8	R331.52C-127T38KM	1.500	.659	1	2.047	.728	1160	2.2	2.03	12400	8	N331.1A-11
6.000	1.929	11	1 1/2	.417	1	10	R331.52C-152T38KM	1.500	.659	2	2.047	.728	1160	2.2	3.15	10800	10	N331.1A-11

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
R331.52C-080T25FM	5513 020-24	5431 105-02	339-831
R331.52C-101T32FM	5513 020-24	5431 105-02	339-831
R331.52C-127T38FM	5513 020-24	5431 105-02	339-831
R331.52C-152T38FM	5513 020-24	5431 105-02	339-831
R331.52C-152T38KM	5513 020-29	5431 105-04	339-831
R331.52C-127T38KM	5513 020-29	5431 105-04	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

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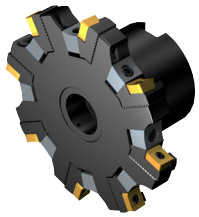
SANDVIK Coromant

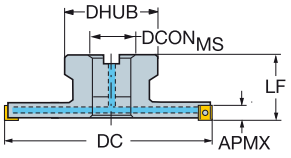
SPA

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado

Eje - Suministro de refrigerante interior

STDNO ISO6462
KAPR 90°





N331.1A

Versión métrica

DC		CZC$_{MS}$	APMX	CNSC		Código de pedido	Dimensiones, mm DCON$_{MS}$	ISO	LF	DHUB	BAR	NM	KG	RPMX	CICT	MIID
80	08	27	7.6	1	6	R331.52C-080Q27EMR	27.0	A	50.00	51.0	80	1.4	0.56	18100	6	N331.1A-08
100	08	27	7.6	1	8	R331.52C-100Q27EMR	27.0	A	50.00	51.0	80	1.4	0.87	15900	8	N331.1A-08
125	08	32	7.6	1	10	R331.52C-125Q32EMR	32.0	B	50.00	61.0	80	1.4	1.10	14100	10	N331.1A-08
160	08	40	7.6	1	12	R331.52C-160Q40EMR	40.0	B	50.00	73.0	80	1.4	1.73	12400	12	N331.1A-08
80	08	27	7.6	1	6	R331.52C-080Q27FMR	27.0	A	50.00	51.0	80	1.4	0.59	18100	6	N331.1A-08
100	08	27	7.6	1	8	R331.52C-100Q27FMR	27.0	A	50.00	51.0	80	1.4	0.93	15900	8	N331.1A-08
125	08	32	7.6	1	10	R331.52C-125Q32FMR	32.0	B	50.00	61.0	80	1.4	1.21	14100	10	N331.1A-08
160	08	40	7.6	1	12	R331.52C-160Q40FMR	40.0	B	50.00	73.0	80	1.4	1.93	12400	12	N331.1A-08
100	11	27	10.6	1	6	R331.52C-100Q27KMR	27.0	A	50.00	51.0	80	3.0	0.95	14000	6	N331.1A-11
125	11	32	10.6	1	8	R331.52C-125Q32KMR	32.0	B	50.00	61.0	80	3.0	1.33	12400	8	N331.1A-11
160	11	40	10.6	1	10	R331.52C-160Q40KMR	40.0	B	50.00	73.0	80	3.0	2.17	10800	10	N331.1A-11

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
R331.52C-080Q27EMR	5513 020-24	5431 105-01	339-831
R331.52C-080Q27FMR	5513 020-24	5431 105-02	269-832
R331.52C-100Q27EMR	5513 020-24	5431 105-01	339-831
R331.52C-100Q27FMR	5513 020-24	5431 105-02	339-831
R331.52C-125Q32EMR	5513 020-24	5431 105-01	339-831
R331.52C-125Q32FMR	5513 020-24	5431 105-02	339-831
R331.52C-160Q40EMR	5513 020-24	5431 105-01	339-831
R331.52C-160Q40FMR	5513 020-24	5431 105-02	339-831
R331.52C-100Q27KMR	5513 020-29	5431 105-04	339-831
R331.52C-125Q32KMR	5513 020-29	5431 105-04	339-831
R331.52C-160Q40KMR	5513 020-29	5431 105-04	339-831

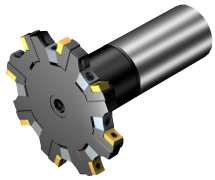
Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

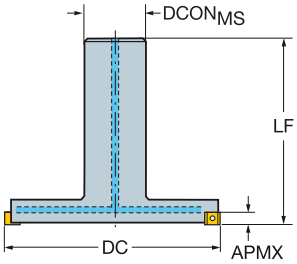
F2 F5

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado

Mango cilíndrico - Suministro de refrigerante interior

KAPR 90°





N331.1A

Versión métrica

DC		CZCMS	APMX	CNSC		Código de pedido	Dimensiones, mm DCONMS	LF	BAR	NM	KG	RPMX	CICT	MIID
80	08	32	7.6	1	6	**R331.52C-080A32EMR**	32.0	115.00	80	1.4	0.87	15900	6	N331.1A-08
100	08	40	7.6	1	8	**R331.52C-100A40EMR**	40.0	125.00	80	1.4	1.64	15900	8	N331.1A-08

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
R331.52C-080A32EMR	5513 020-24	5431 105-01	339-831
R331.52C-100A40EMR	5513 020-24	5431 105-01	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

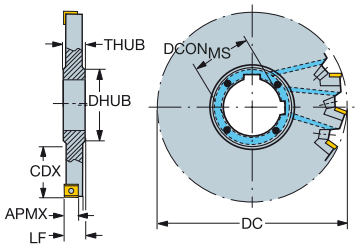
F2 F5

SPA

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado inverso

Árbol con chavetero - Suministro de refrigerante interior

KAPR 90°



N331.1A

Versión métrica

DC	CDX	↔	CZC_{MS}	APMX	CNSC	⬡	Código de pedido	Dimensiones, mm $DCON_{MS}$	LF	DRVCT	DHUB	THUB	BAR	NM	KG	RPMX	CICT	MIID
80	19.5	08	27	7.6	1	6	L331.52C-080S27EM	27.0	13.00	1	39.0	16.0	80	1.4	0.23	18100	6	N331.1A-08
100	25.5	08	32	7.6	1	8	L331.52C-100S32EM	32.0	13.00	1	47.0	16.0	80	1.4	0.37	15900	8	N331.1A-08
125	34.0	08	40	7.6	1	10	L331.52C-125S40EM	40.0	13.00	2	55.0	16.0	80	1.4	0.60	14100	10	N331.1A-08
160	51.5	08	40	7.6	1	12	L331.52C-160S40EM	40.0	13.00	1	55.0	16.0	80	1.4	1.10	12400	12	N331.1A-08
80	19.5	08	27	7.6	1	6	L331.52C-080S27FM	27.0	14.00	1	39.0	16.0	80	1.4	0.27	18100	6	N331.1A-08
100	25.5	08	32	7.6	1	8	L331.52C-100S32FM	32.0	14.00	1	47.0	16.0	80	1.4	0.44	15900	8	N331.1A-08
125	34.0	08	40	7.6	1	10	L331.52C-125S40FM	40.0	14.00	2	55.0	16.0	80	1.4	0.72	14100	10	N331.1A-08
160	51.5	08	40	7.6	1	12	L331.52C-160S40FM	40.0	14.00	1	55.0	16.0	80	1.4	1.33	12400	12	N331.1A-08
100	25.5	11	32	10.6	1	6	L331.52C-100S32KM	32.0	16.75	2	47.0	18.5	80	3.0	0.54	14000	6	N331.1A-11
125	34.0	11	40	10.6	1	8	L331.52C-125S40KM	40.0	16.75	1	55.0	18.5	80	3.0	0.88	12400	8	N331.1A-11
160	51.5	11	40	10.6	1	10	L331.52C-160S40KM	40.0	16.75	2	55.0	18.5	80	3.0	1.62	10800	10	N331.1A-11

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
L331.52C-125S40EM	5513 020-24	5431 105-01	339-831
L331.52C-125S40FM	5513 020-24	5431 105-02	339-831
L331.52C-080S27EM	5513 020-24	5431 105-01	339-831
L331.52C-080S27FM	5513 020-24	5431 105-02	339-831
L331.52C-100S32EM	5513 020-24	5431 105-01	339-831
L331.52C-100S32FM	5513 020-24	5431 105-02	339-831
L331.52C-160S40EM	5513 020-24	5431 105-01	339-831
L331.52C-160S40FM	5513 020-24	5431 105-02	339-831
L331.52C-100S32KM	5513 020-29	5431 105-04	5516 010-02
L331.52C-160S40KM	5513 020-29	5431 105-04	339-831
L331.52C-125S40KM	5513 020-29	5431 105-04	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

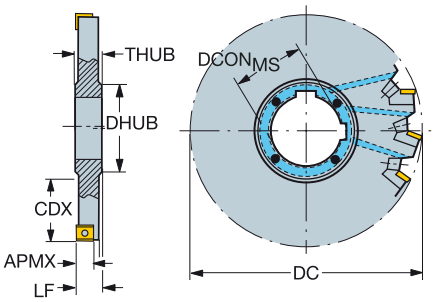
F2 F5

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado inverso

Árbol con chavetero - Suministro de refrigerante interior

KAPR 90°

N331.1A



Versión en pulgadas

DC	CDX		CZC$_{MS}$	APMX	CNSC		Código de pedido	Dimensiones, pulg. DCON$_{MS}$	LF	DRVCT	DHUB	THUB	PSI	FT/LBS	LBS	RPMX	CICT	MIID
3.150	.768	08	1	.299	1	6	L331.52C-080T25FM	1.000	.551	1	1.535	.630	1160	1.0	0.56	18100	6	N331.1A-08
4.000	1.043	08	1 1/4	.299	1	8	L331.52C-101T32FM	1.250	.551	1	1.811	.630	1160	1.0	0.94	15900	8	N331.1A-08
5.000	1.437	08	1 1/2	.299	1	10	L331.52C-127T38FM	1.500	.551	2	2.047	.630	1160	1.0	1.59	14100	10	N331.1A-08
6.000	1.929	08	1 1/2	.299	1	12	L331.52C-152T38FM	1.500	.551	1	2.047	.728	1160	1.0	2.51	12400	12	N331.1A-08
5.000	1.437	11	1 1/2	.417	1	8	L331.52C-127T38KM	1.500	.659	1	2.047	.728	1160	2.2	2.03	12400	8	N331.1A-11
6.000	1.929	11	1 1/2	.417	1	10	L331.52C-152T38KM	1.500	.659	2	2.047	.728	1160	2.2	3.15	10800	10	N331.1A-11

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
L331.52C-080T25FM	5513 020-24	5431 105-02	339-831
L331.52C-101T32FM	5513 020-24	5431 105-02	339-831
L331.52C-127T38FM	5513 020-24	5431 105-02	339-831
L331.52C-152T38FM	5513 020-24	5431 105-02	339-831
L331.52C-152T38KM	5513 020-29	5431 105-04	339-831
L331.52C-127T38KM	5513 020-29	5431 105-04	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

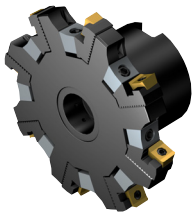
F2 F5

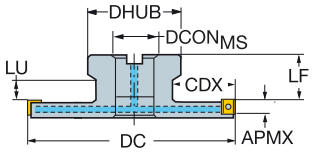
SPA

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado inverso

Eje - Suministro de refrigerante interior

STDNO ISO6462
KAPR 90°





N331.1A

Versión métrica

DC	CDX		CZC_{MS}	APMX	CNSC		Código de pedido	Dimensiones, mm $DCON_{MS}$	ISO	LF	DHUB	BAR	NM	KG	RPMX	CICT	MIID
80	20.3	08	27	7.6	1	6	R331.52C-080Q27EML	27.0	A	40.00	51.0	80	1.4	0.56	18100	6	N331.1A-08
100	23.5	08	27	7.6	1	8	R331.52C-100Q27EML	27.0	A	40.00	51.0	80	1.4	0.87	15900	8	N331.1A-08
125	31.0	08	32	7.6	1	10	R331.52C-125Q32EML	32.0	B	40.00	61.0	80	1.4	1.10	14100	10	N331.1A-08
160	42.5	08	40	7.6	1	12	R331.52C-160Q40EML	40.0	B	40.00	73.0	80	1.4	1.73	12400	12	N331.1A-08
80	20.3	08	27	7.6	1	6	R331.52C-080Q27FML	27.0	A	38.00	51.0	80	1.4	0.59	18100	6	N331.1A-08
100	23.5	08	27	7.6	1	8	R331.52C-100Q27FML	27.0	A	38.00	51.0	80	1.4	0.93	15900	8	N331.1A-08
125	31.0	08	32	7.6	1	10	R331.52C-125Q32FML	32.0	B	38.00	61.0	80	1.4	1.21	14100	10	N331.1A-08
160	42.5	08	40	7.6	1	12	R331.52C-160Q40FML	40.0	B	38.00	73.0	80	1.4	1.94	12400	12	N331.1A-08
100	25.8	11	27	10.6	1	6	R331.52C-100Q27KML	27.0	A	35.00	51.0	80	3.0	0.96	14000	6	N331.1A-11
125	31.0	11	32	10.6	1	8	R331.52C-125Q32KML	32.0	B	35.00	61.0	80	3.0	1.33	12400	8	N331.1A-11
160	42.5	11	40	10.6	1	10	R331.52C-160Q40KML	40.0	B	35.00	73.0	80	3.0	2.17	10800	10	N331.1A-11

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
R331.52C-080Q27EML	5513 020-24	5431 105-01	339-831
R331.52C-080Q27FML	5513 020-24	5431 105-02	269-832
R331.52C-100Q27EML	5513 020-24	5431 105-01	339-831
R331.52C-100Q27FML	5513 020-24	5431 105-02	339-831
R331.52C-125Q32EML	5513 020-24	5431 105-01	339-831
R331.52C-125Q32FML	5513 020-24	5431 105-02	339-831
R331.52C-160Q40EML	5513 020-24	5431 105-01	339-831
R331.52C-160Q40FML	5513 020-24	5431 105-02	339-831
R331.52C-100Q27KML	5513 020-29	5431 105-04	339-831
R331.52C-125Q32KML	5513 020-29	5431 105-04	339-831
R331.52C-160Q40KML	5513 020-29	5431 105-04	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

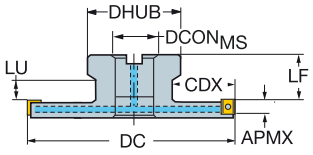
ISO 13399 F2

CNSC CXSC F5

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado inverso

Eje - Suministro de refrigerante interior

STDNO ISO6462
KAPR 90°



N331.1A

Versión en pulgadas

DC	CDX		CZC$_{MS}$	APMX	CNSC		Código de pedido	Dimensiones, pulg. DCON$_{MS}$	ISO	LF	DHUB	PSI	FT/LBS	LBS	RPMX	CICT	MIID
3.150	.799	08	1	.299	1	6	**R331.52C-080R25FML**	1.000	A	1.528	2.008	1160	1.0	1.31	18100	6	N331.1A-08
4.000	.957	08	1	.299	1	8	**R331.52C-101R25FML**	1.000	A	1.528	2.008	1160	1.0	2.10	15900	8	N331.1A-08
5.000	1.260	08	1 1/4	.299	1	10	**R331.52C-127R32FML**	1.250	B	1.528	2.402	1160	1.0	2.65	14100	10	N331.1A-08
4.000	1.016	11	1	.417	1	6	**R331.52C-101R25KML**	1.000	A	1.409	2.008	1160	2.2	2.26	14000	6	N331.1A-11

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
R331.52C-080R25FML	5513 020-24	5431 105-02	269-832
R331.52C-101R25FML	5513 020-24	5431 105-02	339-831
R331.52C-127R32FML	5513 020-24	5431 105-02	339-831
R331.52C-101R25KML	5513 020-29	5431 105-04	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

ISO 13399 F2

CNSC CXSC F5

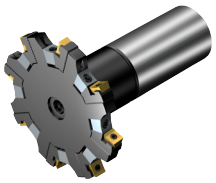
SANDVIK Coromant

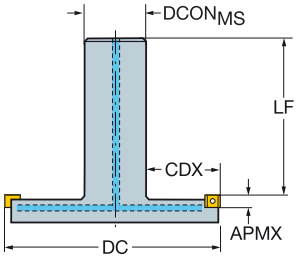
SPA

Fresa de disco ajustable CoroMill® 331 de dos cortes y planeado inverso

Mango cilíndrico - Suministro de refrigerante interior

KAPR 90°





N331.1A

Versión métrica

DC	CDX		CZC_{MS}	APMX	CNSC		Código de pedido	Dimensiones, mm $DCON_{MS}$	LF	BAR	NM	KG	RPMX	CICT	MIID
80	23.0	08	32	7.6	1	6	R331.52C-080A32EML	32.0	105.00	80	1.4	0.87	18100	6	N331.1A-08
100	29.0	08	40	7.6	1	8	R331.52C-100A40EML	40.0	115.00	80	1.4	1.49	15900	8	N331.1A-08

	Piezas de repuesto		
Código de pedido	Tornillo de plaquita	Cuña	Tornillo
R331.52C-080A32EML	5513 020-24	5431 105-01	339-831
R331.52C-100A40EML	5513 020-24	5431 105-01	339-831

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

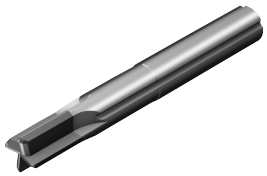
F2

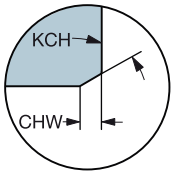
F5

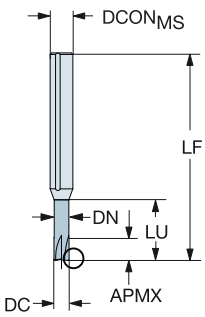
Fresa de ranurar de metal duro enteriza CoroMill® Plura para mecanizado en plunge

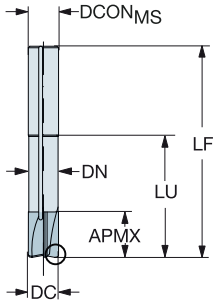
Para aleaciones con base de níquel

FHA 0°
TCDCON h5









Versión métrica

DC	CZC_{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Código de pedido	S 1610	$DCON_{MS}$	LF	DN
											Dimensiones, mm		
4.0	6	1.3	0.48	10°	16.0	4	4	4	2P070-0400-PB	★	6.0	54.9	3.9
6.0	6	2.0	0.72	10°	24.0	4	4	4	2P070-0600-PB	★	6.0	60.3	5.8
8.0	8	2.6	0.96	10°	32.0	4	4	4	2P070-0800-PB	★	8.0	68.4	7.8
10.0	10	3.3	1.20	10°	40.0	4	4	4	2P070-1000-PB	★	10.0	80.4	9.7
12.0	12	4.0	1.44	10°	48.0	4	4	4	2P070-1200-PB	★	12.0	92.5	11.6
16.0	16	5.3	1.92	10°	64.0	4	4	4	2P070-1600-PB	★	16.0	111.7	15.5

Versión en pulgadas

DC	CZC_{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Código de pedido	S 1610	$DCON_{MS}$	LF	DN
											Dimensiones, pulg.		
.187	1/4	.062	.022	10°	.748	4	4	4	2P070-0476-PB	★	.250	2.264	.182
.250	1/4	.083	.030	10°	1.000	4	4	4	2P070-0635-PB	★	.250	2.429	.243
.375	3/8	.124	.045	10°	1.500	4	4	4	2P070-0953-PB	★	.375	3.091	.364
.500	1/2	.165	.060	10°	2.000	4	4	4	2P070-1270-PB	★	.500	3.756	.485
.625	5/8	.206	.075	10°	2.500	4	4	4	2P070-1588-PB	★	.625	4.378	.606

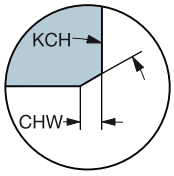
B19 F2 F5 F6

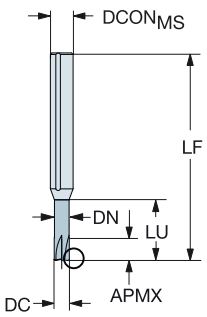
SPA

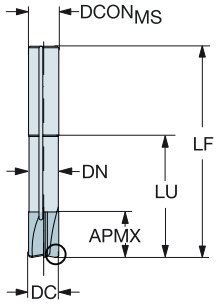
Fresa de ranurar de metal duro enteriza CoroMill® Plura para mecanizado en plunge

Para aleaciones con base de níquel

FHA 0°
TCDCON h5







Versión métrica

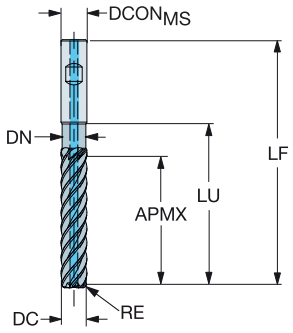
DC	CZC_{MS}	APMX	CHW	KCH	LU	CNSC	CXSC	ZEFP	Código de pedido	S	Dimensiones, mm		
										1610	$DCON_{MS}$	LF	DN
4.0	6	1.3	0.48	10°	24.0	4	4	4	2P090-0400-PB	★	6.0	62.9	3.9
6.0	6	2.0	0.72	10°	36.0	4	4	4	2P090-0600-PB	★	6.0	72.3	5.8
8.0	8	2.6	0.96	10°	48.0	4	4	4	2P090-0800-PB	★	8.0	84.4	7.8
10.0	10	3.3	1.20	10°	60.0	4	4	4	2P090-1000-PB	★	10.0	100.4	9.7
12.0	12	4.0	1.44	10°	72.0	4	4	4	2P090-1200-PB	★	12.0	116.5	11.6
16.0	16	5.3	1.92	10°	96.0	4	4	4	2P090-1600-PB	★	16.0	143.7	15.5

B19 F2 F5 F6

Fresa de ranurar enteriza de metal duro CoroMill® Plura para fresado lateral de alto avance

Para aleaciones de titanio

FHA	45°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Versión métrica

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Código de pedido	S 1745	Dimensiones, mm $DCON_{MS}$	LF	DN
6.0	6	30.0	0.50	34.0	1	1	5	2F380-0600-050ASD	★	6.0	72.0	5.7
	6	30.0	1.00	34.0	1	1	5	2F380-0600-100ASD	★	6.0	72.0	5.7
8.0	8	40.0	0.50	45.0	1	1	5	2F380-0800-050ASD	★	8.0	82.0	7.6
	8	40.0	1.00	45.0	1	1	5	2F380-0800-100ASD	★	8.0	82.0	7.6
10.0	10	50.0	0.50	56.0	1	1	5	2F380-1000-050ASD	★	10.0	97.0	9.5
	10	50.0	1.00	56.0	1	1	5	2F380-1000-100ASD	★	10.0	97.0	9.5
	10	50.0	2.00	56.0	1	1	5	2F380-1000-200ASD	★	10.0	97.0	9.5
12.0	12	60.0	1.00	67.0	1	1	5	2F380-1200-100ASD	★	12.0	115.0	11.4
	12	60.0	2.00	67.0	1	1	5	2F380-1200-200ASD	★	12.0	115.0	11.4
	12	60.0	2.50	67.0	1	1	5	2F380-1200-250ASD	★	12.0	115.0	11.4
	12	60.0	3.00	67.0	1	1	5	2F380-1200-300ASD	★	12.0	115.0	11.4
16.0	16	80.0	2.00	89.0	1	1	5	2F380-1600-200ASD	★	16.0	140.0	15.2
	16	80.0	2.50	89.0	1	1	5	2F380-1600-250ASD	★	16.0	140.0	15.2
	16	80.0	3.00	89.0	1	1	5	2F380-1600-300ASD	★	16.0	140.0	15.2
	16	80.0	4.00	89.0	1	1	5	2F380-1600-400ASD	★	16.0	140.0	15.2
20.0	20	100.0	3.00	111.0	1	1	5	2F380-2000-300ASD	★	20.0	165.0	19.0
	20	100.0	4.00	111.0	1	1	5	2F380-2000-400ASD	★	20.0	165.0	19.0
	20	100.0	6.35	111.0	1	1	5	2F380-2000-635ASD	★	20.0	165.0	19.0
25.0	25	125.0	3.00	138.5	1	1	5	2F380-2500-300ASD	★	25.0	203.0	23.8
	25	125.0	4.00	138.5	1	1	5	2F380-2500-400ASD	★	25.0	203.0	23.8
	25	125.0	6.35	138.5	1	1	5	2F380-2500-635ASD	★	25.0	203.0	23.8

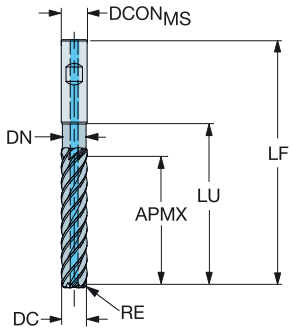
B20 F2 F5 F6

SPA

Fresa de ranurar enteriza de metal duro CoroMill® Plura para fresado lateral de alto avance

Para aleaciones de titanio

FHA	45°
BSG	COROMANT
TCDC	h10
TCDCON	h6



Versión en pulgadas

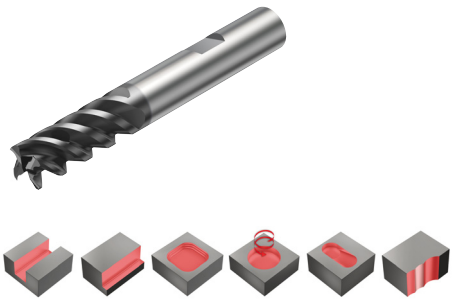
DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Código de pedido	S 1745	$DCON_{MS}$	LF	DN
										Dimensiones, pulg.		
.250	1/4	1.250	.030	1.406	1	1	5	2F380-0635-076ASD	★	.250	2.938	.237
	1/4	1.250	.060	1.406	1	1	5	2F380-0635-152ASD	★	.250	2.938	.237
.375	3/8	1.875	.030	2.094	1	1	5	2F380-0953-076ASD	★	.375	3.750	.356
	3/8	1.875	.060	2.094	1	1	5	2F380-0953-152ASD	★	.375	3.750	.356
	3/8	1.875	.090	2.094	1	1	5	2F380-0953-228ASD	★	.375	3.750	.356
.500	1/2	2.500	.030	2.781	1	1	5	2F380-1270-076ASD	★	.500	4.688	.475
	1/2	2.500	.060	2.781	1	1	5	2F380-1270-152ASD	★	.500	4.688	.475
	1/2	2.500	.090	2.781	1	1	5	2F380-1270-228ASD	★	.500	4.688	.475
	1/2	2.500	.120	2.781	1	1	5	2F380-1270-304ASD	★	.500	4.688	.475
.625	5/8	3.125	.030	3.469	1	1	5	2F380-1588-076ASD	★	.625	5.500	.594
	5/8	3.125	.060	3.469	1	1	5	2F380-1588-152ASD	★	.625	5.500	.594
	5/8	3.125	.090	3.469	1	1	5	2F380-1588-228ASD	★	.625	5.500	.594
	5/8	3.125	.120	3.469	1	1	5	2F380-1588-304ASD	★	.625	5.500	.594
.750	3/4	3.781	.030	4.156	1	1	5	2F380-1905-076ASD	★	.750	6.375	.713
	3/4	3.781	.060	4.156	1	1	5	2F380-1905-152ASD	★	.750	6.375	.713
	3/4	3.781	.090	4.156	1	1	5	2F380-1905-228ASD	★	.750	6.375	.713
	3/4	3.781	.120	4.156	1	1	5	2F380-1905-304ASD	★	.750	6.375	.713
1.000	1	5.031	.030	5.531	1	1	5	2F380-2540-076ASD	★	1.000	8.125	.950
	1	5.031	.060	5.531	1	1	5	2F380-2540-152ASD	★	1.000	8.125	.950
	1	5.031	.090	5.531	1	1	5	2F380-2540-228ASD	★	1.000	8.125	.950
	1	5.031	.120	5.531	1	1	5	2F380-2540-304ASD	★	1.000	8.125	.950

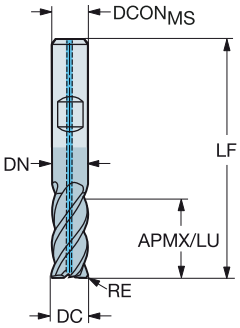
B20 F2 F5 F6

Fresa de ranurar de metal duro enteriza CoroMill® para fresado estable en múltiples operaciones

Para superaleaciones termorresistentes

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h6





Versión métrica

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Código de pedido	S 1725	Dimensiones, mm $DCON_{MS}$	LF	DN
6.0	6	13.0	0.50	19.0	1	1	4	2F440-0600-050ASD	★	6.0	57.0	5.7
	6	13.0	1.00	19.0	1	1	4	2F440-0600-100ASD	★	6.0	57.0	5.7
8.0	8	19.0	0.50	25.0	1	1	4	2F440-0800-050ASD	★	8.0	63.0	7.6
	8	19.0	1.00	25.0	1	1	4	2F440-0800-100ASD	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	1	1	4	2F440-1000-050ASD	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	1	1	4	2F440-1000-100ASD	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	1	1	4	2F440-1000-200ASD	★	10.0	72.0	9.5
12.0	12	26.0	0.50	36.0	1	1	4	2F440-1200-050ASD	★	12.0	83.0	11.4
	12	26.0	1.00	36.0	1	1	4	2F440-1200-100ASD	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	1	1	4	2F440-1200-200ASD	★	12.0	83.0	11.4
16.0	16	32.0	2.00	42.0	1	1	4	2F440-1600-200ASD	★	16.0	92.0	15.2
	16	32.0	3.00	42.0	1	1	4	2F440-1600-300ASD	★	16.0	92.0	15.2
	16	32.0	4.00	42.0	1	1	4	2F440-1600-400ASD	★	16.0	92.0	15.2
20.0	20	38.0	3.00	52.0	1	1	4	2F440-2000-300ASD	★	20.0	104.0	19.0
	20	38.0	4.00	52.0	1	1	4	2F440-2000-400ASD	★	20.0	104.0	19.0
	20	38.0	6.35	52.0	1	1	4	2F440-2000-635ASD	★	20.0	104.0	19.0

Versión en pulgadas

DC	CZC_{MS}	APMX	RE	LU	CNSC	CXSC	ZEFP	Código de pedido	S 1725	Dimensiones, pulg. $DCON_{MS}$	LF	DN
.250	1/4	.625	.030	.875	1	1	4	2F440-0635-076ASD	★	.250	2.500	.237
	1/4	.625	.060	.875	1	1	4	2F440-0635-152ASD	★	.250	2.500	.237
.375	3/8	.781	.030	1.156	1	1	4	2F440-0953-076ASD	★	.375	3.000	.356
	3/8	.781	.060	1.156	1	1	4	2F440-0953-152ASD	★	.375	3.000	.356
	3/8	.781	.090	1.156	1	1	4	2F440-0953-228ASD	★	.375	3.000	.356
.500	1/2	1.125	.030	1.438	1	1	4	2F440-1270-076ASD	★	.500	3.500	.475
	1/2	1.125	.060	1.438	1	1	4	2F440-1270-152ASD	★	.500	3.500	.475
	1/2	1.125	.090	1.438	1	1	4	2F440-1270-228ASD	★	.500	3.500	.475
	1/2	1.125	.120	1.438	1	1	4	2F440-1270-304ASD	★	.500	3.500	.475
.625	5/8	1.313	.030	1.563	1	1	4	2F440-1588-076ASD	★	.625	3.750	.594
	5/8	1.313	.060	1.563	1	1	4	2F440-1588-152ASD	★	.625	3.750	.594
	5/8	1.313	.090	1.563	1	1	4	2F440-1588-228ASD	★	.625	3.750	.594
	5/8	1.313	.120	1.563	1	1	4	2F440-1588-304ASD	★	.625	3.750	.594
.750	3/4	1.625	.030	1.937	1	1	4	2F440-1905-076ASD	★	.750	4.250	.713
	3/4	1.625	.060	1.937	1	1	4	2F440-1905-152ASD	★	.750	4.250	.713
	3/4	1.625	.090	1.937	1	1	4	2F440-1905-228ASD	★	.750	4.250	.713
	3/4	1.625	.120	1.937	1	1	4	2F440-1905-304ASD	★	.750	4.250	.713

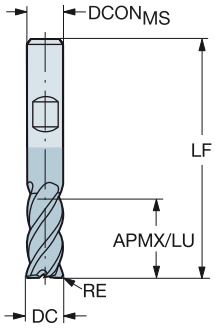
B21 F2 F5 F6

SPA

Fresa de ranurar de metal duro enteriza CoroMill® para fresado estable en múltiples operaciones

Para superaleaciones termorresistentes

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h6



Versión métrica

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Código de pedido	S 1725	$DCON_{MS}$	LF	DN
2.0	6	7.0	0.20	9.5	3	2S440-0200-020-SD	★	6.0	57.0	1.9
3.0	6	8.0	0.30	10.0	3	2S440-0300-030-SD	★	6.0	57.0	2.9
4.0	6	11.0	0.50	15.0	3	2S440-0400-050-SD	★	6.0	57.0	3.8
5.0	6	13.0	0.50	16.0	3	2S440-0500-050-SD	★	6.0	57.0	4.8
6.0	6	13.0	0.50	19.0	4	2S440-0600-050-SD	★	6.0	57.0	5.7
	6	13.0	1.00	19.0	4	2S440-0600-100-SD	★	6.0	57.0	5.7
8.0	8	19.0	0.50	25.0	4	2S440-0800-050-SD	★	8.0	63.0	7.6
	8	19.0	1.00	25.0	4	2S440-0800-100-SD	★	8.0	63.0	7.6
10.0	10	22.0	0.50	30.0	4	2S440-1000-050-SD	★	10.0	72.0	9.5
	10	22.0	1.00	30.0	4	2S440-1000-100-SD	★	10.0	72.0	9.5
	10	22.0	2.00	30.0	4	2S440-1000-200-SD	★	10.0	72.0	9.5
12.0	12	26.0	0.50	36.0	4	2S440-1200-050-SD	★	12.0	83.0	11.4
	12	26.0	1.00	36.0	4	2S440-1200-100-SD	★	12.0	83.0	11.4
	12	26.0	2.00	36.0	4	2S440-1200-200-SD	★	12.0	83.0	11.4
16.0	16	32.0	2.00	42.0	4	2S440-1600-200-SD	★	16.0	92.0	15.2
	16	32.0	3.00	42.0	4	2S440-1600-300-SD	★	16.0	92.0	15.2
	16	32.0	4.00	42.0	4	2S440-1600-400-SD	★	16.0	92.0	15.2
20.0	20	38.0	3.00	52.0	4	2S440-2000-300-SD	★	20.0	104.0	19.0
	20	38.0	4.00	52.0	4	2S440-2000-400-SD	★	20.0	104.0	19.0
	20	38.0	6.35	52.0	4	2S440-2000-635-SD	★	20.0	104.0	19.0

Dimensiones, mm

Versión en pulgadas

DC	CZC_{MS}	APMX	RE	LU	ZEFP	Código de pedido	S 1725	$DCON_{MS}$	LF	DN
.250	1/4	.625	.030	.875	4	2S440-0635-076-SD	★	.250	2.500	.237
	1/4	.625	.060	.875	4	2S440-0635-152-SD	★	.250	2.500	.237
.375	3/8	.781	.030	1.156	4	2S440-0953-076-SD	★	.375	3.000	.356
	3/8	.781	.060	1.156	4	2S440-0953-152-SD	★	.375	3.000	.356
	3/8	.781	.090	1.156	4	2S440-0953-228-SD	★	.375	3.000	.356
.500	1/2	1.125	.030	1.438	4	2S440-1270-076-SD	★	.500	3.500	.475
	1/2	1.125	.060	1.438	4	2S440-1270-152-SD	★	.500	3.500	.475
	1/2	1.125	.090	1.438	4	2S440-1270-228-SD	★	.500	3.500	.475
	1/2	1.125	.120	1.438	4	2S440-1270-304-SD	★	.500	3.500	.475
.625	5/8	1.313	.030	1.563	4	2S440-1588-076-SD	★	.625	3.750	.594
	5/8	1.313	.060	1.563	4	2S440-1588-152-SD	★	.625	3.750	.594
	5/8	1.313	.090	1.563	4	2S440-1588-228-SD	★	.625	3.750	.594
	5/8	1.313	.120	1.563	4	2S440-1588-304-SD	★	.625	3.750	.594
.750	3/4	1.625	.030	1.937	4	2S440-1905-076-SD	★	.750	4.250	.713
	3/4	1.625	.060	1.937	4	2S440-1905-152-SD	★	.750	4.250	.713
	3/4	1.625	.090	1.937	4	2S440-1905-228-SD	★	.750	4.250	.713
	3/4	1.625	.120	1.937	4	2S440-1905-304-SD	★	.750	4.250	.713

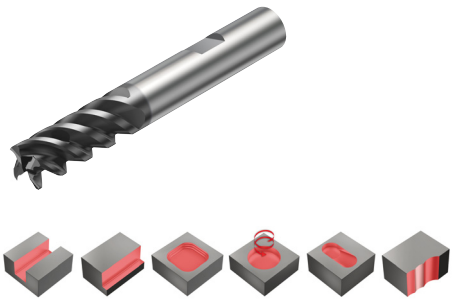
Dimensiones, pulg.

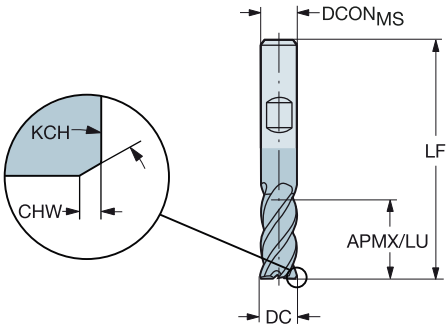
B21 F2 F5 F6

Fresa de ranurar de metal duro enteriza CoroMill® para fresado estable en múltiples operaciones

Para superaleaciones termorresistentes

FHA	50°
BSG	DIN 6527 L
TCDC	h9
TCDCON	h6





Versión métrica

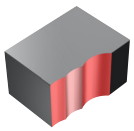
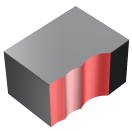
DC	CZC_{MS}	APMX	CHW	KCH	LU	ZEFP	Código de pedido	S 1725	Dimensiones, mm $DCON_{MS}$	LF	DN
6.0	6	13.0	0.10	45°	19.0	4	2P440-0600-SD	★	6.0	57.0	5.7
8.0	8	19.0	0.10	45°	25.0	4	2P440-0800-SD	★	8.0	63.0	7.6
10.0	10	22.0	0.10	45°	30.0	4	2P440-1000-SD	★	10.0	72.0	9.5
12.0	12	26.0	0.10	45°	36.0	4	2P440-1200-SD	★	12.0	83.0	11.4
16.0	16	32.0	0.15	45°	42.0	4	2P440-1600-SD	★	16.0	92.0	15.2
20.0	20	38.0	0.15	45°	52.0	4	2P440-2000-SD	★	20.0	104.0	19.0

B21 F2 F5 F6

SPA

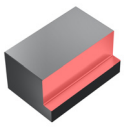
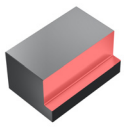
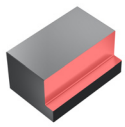
Recomendaciones de velocidad de corte

Optimizada: fresa de ranurar de metal duro enteriza CoroMill® Plura para mecanizado en plunge en aleaciones con base de níquel

											
					a_e = 0.3 x DC a_p = 4 x DC			a_e = 0.3 x DC a_p = 6 x DC			
ISO	Núm. MC	CMC	Material	HB	fz mm/diente	v_c m/min	v_c pie/min	fz mm/diente	v_c m/min	v_c pie/min	
S	S2.0.Z.AG	20.22	Superaleaciones con base de níquel	400	0,02-0,05	25	82	B04	25	82	

Recomendaciones de velocidad de corte

Optimizadas: fresa de ranurar de metal duro enteriza CoroMill® Plura para fresado lateral de alto avance en aleaciones de titanio

				a_e = 0.07 x DC a_p = 5.0 x DC			a_e = 0.033 x DC a_p = 5.0 x DC			a_e = 0.2 mm a_p = 5.0 x DC		
ISO	Núm. MC	Material	HB	f_z	v_c m/min	v_c pie/min	f_z	v_c m/min	v_c pie/min	f_z	v_c m/min	v_c pie/min
S	S4.3.Z.AN	Aleación de titanio Alpha-Beta	330	T01	80	262	T02	120	394	T03	180	590
	S4.4.Z.AN	Aleación de titanio Beta	410	T01	60	197	T02	90	295	T03	120	394

Recomendaciones de avance

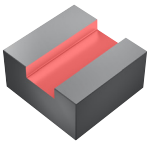
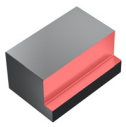
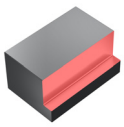
mm/diente
pulg./diente

D_c	6.000	6.350	8.000	9.525	10.000	12.000	12.700	15.875	16.000	19.050	20.000	25.000	25.400
f_z	*0.236*	*0.250*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.625*	*0.630*	*0.750*	*0.787*	*0.984*	*1.000*
T01	0.020	0.021	0.023	0.023	0.024	0.025	0.025	0.026	0.027	0.027	0.028	0.0292	0.029
	.0008	.0008	.0009	.0009	.0009	.0010	.0010	.0010	.0010	.0011	.0011	.0011	.0012
T02	0.032	0.033	0.036	0.037	0.038	0.040	0.041	0.042	0.042	0.044	0.045	0.0467	0.047
	.0013	.0013	.0014	.0015	.0015	.0016	.0016	.0017	.0017	.0017	.0018	.0018	.0019
T03	0.064	0.067	0.072	0.075	0.077	0.080	0.081	0.085	0.085	0.088	0.089	0.093	0.094
	.0025	.0026	.0028	.0030	.0030	.0031	.0032	.0033	.0033	.0035	.0035	.0037	.0037

SPA

Recomendaciones de velocidad de corte

Optimizada: fresa de ranurar de metal duro enteriza CoroMill® para fresado estable en múltiples operaciones de superaleaciones termorresistentes

				a_e = 1.0 x DC a_p = 0.5 x DC			a_e = 0.5 x DC a_p = 1.0 x DC			a_e = 0.25 x DC a_p = 2.0 x DC		
ISO	Núm. MC	Material	HB	f_z	v_c m/min	v_c pie/min	f_z	v_c m/min	v_c pie/min	f_z	v_c m/min	v_c pie/min
S	S1.0.U.AN	Superaleaciones con base de hierro	200	Z01	30	98	Z01	35	115	Z04	40	131
	S2.0.Z.AN	Superaleciones con base de níquel	250	Z02	22	72	Z02	28	92	Z05	30	98
	S2.0.Z.AG	Superaleciones con base de níquel	400	Z03	17	56	Z03	22	72	Z06	25	82
	S3.0.Z.AN	Superaleaciones con base de cobalto	200	Z01	25	82	Z01	30	98	Z04	35	115

Recomendaciones de avance

mm/diente
pulg./diente

D_c	2.000	3.000	4.000	5.000	6.000	6.350	8.000	9.525	10.000	12.000	12.700	15.875	16.000	19.050	20.000
f_z	*0.0787*	*0.1181*	*0.157*	*0.197*	*0.236*	*0.250*	*0.315*	*0.375*	*0.394*	*0.472*	*0.500*	*0.625*	*0.630*	*0.750*	*0.787*
Z01	0.005	0.008	0.011	0.014	0.016	0.017	0.022	0.026	0.027	0.0325	0.0330	0.0365	0.0366	0.0387	0.0393
	.0002	*.0002*	*.0004*	*.0005*	*.0006*	*.0007*	*.0009*	*.0010*	*.0011*	*.0013*	*.0013*	*.0014*	*.0014*	*.0015*	*.0015*
Z02	0.005	0.008	0.010	0.013	0.015	0.016	0.020	0.024	0.025	0.0300	0.0305	0.0337	0.0338	0.0357	0.0363
	.0002	*.0003*	*.0004*	*.0005*	*.0006*	*.0006*	*.0008*	*.0009*	*.0010*	*.0012*	*.0012*	*.0013*	*.0013*	*.0014*	*.0014*
Z03	0.004	0.006	0.008	0.010	0.013	0.013	0.017	0.020	0.021	0.0250	0.0254	0.0281	0.0281	0.0298	0.0302
	.0002	*.0004*	*.0003*	*.0004*	*.0005*	*.0005*	*.0007*	*.0008*	*.0008*	*.0010*	*.0010*	*.0011*	*.0011*	*.0012*	*.0012*
Z04	0.007	0.010	0.013	0.016	0.020	0.021	0.026	0.031	0.033	0.0390	0.041	0.052	0.052	0.062	0.065
	.0003	*.0005*	*.0005*	*.0006*	*.0008*	*.0008*	*.0010*	*.0012*	*.0013*	*.0015*	*.0016*	*.0020*	*.0020*	*.0024*	*.0026*
Z05	0.006	0.009	0.012	0.015	0.018	0.019	0.024	0.029	0.030	0.0360	0.038	0.048	0.048	0.057	0.060
	.0002	*.0004*	*.0005*	*.0006*	*.0007*	*.0008*	*.0009*	*.0011*	*.0012*	*.0014*	*.0015*	*.0019*	*.0019*	*.0023*	*.0024*
Z06	0.006	0.009	0.012	0.015	0.018	0.019	0.023	0.028	0.029	0.035	0.037	0.046	0.047	0.056	0.058
	.0002	*.0006*	*.0005*	*.0006*	*.0007*	*.0007*	*.0009*	*.0011*	*.0011*	*.0014*	*.0015*	*.0018*	*.0018*	*.0022*	*.0023*

Taladrado

Brocas de plaquita intercambiable

CoroDrill® DS20 C2-C5

Datos de corte

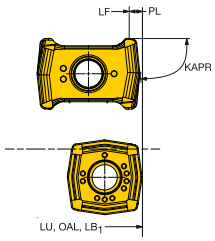
C6

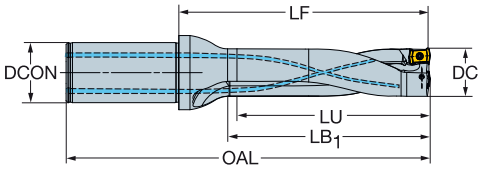
Para ver la gama completa, consulte www.sandvik.coromant.com/es

Broca de plaquita intercambiable CoroDrill® DS20

Mango cilíndrico con plano de apriete, según ISO 9766

Suministro de refrigerante interior





Diseño métrico

									Dimensiones, mm									
		DC	LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Código de pedido	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	NM	KG	RPMX
01C	01P	15.50	62.46	20	1.00	0.00	0.27	DS20-D1550L20-04	20.00	82.53	131.00	63.00	0.46	81°	10	0.6	0.193	24000
			77.96	20	1.00	0.00	0.27	DS20-D1550L20-05	20.00	95.53	146.00	78.00	0.46	81°	10	0.6	0.205	15000
01C	01P	16.50	66.46	20	0.75	0.00	0.27	DS20-D1650L20-04	20.00	84.53	135.00	67.00	0.46	81°	10	0.6	0.203	22000
			82.96	20	0.75	0.00	0.27	DS20-D1650L20-05	20.00	100.53	151.00	83.00	0.46	81°	10	0.6	0.217	14000
01C	01P	17.50	70.46	25	0.50	0.00	0.27	DS20-D1750L25-04	25.00	94.53	151.00	73.00	0.46	81°	10	0.6	0.337	21000
			85.46	25	0.50	0.00	0.27	DS20-D1750L25-05	25.00	105.53	156.00	88.00	0.46	81°	10	0.6	0.353	13000
02C	02P	18.50	72.46	25	0.25	0.00	0.27	DS20-D1850L25-04	25.00	96.53	153.00	75.00	0.46	81°	10	0.6	0.349	20000
			92.96	25	0.25	0.00	0.27	DS20-D1850L25-05	25.00	114.53	171.00	93.00	0.46	81°	10	0.6	0.368	13000
02C	02P	19.50	78.55	25	1.06	0.00	0.33	DS20-D1950L25-04	25.00	100.44	157.00	79.00	0.55	81°	10	0.9	0.362	19000
			98.05	25	1.06	0.00	0.33	DS20-D1950L25-05	25.00	119.44	176.00	98.00	0.55	81°	10	0.9	0.385	12000
06C	06P	41.00	164.00	40	3.73	0.00	0.35	DS20-D4100L40-04	40.00	197.72	269.00	169.00	1.27	81°	10	3.0	1.750	9000
			205.00	40	3.73	0.00	0.35	DS20-D4100L40-05	40.00	238.72	310.00	210.00	1.27	81°	10	3.0	1.961	5000
			246.00	40	3.73	-0.10	0.40	DS20-D4100L40-06	40.00	279.72	351.00	251.00	1.27	81°	10	3.0	2.172	4000
			287.00	40	3.73	-0.10	0.40	DS20-D4100L40-07	40.00	320.72	392.00	292.00	1.27	81°	10	3.0	2.383	3000
06C	06P	42.00	168.00	50	3.46	0.00	0.35	DS20-D4200L50-04	50.00	208.72	290.00	173.00	1.27	81°	10	3.0	2.578	8000
			210.00	50	3.46	0.00	0.35	DS20-D4200L50-05	50.00	250.72	332.00	215.00	1.27	81°	10	3.0	2.805	5000
			252.00	50	3.46	-0.10	0.40	DS20-D4200L50-06	50.00	292.72	374.00	257.00	1.27	81°	10	3.0	3.033	4000
			294.00	50	3.46	-0.10	0.40	DS20-D4200L50-07	50.00	334.72	416.00	299.00	1.27	81°	10	3.0	3.260	2000
06C	06P	43.00	172.00	50	3.19	0.00	0.35	DS20-D4300L50-04	50.00	212.72	294.00	177.00	1.27	81°	10	3.0	2.654	8000
			215.00	50	3.19	0.00	0.35	DS20-D4300L50-05	50.00	255.72	337.00	220.00	1.27	81°	10	3.0	2.898	5000
			258.00	50	3.19	-0.10	0.40	DS20-D4300L50-06	50.00	298.72	380.00	263.00	1.27	81°	10	3.0	3.143	3000
			301.00	50	3.19	-0.10	0.40	DS20-D4300L50-07	50.00	341.72	423.00	306.00	1.27	81°	10	3.0	3.388	2000
06C	06P	44.00	176.00	50	2.92	0.00	0.35	DS20-D4400L50-04	50.00	216.72	298.00	181.00	1.27	81°	10	3.0	2.733	8000
			220.00	50	2.92	0.00	0.35	DS20-D4400L50-05	50.00	260.72	342.00	225.00	1.27	81°	10	3.0	2.996	5000
			264.00	50	2.92	-0.10	0.40	DS20-D4400L50-06	50.00	304.72	386.00	269.00	1.27	81°	10	3.0	3.259	3000
			308.00	50	2.92	-0.10	0.40	DS20-D4400L50-07	50.00	348.72	430.00	313.00	1.27	81°	10	3.0	3.521	2000
06C	06P	45.00	180.00	50	2.65	0.00	0.35	DS20-D4500L50-04	50.00	220.72	302.00	185.00	1.27	81°	10	3.0	2.816	8000
			225.00	50	2.65	0.00	0.35	DS20-D4500L50-05	50.00	265.72	347.00	230.00	1.27	81°	10	3.0	3.101	5000
			270.00	50	2.65	-0.10	0.40	DS20-D4500L50-06	50.00	310.72	392.00	275.00	1.27	81°	10	3.0	3.385	3000
			315.00	50	2.65	-0.10	0.40	DS20-D4500L50-07	50.00	355.72	437.00	320.00	1.27	81°	10	3.0	3.669	2000
06C	06P	46.00	184.00	50	2.38	0.00	0.35	DS20-D4600L50-04	50.00	224.72	306.00	189.00	1.27	81°	10	3.0	2.902	8000
			230.00	50	2.38	0.00	0.35	DS20-D4600L50-05	50.00	270.72	352.00	235.00	1.27	81°	10	3.0	3.206	5000
06C	06P	47.00	188.00	50	2.11	0.00	0.35	DS20-D4700L50-04	50.00	227.72	309.00	193.00	1.27	81°	10	3.0	2.968	8000
			235.00	50	2.11	0.00	0.35	DS20-D4700L50-05	50.00	274.72	356.00	240.00	1.27	81°	10	3.0	3.293	5000
06C	06P	48.00	192.00	50	1.84	0.00	0.35	DS20-D4800L50-04	50.00	231.72	313.00	197.00	1.27	81°	10	3.0	3.061	7000
			240.00	50	1.84	0.00	0.35	DS20-D4800L50-05	50.00	279.72	361.00	245.00	1.27	81°	10	3.0	3.408	5000
06C	06P	49.00	196.00	50	1.57	0.00	0.35	DS20-D4900L50-04	50.00	235.72	317.00	201.00	1.27	81°	10	3.0	3.158	7000
			245.00	50	1.57	0.00	0.35	DS20-D4900L50-05	50.00	284.72	366.00	250.00	1.27	81°	10	3.0	3.528	4000
06C	06P	50.00	200.00	50	1.30	0.00	0.35	DS20-D5000L50-04	50.00	239.72	321.00	205.00	1.27	81°	10	3.0	3.259	7000
			250.00	50	1.30	0.00	0.35	DS20-D5000L50-05	50.00	289.72	371.00	255.00	1.27	81°	10	3.0	3.652	4000

	Piezas de repuesto
DC	Tornillo de plaquita
15.50-17.50	5513 020-27
18.50-19.50	5513 020-88
41.00-65.00	416.1-834

Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

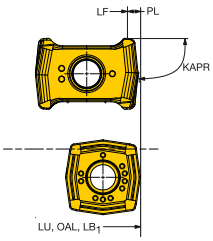
C5 F2 F5

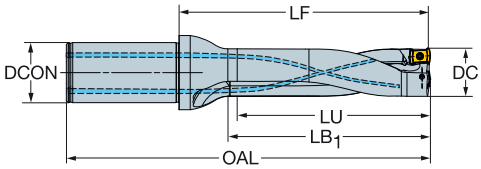
SPA

Broca de plaquita intercambiable CoroDrill® DS20

Mango cilíndrico con plano de apriete, según ISO 9766

Suministro de refrigerante interior





Diseño métrico

									Dimensiones, mm									
		DC	LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Código de pedido	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	NM	KG	RPMX
06C	06P	51.00	204.00	50	1.03	0.00	0.35	DS20-D5100L50-04	50.00	243.72	325.00	209.00	1.27	81°	10	3.0	3.363	7000
			255.00	50	1.03	0.00	0.35	DS20-D5100L50-05	50.00	294.72	376.00	260.00	1.27	81°	10	3.0	3.781	4000
06C	06P	52.00	208.00	50	0.76	0.00	0.35	DS20-D5200L50-04	50.00	247.72	329.00	213.00	1.27	81°	10	3.0	3.472	7000
			260.00	50	0.76	0.00	0.35	DS20-D5200L50-05	50.00	299.72	381.00	265.00	1.27	81°	10	3.0	3.916	4000
07C	07P	53.00	212.00	50	4.21	0.00	0.35	DS20-D5300L50-04	50.00	251.41	333.00	217.00	1.58	81°	10	3.0	3.459	7000
			265.00	50	4.21	0.00	0.35	DS20-D5300L50-05	50.00	304.41	386.00	270.00	1.58	81°	10	3.0	3.911	4000
07C	07P	54.00	216.00	50	3.92	0.00	0.35	DS20-D5400L50-04	50.00	255.41	337.00	221.00	1.58	81°	10	3.0	3.573	7000
			270.00	50	3.92	0.00	0.35	DS20-D5400L50-05	50.00	309.41	391.00	275.00	1.58	81°	10	3.0	4.052	4000
07C	07P	55.00	220.00	50	3.63	0.00	0.35	DS20-D5500L50-04	50.00	259.41	341.00	225.00	1.58	81°	10	3.0	3.694	6000
			275.00	50	3.63	0.00	0.35	DS20-D5500L50-05	50.00	314.41	396.00	280.00	1.58	81°	10	3.0	4.202	4000
07C	07P	56.00	224.00	50	3.34	0.00	0.35	DS20-D5600L50-04	50.00	263.41	345.00	229.00	1.58	81°	10	3.0	3.827	6000
			280.00	50	3.34	0.00	0.35	DS20-D5600L50-05	50.00	319.41	401.00	285.00	1.58	81°	10	3.0	4.367	4000
07C	07P	57.00	228.00	50	3.05	0.00	0.35	DS20-D5700L50-04	50.00	267.41	349.00	233.00	1.58	81°	10	3.0	3.957	6000
			285.00	50	3.05	0.00	0.35	DS20-D5700L50-05	50.00	324.41	406.00	290.00	1.58	81°	10	3.0	4.528	4000
07C	07P	58.00	232.00	50	2.76	0.00	0.35	DS20-D5800L50-04	50.00	271.41	353.00	237.00	1.58	81°	10	3.0	4.300	6000
			290.00	50	2.76	0.00	0.35	DS20-D5800L50-05	50.00	329.41	411.00	295.00	1.58	81°	10	3.0	4.623	4000
07C	07P	59.00	236.00	50	2.47	0.00	0.35	DS20-D5900L50-04	50.00	274.41	356.00	241.00	1.58	81°	10	3.0	4.146	6000
			295.00	50	2.47	0.00	0.35	DS20-D5900L50-05	50.00	333.41	415.00	300.00	1.58	81°	10	3.0	4.768	4000
07C	07P	60.00	240.00	50	2.18	0.00	0.35	DS20-D6000L50-04	50.00	278.41	360.00	245.00	1.58	81°	10	3.0	4.350	6000
			300.00	50	2.18	0.00	0.35	DS20-D6000L50-05	50.00	338.41	420.00	305.00	1.58	81°	10	3.0	5.021	4000
07C	07P	61.00	244.00	50	1.89	0.00	0.35	DS20-D6100L50-04	50.00	282.41	364.00	249.00	1.58	81°	10	3.0	4.498	6000
			305.00	50	1.89	0.00	0.35	DS20-D6100L50-05	50.00	343.41	425.00	310.00	1.58	81°	10	3.0	5.204	4000
07C	07P	62.00	248.00	50	1.60	0.00	0.35	DS20-D6200L50-04	50.00	286.41	368.00	253.00	1.58	81°	10	3.0	4.651	6000
			310.00	50	1.60	0.00	0.35	DS20-D6200L50-05	50.00	348.41	430.00	315.00	1.58	81°	10	3.0	5.393	3000
07C	07P	63.00	252.00	50	1.31	0.00	0.35	DS20-D6300L50-04	50.00	290.41	372.00	257.00	1.58	81°	10	3.0	4.806	6000
			315.00	50	1.31	0.00	0.35	DS20-D6300L50-05	50.00	353.41	435.00	320.00	1.58	81°	10	3.0	5.587	3000
07C	07P	64.00	256.00	50	1.02	0.00	0.35	DS20-D6400L50-04	50.00	295.41	377.00	261.00	1.58	81°	10	3.0	4.848	5000
			320.00	50	1.02	0.00	0.35	DS20-D6400L50-05	50.00	359.41	441.00	325.00	1.58	81°	10	3.0	5.633	3000
07C	07P	65.00	260.00	50	0.73	0.00	0.35	DS20-D6500L50-04	50.00	299.41	381.00	265.00	1.58	81°	10	3.0	5.167	5000
			325.00	50	0.73	0.00	0.35	DS20-D6500L50-05	50.00	364.41	446.00	330.00	1.58	81°	10	3.0	6.027	3000

	Piezas de repuesto
DC	Tornillo de plaquita
15.50-17.50	5513 020-27
18.50-19.50	5513 020-88
41.00-65.00	416.1-834

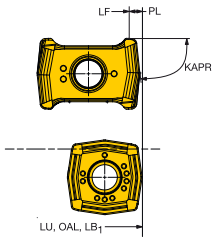
Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

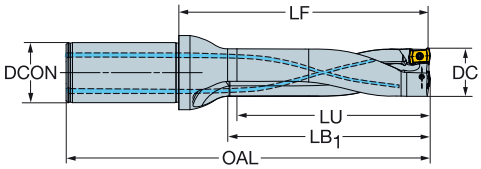
C5 F2 F5

Broca de plaquita intercambiable CoroDrill® DS20

Mango cilíndrico con plano de apriete, según ISO 9766

Suministro de refrigerante interior





Diseño en pulgadas

									Dimensiones, pulg.									
		DC	LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Código de pedido	$DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	PSI	FT/LBS	LBS	RPMX
06C	06P	1.625	6.500	1 1/2	.143	.000	.014	DS20-D4128LX38-04	1.500	7.770	10.576	6.666	.050	81°	145	2.2	3.968	9000
			8.125	1 1/2	.143	.000	.014	DS20-D4128LX38-05	1.500	9.395	12.201	8.291	.050	81°	145	2.2	4.409	5000
			9.750	1 1/2	.143	-.004	.016	DS20-D4128LX38-06	1.500	11.020	13.826	9.916	.050	81°	145	2.2	5.511	4000
			11.375	1 1/2	.143	-.004	.016	DS20-D4128LX38-07	1.500	12.645	15.451	11.541	.050	81°	145	2.2	5.952	3000
06C	06P	1.687	6.748	1 1/2	.127	.000	.014	DS20-D4285LX38-04	1.500	8.013	10.819	6.914	.050	81°	145	2.2	4.409	8000
			8.435	1 1/2	.127	.000	.014	DS20-D4285LX38-05	1.500	9.700	12.506	8.601	.050	81°	145	2.2	4.629	5000
			10.122	1 1/2	.127	-.004	.016	DS20-D4285LX38-06	1.500	11.387	14.193	10.288	.050	81°	145	2.2	5.952	3000
			11.809	1 1/2	.127	-.004	.016	DS20-D4285LX38-07	1.500	13.074	15.880	11.975	.050	81°	145	2.2	6.393	2000
06C	06P	1.750	7.000	1 1/2	.110	.000	.014	DS20-D4445LX38-04	1.500	8.260	11.066	7.166	.050	81°	145	2.2	4.409	8000
			8.750	1 1/2	.110	.000	.014	DS20-D4445LX38-05	1.500	10.010	12.816	8.916	.050	81°	145	2.2	4.841	5000
			10.500	1 1/2	.110	-.004	.016	DS20-D4445LX38-06	1.500	11.760	14.566	10.666	.050	81°	145	2.2	6.172	3000
			12.250	1 1/2	.110	-.004	.016	DS20-D4445LX38-07	1.500	13.510	16.316	12.416	.050	81°	145	2.2	6.038	2000
06C	06P	1.875	7.500	1 1/2	.076	.000	.014	DS20-D4763LX38-04	1.500	8.750	11.556	7.666	.050	81°	145	2.2	5.070	7000
			9.375	1 1/2	.076	.000	.014	DS20-D4763LX38-05	1.500	10.625	13.431	9.541	.050	81°	145	2.2	6.393	5000
06C	06P	2.000	8.000	1 1/2	.042	.000	.014	DS20-D5080LX38-04	1.500	9.520	12.326	8.166	.050	81°	145	2.2	6.172	7000
			10.000	1 1/2	.042	.000	.014	DS20-D5080LX38-05	1.500	11.520	14.326	10.166	.050	81°	145	2.2	7.716	4000
07C	07P	2.125	8.500	1 1/2	.154	.000	.014	DS20-D5398LX38-04	1.500	10.009	12.828	8.678	.063	81°	145	2.2	6.530	7000
			10.625	1 1/2	.154	.000	.014	DS20-D5398LX38-05	1.500	12.134	14.953	10.803	.063	81°	145	2.2	8.377	4000
07C	07P	2.250	9.000	1 1/2	.118	.000	.014	DS20-D5715LX38-04	1.500	10.499	13.318	9.178	.063	81°	145	2.2	7.414	6000
			11.250	1 1/2	.118	.000	.014	DS20-D5715LX38-05	1.500	12.749	15.568	11.428	.063	81°	145	2.2	9.259	4000
07C	07P	2.375	9.500	1 1/2	.082	.000	.014	DS20-D6033LX38-04	1.500	10.989	13.808	9.678	.063	81°	145	2.2	8.377	6000
			11.875	1 1/2	.082	.000	.014	DS20-D6033LX38-05	1.500	13.364	16.183	12.053	.063	81°	145	2.2	10.582	4000
07C	07P	2.500	10.000	1 1/2	.045	.000	.014	DS20-D6350LX38-04	1.500	11.480	14.299	10.178	.063	81°	145	2.2	9.389	6000
			12.500	1 1/2	.045	.000	.014	DS20-D6350LX38-05	1.500	13.980	16.799	12.678	.063	81°	145	2.2	11.905	3000

Piezas de repuesto
Tornillo de plaquita
416.1-834

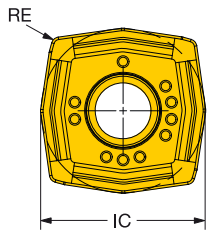
Para ver la lista completa de piezas de repuesto, consulte www.sandvik.coromant.com/es

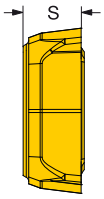
C5 F2 F5

SANDVIK Coromant

Plaquita CoroDrill® DS20 para taladrado

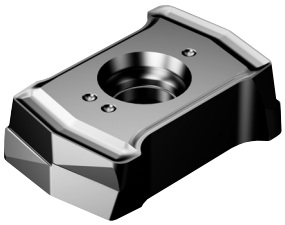
Plaquita central

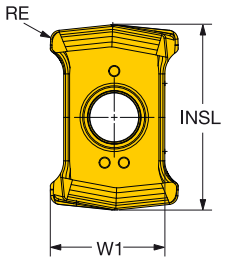


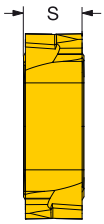


	INSUC	Código de pedido	P			M		K			N		S			H		Dimensiones, mm, pulg.			
			1344	1144	1344	H13A	1344	1344	H13A	1344	S	RE	IC								
06	C	DS20-0608-C-L5	★	★		★	☆	★	☆	★	3.90	0.35	17.5								
											.154	*.014*	*.687*								
06	C	DS20-0608-C-M7	★		★					☆	3.90	0.35	17.5								
											.154	*.014*	*.687*								
07	C	DS20-0708-C-L5	★	★		★	☆	★	☆	★	4.50	0.35	21.8								
											.177	*.014*	*.859*								
07	C	DS20-0708-C-M7	★		★					☆	4.50	0.35	21.8								
											.177	*.014*	*.859*								

Plaquita periférica

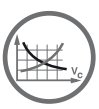






	INSUC	Código de pedido	P			M			K			N		S			H		Dimensiones, mm, pulg.			
			4324	4334	4344	2044	4334	4344	4324	4334	4344	4344	H13A	2044	4344	H13A	4334	4344	S	RE	W1	INSL
06	P	DS20-0608-P-H5W		★	☆	★	☆	☆											6.20	0.80	14.4	19.4
																			.244	*.031*	*.568*	*.764*
06	P	DS20-0608-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				6.20	0.80	14.4	19.4
																			.244	*.031*	*.568*	*.764*
06	P	DS20-0608-P-L6W			★			★			★	★			★			★	6.20	0.80	14.4	19.4
																			.244	*.031*	*.568*	*.764*
06	P	DS20-0608-P-M7W	☆	★	☆				☆	★	☆						☆	★	6.20	0.80	14.4	19.4
																			.244	*.031*	*.568*	*.764*
06	P	DS20-0608-P-S5W						★				☆	★		★	☆			6.20	0.80	14.4	19.4
																			.244	*.031*	*.568*	*.764*
07	P	DS20-0708-P-H5W		★	☆	★	☆	☆											7.00	0.80	18.0	21.9
																			.276	*.031*	*.710*	*.862*
07	P	DS20-0708-P-L5W	☆	★	☆	★	☆	☆				★		★	☆				7.00	0.80	18.0	21.9
																			.276	*.031*	*.710*	*.862*
07	P	DS20-0708-P-L6W			★			★			★	★			★			★	7.00	0.80	18.0	21.9
																			.276	*.031*	*.710*	*.862*
07	P	DS20-0708-P-M7W	☆	★	☆				☆	★	☆						☆	★	7.00	0.80	18.0	21.9
																			.276	*.031*	*.710*	*.862*
07	P	DS20-0708-P-S5W						★				☆	★		★	☆			7.00	0.80	18.0	21.9
																			.276	*.031*	*.710*	*.862*

C2


C6

F2

CoroDrill® DS20

4-5xD

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD Mín.	Rec.	Máx.	Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance									
									f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.
P	P1.0.Z.AN	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado Fundición - sin tratar	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	Acero de baja aleación Recocido	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	Acero de baja aleación Recocido	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	Acero de baja aleación Endurecido y templado	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	Acero de baja aleación Fundición - sin tratar	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	Acero de alta aleación Recocido	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

SPA

CoroDrill® DS20

4-5xD

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD			Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance									
P	P3.0.Z.HT	Acero de alta aleación	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**	-
		Endurecido y templado		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	Acero inoxidable ferrítico/ martensítico	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
		Recocido		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	Acero inoxidable ferrítico/ martensítico	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
		Endurecido y templado		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	Acero inoxidable austenítico	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
		Recocido/revenido		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	Acero inoxidable austenítico	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
		Maquinabilidad optimizada		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	Acero inoxidable súper austenítico (Ni>20%)	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
		Recocido/revenido						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	Acero inoxidable dúplex	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
		>60% ferrita (N<0.10%)		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	Acero inoxidable dúplex	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
		<60% ferrita (N>0.10%)		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	Superaleaciones termorresistentes	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	-	-
	S2.0.Z.AG	Con base Ni		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	-	-
	S2.0.Z.NS			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	Superaleaciones termorresistentes	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	-	-
	S4.3.Z.AG	Con base de Ti		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

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD			Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance									
K	K1.1.C.NS	Fundición maleable	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**	-
		Baja resistencia a la tracción		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	Fundición gris	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**	-
		Baja resistencia a la tracción		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	Fundición gris	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**	-
		Alta resistencia a la tracción		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	Fundición nodular	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**	-
		Ferrítica		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	Fundición nodular	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**	-
		Perlítica		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	Fundición de grafito compactado	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**	-
		Gran resistencia a la tracción (Perlita>90%)		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	Aceros extraduros	60	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	-
		Endurecido y templado	(HRC)	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	-

SANDVIK Coromant

SPA

CoroDrill® DS20

4-5xD

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD			Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance									
N	N1.2.Z.AG	Aleaciones con base de aluminio Aleaciones AlSi, Si ≤ 1%	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	-	-
				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	Aleaciones con base de aluminio Aleaciones de fundición AlSi (1% < Si < 13%)	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	-	-
				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	Aleaciones con base de aluminio AlSi cast and aged alloys (1%< Si <13%)	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	-	-
				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	Aleaciones con base de cobre Aleaciones fáciles de mecanizar con base de cobre	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	-	-
				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	Aleaciones con base de cobre Latón y bronces al plomo (Pb<1%)	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	-	-
				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

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD Mín.	Rec.	Máx.	Diámetro de taladrado	Longitud de taladrado 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de taladrado 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance									
P									f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.	f_n mm/rev.
	P1.0.Z.AN	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado Fundición - sin tratar	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	Acero de baja aleación Recocido	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	Acero de baja aleación Recocido	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	Acero de baja aleación Endurecido y templado	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	Acero de baja aleación Fundición - sin tratar	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	Acero de alta aleación Recocido	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**	-

El avance a la entrada del agujero debe ser el 75% de la velocidad de avance. Para el avance a la salida del agujero, utilice 0.05 mm/rev.

SANDVIK Coromant

SPA

CoroDrill® DS20

6-7xD

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD			Diámetro de taladrado	Longitud de taladrado 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de taladrado 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance									
P	P3.0.Z.HT	Acero de alta aleación	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**	-
		Endurecido y templado		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	Acero inoxidable ferrítico/ martensítico	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
		Recocido		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	Acero inoxidable ferrítico/ martensítico	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
		Endurecido y templado		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	Acero inoxidable austenítico	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
		Recocido/revenido		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	Acero inoxidable austenítico	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
		Maquinabilidad optimizada		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	Acero inoxidable súper austenítico (Ni>20%)	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
		Recocido/revenido						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	Acero inoxidable dúplex	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
		>60% ferrita (N<0.10%)		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	Acero inoxidable dúplex	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
		<60% ferrita (N>0.10%)		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	Superaleaciones termorresistentes	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	-	-
	S2.0.Z.AG	Con base Ni		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	-	-
	S2.0.Z.NS			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	Superaleaciones termorresistentes	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	-	-
	S4.3.Z.AG	Con base de Ti		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	-	-

El avance a la entrada del agujero debe ser el 75% de la velocidad de avance. Para el avance a la salida del agujero, utilice 0.05 mm/rev.

CoroDrill® DS20

6-7xD

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD			Diámetro de taladrado	Longitud de taladrado 6xD Valor inicial recomendado en la mitad del rango de avance					Longitud de taladrado 7xD Valor inicial recomendado en la mitad del rango de avance				
									-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
K	K1.1.C.NS	Fundición maleable	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**	-
		Baja resistencia a la tracción		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	Fundición gris	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**	-
		Baja resistencia a la tracción		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	Fundición gris	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**	-
		Alta resistencia a la tracción		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	Fundición nodular	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**	-
		Ferrítica		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	Fundición nodular	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**	-
		Perlítica		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	Fundición de grafito compactado	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**	-
		Gran resistencia a la tracción (Perlita>90%)		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	Aceros extraduros	60	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**	-
		Endurecido y templado	(HRC)	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**	-

El avance a la entrada del agujero debe ser el 75% de la velocidad de avance. Para el avance a la salida del agujero, utilice 0.05 mm/rev.

SPA

CoroDrill® DS20

6-7xD

Valores métricos

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD			Diámetro de taladrado	Longitud de taladrado 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de taladrado 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance									
N	N1.2.Z.AG	Aleaciones con base de aluminio Aleaciones AlSi, Si ≤ 1%	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	-	-
				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	Aleaciones con base de aluminio Aleaciones de fundición AlSi (1% < Si < 13%)	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	-	-
				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	Aleaciones con base de aluminio AlSi cast and aged alloys (1%< Si <13%)	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	-	-
				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	Aleaciones con base de cobre Aleaciones fáciles de mecanizar con base de cobre	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	-	-
				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	Aleaciones con base de cobre Latón y bronces al plomo (Pb<1%)	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	-	-
				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	-	-

El avance a la entrada del agujero debe ser el 75% de la velocidad de avance. Para el avance a la salida del agujero, utilice 0.05 mm/rev.

CoroDrill® DS20

4-5xD

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD Mín.	Rec.	Máx.	Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
									fz pulg./rev	fz pulg./rev	fz pulg./rev	fz pulg./rev	fz pulg./rev	fz pulg./rev	fz pulg./rev	fz pulg./rev	fz pulg./rev	fz pulg./rev
P	P1.0.Z.AN	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado Fundición - sin tratar	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	Acero de baja aleación Recocido	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	Acero de baja aleación Recocido	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	Acero de baja aleación Endurecido y templado	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	Acero de baja aleación Fundición - sin tratar	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	Acero de alta aleación Recocido	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

SPA

CoroDrill® DS20

4-5xD

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD			Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
P	P3.0.Z.HT	Acero de alta aleación	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**	-
		Endurecido y templado		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	Acero inoxidable ferrítico/ martensítico	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
		Recocido		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	Acero inoxidable ferrítico/ martensítico	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
		Endurecido y templado		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	Acero inoxidable austenítico	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
		Recocido/revenido		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	Acero inoxidable austenítico	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
		Maquinabilidad optimizada		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	Acero inoxidable súper austenítico (Ni>20%)	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
		Recocido/revenido						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	Acero inoxidable dúplex	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
		>60% ferrita (N<0.10%)		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	Acero inoxidable dúplex	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
		<60% ferrita (N ≥ 0.10%)		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	Superaleaciones termorresistentes	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	-	-
	S2.0.Z.AG	Con base Ni		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	-	-
	S2.0.Z.NS			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	Superaleaciones termorresistentes	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	-	-
	S4.3.Z.AG	Base de Ti		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

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD			Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
K	K1.1.C.NS	Fundición maleable Baja resistencia a la tracción	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	Fundición gris Baja resistencia a la tracción	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	Fundición gris Alta resistencia a la tracción	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	Fundición nodular Ferrítica	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	Fundición nodular Ferrítica	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	Fundición de grafito compactado Alta resistencia a la tracción	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	Acero extraduro Endurecido y templado	60	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	-
			(HRC)	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	-

SPA

CoroDrill® DS20

4-5xD

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 4-5xD			Diámetro de taladrado	Longitud de broca 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de broca 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
N	N1.2.Z.AG	Aleaciones con base de aluminio Aleaciones AlSi, Si ≤ 1%	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	-	-
				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	Aleaciones con base de aluminio Aleaciones AlSi, Si ≤ 1%	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	-	-
				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	Aleaciones con base de aluminio AlSi cast and aged alloys (1%< Si <13%)	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	-	-
				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	Aleaciones con base de cobre Aleaciones fáciles de mecanizar con base de cobre	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	-	-
				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	Aleaciones con base de cobre Latón con plomo y bronces (Pb ≤ 1%)	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	-	-
				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

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD Mín.	Rec.	Máx.	Diámetro de taladrado	Longitud de taladrado 6xD -S5W fn inch/rev	-L5W fn inch/rev	-L6W fn inch/rev	-M7W fn inch/rev	-H5W fn inch/rev	Longitud de taladrado 7xD -S5W fn inch/rev	-L5W fn inch/rev	-L6W fn inch/rev	-M7W fn inch/rev	-H5W fn inch/rev
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
P																		
	P1.0.Z.AN	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado 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	Acero no aleado Fundición - sin tratar	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	Acero de baja aleación Recocido	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	Acero de baja aleación Recocido	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	Acero de baja aleación Endurecido y templado	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	Acero de baja aleación Fundición - sin tratar	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	Acero de alta aleación Recocido	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**	-

SANDVIK Coromant

SPA

CoroDrill® DS20

6-7xD

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD			Diámetro de taladrado	Longitud de taladrado 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de taladrado 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
P	P3.0.Z.HT	Acero de alta aleación	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**	-
		Endurecido y templado		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	Acero inoxidable ferrítico/ martensítico	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
		Recocido		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	Acero inoxidable ferrítico/ martensítico	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
		Endurecido y templado		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	Acero inoxidable austenítico	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
		Recocido/revenido		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	Acero inoxidable austenítico	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
		Maquinabilidad optimizada		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	Acero inoxidable súper austenítico (Ni>20%)	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
		Recocido/revenido						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	Acero inoxidable dúplex	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
		>60% ferrita (N<0.10%)		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	Acero inoxidable dúplex	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
		<60% ferrita (N ≥ 0.10%)		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	Superaleaciones termorresistentes	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	-	-
	S2.0.Z.AG	Con base Ni		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	-	-
	S2.0.Z.NS			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	Superaleaciones termorresistentes	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	-	-
	S4.3.Z.AG	Base de Ti		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	-	-

El avance a la entrada del agujero debe ser el 75% de la velocidad de avance. Para el avance a la salida del agujero, utilice 0.002 pulgadas/rev.

CoroDrill® DS20

6-7xD

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD			Diámetro de taladrado	Longitud de taladrado 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de taladrado 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
K	K1.1.C.NS	Fundición maleable Baja resistencia a la tracción	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**	-
				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	Fundición gris Baja resistencia a la tracción	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**	-
				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	Fundición gris Alta resistencia a la tracción	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**	-
				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	Fundición nodular Ferrítica	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**	-
				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	Fundición nodular Ferrítica	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**	-
				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	Fundición de grafito compactado Alta resistencia a la tracción	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**	-
				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	Acero extraduro Endurecido y templado	60	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	-
			(HRC)	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	-

El avance a la entrada del agujero debe ser el 75% de la velocidad de avance. Para el avance a la salida del agujero, utilice 0.002 pulgadas/rev.

SANDVIK Coromant

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CoroDrill® DS20

6-7xD

Valores en pulgadas

ISO	Núm. MC	Material	HB	Calidad	Recomendaciones de velocidad de corte 6-7xD			Diámetro de taladrado	Longitud de taladrado 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Longitud de taladrado 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Valor inicial recomendado en la mitad del rango de avance					Valor inicial recomendado en la mitad del rango de avance				
N	N1.2.Z.AG	Aleaciones con base de aluminio Aleaciones AlSi, Si ≤ 1%	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	-	-
				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	Aleaciones con base de aluminio Aleaciones AlSi, Si ≤ 1%	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	-	-
				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	Aleaciones con base de aluminio AlSi cast and aged alloys (1%< Si <13%)	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	-	-
				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	Aleaciones con base de cobre Aleaciones fáciles de mecanizar con base de cobre	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	-	-
				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	Aleaciones con base de cobre Latón con plomo y bronces (Pb ≤ 1%)	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	-	-
				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	-	-

El avance a la entrada del agujero debe ser el 75% de la velocidad de avance. Para el avance a la salida del agujero, utilice 0.002 pulgadas/rev.

Seleccionar sus datos de corte

La formación y la evacuación de la viruta son factores críticos en taladrado y dependen del material de la pieza, la elección de la geometría de la plaquita/broca, el volumen y la presión de refrigerante y los datos de corte. El atasco de la viruta puede provocar el desplazamiento radial de la broca y, por consiguiente, afectar a la calidad del agujero, la vida útil y la fiabilidad de la broca, o provocar la rotura de brocas/plaquitas.

Se considera que la formación de viruta es aceptable cuando es posible evacuar la viruta de la broca sin perturbaciones. El mejor modo de identificarlo es escuchar durante el taladrado. Un sonido homogéneo significa que la evacuación de la viruta es buena, pero un sonido intermitente indica que la viruta se atasca. Compruebe la fuerza de avance o el monitor de potencia. Si existen irregularidades, el atasco de la viruta podría ser el motivo. Observe la viruta: si es larga y está doblada, en lugar de enroscada, se ha producido algún atasco. Observe el agujero: si se ha producido atasco de viruta, se apreciará una superficie irregular.

Efectos de la velocidad de corte: v_c

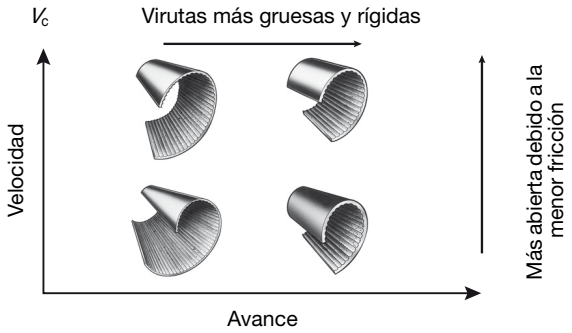
Velocidad de corte demasiado alta:
Rápido desgaste en incidencia
Deformación plástica
Calidad y tolerancia del agujero deficientes

Velocidad de corte demasiado baja:
Filo de aportación
Evacuación deficiente de la viruta
Mayor tiempo de corte

Efectos de la velocidad de avance: f_n

Alta velocidad de avance:
Rotura de la viruta más difícil
Menor tiempo de corte
Menor desgaste de la herramienta, pero mayor riesgo de rotura de la broca
Calidad del agujero reducida

Baja velocidad de avance:
Preferible para materiales de viruta larga
Mejora de la calidad
Desgaste acelerado de la herramienta
Mayor tiempo de corte



Alcanzar agujeros de buena calidad

Evacuación de la viruta
Compruebe que la evacuación de la viruta sea la adecuada. El atasco de viruta afecta a la calidad del agujero y a la fiabilidad/vida útil de la herramienta. La geometría de la plaquita o broca y los datos de corte son cruciales.

Estabilidad, reglaje de la herramienta
Utilice la broca más corta posible. Utilice un portaherramientas rígido y preciso con una desviación mínima. Asegúrese de que el husillo de la máquina esté en buenas condiciones y bien alineado. Compruebe que la pieza esté fija y estable. Defina la velocidad de avance correcta para superficies irregulares y en ángulo y agujeros cruzados.

Duración de la herramienta
Compruebe el desgaste de la plaquita y defina un programa predeterminado de vida útil de la herramienta. La forma más eficaz de supervisar el taladrado es utilizar un monitor de fuerza de avance.

Mantenimiento
Cambie con regularidad el tornillo de sujeción de la plaquita. Limpie el asiento de la punta antes de cambiar la plaquita y asegúrese de usar una llave dinamométrica. No supere el desgaste máximo antes de rectificar las brocas enterizas de metal duro.

Taladrado de agujeros profundos con CoroDrill® DS20
Si necesita alcanzar la mejor calidad del agujero al taladrar agujeros de 6-7xD con CoroDrill DS20, es importante utilizar una velocidad de avance reducida a la entrada (primeros 1-2 mm) (.039-.787 pulg.) y a la salida (últimos 5 mm) (.197 pulg.).

Mandrinado

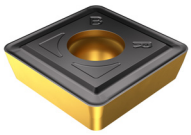
Mandrinado en desbaste

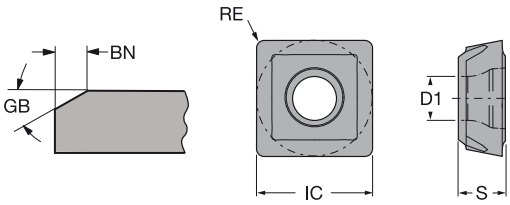
Plaquitas CoroBore® 111 para mandrinado en desbaste D2

Para ver la gama completa, consulte www.sandvik.coromant.com/es

Plaquitas CoroBore® 111 para mandrinado en desbaste

Plaquita tipo S (Cuadrada)





			S	RE	BSR	GB	BN	CÓDIGO ISO	P 4425
Desbaste	BR	06	2.60	0.60	5.0	5°	0.10	SPMT0606-BR	★
			.102	*.024*	*.197*	*5°*	*.004*		
		08	3.00	0.80	5.0	5°	0.10	SPMT0808-BR	★
			.118	*.031*	*.197*	*5°*	*.004*		
		12	4.00	1.20	5.0	5°	0.15	SPMT1212-BR	★
			.157	*.047*	*.197*	*5°*	*.006*		
		18	5.50	1.20	5.0	5°	0.15	SPMT1812-BR	★
			.217	*.047*	*.197*	*5°*	*.006*		

Adaptadores de herramientas rotativas

Adaptador de máquina Coromant Capto®

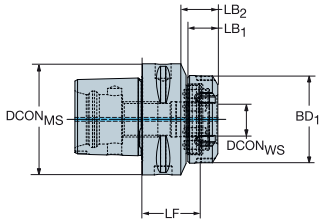
Coromant Capto® a MDI, adaptador E2

Adaptador de máquina HSK

HSK a MDI, adaptador E3

Para ver la gama completa, consulte www.sandvik.coromant.com/es

Coromant Capto® a MDI, adaptador



					Dimensiones, mm, pulg.										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Código de pedido**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BAR PSI	NM	KG	RPMX
C8	MDI-25	3	1	**C8-DM25-N-042**	80.0	25.0	42.0	17.0	52.0	62.7	80	170.0	2.08	14000
					3.150	*.984*	*1.654*	*.669*	*2.047*	*2.469*	*1160*			

Para obtener información sobre piezas de repuesto, visite www.sandvik.coromant.com/es

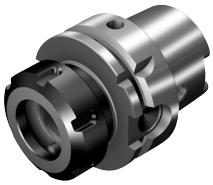
ISO 13399 F2

CNSC CXSC F5

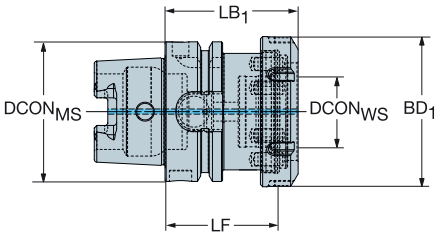
SPA

HSK a MDI, adaptador

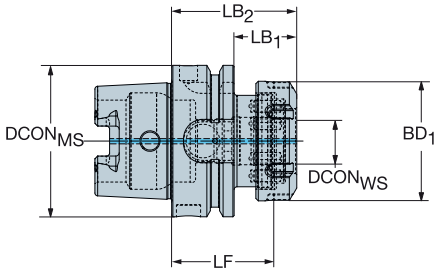
Adaptador del lado de la máquina HSK A/C/T



DSGN 1



2



Agujero métrico

						Dimensiones, mm, pulg.										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Código de pedido**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR PSI	NM	KG	RPMX
63.0	MDI-40	1	1	1	**HT06-DM40-N-061**	63.0	40.0	61.0	73.0		79.7		80	230.0	1.51	20500
						2.480	*1.575*	*2.402*	*2.874*		*3.138*		*1160*			
100.0	MDI-25	1	1	2	**HT10-DM25-N-048**	100.0	25.0	48.0	29.0	58.0	62.7	100.0	80	170.0	2.37	12500
						3.937	*.984*	*1.890*	*1.142*	*2.283*	*2.469*	*3.937*	*1160*			
	MDI-32	1	1	2	**HT10-DM32-N-048**	100.0	32.0	48.0	29.0	58.0	67.7	100.0	80	200.0	2.40	12500
						3.937	*1.260*	*1.890*	*1.142*	*2.283*	*2.665*	*3.937*	*1160*			
	MDI-40	1	1	2	**HT10-DM40-N-048**	100.0	40.0	48.0	31.0	60.0	79.7	100.0	80	230.0	2.60	12500
						3.937	*1.575*	*1.890*	*1.220*	*2.362*	*3.138*	*3.937*	*1160*			
	MDI-50	1	1	2	**HT10-DM50-N-055**	100.0	50.0	55.0	40.0	69.0	94.7	100.0	80	250.0	3.15	12500
						3.937	*1.969*	*2.165*	*1.575*	*2.717*	*3.728*	*3.937*	*1160*			

Para obtener información sobre piezas de repuesto, visite www.sandvik.coromant.com/es

F2 F5

Información general

ISO 13399 F2

Información sobre el suministro de refrigerante F5

Reacondicionamiento F6

Información de seguridad F7

Concepto Coromant para Reciclado (CRC) F8

ISO 13399 es un estándar internacional cuyo objetivo es simplificar el intercambio de datos para herramientas de corte. Por ello, notará una ligera diferencia en los nuevos parámetros y descripciones de cada herramienta.

Por primera vez en la historia disponemos de una forma normalizada para describir los datos relativos a las herramientas de corte disponibles. Cuando todas las herramientas de la industria comparten los mismos parámetros y definiciones, la comunicación de la información de las herramientas entre distintos sistemas de software pasa a ser un proceso muy sencillo.

B

¿Qué significa esto para usted?

Básicamente, quiere decir que sus sistemas y los nuestros podrán comunicarse sin ningún tipo de barrera gracias a que compartirán un mismo idioma. Descárguese la información de los productos de nuestra página web y utilícela directamente en su software CAD/ CAM para montar las herramientas que utiliza en su producción. No necesitará buscar información en catálogos ni interpretar datos para pasar de un sistema a otro. ¡Imagine cuánto tiempo ahorrará!

C

D

E

F

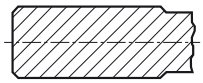
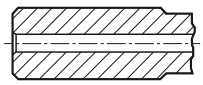
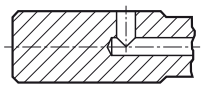
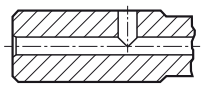
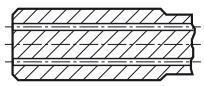
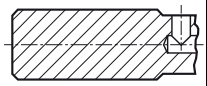
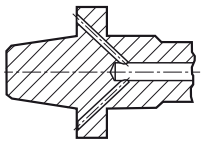
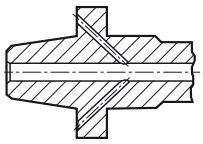
Abreviatura	Nombre
ADJLN	Límite de ajuste mínimo
ADJLX	Límite de ajuste máximo
ADJRG	Intervalo de ajuste
ALP	Ángulo de incidencia axial
AN	Ángulo de incidencia mayor
ANN	Ángulo de incidencia menor
APMX	Profundidad de corte máxima
APMX_EFW	Profundidad de corte máxima - avance final
APMX_FFW	Profundidad de corte máxima - avance lateral
AZ	Profundidad de avance axial máxima
B	Anchura de mango
BAWS	Ángulo de cuerpo del lado de la pieza
BAMS	Ángulo del cuerpo del lado de la máquina
BBD	Equilibrado por diseño
BBR	Equilibrado por prueba de rotación
BCH	Longitud del chaflán del vértice
BD	Diámetro del cuerpo
BHTA	Ángulo de conicidad del cuerpo
BN	Anchura de la faceta frontal
BS	Longitud del filo Wiper
BSG	Grupo estándar básico
BSR	Radio del filo wiper
CBMD	Fabricante del rompevirutas
CDX	Profundidad de corte máxima
CEMR	Radio mayor del filo de corte
CF	Chaflán de punto
CHBA	Ángulo del chaflán del cuerpo
CHBL	Longitud del chaflán del cuerpo
CHW	Anchura del chaflán del vértice
CICT	Número de elementos de corte
$CICT_{BALL}$	Número de artículos de corte - plaquita de punta esférica
$CICT_{E}$	Número de elementos de corte - posición final
$CICT_{P}$	Número de elementos de corte - posición periférica
$CICT_{S}$	Número de elementos de corte - posición lateral
$CICT_{SP}$	Número de artículos de corte - plaquita de protección del mango
$CICT_{T}$	Número de elementos de corte - total
CND	Diámetro de la entrada de refrigerante
CNSC	Código del tipo de entrada de refrigerante
CNT	Tamaño de la rosca de entrada de refrigerante
COATING	Recubrimiento
CP	Presión de refrigerante máx.
CRKS	Tamaño de la rosca del tirador de retención de la conexión
CRNT	Tamaño de la rosca de la entrada de refrigerante radial
CTPT	Tipo de operación
CUTDIA	Diámetro de tronzado de pieza máximo
CW	Anchura de corte
CWN	Anchura de corte mínima
CWTOLL	Tolerancia inferior de la anchura de corte
CWTOLU	Tolerancia superior de la anchura de corte
CWX	Anchura de corte máxima
CXSC	Código del tipo de salida de refrigerante
CZC	Código de tamaño de conexión
CZC_{MS}	Código del tamaño de la conexión del lado de la máquina
CZC_{WS}	Código del tamaño de la conexión del lado de la pieza
D1	Diámetro del agujero de fijación
DAH	Diámetro del agujero de acceso
DAXIN	Diámetro interior mínimo de la ranura axial
DAXN	Diámetro exterior mínimo de ranura axial

DAXX	Diámetro exterior mínimo de la ranura axial
DBC	Diámetro del agujero de fijación
DC	Diámetro de corte
DCB	Diámetro del agujero de conexión
DCBN	Diámetro del agujero de conexión mínimo
DCBX	Diámetro del agujero de conexión máximo
DCF	Contacto frontal del diámetro de corte
DCIN	Diámetro de corte interior
DCN	Diámetro de corte mínimo
DCON	Diámetro de conexión
$DCON_{MS}$	Diametro de conexión del lado de la maquina
$DCON_{WS}$	Diámetro de conexión del lado de la pieza
$DCONN_{WS}$	Diámetro de conexión mínimo del lado de la pieza
$DCONX_{WS}$	Diámetro de conexión máximo del lado de la pieza
DCPS	Capacidad del chip de datos
$DCSF_{MS}$	Diámetro de superficie de contacto del lado de la máquina
$DCSF_{WS}$	Diámetro de superficie de contacto, lado de la pieza
DCX	Diámetro de corte máximo
DHUB	Diámetro de cubo
DIX	Diámetro de interferencia máximo del cambiador de herramientas
DMIN	Diámetro de agujero mínimo
DMM	Diámetro del mango
DN	Diámetro del cuello
DRVCT	Número de arrastres
DSGN	Diseño
EPSR	Ángulo con plaquita incluida
FHA	Ángulo helicoidal de la ranura
FLGT	Grosor de la brida
FTDZ	Para tamaño del diámetro de la rosca
GB	Ángulo de la faceta frontal
H	Altura del mango
HA	Altura teórica de la rosca
HB	Diferencia de la altura de la rosca
HBH	Altura de desajuste de base a cabeza
HC	Altura real de la rosca
HF	Altura funcional
HRY	Punto más bajo desde el plano de referencia
HSUP	Altura de soporte
HTB	Altura del cuerpo
HTH	Altura
IC	Diámetro de la circunferencia inscrita
INSL	Longitud de la plaquita
INSUC	Código de utilización de la plaquita
IZC	Código de tamaño de plaquita
KAPR	Ángulo del filo de corte de la herramienta
KAPR_EFW	Ángulo del filo de la herramienta - avance final
KCH	Chaflán del vértice
KRINS	Ángulo del filo mayor
KWW	Anchura del chavetero
L	Longitud del filo de corte
LAMS	Ángulo de inclinación
LB	Longitud del cuerpo
LCF	Longitud de la ranura para viruta
LCOX	Longitud máxima de tronzado
LE	Longitud efectiva del filo
LF	Longitud funcional
LFN	Longitud funcional mínima
LH	Longitud de la cabeza
LPR	Longitud saliente
LS	Longitud del mango
LSC	Longitud de sujeción
LSCN	Longitud de sujeción mínima
LSCS	Distancia hasta el inicio de la sujeción
LSCX	Longitud de sujeción máxima
LSD	Longitud exacta del mango
LU	Longitud útil (máx. recomendada)
LU_BFW	Longitud útil - refrentado inverso
LUX	Longitud utilizable máxima
MHD	Distancia del agujero de montaje
MIID	Identificación de la plaquita maestra
$MIID_E$	Identificación de plaquita principal - posición final
$MIID_S$	Identificación de plaquita principal - posición lateral
$MIID_C$	Identificación de plaquita principal - posición central
$MIID_P$	Identificación de plaquita principal - posición periférica
$MIID_I$	Identificación de plaquita principal - posición intermedia
MMCC	Código del par pre-reglado
MMCX	Par de corte máx.
NOF	Número de ranuras
NT	Número de dientes
OAH	Altura global
OAL	Longitud global
OAW	Anchura global
OH	Voladizo recomendado
OHN	Voladizo mínimo

OHX	Voladizo máximo
ORDCODE	Código de pedido
PCL	Longitud cilíndrica periférica
PDX	Distancia ex del perfil
PDY	Distancia ey del perfil
PHD	Diámetro del agujero premecanizado
PHDX	Diámetro de agujero premecanizado máximo
PL	Longitud de punta
PNA	Ángulo con perfil incluido
PRFRAD	Radio del perfil
PRSPC	Especificación del perfil
PSIR	Ángulo de posición de la herramienta
PSIRL	Ángulo del filo mayor a izquierda
PSIRR	Ángulo del filo mayor a derecha
PSW	Anchura de ranura premecanizada
RADH	Altura radial del cuerpo
RADW	Anchura radial del cuerpo
RAR	Ángulo de relieve a derecha
RE	Radio de punta
REEQ	Equivalente del radio de punta
REL	Radio de punta izquierdo
RER	Radio de punta derecho
RETOLL	Tolerancia inferior del radio de punta
RETOLU	Tolerancia superior del radio de punta
RGL	Longitud de rectificado
RMPX	Ángulo de mecanizado en rampa máximo
RPMX	Velocidad de rotación máxima
S	Grosor de la plaquita
SDL	Longitud del diámetro del paso
SIG	Ángulo de punta
SPTL	Línea divisoria
SSC	Código del tamaño del alojamiento de la plaquita
SSC_E	Código del tamaño del alojamiento - posición final
SSC_P	Código del tamaño del alojamiento - posición periférica
SSC_S	Código del tamaño del alojamiento - posición lateral
STA	Ángulo con paso incluido
STDNO	Número estándar
SUBSTRATE	Sustrato
TCDC	Clase de tolerancia del diámetro de corte
TCDCON	Tolerancia de diámetro de conexión
TCDMM	Tolerancia del diámetro del mango
TCHA	Tolerancia de agujero posible
TCHAL	Tolerancia de agujero posible inferior
TCHAU	Tolerancia de agujero posible superior
TCT	Clase de tolerancia de la herramienta
TCTR	Clase de tolerancia de la rosca
TD	Diámetro de la rosca
TDZ	Tamaño del diámetro de la rosca
TFLA	Longitud frontal flotante del macho
TFLB	Longitud trasera flotante del macho
TG	Gradiente de conicidad
THBTP	Propiedad de rosca de cono posterior
THCA	Ángulo de corrección de la hélice de la rosca
THCHT	Tipo de chaflán de rosca
THFT	Tipo de la forma
THFTS	Serie estándar de la forma de la rosca
THL	Longitud de la rosca
THUB	Grosor del cubo
TP	Paso de la rosca
TPI	Roscas por pulgada
TPIN	Roscas por pulgada, mínimo
TPIX	Roscas por pulgada, máximo
TPN	Paso de rosca mínimo
TPT	Tipo de perfil de rosca
TPX	Paso de rosca, máximo
TRMAX	Rango de macho máx.
TQ	Par
TSYC	Código de tipo de herramienta
TTP	Tipo de rosca
ULDR	Proporción del diámetro de longitud útil
VCX	Velocidad de corte máxima
W1	Anchura de la plaquita
WB	Anchura del cuerpo
WF	Anchura funcional
WFCIRP	Anchura hasta el punto de referencia del elemento de corte
WSC	Anchura de sujeción
WT	Peso del artículo
ZADJ	Número de plaquitas ajustables
ZEFF	Número de filos efectivos por lado
ZEFP	Recuento de filos de corte periféricos efectivos (ZEFP)
ZWX	Número máximo de plaquitas Wiper

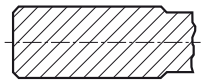
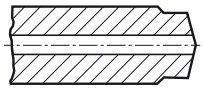
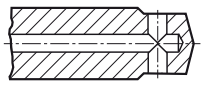
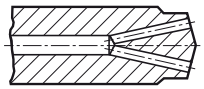
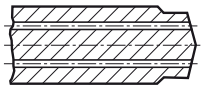
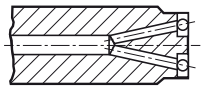
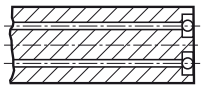
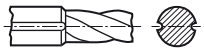
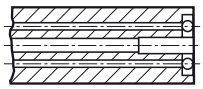
CNSC

Código del tipo de entrada de refrigerante

Código	Descripción	Imagen
0	Sin refrigerante	
1	Entrada concéntrica axial	
2	Entrada radial	
3	Entrada concéntrica axial y entrada radial	
4	Entrada concéntrica axial en círculo	
5	Entrada radial antes del adaptador	
6	Descentralizado sobre la brida	
7	Descentralizado sobre la brida y axial	
8	Descentralizado sobre las ranuras del mango	

CXSC

Código del tipo de salida de refrigerante

Código	Descripción	Imagen
0	Sin salida de refrigerante	
1	Salida concéntrica axial	
2	Salida radial	
3	Salida inclinada axial	
4	Concéntrica axial en círculo	
5	Salida inclinada axial con boquilla, ajustable	
6	Salida descentralizada con boquilla, ajustable	
7	Descentralizado sobre las ranuras del mango	
8	Salida axial o descentralizada con boquilla, ajustable	

Reacondicionamiento

Ofrecemos mucho más que un «rectificado tradicional. Con nuestro servicio de reacondicionado, garantizamos el rendimiento original una y otra vez para reducir sus costes por aplicación.

B

Nuestra oferta

100%

Fiabilidad
Nuestros especialistas están disponibles para proporcionarle soporte y conocimientos.

x3

Rendimiento original
La calidad original de la herramienta está garantizada hasta tres veces.

50%

Reducción
El reacondicionado le permite reducir sus costes de herramienta hasta un 50 %.

C

Productos incluidos

Taladrado

Fresado

Escariado

Como indica el símbolo de reacondicionado en las páginas de la gama y el producto.

D

Información adicional

E

Caja de reacondicionado
La caja está disponible en dos tamaños
- Pequeña (300 x 200 x 138 mm)
Número de artículo: 6949557

- Mediana (400 x 300 x 138 mm)
Número de artículo: 6949558

Todas las herramientas de Sandvik Coromant pueden enviarse en la misma caja.

Servicio de reacondicionamiento
- - Antes del reacondicionado, una inspección determinará si su herramienta puede reacondicionarse. Las herramientas que no puedan reacondicionarse le serán devueltas

- Un marcado láser en el mango de la herramienta indica cada servicio de reacondicionado realizado

- Las herramientas se suministran en su embalaje original

¿Qué sucede con sus herramientas?
- - Restauración total de la geometría

- Reducción de la longitud de la broca

- Reducción del diámetro y longitud de la fresa de ranurar (Diámetro mínimo de en torno a 0.9xDc)

- La tolerancia del diámetro del escariador se mantiene

F

Para obtener información sobre los precios, póngase en contacto con su representante de Sandvik Coromant más cercano.

SPA

Información de seguridad respecto al rectificado de metal duro

Composición de los materiales

La mayoría de los productos de metal duro contienen carburo de tungsteno y cobalto. Otras sustancias pueden contener carburo de titanio, carburo de tantalio, carburo de niobio, carburo de cromo, carburo de molibdeno o carburo de vanadio. Algunas calidades contienen carbonitruro de titanio y/o de níquel.

Vías de exposición

Al rectificar o calentar una barrita o un producto de metal duro, se producirá polvo o humo con sustancias peligrosas que pueden ser inhaladas o ingeridas, o que pueden entrar en contacto con la piel o los ojos.

Toxicidad aguda

La inhalación o ingesta de dichas sustancias es tóxica. La inhalación puede ocasionar irritación e inflamación de las vías respiratorias. La inhalación simultánea de carburos de cobalto y tungsteno ha dado lugar a una toxicidad por inhalación mucho más elevada que la inhalación sólo de cobalto.
El contacto con la piel puede producir irritación y prurito. Las personas sensibilizadas pueden sufrir una reacción alérgica.

Toxicidad crónica

La inhalación repetida de aerosoles con contenido en cobalto puede ocasionar obstrucción de las vías respiratorias. La inhalación prolongada de concentraciones crecientes puede producir fibrosis o cáncer de pulmón. Los estudios epidemiológicos indican que los trabajadores expuestos anteriormente a concentraciones elevadas de carburo de tungsteno/cobalto tienen mayor riesgo de desarrollar cáncer de pulmón.
El cobalto y el níquel son sensibilizadores potenciales. Un contacto prolongado o repetido puede provocar irritación.

Riesgos

Tóxico: riesgo de daños graves para la salud por exposición prolongada a su inhalación
Tóxico por inhalación
Evidencia limitada de efecto carcinógeno.
Puede producir sensibilización por inhalación y contacto con la piel

Medidas preventivas

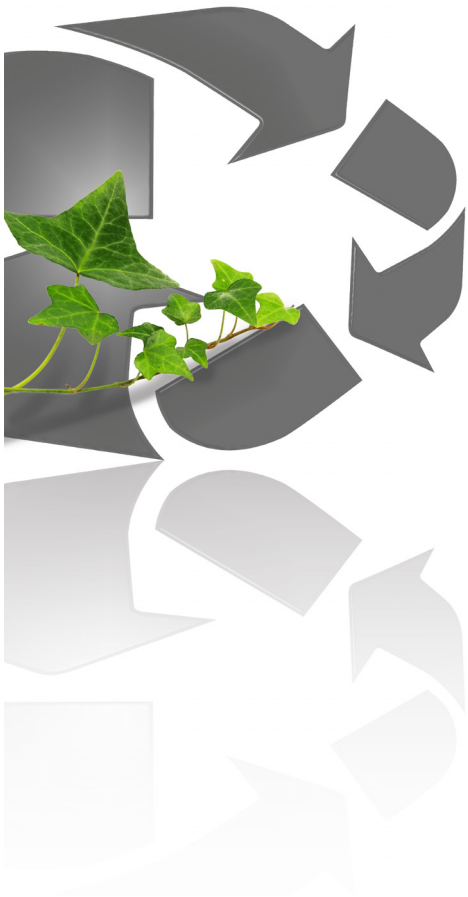
Evite la formación e inhalación de polvo. Utilice un sistema local de ventilación adecuado para mantener la exposición del personal por debajo de los límites nacionales autorizados.
Si no se puede proveer de una buena ventilación, o ésta no es adecuada, utilice respiradores aprobados para este fin.
Utilice gafas de seguridad con protectores laterales cuando sea necesario.
Evite un contacto repetido con la piel. Utilice guantes de protección adecuados. Lávese a fondo la parte en contacto con el material después de su manipulación.
Utilice equipo de protección adecuado. Lave la ropa siempre que sea necesario.
No consuma alimentos ni bebidas ni fume en el área de trabajo. Lávese a fondo antes de comer, beber o fumar.

Por el bien del medio ambiente

Haga suyo el concepto de Coromant Para Reciclado (CRC).

B

El concepto Coromant para Reciclado (CRC) es un servicio completo de recogida de plaquitas de metal duro usadas que Sandvik Coromant ofrece a todos sus clientes. A la vista del creciente uso de materias primas no renovables, el uso responsable de unos recursos cada vez más escasos es una responsabilidad ineludible para todos los fabricantes.
Por ello, Sandvik Coromant pone su grano de arena con su servicio de recogida de plaquitas y herramientas de metal duro usadas, para posteriormente reciclarlas de la manera más respetuosa con el medio ambiente.
Todas las plaquitas de metal duro usadas se recogen en la caja de acopio del taller. Cuando se llena dicha caja, se transfiere su contenido a otra caja de transporte, que se envía a la oficina de Sandvik Coromant más cercana o se entrega a su contacto Coromant habitual, quien también puede facilitarle más información.



C

Las ventajas del CRC son evidentes

- Un sistema de reciclado internacional unificado.
- Para clientes directos y comerciales.
- Un procedimiento sencillo con cajas de acopio y transporte.
- Menos residuos, más respetuoso con el medio ambiente.
- Un mejor uso de los recursos.
- Se aceptan también plaquitas de metal duro de otros fabricantes.

D

E

Solicite cajas de acopio para cada torno, máquina fresadora, taladradora o centro de mecanizado. Le recomendamos que coloque una caja de acopio para las plaquitas y otra para las herramientas de metal duro en cada puesto de trabajo.

F

	Números de pedido
Caja de acopio:	91617
Caja de transporte para herramientas de metal duro (madera):	92994
Caja de transporte para plaquitas (madera):	92995