Small part machining

GENERAL TURNING | PARTING AND GROOVING | THREADING | MILLING | DRILLING
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Introduction

When you face the task of producing thousands upon thousands of small and tricky parts, Sandvik Coromant has the tools to tackle the job. This brochure guides you through our comprehensive range of high precision tools for machining components up to diameter 40 mm (1.5 inch), manufactured in sliding head machines. So regardless of needs or machining requirements, you can rely on easily finding a tool that fits your specific component and application.

www.sandvik.coromant.com

For more information about our tools, cutting data or ordering visit our website. Simply scan the QR code or type in the web address found on each page.
Sometimes that exact dimension you require might be missing. If so, simply turn to our Tailor Made service. Tailor Made gives tooling options designed for your specific component manufacturing needs, without having to wait for an engineered solution.

On our website you find a small part machining section with products, solutions, tips and knowledge, just a click away!
Sliding head machines offer several axes, front end and back end machining with turning tools and rotating tools. The machines are optimized for productive machining of precision components up to 40 mm (1.5 inch) in diameter in large batches.

ISO application area

- Steels = P
- Stainless steels = M
- Non-ferrous materials = N
- Heat resistant super alloys = S

These are the material groups machined in sliding head machines, hence the ones included in this brochure.
The guide bushing
In sliding head machines, the bar stock slides through a guide bushing while it is rotated by a spindle feeding out the material to produce the component. This enables the tools to work close to the guide bushing, for maximum stability and great surface finish of the component.

QS™ holding system
This quick change system of tool holders, stops and wedges is designed to maximize effective production time in sliding head machines.

http://www.sandvik.coromant.com/qsholdingsystem
Application overview
Face milling

Drilling

Chamfering

Thread milling

Slot milling

Tapping
External turning

**CoroCut® XS**
*Turning, profiling, back turning*
- Diameter: 1–8 mm (0.04–0.315 inch)
- Corner radius from 0.03 mm (0.001 inch)

**CoroTurn® 107**
*Turning, profiling*
- Diameter: 6–32 mm (0.236–1.260 inch)

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**PMNS**

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**PMNS**
Internal turning

CoroTurn® XS
Turning, profiling, back boring, pre-parting
Min. hole diameter: 0.3 mm (0.012 inch)

CoroTurn® 107
Turning, profiling
Min. hole diameter: 6 mm (0.236 inch)

CoroCut® MB
Turning, profiling, back boring, pre-parting
Min. hole diameter: 10 mm (0.394 inch)
External grooving

CoroCut® 1-2
Max. cutting depth: 6–16 mm
(0.24–0.63 inch)
Cutting width: 1.5–3 mm
(0.06–0.13 inch)

CoroCut® QD
Max. cutting depth: >16 mm
(0.63 inch)
Cutting width: 1–3 mm
(0.04–0.12 inch)

CoroCut® XS
Max. cutting depth: 1.3–3.7 mm
(0.05–0.15 inch)
Cutting width: 0.5–2.5 mm
(0.02–0.098 inch)

CoroCut® 3
Max. cutting depth: 3–6 mm
(0.12–0.24 inch)
Cutting width: 0.5–3.18 mm
(0.02–0.12 inch)
Internal grooving

CoroTurn® XS
Max. cutting depth: 2.5 mm (0.100 inch)
Cutting width: ≥0.78 mm (0.031 inch)
Min. hole diameter: 4.2 mm (0.165 inch)

CoroCut® MB
Max. cutting depth: 8 mm (0.315 inch)
Cutting width: ≥0.73 mm (0.029 inch)
Min. hole diameter: 10 mm (0.394 inch)
Face grooving

CoroCut® MB
- Min. groove diameter: 12 mm (0.47 inch)
- Max. cutting depth: 1.5–10 mm (0.06–0.39 inch)
- Cutting width: 1–4 mm (0.04–1.57 inch)

CoroTurn® XS
- Min. groove diameter: 6 mm (0.24 inch)
- Max. cutting depth: 2–30 mm (0.08–1.18 inch)
- Cutting width: 1–5 mm (0.04–0.2 inch)
Parting off

**CoroCut® 1-2**  
Diameter: 6–32 mm (0.24–1.25 inch)  
Cutting width ≥1.5 mm (0.06 inch)

**CoroCut® QD**  
Diameter: ≥20 mm (0.79 inch)  
Cutting width ≥1 mm (0.04 inch)

**CoroCut® XS**  
Diameter: <8 mm (0.315 inch)  
Cutting width ≥0.7 mm (0.03 inch)

**CoroCut® 3**  
Diameter: 6–12 mm (0.24–0.5 inch)  
Cutting width ≥1 mm (0.04 inch)
Internal threading

Thread milling
CoroMill® Plura
Pitches: 0.35–3 mm (64–10 TPI)
Min. thread size: M1.6×0.35
Thread forms: M, UNC, UNF, NPT, NPTF, G

Tapping
CoroTap™ 200, 300 (-XM geometry)
Spiral point and spiral flute taps for blind and through holes
Min. thread size: M1×0.25
Thread forms: M, MF, UNC, UNF, NPT, NPTF, G
Thread turning

**CoroThread® 266**
Pitches: 0.5–8 mm (32–3 threads/in)
Min. hole diameter: 12 mm (0.472 inch)
Available for most thread forms

**CoroCut® MB**
Pitches: 0.5–3 mm (32–8 threads/in)
Min. hole diameter: 10 mm (0.393 inch)
Thread forms: M, UN, NPT, TR, AC, SA

**CoroTurn® XS**
Pitches: 0.5–3 mm (32–16 threads/in)
Min. hole diameter: 4 mm (0.157 inch)
Thread forms: M, UN, WH, NPT, TR and V-forms
External threading

**Thread turning**

**CoroCut® XS**
Thread forms: Metric and V profile 60°
Diameter: 1–8 mm (0.04–0.315 inch)

**CoroThread® 266**
Available for most thread forms
Multi- or single-point profiles
Diameter: 8–40 mm (0.315–1.57 inch)

**Thread whirling**

**CoroMill® 325**
Screw diameter: 3–10 mm (0.118–0.394 inch)
Thread forms: HA and HB
Chamfering

CoroMill® 326
Chamfer angle: 45°
Min. hole diameter: 5.8 mm (0.228 inch)

CoroMill® 316
Chamfer angles: 15°, 30°, 45°, 49° and 60°
Convex workpiece chamfer radii: 1.5–8.0 mm (0.059–0.315 inch)

CoroMill® Plura
Chamfer angles: 45° and 60°
Convex workpiece chamfer radii: 0.5–6.0 mm (0.020–0.236 inch)

http://www.sandvik.coromant.com/coromill326
Face milling

CoroMill® Plura
High feed face milling cutters
Diameter: 4–20 mm (0.157–0.787 inch)

CoroMill® 316
High feed face milling cutters
Diameter: 10–25 mm (0.375–1.00 inch)

CoroMill® 490
Diameter: 20–32 mm (0.75–1.25 inch)

CoroMill® 327
Diameter: 9.7–34.7 mm (0.382–1.366 inch)
Slot milling

CoroMill® Plura
Slot width: 0.4–25 mm (0.016–0.984 inch)

CoroMill® 327
Slot width: 0.7–5.15 mm (0.028–0.203 inch)
Drilling

**CoroDrill® R840**
*First choice for small diameters below 3 mm (0.118 inch)*
Diameter: 0.3–2.9 mm (0.012–0.114 inch)
Drilling depths: 2–7 × drill diameter
Hole tolerance: IT8–IT10

**CoroDrill® 460**
*High performance in a wide range of materials*
Diameter: 3–20 mm (0.118–0.787 inch)
Drilling depths: 2–8 × drill diameter
Hole tolerance: IT8–IT9
Available as Tailor Made
CoroDrill® 860

Maximum performance in specific materials
Diameter: 3–20 mm (0.118–0.787 inch)
Drilling depths: 2–8 × drill diameter
Hole tolerance: IT8–IT9

CoroDrill® 861

Deep hole drilling up to 30 × diameter
Diameter: 3–20 mm (0.118–0.787 inch)
Drilling depths: 12–30 × drill diameter
Hole tolerance: IT8–IT9

Gun drills (CoroDrill® 428.5)

Deep hole drilling for hole depths ≤300 mm
Diameter range: 0.8–12 mm (0.031–0.472 inch)
Hole depth: ≤300 mm (11.811 inch)
Hole tolerance: IT 8

CoroDrill® 862

Micro drilling up to 12 × diameter
Standard diameter: 1.85–2.95 mm (0.073–0.116 inch)
Drilling depths: 8–12 × drill diameter
Hole tolerance: IT8–IT9
QS™ holding system
Quick change in sliding head machines

Get more out of your sliding head machine

QS holding system is a quick change system of tool holders, stops and wedges for maximized machine utilization in sliding head machines. The system is available with high precision coolant for excellent process security. The stable tool clamping gives secure insert edge position for good repeatability and accuracy.

QS holding system can be quickly mounted in the machine and is available for CoroTurn® 107, CoroCut® 1-2, CoroCut® 3, CoroCut® QD, CoroThread® 266 and CoroCut® XS.

http://www.sandvik.coromant.com/qsholdingsystem
High precision coolant

PRE-DIRECTED HIGH PRECISION NOZZLES

The nozzles direct the coolant to the right place of the insert edge for excellent chip control and long tool life.

Chip control and process security

The CoroTurn® HP program consists of tool holders with high precision nozzles that create laminar jets of coolant with high velocity, directed at the right place of the insert edge. This improves chip control, process security, tool life and component quality. The positive effects start at low coolant pressure, but the higher the pressure is, the more demanding material can successfully be machined.

http://www.sandvik.coromant.com/coroturnhp
CoroTurn® 107

External and internal turning

Excellent surface finish

When turning internally or machining slender components, you can rely on the super sharp cutting edges of CoroTurn 107. With a broad range of inserts CoroTurn 107 is the first choice for small part turning, combining low cutting forces with high precision coolant. This combination ensures good chip control resulting in an excellent surface finish of the machined component.

External turning and profiling

Diameter: 6–40 mm (0.236–1.5 inch)

Internal turning and profiling

Min. diameter: 6 mm (0.236 inch)
Wide range of inserts

- Available in all insert geometries, grades, shapes and entering angles
- Wiper inserts for excellent finish
- VCET and VCEX, grounded wiper inserts with extra sharp cutting edges for high precision at small feed and big depth of cut
- High precision -UM geometry with E- and G tolerances ensuring precision indexing of inserts
- For corner radii down to 0.02 mm (0.0008 inch)

Combine with QS™ holders equipped with high precision coolant for chip control and long tool life. See page 22.

Back turning operation with VCEX inserts. The design of these VCEX inserts allows plunging into the material behind a shoulder.
CoroTurn® TR
For stable external profiling

Unmatched tolerances at high cutting data
CoroTurn TR provides stable machining in demanding operations. The stable and secure insert clamping reduces setup times and allows for increased cutting data, perfect when working with mass production!

Turning, profiling
Diameter: 6–32 mm (0.236–1.26 inch)

http://www.sandvik.coromant.com/coroturntr
EasyFix™
Sleeves for mounting of cylindrical bars

Always correct center height of the inserts
EasyFix is a solution for cylindrical boring bars reducing setup time. A spring plunger mounted in the sleeve clicks into a groove in the bar to guarantee the correct center height of the insert for easy indexing.

A solution for CoroTurn® 107 and CoroCut® MB

REDUCE YOUR SETUP TIME!
CoroTurn® XS
Internal machining and face grooving

High quality holes
This precision ground tool is perfect when producing small holes with high quality. The large variety of adapters fit most types of sliding head machines. The tools are designed for exact insert location which enables high precision and repeatability.

Internal machining of really small holes

Locking precision
The inserts locate precisely into the boring bar thanks to a locating pin.

Internal coolant
The holders are designed with internal high precision coolant supply.

http://www.sandvik.coromant.com/coroturnxs
Internal turning
Min. hole diameter: 0.3 mm (0.012 inch)

Internal grooving
Max. cutting depth: 2.5 mm (0.1 inch)
Cutting width: ≥0.78 mm (0.031 inch)
Min. hole diameter: 4.2 mm (0.165 inch)

Internal profiling
Min. hole diameter: 0.3 mm (0.012 inch)

Internal threading
Max. cutting depth: 2.5 mm (0.1 inch)
Cutting width: ≥0.78 mm (0.031 inch)
Min. hole diameter: 4.2 mm (0.165 inch)
Thread forms: M, UN, WH, NPT, TR and V-forms

Face grooving
Min. groove diameter: 1–8 mm (0.04–0.315 inch)
Max. cutting depth: 2–30 mm (0.08–1.18 inch)
Cutting width: 1–5 mm (0.04–0.2 inch)

Tools are also available for pre-parting operations.

The inserts with A-geometry are optimized for preventing chip jamming in small holes.
CoroCut® XS
Parting and external machining

High quality components
CoroCut XS ground inserts are excellent for producing high quality components, since the sharp cutting edges offer high tolerances and high precision at low feeds. All inserts fit the same tool holder keeping the tool inventory small.

Tools with high precision coolant are available. See more on page 22.

http://www.sandvik.coromant.com/corocutxs
Parting off
Diameter: <8 mm (0.315 inch)
Cutting width: ≥0.7 mm (0.03 inch)

External grooving
Max. cutting depth: 1.3–3.7 mm (0.05–0.15 inch)
Cutting width: 0.5–2.5 mm (0.02–0.098 inch)

External turning
Diameter: 1–8 mm (0.04–0.315 inch)
Corner radius: >0.03 mm (0.001 inch)
Turning, profiling and back turning

Threading
Thread forms: Metric and V profile 60°
Diameter: 1–8 mm (0.04–0.315 inch)
CoroCut® 1-2
First choice for parting and grooving

Stable and efficient machining
With a wide range of dedicated geometries and grades for all material groups, CoroCut 1-2 is the first choice system for parting and grooving. The tool holders have high precision coolant for good chip control, less tool wear and a more stable performance. The rigid rail interface between tool holder and insert provides high accuracy and efficient machining.

Choose CoroCut 2-edged inserts for the most cost-efficient machining
Parting off
Diameter: 6–32 mm (0.24–1.25 inch)
Cutting width: ≥1.5 mm (0.06 inch)

External grooving
Max. cutting depth: 6–16 mm (0.24–0.63 inch)
Cutting width: 1.5–3 mm (0.06–0.13 inch)

Profiling
Corner radii: 1–4 mm (0.04–0.157 inch)

Tailor Made option available – for example when you need to make a chamfer on the groove.
CoroCut® 3
Narrow parting off and precision grooving

Material savings in mass production
This system offers precision grooving down to the smallest widths. The inserts have three edges and they all fit the same holder, making CoroCut 3 a flexible and cost-efficient solution. The effects can be seen in terms of material savings, especially when working with mass production.

The inserts can be indexed directly in the machine. If insert breakage should occur, the clamping mechanism will not be affected – just index the insert and re-start the machine.

Parting off
Diameter: 6–12 mm (0.24–0.5 inch)
Cutting width ≥1 mm (0.04 inch)

External grooving
Max. cutting depth: 3–6 mm (0.12–0.24 inch)
Cutting width: 0.5–3.18 mm (0.02–0.12 inch)
CoroCut® QD
Parting off and deep grooving

Reliability and easy handling
When machining components with diameter larger than 32 mm (1.26 inch) or parting off with long overhang CoroCut QD is the first choice. The tools have over- and under coolant and a stable clamping mechanism for chip control and secure performance. With support from plug and play coolant adapters and easy insert changes, CoroCut QD is both reliable and easy to use.

Parting off
- Diameter: ≥20 mm (0.79 inch)
- Cutting width ≥1 mm (0.04 inch)

External grooving
- Max. cutting depth: >16 mm (0.63 inch)
- Cutting width: 1–3 mm (0.04–0.12 inch)

PMNS
CoroCut® MB
Internal grooving, threading and turning

Internal machining with high precision
The sharp cutting edges of CoroCut MB are perfect for internal machining with high quality demands at low feed and speed. The system is easy to index for fast setup of both tools and inserts, keeping the machine down-time to a minimum. For long overhangs steel shanks and carbide shanks are available for up to 5.5 × bar diameter.

Combine with EasyFix™ for easy insert indexing and less vibration. See page 27.

http://www.sandvik.coromant.com/corocutmb

Internal turning
Turning, profiling, back boring, pre-parting
Min. hole diameter: 10 mm (0.394 inch)

Internal grooving
Max. cutting depth: 8 mm (0.315 inch)
Cutting width: ≥0.73 mm (0.029 inch)

Face grooving
Min. groove diameter: 12 mm (0.47 inch)
Max. cutting depth: 1.5–10 mm (0.06–0.394 inch)
Cutting width: 1–4 mm (0.04–0.157 inch)

Internal threading
Pitches: 0.5–3 mm (32–8 threads/in)
Min. hole diameter: 10 mm (0.394 inch)
Thread forms: M, UN, NPT, TR, AC, SA

PMNS
CoroThread® 266
First choice for thread turning

Highly productive threading
When talking about thread turning CoroThread 266 has a solution for any component. The three-edged system includes almost every thread profile, and the excellent insert stability secures high thread quality while at the same time allowing for increased cutting data.

CoroThread® 266
First choice for thread turning

Thread profiles

- Full profile
- V-profile
- Multi-point

Thread forms:
- M, UN, WH, PT, NT, NF, RN, MJ, UNJ, TR, AC, SA
- Pitches: 0.5–8 mm (32–3 threads/in)

http://www.sandvik.coromant.com/corothread266
CoroMill® 325
Threading of slender components

High quality threads
The whirling process allows high thread quality when machining external threads on slender components. The thread whirling rings are available for different drive units in most sliding head machines. A small stocked insert assortment for HA and HB thread forms and engineered solutions to fit specific components are available.

External threading
For sliding head machines equipped with PCM, Jarvis, Star, Tsugami, Tornos or WTO drive units

TYPICAL COMPONENT: BONE SCREW

http://www.sandvik.coromant.com/coromill325
CoroMill® Plura
Solid end mills

2-series: Tools with geometries and grades optimized for specific materials and applications, maximizing production output per time unit.

1-series: Tools designed for high-performance and secure machining in a variety of applications, component sizes, shapes and materials, allowing maximum machine utilization.

http://www.sandvik.coromant.com/coromillplura

High component quality
CoroMill Plura includes end mills for many different challenges, for example chip space, stability and component quality. The broad assortment ranges from micro-sized ball nose cutters and thread mills to regular shoulder and face milling cutters.

Slot milling, shoulder milling, profile milling, face milling, chamfering, ramping, helical interpolation, plunging, internal threading, turn milling
High feed side milling
Make chips fly at super speed with cutters with unequal helix angle, designed to reduce vibration in high feed side milling operations. In addition, the low vibration enables a very long tool life and excellent surface finish. Utilize the full cutting length for best metal removal rate.

Cutters dedicated for non-ferrous materials
• Long tool life at high material removal rate
• Great chip evacuation thanks to polished flutes with large chip space
• Specific cylindrical land reduces tool vibration, giving minimized chipping problems and a brilliant surface finish
• Available with undersized shanks for maximum flexibility and reach
CoroMill® 316
Exchangeable head milling system

Flexible milling
The exchangeable heads are a cost-efficient alternative to solid carbide end mills. The same holder fits many different head styles, offering flexibility in a variety of milling operations. The Coromant EH coupling provides reliability and accuracy between the head and the shank. It is easy to handle and the head can be changed in a few seconds.

Slot milling, shoulder milling, profile milling, face milling, chamfering, ramping, helical interpolation, plunging

http://www.sandvik.coromant.com/coromill316

 CHANGE HEAD IN A FEW SECONDS
CoroMill® 490
Face and shoulder mill for precise contours

Shoulder milling, repeated shoulder milling, circular interpolation, face milling, slot milling
Diameter: 20–32 mm (0.75–1.25 inch)

Productive solution with easy handling
CoroMill 490 is an indexable milling cutter for economical shoulder milling with high precision. The Coromant EH coupling gives rigidity, enabling high cutting data and high metal removal rates.
In small part machining it is recommended to use the cutter body with an integrated ER collet or cylindrical holder.

http://www.sandvik.coromant.com/coromill490
Coromant EH modular system
Small diameter milling and boring

Tooling flexibility
With the modular system Coromant EH you get tooling flexibility and a small inventory. The robust coupling gives great security and enables quick and easy tool changes. Coromant EH includes a wide assortment of solid carbide heads, indexable milling cutters, boring heads, integrated machine adapters and different shanks.

The Coromant EH coupling has a self-centering screw that makes mounting of heads easy. The coupling has a physical stop which makes it easy to feel when the head is correctly tightened and helps to not overstress the clamping.
ER collets with Coromant EH or CoroMill® 327 coupling

Integrated machine adapters
The short gauge length of the ER collet plus cutter head makes machining with low vibration and high productivity possible.
The integrated ER collets in sizes ER11–ER16 for CoroMill 327 and ER16 for Coromant EH offer an easy to use solution for driven tools in sliding head machines.
Combine with a large assortment of different milling heads with Coromant EH or CoroMill 327 coupling.

RIGID AND SECURE TOOL HOLDING
CoroMill® 327
Grooving, threading and face milling

Quick face milling
In small part machining CoroMill 327 offers productive face milling, making it ideal for long series production. These cutters are also a good choice for grooving and thread milling.
Combine the heads with integrated ER collets for easy handling and quick tool changes in sliding head machines.

Groove milling, circlip grooving, thread milling, chamfering, face milling
Three or six teeth
Diameter: 9.7–34.7 mm (0.382–1.366 inch)

http://www.sandvik.coromant.com/coromill327
CoroDrill® R840
Solid carbide drill for all materials

Diameter: 0.3–2.90 mm (0.012–0.114 inch)
Drilling depths: 2–7 × drill diameter
Hole tolerance: IT8–10

Small precision holes
CoroDrill R840 is your first choice for small part machining, covering hole diameters from 0.3 mm (0.012 inch). This solid carbide drill is suitable for drilling in all materials and designed for precision holes of IT 8–10 tolerance.

http://www.sandvik.coromant.com/corodrillr840
CoroDrill® 460
High performance in a wide range of materials

WITH TAILOR MADE STEP AND CHAMFER

High performance drilling
CoroDrill 460 is a multi-application, high performance drill that can be used across a wide range of materials. It provides high capacity utilization and flexibility. With this versatile drill stock holding is reduced and greater machine flexibility is offered, leading to reduced set-up time.

Step and chamfer Tailor Made option for boosting your productivity

Diameter: 3–20 mm
(0.118–0.787 inch)
Drilling depths: 2–8 × drill diameter
Hole tolerance: IT8–IT9

http://www.sandvik.coromant.com/corodrill460
CoroDrill® 860
Maximum performance in specific materials

Green light machining
CoroDrill 860 is a highly productive solid carbide drill optimized for steel, stainless steel and aluminum. With excellent chip evacuation in long and short chipping materials, this drill provides green light machining at high penetration rates.

Drilling depths: 3–8 × drill diameter
Hole tolerance:
-PM and -NM: IT8–IT9
-MM: IT6–IT8

Available as Tailor Made option in intermediate sizes up to 20 mm (0.787 inch)

860 -PM for steels
3–20 mm (0.118–0.787 inch)

860 -NM for non-ferrous materials
3–20 mm (0.118–0.787 inch)

860 -MM for stainless steel
3–16 mm (0.118–0.629 inch)

CoroDrill® R846 for heat resistant super alloys
3–16 mm (0.118–0.629 inch)

http://www.sandvik.coromant.com/corodrill860
CoroDrill® 861
Deep hole drilling up to 30 × diameter

High penetration rates
CoroDrill 861 provides high stability, essential for drilling holes down to 3 mm (0.118 inch) in diameter. It is suitable for steel, stainless steel and aluminum within the small part machining area and optimized for varying deep hole application demands. High penetration rates can be achieved in holes up to 30 × drill diameter without the need for pecking.

Drilling depths and diameter:
12 × D: 3–20 mm (0.118–0.787 inch)
15 × D: 3–12 mm (0.118–0.472 inch)
20 × D: 3–12 mm (0.118–0.472 inch)
30 × D: 3–8 mm (0.118–0.315 inch)
Hole tolerance: H8–H9
CoroDrill® 862
Micro drilling for up to 12 × diameter in depth

Excellent chip evacuation
CoroDrill 862 offers outstanding performance for holes up to 2.95 mm (0.116 inch) diameter. This solid carbide through-coolant drill features a thin, effective coating that helps to retain cutting edge geometry. In addition, it provides a smooth surface for excellent chip evacuation.

Diameter: 1.85−2.95 mm
(0.073−0.116 inch)
Drilling depths: 8–12 × drill diameter
Hole tolerance: IT8–IT9

http://www.sandvik.coromant.com/corodrill862
CoroTap™ 200 and CoroTap™ 300
For through and blind hole

Flexible tapping solution
CoroTap with -XM geometry is an easy to choose, multi-functional tapping solution for a wide range of materials. Featuring spiral point taps for through holes and spiral flute taps for blind holes, the -XM geometry is available in different grade options for various types of threads. These flexible taps are designed for high productivity and long tool life in most workpiece materials.

See complete tapping overview here

http://www.sandvik.coromant.com/taps
CoroTap 200
• Spiral point taps for through holes
• Strong design due to shallow flutes
• Flutes only used for cutting fluid, not for chip evacuation

Tapping range: M2−M30
Depth up to 2.5 × diameter
Tolerances with -XM:
6G, 6H, 2B, 3B

CoroTap 300
• Spiral flute taps for blind holes
• Different helix angles for different applications
• Flutes used for both cutting fluid and chip evacuation
• Different threading depths due to application and geometry

Tapping range: M2−M36
Depth up to 2.5 × diameter
Tolerances with -XM:
6G, 6H, 2B, 3B
**CoroGuide® 2.0**
Specify your material, task and parameters to receive the tool recommendation best suited to your needs.

**First choice**
Are you working with turning? Let First choice advise you on how to get up and running! Choose your application and get a tool recommendation.

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