

Tailor Made

SANDVIK
Coromant

CoroDrill® DS20 Tailor Made options

- CAPP family: D116
- Insert sizes: 01, 02, 03, 04, 05, 06, 07
- Diameter range DC1: 15–65 mm (0.591–2.56 inch)
- Drilling depth LU: 4–7xDC
- Internal coolant options: Yes
- Coupling type: ISO 9766, Cylindrical, MDI
- One step (two inserts) or one chamfer (one insert)
- Flute design: Helical



MDI



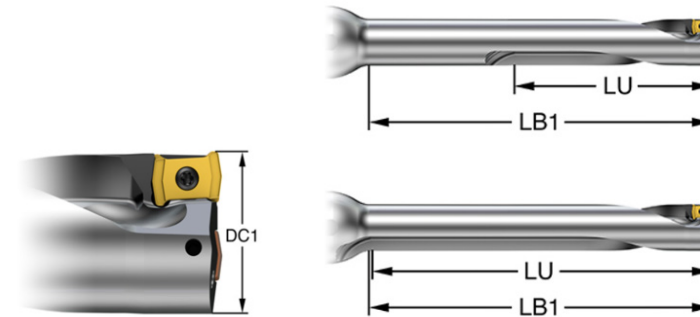
ISO 9766



CYL

Tailor Made, conventional




Available in Tailor Made web



| Drill diameter DC1, mm (inch) | Usable length LU (min-max) | Insert size | Screw size | Screw article code (SCCOD) | TORXKEY | Torque, Nm (lbf-ft) | TORXBIT article code (KEYCOD) |
|----------------------------------|-------------------------------|-------------|------------|-------------------------------|----------------|------------------------|----------------------------------|
| 15.00-18.00 (0.591-0.708) | 4-7×DC | 01 | M2.0 | 5513 020-27 | 6IP TORX PLUS | 0.6 (0.44) | 5680 084-17 |
| 18.01-22.00 (0.709-0.866) | 4-7×DC | 02 | M2.2 | 5513 020-88 | 7IP TORX PLUS | 0.9 (0.66) | 5680 084-18 |
| 22.01-27.00 (0.867-1.06) | 4-7×DC | 03 | M2.5 | 5513 020-58 | 7IP TORX PLUS | 0.9 (0.66) | 5680 084-18 |
| 27.01-33.00 (1.06-1.30) | 4-7×DC | 04 | M3.0 | 5513 020-57 | 9IP TORX PLUS | 1.4 (1.03) | 5680 084-20 |
| 33.01-40.00 (1.30-1.57) | 4-7×DC | 05 | M3.5 | 416.1-833 | 10IP TORX PLUS | 2.0 (1.48) | 5680 084-21 |
| 40.01-52.00 (1.58-2.05) | 4-7×DC | 06 | M4.0 | 416.1-834 | 15IP TORX PLUS | 3.0 (2.21) | 5680 084-15 |
| 52.01-65.00 (2.05-2.56) | 4-7×DC | 07 | M4.0 | 416.1-834 | 15IP TORX PLUS | 3.0 (2.21) | 5680 084-15 |

Tailor Made, couplings

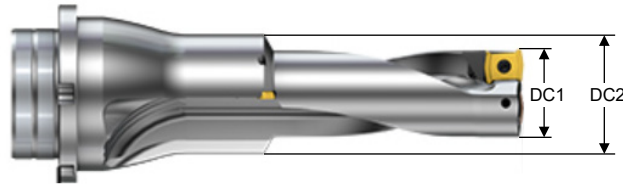
Available in Tailor Made web

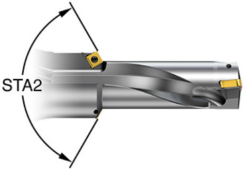
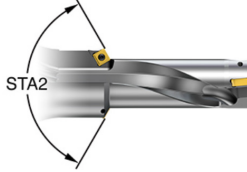
| Coupling type | Usable drilling depth LU (min-max) | Internal coolant | Drill diameter DC1, mm (inch) | | | | | | |
|--|---------------------------------------|---------------------|-------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|
| | | | | 15.00–17.43 (0.591–0.686) | 17.44–20.99 (0.687–0.826) | 21.00–25.99 (0.827–1.023) | 26.00–30.99 (1.024–1.220) | 31.00–41.99 (1.221–1.653) | 42.00–65.00 (1.654–2.559) |
| ISO 9766  | 4–7×DC | Yes | Metric | 20, 25 | 20, 25, 32 | 25, 32 | 25, 32, 40 | 32, 40 | 40, 50 |
| | | | Inch | 0.75, 1.0 | 1.0, 1.25 | 1.0, 1.25 | 1.25, 1.50 | 1.50 | 2.0 |
| Cylindrical  | 4–7×DC | Yes | Metric | 20, 25 | 20, 25, 32 | 25, 32 | 25, 32, 40 | 32, 40 | 40, 50 |
| | | | Inch | 0.75, 1.0 | 1.0, 1.25 | 1.0, 1.25 | 1.25, 1.50 | 1.50 | 2.0 |
| MDI  | 4–7×DC | Yes | Metric | 20 | 25 | 25 | 32 | 40* | 50** |

* DM40 is available for drill diameter 32.00–43.99 (1.260–1.732).

** DM50 is available for drill diameter 44.00–59.00 (1.732–2.323).

Tailor Made, step and chamfer



| | Step and chamfer angle, STA2 | Diameter, DC1 mm (inch) | Step and chamfer length (Lstep min – max)* | Shank type** | Step and chamfer insert type*** |
|---|------------------------------|------------------------------|--|--------------------------------|---------------------------------|
| Step (two inserts)  | 176° | 15.00–52.20 (0.591–2.055) | ~3-7×DC | ISO 9766 Cylindrical MDI | CoroDrill® 880 periphery insert |
| | 120° | 23.00–52.20 (0.906–2.055) | | | |
| | 90° | 26.00–52.20 (1.024–2.055) | | | |
| Chamfer (one insert)  | 120° | 23.00–52.20 (0.906–2.055) | ~3-7×DC | ISO 9766 Cylindrical MDI | CoroDrill® 880 periphery insert |
| | 90° | 26.00–52.20 (1.024–2.055) | | | |
| | 60° | 27.00–52.20 (1.063–2.055) | | | |

Customized offer possible for other angles.

* Step and chamfer length depends on DC1 and STA2 values

** Available options is connected to step and chamfer diameter DC2

*** Choice of insert depends on workpiece material.