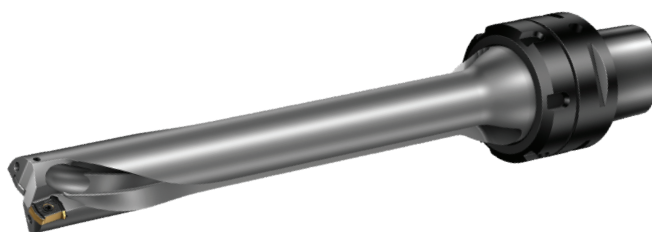
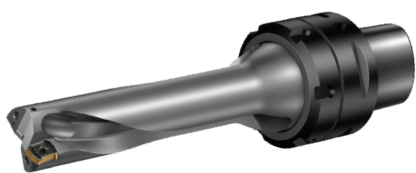


## CoroDrill® DS20 - Range extension

Indexable insert drill that offers reliability, predictability and outstanding penetration rates for 4–7×DC drilling operations.

### Drill body



#### 4–5 × DC

- Plug and play
- Predictable and consistent chip control
- Versatile and cost-efficient
- Increased productivity in all materials
- Large functionality over a broad cutting data range
- H12–H13 hole tolerances
- Now available up to 65mm diameter

#### 6–7 × DC

- First to market with a 7 × DC indexable insert drill
- Cost-efficient drilling for deeper holes with less demanding hole tolerances
- Opens up for new machining processes with increased productivity
- No pilot drilling needed

### Assortment

Diameter, mm (inch)	Shank type	Drill depth (×DC)
15–45 (0.591–1.77)	Cylindrical with flat according to ISO 9766 (mm & inch)	4, 5, 6, 7
46–65 (1.811–2.56)	Cylindrical with flat according to ISO 9766 (mm & inch)	4, 5
15–45 (0.591–1.77)	Coromant Capto® and HSK with MDI (mm & inch)	4, 7
46–65 (1.81–2.56)	Coromant Capto® and HSK with MDI (mm & inch)	4

































### Insert seat, screw key information

Drill dimension, mm (inch)	Insert size	Screw article code (SCCOD)	TORXBIT article code (KEYCOD)
15.00–18.00 (0.591–0.708)	01	5513 020-27	5680 084-17
18.01–22.00 (0.709–0.866)	02	5513 020-88	5680 084-18
22.01–27.00 (0.867–1.06)	03	5513 020-58	5680 084-18
27.01–33.00 (1.06–1.30)	04	5513 020-57	5680 084-20
33.01–40.00 (1.30–1.57)	05	416.1-833	5680 084-21
40.01–52.00 (1.58–2.05)	06	416.1-834	5680 084-15
52.01–65 (2.05–2.56)	07	416.1-834	5680 084-15



# Insert grades and geometries

Central insert		Geometry information
L5	 	<ul style="list-style-type: none"> <li>- Long-chipping materials</li> <li>- Hardened steel</li> <li>- Low to medium feed</li> <li>- Light cutting</li> </ul>
M7	 	<ul style="list-style-type: none"> <li>- Short-chipping material</li> <li>- Low to high feed</li> <li>- Strong reinforced edge</li> </ul>
Peripheral insert		Geometry information
M7W	 	<ul style="list-style-type: none"> <li>- First choice in short chipping materials</li> <li>- Low to high feed</li> <li>- Strong reinforced edge</li> </ul>
L5W	 	<ul style="list-style-type: none"> <li>- Long-chipping materials</li> <li>- Low to medium feed</li> <li>- Light cutting</li> </ul>
H5W	 	<ul style="list-style-type: none"> <li>- Complementary for long-chipping materials</li> <li>- Low to medium feed</li> <li>- Negative T-land</li> <li>- High cutting forces</li> </ul>
S5W	 	<ul style="list-style-type: none"> <li>- Sharp and extremely light cutting</li> <li>- Low feed</li> </ul>
L6W	 	<ul style="list-style-type: none"> <li>- All-round geometry for mixed production</li> <li>- First choice in Inconel and hardened steel</li> <li>- Low to medium feed</li> <li>- Light cutting</li> </ul>

Central insert		Grade information
		<b>GC1344</b> <ul style="list-style-type: none"> <li>- PVD-coated with Zertivo® technology</li> <li>- Excellent wear resistance and toughness</li> </ul>
		<b>GC1144</b> <ul style="list-style-type: none"> <li>- PVD-coated grade for all types of ISO M and titanium materials</li> </ul>
		<b>H13A</b> <ul style="list-style-type: none"> <li>- Universal, tough and uncoated grade best for low to moderate cutting speeds</li> <li>- Complementary grade for ISO S</li> </ul>
Peripheral insert		Grade information
		<b>GC4334</b> <ul style="list-style-type: none"> <li>- Good to average conditions</li> <li>- CVD coating with Inveio® technology provides a high level of wear resistance</li> </ul>
		<b>GC2044</b> <ul style="list-style-type: none"> <li>- PVD-oxide coating for excellent wear resistance</li> </ul>
		<b>GC4344</b> <ul style="list-style-type: none"> <li>- PVD-coating with Zertivo® technology</li> <li>- Tough and demanding operations</li> <li>- Provides good edge-line properties and reliable tool life</li> </ul>
		<b>GC4324</b> <ul style="list-style-type: none"> <li>- MT-CVD coating with Inveio® technology</li> <li>- Productive choice in stable conditions</li> </ul>
		<b>H13A</b> <ul style="list-style-type: none"> <li>- Universal, tough and uncoated grade best for low to moderate cutting speeds</li> <li>- Complementary grade for ISO S</li> </ul>



**Tas Bearing  
& Chain**

34 McKenzie Street, Launceston, Tasmania 7248.  
 Phone: +613 6326 6377  
 Email: [info@tasbearing.com.au](mailto:info@tasbearing.com.au)  
<http://www.tasbearing.com.au/>

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