

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



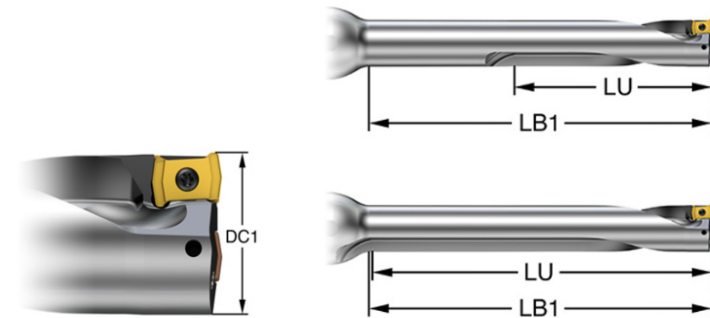
ISO 9766



CYL

Tailor Made, conventional



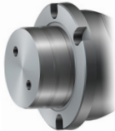
Available in Tailor Made web



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

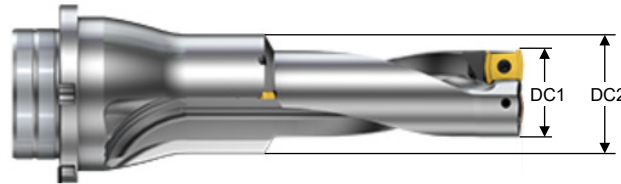
Available in Tailor Made web

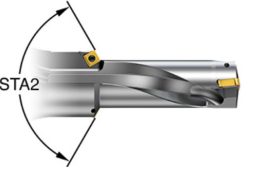
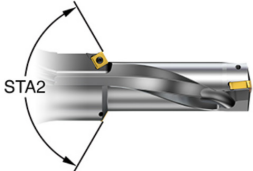
Coupling type	Usable drilling depth LU (min-max)	Internal coolant	Drill diameter DC1, mm (inch)						
				15.00–17.43 (0.591–0.686)	17.44–20.99 (0.687–0.826)	21.00–25.99 (0.827–1.023)	26.00–30.99 (1.024–1.220)	31.00–41.99 (1.221–1.653)	42.00–65.00 (1.654–2.559)
ISO 9766 	4–7×DC	Yes	Metric	20, 25	20,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

* 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.