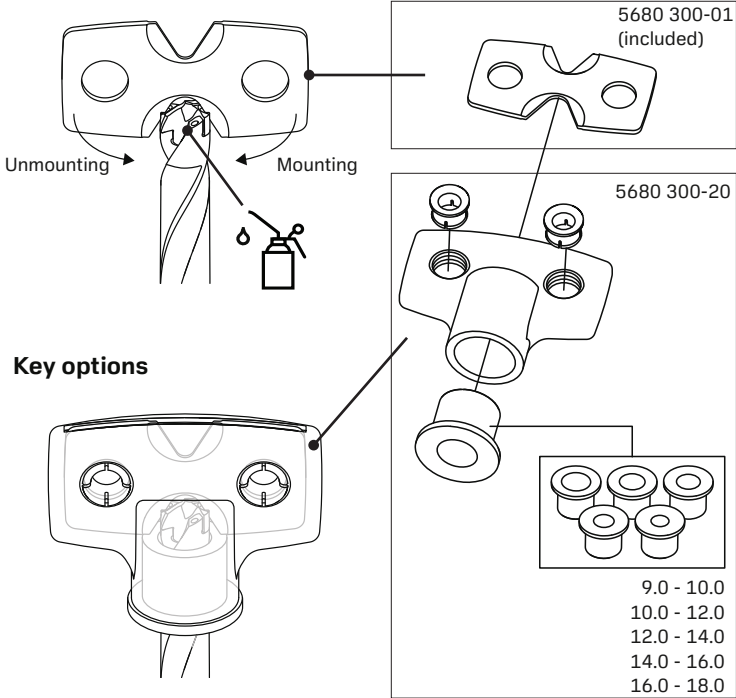


CoroDrill® DE10

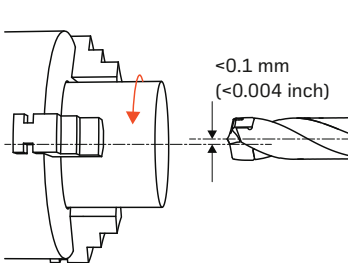


Mounting drill tip

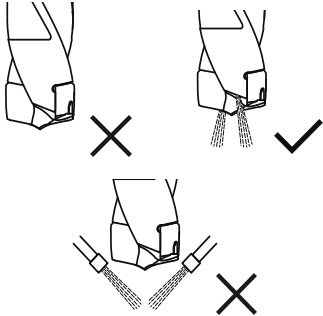


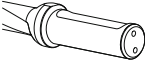
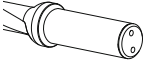
Application tips

Stationary applications



Use internal coolant



Chuck selection		
ISO 9766 chuck	✓	N/A
Hydraulic chuck (CoroChuck® 930)	✓✓ with collet	✓✓
Weldon chuck	—	N/A

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[sandvik.coromant.com/
corodrill-de10](https://sandvik.coromant.com/corodrill-de10)



Cutting speed recommendation

Material	MC No.	HB	Vc (m/min)	SFM (ft/min)	Material	MC No.	HB	Vc (m/min)	SFM (ft/min)
Unalloyed steel	P1.1.Z.AN	125	120 (80 - 160)	394 (262 - 525)	Austenitic stainless steel	M1.0.Z.AQ	200	50 (40 - 60)	164 (131 - 197)
	P1.2.Z.AN	190	120 (80 - 160)	394 (262 - 525)		M1.0.C.UT	200	60 (50 - 70)	197 (164 - 230)
	P1.3.Z.AN	190	100 (80 - 130)	328 (262 - 427)		M1.1.Z.AQ	200	75 (60 - 90)	246 (197 - 295)
	P1.5.C.UT	150	110 (80 - 130)	361 (262 - 459)	Super-austenitic stainless steel	M2.0.Z.AQ	200	40 (20 - 60)	131 (66 - 197)
Low-alloyed steel	P2.1.Z.AN	175	110 (80 - 140)	361 (262 - 459)		M2.0.C.AQ	200	40 (20 - 60)	131 (66 - 197)
	P2.2.Z.AN	240	110 (80 - 140)	361 (262 - 459)	Duplex stain-less steel	M3.1.Z.AQ	230	55 (40 - 70)	180 (131 - 230)
	P2.4.Z.AN	225	110 (80 - 140)	361 (262 - 459)		M3.2.Z.AQ	260	40 (20 - 60)	131 (66 - 197)
	P2.5.Z.HT	330	100 (70 - 130)	328 (230 - 427)	Malleable cast iron	K.1.1.C.NS	130	145 (100 - 190)	476 (328 - 623)
High alloyed steel	P2.6.C.UT	200	100 (70 - 130)	328 (230 - 427)		K.1.1.C.NS	200	145 (100 - 190)	476 (328 - 623)
	P3.0.Z.AN	200	80 (60 - 100)	262 (197 - 328)	Grey cast iron	K2.1.C.UT	180	150 (100 - 200)	492 (328 - 656)
	P3.0.Z.HT	380	60 (40 - 80)	197 (131 - 262)		K2.2.C.UT	245	130 (90 - 170)	427 (295 - 558)
Ferritic/ Martensitic stainless steel	P5.0.Z.AN	200	70 (50 - 80)	230 (164 - 262)	Nodular cast iron	K3.1.C.UT	155	145 (100 - 190)	476 (328 - 623)
	P5.0.Z.HT	330	60 (40 - 70)	197 (131 - 230)		K3.3.C.UT	265	125 (90 - 160)	410 (295 - 525)

Grade selection:

P	4334	K	3334
M S	2334	Multi-material	4334

Feed recommendation

	Unalloyed and low alloys steels	High alloy steel	Ferritic/Martensitic stainless steel	Austenitic stainless steel	Duplex and super austenitic stainless steel	Cast iron	
DC range	All	All	P5.0.Z.AN	P5.0.Z.HT	All	All	All
Metric (mm/rev)	9.0 - 11.9 (0.13 - 0.28)	0.18 (0.11 - 0.24)	0.15 (0.12 - 0.19)	0.13 (0.1 - 0.16)	0.14 (0.1 - 0.16)	0.14 (0.1 - 0.16)	0.25 (0.17 - 0.45)
	12 – 14.9 (0.18 - 0.41)	0.24 (0.14 - 0.38)	0.18 (0.14 - 0.24)	0.15 (0.12 - 0.18)	0.16 (0.11 - 0.21)	0.14 (0.11 - 0.16)	0.35 (0.2 - 0.55)
	15 – 17.9 (0.22 - 0.45)	0.25 (0.16 - 0.4)	0.24 (0.18 - 0.3)	0.18 (0.14 - 0.22)	0.18 (0.12 - 0.24)	0.14 (0.12 - 0.18)	0.45 (0.22 - 0.65)
Imperial (inch/rev)	.354 - .469 (.0051 - .011)	.0071 (.0043 - .0094)	.0059 (.0047 - .0075)	.0051 (.0039 - .0063)	.0055 (.0039 - .0063)	.0055 (.0039 - .0063)	.0098 (.0067 - .0177)
	.472 - .587 (.0071 - .0161)	.0094 (.0055 - .015)	.0071 (.0055 - .0094)	.0059 (.0047 - .0071)	.0063 (.0043 - .0083)	.0055 (.0043 - .0063)	.0138 (.0079 - .0217)
	.591 - .705 (.0087 - .0177)	.0098 (.0063 - .0157)	.0094 (.0071 - .0118)	.0071 (.0055 - .0087)	.0071 (.0047 - .0094)	.0055 (.0047 - .0071)	.0177 (.0087 - .0256)

Geometry selection:

P	M5	K	M5C, M5*
M S	M5	Multi-material	M5

* For M5 in ISO K, reduce feed by 15%