

TCHA: H7
Grade: H10F



Order number			Dimensions, mm				Discount group 725	
DC	Straight chip flute for blind holes (GB)	Twisted chip flute for through-holes (DB)	DCON	L	LU	LF	H10F GB	H10F DB
4.00	435.B-0400-A1-XF	435.T-0400-A1-XF	6	12	39	74.40	•	•
4.01	435.B-0401-A1-XF		6	12	39	74.40	•	
4.50	435.B-0450-A1-XF		6	12	39	74.32	•	
5.00	435.B-0500-A1-XF	435.T-0500-A1-XF	6	12	39	74.25	•	•
5.01	435.B-0501-A1-XF		6	12	39	74.25	•	
6.00	435.B-0600-A1-XF	435.T-0600-A1-XF	6	12	39	74.10	•	•
6.01	435.B-0601-A1-XF		6	12	39	74.10	•	
6.02		435.T-0602-A1-XF	6	12	39	74.10		•
6.50		435.T-0650-A1-XF	8	16	64	99.02		•
7.00	435.B-0700-A1-XF	435.T-0700-A1-XF	8	16	64	98.95	•	•
8.00	435.B-0800-A1-XF	435.T-0800-A1-XF	8	16	64	98.80	•	•
8.01	435.B-0801-A1-XF		8	16	64	98.80	•	
9.00		435.T-0900-A1-XF	10	20	60	98.65		•
9.50		435.T-0950-A1-XF	10	20	80	118.57		•
9.98		435.T-0998-A1-XF	10	20	80	118.50		•
10.00	435.B-1000-A1-XF	435.T-1000-A1-XF	10	20	80	118.50	•	•
10.01	435.B-1001-A1-XF	435.T-1001-A1-XF	10	20	80	118.50	•	•
11.00		435.T-1100-A1-XF	12	20	75	118.35		•
12.00	435.B-1200-A1-XF	435.T-1200-A1-XF	12	20	75	118.20	•	•
12.03	435.B-1203-A1-XF		12	20	75	118.19	•	
13.00	435.B-1300-A1-XF	435.T-1300-A1-XF	14	22	85	128.05	•	•
14.00	435.B-1400-A1-XF	435.T-1400-A1-XF	14	22	85	127.90	•	•
15.00	435.B-1500-A1-XF	435.T-1500-A1-XF	16	22	82	127.75	•	•
16.00	435.B-1600-A1-XF	435.T-1600-A1-XF	16	25	102	147.60	•	•
17.00	435.B-1700-A1-XF	435.T-1700-A1-XF	18	25	102	147.45	•	•
18.00	435.B-1800-A1-XF	435.T-1800-A1-XF	18	25	102	147.30	•	•
19.00		435.T-1900-A1-XF	20	25	100	147.14		•
20.00	435.B-2000-A1-XF	435.T-2000-A1-XF	20	25	100	146.99	•	•

Cutting data for the CoroReamer™ 435

Feed

ISO	MC no.	3	5	8	10	12	16	20
fn mm/rev								
P	P1.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.2.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.2.Z.HT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.3.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P1.3.Z.HT	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P2.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P2.2.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P2.3.Z.AN	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P2.5.Z.HT.1	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P1.5.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P2.6.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P3.0.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P3.0.Z.HT.1	0.11	0.15	0.18	0.21	0.24	0.28	0.31
	P3.1.Z.AN	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P5.0.Z.HT.1	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	P5.0.Z.PH	0.16	0.2	0.27	0.32	0.36	0.41	0.47
M	M1.0.Z.AQ							
	M2.0.Z.AQ							
	M3.1.Z.AQ							
	M3.2.Z.AQ							
	M1.0.C.UT							
	M2.0.C.AQ							
	M3.1.C.AQ							
K	K1.1.C.NS	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K2.1.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K2.2.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K2.3.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.1.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.2.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.3.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K3.5.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	K5.1.C.NS	0.16	0.2	0.27	0.32	0.36	0.41	0.47
N	N1.2.Z.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.2.Z.AG	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.3.C.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.3.C.AG	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N1.4.C.NS	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N3.3.U.UT	0.16	0.2	0.27	0.32	0.36	0.41	0.47
	N3.1.U.UT	0.18	0.25	0.35	0.39	0.43	0.5	0.53

Tapping in many different materials

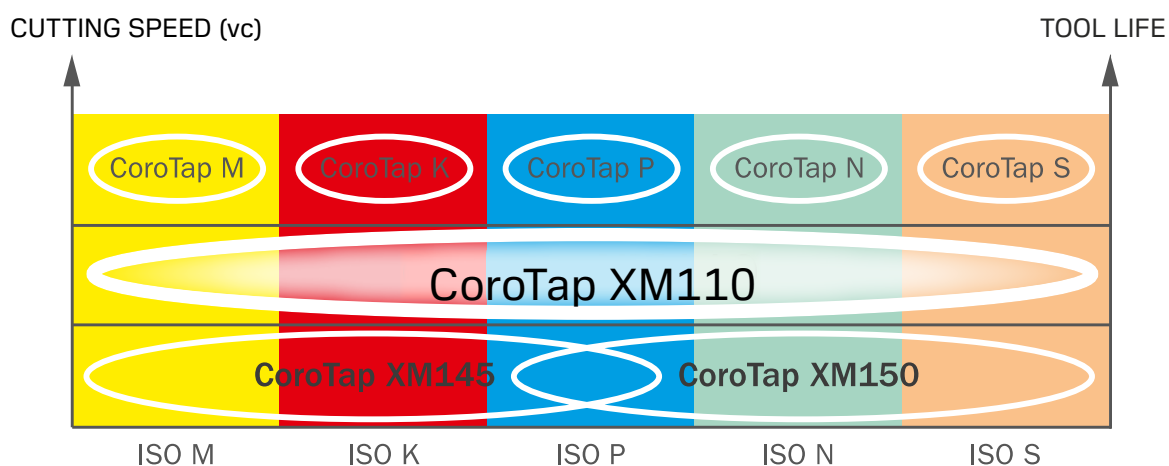
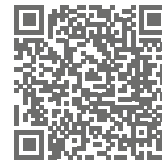
CoroTap™-XM is an obvious solution for tapping in numerous materials. Different grade options are available depending on your requirements. All options are suitable for virtually any material and guarantee exceptionally high machine capacity utilisation.

Features and advantages

- Reduces inventory and lowers costs
- Offers a long tool life
- Enables increased process reliability thanks to outstanding cutting edge geometry
- Large helix angles offer excellent swarf evacuation and machining up to $2.5 \times D$

Application range

- For through and blind holes
- Drilling depth to $2.5 \times D$
- Chamfer form E with minimal clearance in blind holes
- Tapping up to 350 HB ($\sim 1200 \text{ N/mm}^2$)
- Suitable for all industrial sectors



Grades



C150/B150
(Uncoated) for reduced
"sticking" in soft materials



C145/B145
(Steam-tempered) for
protecting and preventing
build-up on the nose



C110/B110 (AlCrN coated)
with a high level of wear
resistance and hot hardness.
Offers a long tool life and
increased cutting speeds

C grade: HSS-PM, powdered high-speed steel with vanadium alloy, offers increased stability and toughness for good wear resistance.
B grade: HSS-E, high-alloy high-speed steel with cobalt for increased wear resistance and toughness for large diameters ($> 17 \text{ mm}$)

Product range

Thread form	Range	Tolerance range	BSG	CoroTap™	Grade
M	M2-M64	6H	DIN	T200*/T300	C150/C145/C110 – B150/B145/B110**
M	M3-M20	6G	DIN	T200/T300	C150/C145/C110 – B150/B145/B110
M	M3-M10	6H	DIN 376	T200/T300	C150/C145/C110 – B150/B145/B110
MF	M4-M30	6H	DIN	T200/T300	C150/C145/C110 – B150/B145/B110
UNC	#4-1"	2B	DIN	T200/T300	C150/C145/C110 – B150/B145/B110
UNF	#8-1"	2B	DIN	T200/T300	C150/C145/C110 – B150/B145/B110
G	1/8-1 1/2	Normal	DIN	T200***/T300	C150/C145/C110 – B150/B145/B110

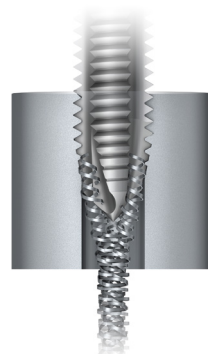
* Up to M30

** Up to M36 (T300)

*** Up to 1"

CoroTap™ 200

Tap for through-holes



Page	P. 18			P. 19			P. 23			P. 25			P. 27			P. 29		
	T200-XM100DA T200-XM101DA			T200-XM104DA T200-XM105DA			T200-XM100DB			T200-XM100DE T200-XM101DE			T200-XM100DF T200-XM101DF			T200-XM100DK		
Grade	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110
THFT (thread form)	M			M			MF			UNC			UNF			G		
	M2-M30			M3-M20			M4-M30			#4 - 1"			#8 - 1"			1/8 - 1"		
THCHT (chamfer)	B			B			B			B			B			B		
BSG (standard)	DIN 371/DIN 376			DIN 371/DIN 376			DIN 374			DIN 2184-1			DIN 2184-1			DIN 5156		
TCTR (tolerance)	6H			6G			6H			2B			2B			Normal		
ULDR (depth)	2.5			2.5			2.5			2.5			2.5			2.5		

CoroTap™ 300

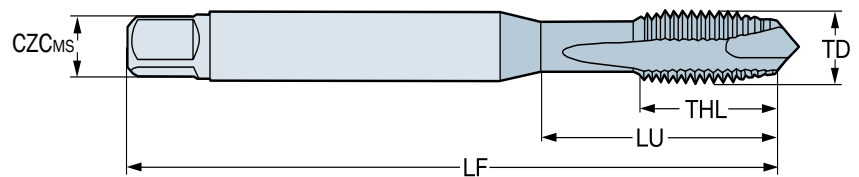
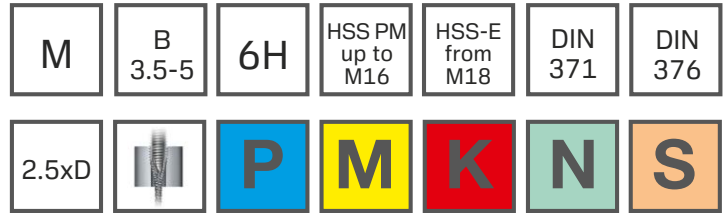
Tap for blind holes



Page	P.20			P.21			P.22			P. 24			P. 26			P. 28			P.30		
Grade	T300-XM100DA T300-XM101DA			T300-XM104DA T300-XM105DA			T300-XM102DA T300-XM103DA			T300-XM100DB			T300-XM100DE T300-XM101DE			T300-XM100DF T300-XM101DF			T300-XM100DK		
	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110	C150 B150	C145 B145	C110 B110
THFT (thread form)	M			M			M			MF			UNC			UNF			G		
	M2-M64			M3-M20			M3-M20			M4-M30			#8-1"			#8-1"			1/8 - 1 1/2"		
THCHT (chamfer)	C			C			E			C			C			C			C		
BSG (standard)	DIN 371/DIN 376			DIN 371/DIN 376			DIN 371/DIN 376			DIN 374			DIN 2184-1			DIN 2184-1			DIN 5156		
TCTR (tolerance)	6H			6G			6H			6H			2B			2B			Normal		
ULDR (depth)	2.5			2.5			2.5			2.5			2.5			2.5			2.5		

CoroTap™ 200 tap for through-holes

Thread form metric

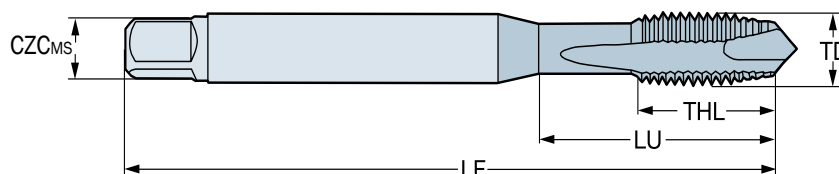


TDZ	CZC _{MS}			TP	Order number	Dimensions, mm						Discount group 781		
												(coated)	(steam-temp.)	(uncoated)
	Shank	Square		Lead		TD	LF	LU	THL	NOF	BSG	C110	C145	C150
M 2	2.80	x 2.10		0.40	T200-XM100DA-M2	2.0	45.0	9.0	6.0	2	DIN 371	•	•	•
M 2.5	2.80	x 2.10		0.45	T200-XM100DA-M2.5	2.5	50.0	12.5	8.0	2	DIN 371	•	•	•
M 3	3.50	x 2.70		0.50	T200-XM100DA-M3	3.0	56.0	18.0	8.9	3	DIN 371	•	•	•
M 3.5	4.00	x 3.00		0.60	T200-XM100DA-M3.5	3.5	56.0	20.0	10.8	3	DIN 371	•	•	•
M 4	4.50	x 3.40		0.70	T200-XM100DA-M4	4.0	63.0	21.0	11.7	3	DIN 371	•	•	•
M 4.5	6.00	x 4.90		0.75	T200-XM100DA-M4.5	4.5	70.0	25.0	13.0	3	DIN 371	•	•	
M 5	6.00	x 4.90		0.80	T200-XM100DA-M5	5.0	70.0	25.0	12.6	3	DIN 371	•	•	•
M 6	6.00	x 4.90		1.00	T200-XM100DA-M6	6.0	80.0	30.0	14.5	3	DIN 371	•	•	•
M 7	7.00	x 5.50		1.00	T200-XM100DA-M7	7.0	80.0	30.0	14.5	3	DIN 371	•	•	•
M 8	8.00	x 6.20		1.25	T200-XM100DA-M8	8.0	90.0	35.0	17.4	3	DIN 371	•	•	•
M 10	10.00	x 8.00		1.50	T200-XM100DA-M10	10.0	100.0	39.0	19.2	3	DIN 371	•	•	•
M 12	9.00	x 7.00		1.75	T200-XM101DA-M12	12.0	110.0	83.0	23.0	3	DIN 376	•	•	•
M 14	11.00	x 9.00		2.00	T200-XM101DA-M14	14.0	110.0	81.0	25.0	3	DIN 376	•	•	•
M 16	12.00	x 9.00		2.00	T200-XM101DA-M16	16.0	110.0	68.0	25.0	3	DIN 376	•	•	•
												B110	B145	B150
M 18	14.00	x 11.00		2.50	T200-XM101DA-M18	18.0	125.0	81.0	30.0	4	DIN 376	•	•	•
M 20	16.00	x 12.00		2.50	T200-XM101DA-M20	20.0	140.0	95.0	30.0	4	DIN 376	•	•	•
M 22	18.00	x 14.50		2.50	T200-XM101DA-M22	22.0	140.0	93.0	34.0	4	DIN 376	•	•	•
M 24	18.00	x 14.50		3.00	T200-XM101DA-M24	24.0	160.0	113.0	38.0	4	DIN 376	•	•	•
M 27	20.00	x 16.00		3.00	T200-XM101DA-M27	27.0	160.0	97.0	38.0	4	DIN 376	•	•	•
M 30	22.00	x 18.00		3.50	T200-XM101DA-M30	30.0	180.0	115.0	45.0	4	DIN 376	•	•	•
												C110	C145	C150
M 3	2.20	x 1.80		0.50	T200-XM101DA-M3	3.0	56.0	37.0	10.0	3	DIN 376	•	•	•
M 4	2.80	x 2.10		0.70	T200-XM101DA-M4	4.0	63.0	43.0	11.9	3	DIN 376	•	•	•
M 5	3.50	x 2.70		0.80	T200-XM101DA-M5	5.0	70.0	49.0	13.2	3	DIN 376	•	•	•
M 6	4.50	x 3.40		1.00	T200-XM101DA-M6	6.0	80.0	59.0	15.1	3	DIN 376	•	•	•
M 8	6.00	x 4.90		1.25	T200-XM101DA-M8	8.0	90.0	67.0	18.0	3	DIN 376	•	•	•
M 10	7.00	x 5.50		1.50	T200-XM101DA-M10	10.0	100.0	77.0	20.0	3	DIN 376	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form metric, 6G tolerance

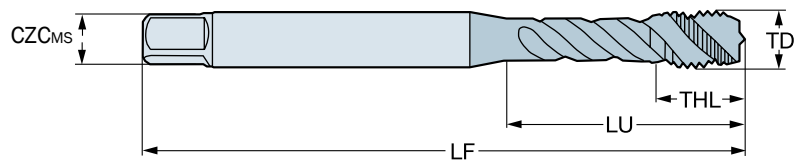
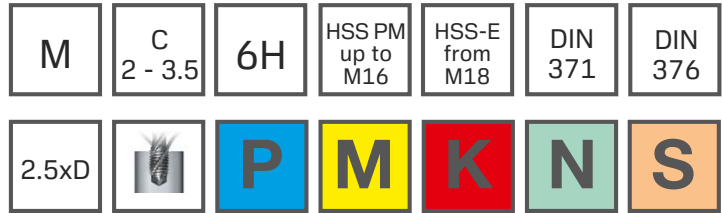


TDZ	CZC _{MS}		TP	Order number	Dimensions, mm							Discount group 781		
	Shank	Square										(coated)	(steam-temp.)	(uncoated)
			Lead			TD	LF	LU	THL	NOF	BSG	C110	C145	C150
M 3	3.50	x 2.70	0.50	T200-XM104DA-M3		3.0	56.0	18.0	8.9	3	DIN 371	•	•	•
M 4	4.50	x 3.40	0.70	T200-XM104DA-M4		4.0	63.0	21.0	12.0	3	DIN 371	•	•	•
M 5	6.00	x 4.90	0.80	T200-XM104DA-M5		5.0	70.0	25.0	13.0	3	DIN 371	•	•	•
M 6	6.00	x 4.90	1.00	T200-XM104DA-M6		6.0	80.0	30.0	15.0	3	DIN 371	•	•	•
M 8	8.00	x 6.20	1.25	T200-XM104DA-M8		8.0	90.0	35.0	18.0	3	DIN 371	•	•	•
M 10	10.00	x 8.00	1.50	T200-XM104DA-M10		10.0	100.0	39.0	20.0	3	DIN 371	•	•	•
M 12	9.00	x 7.00	1.75	T200-XM105DA-M12		12.0	110.0	83.0	23.0	3	DIN 376	•	•	•
M 16	12.00	x 9.00	2.00	T200-XM105DA-M16		16.0	110.0	68.0	25.0	3	DIN 376	•	•	•
												B110	B145	B150
M 20	16.00	x 12.00	2.50	T200-XM105DA-M20		20.0	140.0	95.0	30.0	4	DIN 376	•	•	

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric

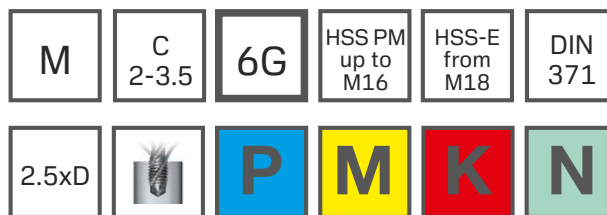


TDZ	CZC _{MS}		TP	Order number	Dimensions, mm						Discount group 781		
											(coated)	(steam-temp.)	(uncoated)
	Shank	Square	Lead		TD	LF	LU	THL	NOF	BSG	C110	C145	C150
M 2	2.80	x 2.10	0.40	T300-XM100DA-M2	2.0	45.0	9.0	4.0	3	DIN 371	•	•	•
M 2.5	2.80	x 2.10	0.45	T300-XM100DA-M2.5	2.5	50.0	12.5	4.0	3	DIN 371	•	•	•
M 3	3.50	x 2.70	0.50	T300-XM100DA-M3	3.0	56.0	18.0	5.9	3	DIN 371	•	•	•
M 3.5	4.00	x 3.00	0.60	T300-XM100DA-M3.5	3.5	56.0	20.0	6.3	3	DIN 371	•	•	•
M 4	4.50	x 3.40	0.70	T300-XM100DA-M4	4.0	63.0	21.0	6.7	3	DIN 371	•	•	•
M 5	6.00	x 4.90	0.80	T300-XM100DA-M5	5.0	70.0	21.0	7.7	3	DIN 371	•	•	•
M 6	6.00	x 4.90	1.00	T300-XM100DA-M6	6.0	80.0	31.0	10.0	3	DIN 371	•	•	•
M 7	7.00	x 5.50	1.00	T300-XM100DA-M7	7.0	80.0	31.0	10.0	3	DIN 371	•	•	•
M 8	8.00	x 6.20	1.25	T300-XM100DA-M8	8.0	90.0	35.0	11.6	3	DIN 371	•	•	•
M 10	10.00	x 8.00	1.50	T300-XM100DA-M10	10.0	100.0	39.0	15.1	3	DIN 371	•	•	•
M 12	9.00	x 7.00	1.75	T300-XM101DA-M12	12.0	110.0	83.0	16.0	3	DIN 376	•	•	•
M 14	11.00	x 9.00	2.00	T300-XM101DA-M14	14.0	110.0	81.0	20.0	3	DIN 376	•	•	•
M 16	12.00	x 9.00	2.00	T300-XM101DA-M16	16.0	110.0	68.0	20.0	4	DIN 376	•	•	•
											B110	B145	B150
M 18	14.00	x 11.00	2.50	T300-XM101DA-M18	18.0	125.0	81.0	25.0	4	DIN 376	•	•	•
M 20	16.00	x 12.00	2.50	T300-XM101DA-M20	20.0	140.0	95.0	25.0	4	DIN 376	•	•	•
M 22	18.00	x 14.50	2.50	T300-XM101DA-M22	22.0	140.0	93.0	25.0	4	DIN 376	•	•	•
M 24	18.00	x 14.50	3.00	T300-XM101DA-M24	24.0	160.0	113.0	30.0	4	DIN 376	•	•	•
M 27	20.00	x 16.00	3.00	T300-XM101DA-M27	27.0	160.0	97.0	30.0	4	DIN 376	•	•	•
M 30	22.00	x 18.00	3.50	T300-XM101DA-M30	30.0	180.0	115.0	36.0	4	DIN 376	•	•	•
M 33	25.00	x 20.00	3.50	T300-XM101DA-M33	33.0	180.0	113.0	36.0	4	DIN 376	•	•	•
M 36	28.00	x 22.00	4.00	T300-XM101DA-M36	36.0	200.0	131.0	40.0	4	DIN 376	•	•	•
M 39	32.00	x 24.00	4.00	T300-XM101DA-M39	39.0	200.0	102.0	40.0	4	DIN 376		•	
M 42	32.00	x 24.00	4.50	T300-XM101DA-M42	42.0	200.0	102.0	45.0	4	DIN 376		•	•
M 48	36.00	x 29.00	5.00	T300-XM101DA-M48	48.0	250.0	147.0	50.0	4	DIN 376		•	
											C110	C145	C150
M 6	4.50	x 3.40	1.00	T300-XM101DA-M6	6.0	80.0	59.0	10.0	3	DIN 376	•	•	•
M 8	6.00	x 4.90	1.25	T300-XM101DA-M8	8.0	90.0	67.0	12.0	3	DIN 376	•	•	•
M 10	7.00	x 5.50	1.50	T300-XM101DA-M10	10.0	100.0	77.0	15.0	3	DIN 376	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric, 6G tolerance



TDZ	CZC _{MS}		TP	Order number	Dimensions, mm							Discount group 781		
	Shank	Square										(coated)	(steam-temp.)	(uncoated)
			Lead			TD	LF	LU	THL	NOF	BSG	C110	C145	C150
M 3	3.50	x 2.70	0.50	T300-XM104DA-M3		3.0	56.0	18.0	5.9	3	DIN 371	•	•	•
M 4	4.50	x 3.40	0.70	T300-XM104DA-M4		4.0	63.0	21.0	6.7	3	DIN 371	•	•	•
M 5	6.00	x 4.90	0.80	T300-XM104DA-M5		5.0	70.0	25.0	7.7	3	DIN 371	•	•	•
M 6	6.00	x 4.90	1.00	T300-XM104DA-M6		6.0	80.0	31.0	10.0	3	DIN 371	•	•	•
M 8	8.00	x 6.20	1.25	T300-XM104DA-M8		8.0	90.0	35.0	12.0	3	DIN 371	•	•	•
M 10	10.00	x 8.00	1.50	T300-XM104DA-M10		10.0	100.0	39.0	15.1	3	DIN 371	•	•	•
M 12	9.00	x 7.00	1.75	T300-XM105DA-M12		12.0	110.0	83.0	16.0	3	DIN 376	•	•	•
M 14	11.00	x 9.00	2.00	T300-XM105DA-M14		14.0	110.0	81.0	20.0	3	DIN 376	•	•	•
M 16	12.00	x 9.00	2.00	T300-XM105DA-M16		16.0	110.0	68.0	20.0	4	DIN 376	•	•	
												B110	B145	B150
M 20	16.00	x 12.00	2.50	T300-XM105DA-M20		20.0	140.0	95.0	25.0	4	DIN 376	•	•	•

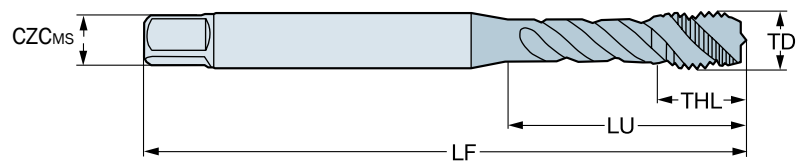
C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric, chamfer form E



M	E 1.5-2	6H	HSS PM up to M16	HSS-E from M18	DIN 371	DIN 376
2.5xD		P	M	K	N	S

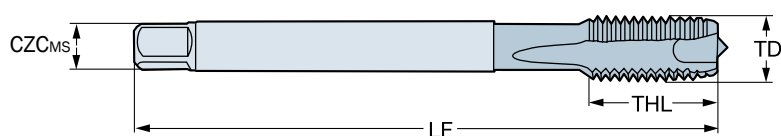


TDZ	CZC _{MS}			TP	Order number	Dimensions, mm						Discount group 781		
												(coated)	(steam-temp.)	(uncoated)
	Shank	Square		Lead		TD	LF	LU	THL	NOF	BSG	C110	C145	C150
M 3	3.50	x 2.70		0.50	T300-XM102DA-M3	3.0	56.0	18.0	5.9	3	DIN 371	•	•	•
M 4	4.50	x 3.40		0.70	T300-XM102DA-M4	4.0	63.0	21.0	6.7	3	DIN 371	•	•	•
M 5	6.00	x 4.90		0.80	T300-XM102DA-M5	5.0	70.0	21.0	7.7	3	DIN 371	•	•	•
M 6	6.00	x 4.90		1.00	T300-XM102DA-M6	6.0	80.0	31.0	10.0	3	DIN 371	•	•	•
M 8	8.00	x 6.20		1.25	T300-XM102DA-M8	8.0	90.0	35.0	11.6	3	DIN 371	•	•	•
M 10	10.00	x 8.00		1.50	T300-XM102DA-M10	10.0	100.0	39.0	15.1	3	DIN 371	•	•	•
M 12	9.00	x 7.00		1.75	T300-XM103DA-M12	12.0	110.0	83.0	16.0	3	DIN 376	•	•	•
M 14	11.00	x 9.00		2.00	T300-XM103DA-M14	14.0	110.0	81.0	20.0	3	DIN 376	•	•	
M 16	12.00	x 9.00		2.00	T300-XM103DA-M16	16.0	110.0	68.0	20.0	4	DIN 376	•	•	•
												B110	B145	B150
M 20	16.00	x 12.00		2.50	T300-XM103DA-M20	20.0	95.0	140.0	25.0	4	DIN 376	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form metric fine

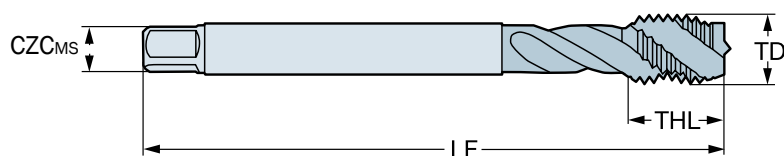


TDZ	CZC _{MS}		Order number	Dimensions, mm						Discount group 781		
										(coated)	(steam-temp.)	(uncoated)
	Shank	Square		TD	LF	LU	THL	NOF	BSG	C110	C145	C150
MF 4x0.5	2.80	x 2.10	T200-XM100DB-M4X050	4.0	63.0	43.0	11.9	3	DIN 374	•	•	•
MF 5x0.5	3.50	x 2.70	T200-XM100DB-M5X050	5.0	70.0	49.0	13.2	3	DIN 374	•	•	•
MF 6x0.75	4.50	x 3.40	T200-XM100DB-M6X075	6.0	80.0	59.0	15.1	3	DIN 374	•	•	•
MF 8x0.75	6.00	x 4.90	T200-XM100DB-M8X075	8.0	80.0	57.0	14.9	3	DIN 374	•	•	•
MF 8x1	6.00	x 4.90	T200-XM100DB-M8X100	8.0	90.0	67.0	18.0	3	DIN 374	•	•	•
MF 10x0.75	7.00	x 5.50	T200-XM100DB-M10X075	10.0	90.0	67.0	17.6	3	DIN 374	•	•	•
MF 10x1	7.00	x 5.50	T200-XM100DB-M10X100	10.0	90.0	67.0	17.6	3	DIN 374	•	•	•
MF 10x1.25	7.00	x 5.50	T200-XM100DB-M10X125	10.0	100.0	77.0	19.8	3	DIN 374	•	•	•
MF 12x1	9.00	x 7.00	T200-XM100DB-M12X100	12.0	100.0	73.0	21.0	3	DIN 374	•	•	•
MF 12x1.25	9.00	x 7.00	T200-XM100DB-M12X125	12.0	100.0	73.0	21.0	3	DIN 374	•	•	•
MF 12x1.5	9.00	x 7.00	T200-XM100DB-M12X150	12.0	100.0	73.0	21.0	3	DIN 374	•	•	•
MF 14x1	11.00	x 9.00	T200-XM100DB-M14X100	14.0	100.0	71.0	21.0	3	DIN 374	•	•	•
MF 14x1.25	11.00	x 9.00	T200-XM100DB-M14X125	14.0	100.0	71.0	21.0	3	DIN 374	•	•	•
MF 14x1.5	11.00	x 9.00	T200-XM100DB-M14X150	14.0	100.0	71.0	21.0	3	DIN 374	•	•	•
MF 16x1	12.00	x 9.00	T200-XM100DB-M16X100	16.0	100.0	58.0	21.0	3	DIN 374	•	•	•
MF 16x1.5	12.00	x 9.00	T200-XM100DB-M16X150	16.0	100.0	58.0	21.0	3	DIN 374	•	•	•
										B110	B145	B150
MF 18x1	14.00	x 11.00	T200-XM100DB-M18X100	18.0	110.0	66.0	24.0	4	DIN 374	•	•	•
MF 18x1.5	14.00	x 11.00	T200-XM100DB-M18X150	18.0	110.0	66.0	24.0	4	DIN 374	•	•	•
MF 20x1	16.00	x 12.00	T200-XM100DB-M20X100	20.0	125.0	80.0	24.0	4	DIN 374	•	•	•
MF 20x1.5	16.00	x 12.00	T200-XM100DB-M20X150	20.0	125.0	80.0	24.0	4	DIN 374	•	•	•
MF 22x1.5	18.00	x 14.50	T200-XM100DB-M22X150	22.0	125.0	78.0	25.0	4	DIN 374	•	•	•
MF 24x1.5	18.00	x 14.50	T200-XM100DB-M24X150	24.0	140.0	93.0	28.0	4	DIN 374	•	•	•
MF 24x2	18.00	x 14.50	T200-XM100DB-M24X200	24.0	140.0	93.0	28.0	4	DIN 374	•	•	•
MF 25x1.5	18.00	x 14.50	T200-XM100DB-M25X150	25.0	140.0	93.0	28.0	4	DIN 374	•	•	•
MF 26x1.5	18.00	x 14.50	T200-XM100DB-M26X150	26.0	140.0	93.0	28.0	4	DIN 374	•	•	•
MF 27x2	20.00	x 16.00	T200-XM100DB-M27X200	27.0	140.0	77.0	28.0	4	DIN 374	•	•	•
MF 30x1.5	22.00	x 18.00	T200-XM100DB-M30X150	30.0	150.0	85.0	28.0	4	DIN 374	•	•	•
MF 30x2	22.00	x 18.00	T200-XM100DB-M30X200	30.0	150.0	85.0	28.0	4	DIN 374	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form metric fine

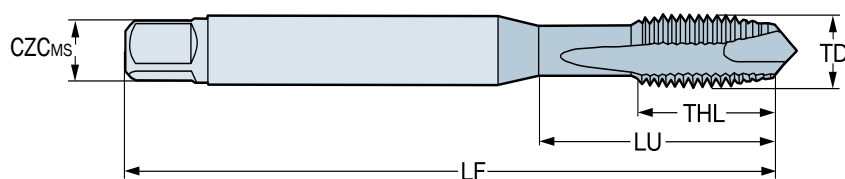
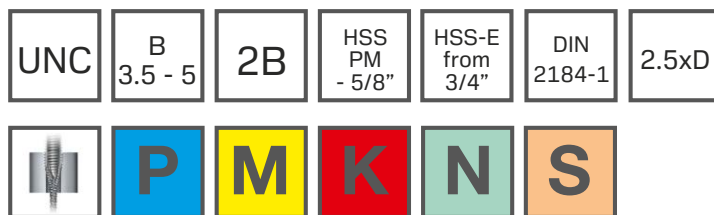


TDZ	CZC _{MS}		Order number	Dimensions, mm						Discount group 781		
	Shank	Square		TD	LF	LU	THL	NOF	BSG	(coated) C110	(steam-temp.) C145	(uncoated) C150
MF 4x0.5	2.80	x 2.10	T300-XM100DB-M4X050	4.0	63.0	43.0	6.8	3	DIN 374	•	•	•
MF 5x0.5	3.50	x 2.70	T300-XM100DB-M5X050	5.0	70.0	49.0	8.2	3	DIN 374	•	•	•
MF 6x0.75	4.50	x 3.40	T300-XM100DB-M6X075	6.0	80.0	59.0	10.0	3	DIN 374	•	•	•
MF 8x0.75	6.00	x 4.90	T300-XM100DB-M8X075	8.0	80.0	57.0	13.0	3	DIN 374	•	•	•
MF 8x1	6.00	x 4.90	T300-XM100DB-M8X100	8.0	90.0	67.0	13.0	3	DIN 374	•	•	•
MF 10x0.75	7.00	x 5.50	T300-XM100DB-M10X075	10.0	90.0	67.0	13.0	3	DIN 374	•	•	•
MF 10x1	7.00	x 5.50	T300-XM100DB-M10X100	10.0	90.0	67.0	13.0	3	DIN 374	•	•	•
MF 10x1.25	7.00	x 5.50	T300-XM100DB-M10X125	10.0	100.0	77.0	15.0	3	DIN 374	•	•	•
MF 12x1	9.00	x 7.00	T300-XM100DB-M12X100	12.0	100.0	73.0	15.0	3	DIN 374	•	•	•
MF 12x1.25	9.00	x 7.00	T300-XM100DB-M12X125	12.0	100.0	73.0	15.0	3	DIN 374	•	•	•
MF 12x1.5	9.00	x 7.00	T300-XM100DB-M12X150	12.0	100.0	73.0	15.0	3	DIN 374	•	•	•
MF 14x1	11.00	x 9.00	T300-XM100DB-M14X100	14.0	100.0	71.0	15.0	3	DIN 374	•	•	•
MF 14x1.25	11.00	x 9.00	T300-XM100DB-M14X125	14.0	100.0	71.0	15.0	3	DIN 374	•	•	•
MF 14x1.5	11.00	x 9.00	T300-XM100DB-M14X150	14.0	100.0	71.0	15.0	3	DIN 374	•	•	•
MF 16x1	12.00	x 9.00	T300-XM100DB-M16X100	16.0	100.0	58.0	15.0	4	DIN 374	•	•	•
MF 16x1.5	12.00	x 9.00	T300-XM100DB-M16X150	16.0	100.0	58.0	15.0	4	DIN 374	•	•	•
										B110	B145	B150
MF 18x1	14.00	x 11.00	T300-XM100DB-M18X100	18.0	110.0	66.0	17.0	4	DIN 374	•	•	•
MF 18x1.5	14.00	x 11.00	T300-XM100DB-M18X150	18.0	110.0	66.0	17.0	4	DIN 374	•	•	•
MF 20x1	16.00	x 12.00	T300-XM100DB-M20X100	20.0	125.0	80.0	17.0	4	DIN 374	•	•	•
MF 20x1.5	16.00	x 12.00	T300-XM100DB-M20X150	20.0	125.0	80.0	17.0	4	DIN 374	•	•	•
MF 22x1.5	18.00	x 14.50	T300-XM100DB-M22X150	22.0	125.0	78.0	17.0	4	DIN 374	•	•	•
MF 24x1.5	18.00	x 14.50	T300-XM100DB-M24X150	24.0	140.0	93.0	20.0	4	DIN 374	•	•	•
MF 24x2	18.00	x 14.50	T300-XM100DB-M24X200	24.0	140.0	93.0	20.0	4	DIN 374	•	•	•
MF 25x1.5	18.00	x 14.50	T300-XM100DB-M25X150	25.0	140.0	93.0	20.0	4	DIN 374	•	•	•
MF 26x1.5	18.00	x 14.50	T300-XM100DB-M26X150	26.0	140.0	93.0	20.0	4	DIN 374	•	•	•
MF 27x1.5	20.00	x 16.00	T300-XM100DB-M27X150	27.0	140.0	77.0	20.0	4	DIN 374	•	•	•
MF 27x2	20.00	x 16.00	T300-XM100DB-M27X200	27.0	140.0	77.0	20.0	4	DIN 374	•	•	•
MF 30x1.5	22.00	x 18.00	T300-XM100DB-M30X150	30.0	150.0	85.0	20.0	4	DIN 374	•	•	•
MF 30x2	22.00	x 18.00	T300-XM100DB-M30X200	30.0	150.0	85.0	20.0	4	DIN 374	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form UNC

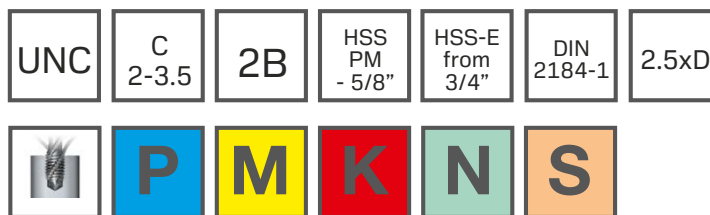


TDZ	CZC _{MS}		Order number	Dimensions, mm						Discount group 781		
	Shank	Square		TD	LF	LU	THL	NOF	BSG	(coated) C110	(steam-temp.) C145	(uncoated) C150
UNC #4-40	3.50	x 2.70	T200-XM100DE-4-40	2.8	56.0	18.0	8.5	3	DIN 2184-1	•	•	•
UNC #5-40	3.50	x 2.70	T200-XM100DE-5-40	3.1	56.0	18.0	9.5	3	DIN 2184-1	•	•	•
UNC #6-32	4.00	x 3.00	T200-XM100DE-6-32	3.5	56.0	20.0	10.4	3	DIN 2184-1	•	•	•
UNC #8-32	4.50	x 3.40	T200-XM100DE-8-32	4.1	63.0	21.0	11.4	3	DIN 2184-1	•	•	•
UNC #10-24	6.00	x 4.90	T200-XM100DE-10-24	4.8	70.0	25.0	13.0	3	DIN 2184-1	•	•	•
UNC #12-24	6.00	x 4.90	T200-XM100DE-12-24	5.4	80.0	30.0	15.0	3	DIN 2184-1	•	•	•
UNC 1/4-20	7.00	x 5.50	T200-XM100DE-1/4	6.3	80.0	30.0	14.1	3	DIN 2184-1	•	•	•
UNC 5/16-18	8.00	x 6.20	T200-XM100DE-5/16	7.9	90.0	35.0	17.4	3	DIN 2184-1	•	•	•
UNC 3/8-16	10.00	x 8.00	T200-XM100DE-3/8	9.5	100.0	39.0	18.9	3	DIN 2184-1	•	•	•
UNC 7/16-14	8.00	x 6.20	T200-XM101DE-7/16	11.1	100.0	76.0	20.0	3	DIN 2184-1	•	•	•
UNC 1/2-13	9.00	x 7.00	T200-XM101DE-1/2	12.7	110.0	83.0	23.0	3	DIN 2184-1	•	•	•
UNC 5/8-11	12.00	x 9.00	T200-XM101DE-5/8	15.8	110.0	68.0	25.0	3	DIN 2184-1	•	•	•
										B110	B145	B150
UNC 3/4-10	14.00	x 11.00	T200-XM101DE-3/4	19.0	125.0	81.0	30.0	4	DIN 2184-1	•	•	•
UNC 7/8-9	18.00	x 14.50	T200-XM101DE-7/8	22.2	140.0	93.0	34.0	4	DIN 2184-1	•	•	•
UNC 1"-8	18.00	x 14.50	T200-XM101DE-1	25.4	160.0	113.0	38.0	4	DIN 2184-1	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form UNC

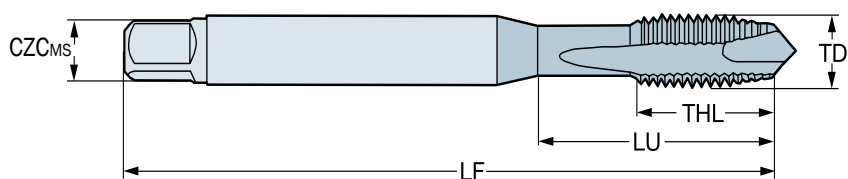
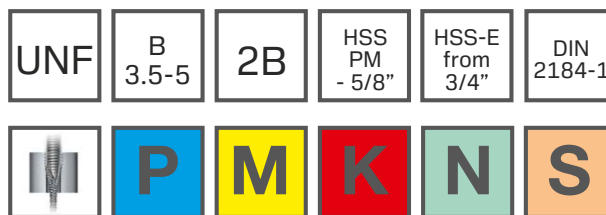


TDZ	CZC _{MS}		Order number	Dimensions, mm						Discount group 781		
	Shank	Square		TD	LF	LU	THL	NOF	BSG	(coated) C110	(steam-temp.) C145	(uncoated) C150
UNC #4-40	3.50	x 2.70	T300-XM100DE-4-40	2.8	56.0	18.0	5.6	3	DIN 2184-1	•	•	•
UNC #5-40	3.50	x 2.70	T300-XM100DE-5-40	3.1	56.0	18.0	5.6	3	DIN 2184-1	•	•	•
UNC #6-32	4.00	x 3.00	T300-XM100DE-6-32	3.5	56.0	20.0	6.5	3	DIN 2184-1	•	•	•
UNC #8-32	4.50	x 3.40	T300-XM100DE-8-32	4.1	63.0	21.0	6.5	3	DIN 2184-1	•	•	•
UNC #10-24	6.00	x 4.90	T300-XM100DE-10-24	4.8	70.0	25.0	8.0	3	DIN 2184-1	•	•	•
UNC #12-24	6.00	x 4.90	T300-XM100DE-12-24	5.4	80.0	30.0	10.0	3	DIN 2184-1	•	•	•
UNC 1/4-20	7.00	x 5.50	T300-XM100DE-1/4	6.3	80.0	30.0	10.0	3	DIN 2184-1	•	•	•
UNC 5/16-18	8.00	x 6.20	T300-XM100DE-5/16	7.9	90.0	35.0	12.0	3	DIN 2184-1	•	•	•
UNC 3/8-16	10.00	x 8.00	T300-XM100DE-3/8	9.5	100.0	39.0	15.0	3	DIN 2184-1	•	•	•
UNC 7/16-14	8.00	x 6.20	T300-XM101DE-7/16	11.1	100.0	75.7	15.0	3	DIN 2184-1	•	•	•
UNC 1/2-13	9.00	x 7.00	T300-XM101DE-1/2	12.7	110.0	82.7	18.0	3	DIN 2184-1	•	•	•
UNC 5/8-11	12.00	x 9.00	T300-XM101DE-5/8	15.8	110.0	67.7	20.0	4	DIN 2184-1	•	•	•
										B110	B145	B150
UNC 3/4-10	14.00	x 11.00	T300-XM101DE-3/4	19.0	125.0	80.7	25.0	4	DIN 2184-1	•	•	•
UNC 7/8-9	18.00	x 14.50	T300-XM101DE-7/8	22.2	140.0	92.7	25.0	4	DIN 2184-1	•	•	•
UNC 1"-8	18.00	x 14.50	T300-XM101DE-1	25.4	160.0	112.7	30.0	4	DIN 2184-1	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form UNF

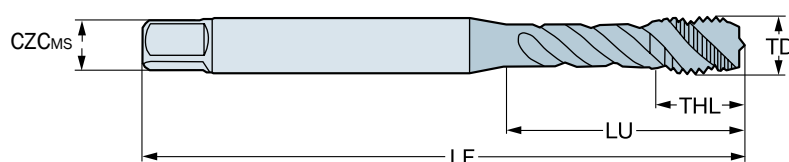
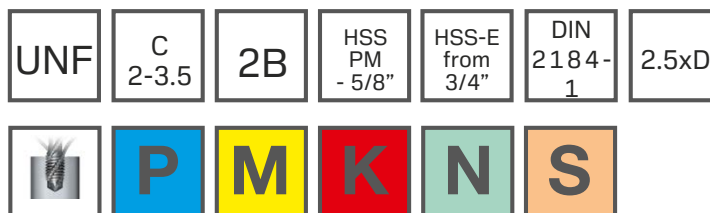


TDZ	CZC _{MS}		Order number	Dimensions, mm						Discount group 781		
	Shank	Square		TD	LF	LU	THL	NOF	BSG	(coated) C110	(steam-temp.) C145	(uncoated) C150
UNF #8-36	4.50	x 3.40	T200-XM100DF-8-36	4.1	63.0	21.0	11.4	3	DIN 2184-1	•	•	
UNF #10-32	6.00	x 4.90	T200-XM100DF-10-32	4.8	70.0	25.0	12.2	3	DIN 2184-1	•	•	•
UNF 1/4-28	7.00	x 5.50	T200-XM100DF-1/4	6.3	80.0	30.0	14.1	3	DIN 2184-1	•	•	•
UNF 5/16-24	8.00	x 6.20	T200-XM100DF-5/16	7.9	90.0	35.0	17.4	3	DIN 2184-1	•	•	
UNF 3/8-24	10.00	x 8.00	T200-XM100DF-3/8	9.5	100.0	39.0	18.9	3	DIN 2184-1	•	•	
UNF 7/16-20	8.00	x 6.20	T200-XM101DF-7/16	11.1	100.0	76.0	20.0	3	DIN 2184-1	•	•	•
UNF 1/2-20	9.00	x 7.00	T200-XM101DF-1/2	12.7	110.0	83.0	23.0	3	DIN 2184-1	•	•	•
UNF 5/8-18	12.00	x 9.00	T200-XM101DF-5/8	15.8	110.0	68.0	25.0	3	DIN 2184-1	•	•	•
										B110	B145	B150
UNF 3/4-16	14.00	x 11.00	T200-XM101DF-3/4	19.0	125.0	81.0	30.0	4	DIN 2184-1	•	•	•
UNF 7/8-14	18.00	x 14.50	T200-XM101DF-7/8	22.2	140.0	93.0	34.0	4	DIN 2184-1	•	•	
UNF 1"-12	18.00	x 14.50	T200-XM101DF-1	25.4	160.0	113.0	38.0	4	DIN 2184-1	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form UNF

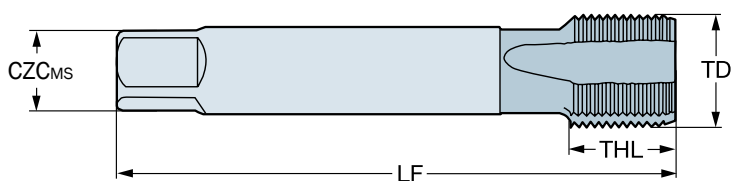
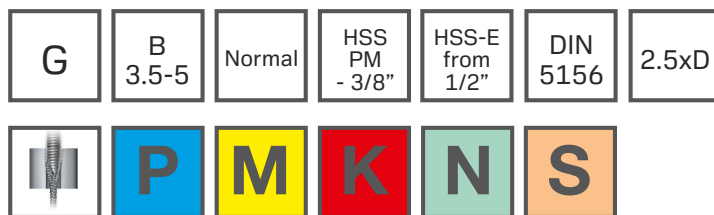


TDZ	CZC _{MS}		Order number	Dimensions, mm						Discount group 781		
	Shank	Square		TD	LF	LU	THL	NOF	BSG	(coated) C110	(steam-temp.) C145	(uncoated) C150
UNF #8-36	4.50	x 3.40	T300-XM100DF-8-36	4.1	63.0	21.0	6.5	3	DIN 2184-1	•		•
UNF #10-32	6.00	x 4.90	T300-XM100DF-10-32	4.8	70.0	25.0	7.3	3	DIN 2184-1	•	•	•
UNF 1/4-28	7.00	x 5.50	T300-XM100DF-1/4	6.3	80.0	30.0	10.0	3	DIN 2184-1	•	•	•
UNF 5/16-24	8.00	x 6.20	T300-XM100DF-5/16	7.9	90.0	35.0	12.0	3	DIN 2184-1	•	•	•
UNF 3/8-24	10.00	x 8.00	T300-XM100DF-3/8	9.5	100.0	39.0	15.0	3	DIN 2184-1	•	•	•
UNF 7/16-20	8.00	x 6.20	T300-XM101DF-7/16	11.1	100.0	75.7	15.0	3	DIN 2184-1	•	•	•
UNF 1/2-20	9.00	x 7.00	T300-XM101DF-1/2	12.7	110.0	83.0	18.0	3	DIN 2184-1	•	•	•
UNF 5/8-18	12.00	x 9.00	T300-XM101DF-5/8	15.8	110.0	67.7	20.0	4	DIN 2184-1	•	•	•
										B110	B145	B150
UNF 3/4-16	14.00	x 11.00	T300-XM101DF-3/4	19.0	125.0	77.5	25.0	4	DIN 2184-1	•	•	•
UNF 7/8-14	18.00	x 14.50	T300-XM101DF-7/8	22.2	140.0	92.7	25.0	4	DIN 2184-1	•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 200 tap for through-holes

Thread form G

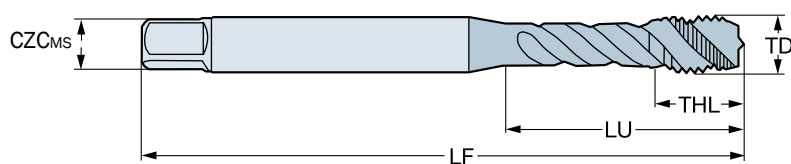
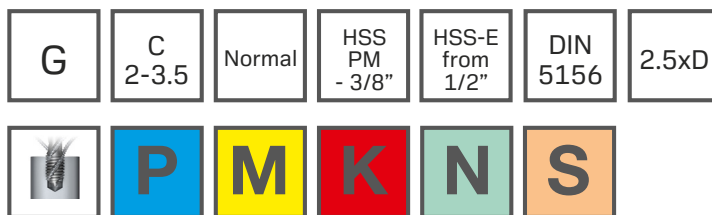


TDZ	CZC _{MS}		Order number	Dimensions, mm							Discount group 781		
	Shank	Square		TD	LF	LU	THL	NOF	BSG		(coated) C110	(steam-temp.) C145	(uncoated) C150
G 1/8-28	7.00	x 5.50	T200-XM100DK-1/8	9.7	90.0	67.0	18.0	3	DIN 5156		•	•	•
G 1/4-19	11.00	x 9.00	T200-XM100DK-1/4	13.1	100.0	71.0	21.0	3	DIN 5156		•	•	•
G 3/8-19	12.00	x 9.00	T200-XM100DK-3/8	16.6	100.0	58.0	21.0	4	DIN 5156		•	•	•
											B110	B145	B150
G 1/2-14	16.00	x 12.00	T200-XM100DK-1/2	20.9	125.0	80.0	24.0	4	DIN 5156		•	•	•
G 5/8-14	18.00	x 14.50	T200-XM100DK-5/8	22.9	125.0	78.0	24.0	4	DIN 5156				•
G 3/4-14	20.00	x 16.00	T200-XM100DK-3/4	26.4	140.0	77.0	28.0	4	DIN 5156		•	•	•
G 1"-11	25.00	x 20.00	T200-XM100DK-1	33.2	160.0	93.0	30.0	4	DIN 5156		•	•	•

C grade: HSS-PM
B grade: HSS-E

CoroTap™ 300 tap for blind holes

Thread form G



TDZ	CZC _{MS}		Order number	Dimensions, mm							Discount group 781		
	Shank	Square		TD	LF	LU	THL	NOF	BSG		(coated) C110	(steam-temp.) C145	(uncoated) C150
G 1/8-28	7.00	x 5.50	T300-XM100DK-1/8	9.7	90.0	67.0	13.0	3	DIN 5156		•	•	•
G 1/4-19	11.00	x 9.00	T300-XM100DK-1/4	13.1	100.0	71.0	15.0	3	DIN 5156		•	•	•
G 3/8-19	12.00	x 9.00	T300-XM100DK-3/8	16.6	100.0	58.0	15.0	4	DIN 5156		•	•	•
											B110	B145	B150
G 1/2-14	16.00	x 12.00	T300-XM100DK-1/2	20.9	125.0	80.0	18.0	4	DIN 5156		•	•	•
G 5/8-14	18.00	x 14.50	T300-XM100DK-5/8	22.9	125.0	78.0	18.0	4	DIN 5156			•	
G 3/4-14	20.00	x 16.00	T300-XM100DK-3/4	26.4	140.0	77.0	20.0	4	DIN 5156		•	•	•
G 1"-11	25.00	x 20.00	T300-XM100DK-1	33.2	160.0	93.0	22.0	4	DIN 5156		•	•	•
G 1.1/4-11	32.00	x 24.00	T300-XM100DK-1.1/4	41.9	170.0	72.0	22.0	4	DIN 5156			•	
G 1.1/2-11	36.00	x 29.00	T300-XM100DK-1.1/2	47.8	190.0	87.0	23.0	4	DIN 5156			•	

C grade: HSS-PM
B grade: HSS-E

Cutting data for the CoroTap™ 200/300

Cutting speed

ISO	MC no.	Material	Hard- ness Brinell HB	Grade B/C110			Grade B/C145			Grade B/C150		
				1.5xD	2xD	2.5xD	1.5xD	2xD	2.5xD	1.5xD	2xD	2.5xD
				v _C (m/min)			v _C (m/min)			v _C (m/min)		
P		Non-alloy carbon steel										
	P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	125	43	35	30	31	25	21	31	25	21
	P1.1.Z.HT	See heat-treated above	190	41	34	29	27	22	19	27	22	19
	P1.2.Z.AN	S355J2G3; C45; 40Mn6; St52	190	39	32	27	22	18	15	22	18	15
	P1.2.Z.HT	See heat-treated above	210	31	26	22	20	16	14	20	16	14
	P1.3.Z.AN	S340 MGC; C60; C105W1	190	39	32	27	22	18	15	22	18	15
	P1.3.Z.HT	See heat-treated above	300	21	17	15	12	10	9	12	10	9
		Low-alloy steel										
	P2.1.Z.AN	17CrNiMo6; 16MnCr5	175	39	32	27	22	18	15	22	18	15
	P2.2.Z.AN	31CrMo12; 34CrNiMo6; 51CrV4; 42CrMo4	240	31	26	22	20	16	14	20	16	14
	P2.3.Z.AN	100Cr6; 105WCr6	260	21	17	15	12	10	9	12	10	9
	P2.5.Z.HT.1	34CrNiMo6 V; 51CrV4 V; 41CrAlMo7 V	285	21	17	15	12	10	9	12	10	9
		High-alloy steel										
	P3.0.Z.AN	X210Cr12; X100CrMoV5 1; X155CrMoV12-1	200	31	26	22	20	16	14	20	16	14
	P3.0.Z.HT.1	See hardened above	380	10	8	7	6	5	4	6	5	4
	P3.1.Z.AN	S6-5-2; HS 6-5-2-5; HS 2-9-2	250	31	26	22	20	16	14	20	16	14
M		Cast steel										
	P1.5.C.UT	GC16E (1.1142)	150	39	32	27	22	18	15	22	18	15
	P2.6.C.UT	22Mo4; 25CrMo4	200	31	26	22	20	16	14	20	16	14
		Ferritic/martensitic stainless steel										
	P5.0.Z.HT.1	X6Cr17; X6CrMo17-1; X20CrMoV12-1	330	32	26	22	20	16	14	20	16	14
	P5.0.Z.PH	X85CrMoV18-2; X19CrNi17-2; X4 CrNiMo16-5	330	12	10	9	5	4	3			
		Austenitic stainless steel										
	M1.0.Z.AQ	1.4301; 1.4404	200	10	8	7	7	6	5			
	M1.0.C.UT	1.4848; X2CrNiMo17-12-2; X2CrNiMoN17-11-2	230	10	8	7	7	6	5			
		Super austenitic stainless steel										
K	M2.0.Z.AQ	X1NiCrMoCu25-20-5; X8CrNi25-21; X12NiCrSi36 16	200	10	8	7	7	6	5			
	M2.0.C.AQ	654 SMO	260	10	8	7	7	6	5			
		Stainless (austenitic/ferritic) duplex steels										
	M3.1.Z.AQ	X2CrNiN23-4; X8CrNiMo27-5; 1.4362	200	6	5	4	5	4	3			
	M3.2.Z.AQ	X2CrNiMoN22-53; X2CrNiN23-4	200	6	5	4	5	4	3			
	M3.1.C.AQ	X2CrNiN23-4; X8CrNiMo27-5	230	6	5	4	5	4	3			
		Malleable cast iron										
	K1.1.C.NS	EN-GJMB350-10; EN-GJMB550-4; EN-GJMB700-2	200	24	20	17	18	15	13	18	15	13
N		Grey cast iron										
	K2.1.C.UT	EN-GJL-150; EN-GJL-200; EN-GJL-250 (GG25)	180	23	19	16	18	15	13	18	15	13
	K2.2.C.UT	EN-GJL-300; EN-GJL-350	245	16	13	11	10	8	7	10	8	7
	K2.3.C.UT	GGL-NiCr20-2	175	24	20	17	18	15	13	18	15	13
		Ductile cast iron										
	K3.1.C.UT	EN-GJS-400-15; N-GJS-800-7; EN-GJS-400-18-LT (GGG40)	155	24	20	17	18	15	13	18	15	13
	K3.2.C.UT	EN-GJS-600-3 (GGG50)	215	24	20	17	18	15	13	18	15	13
	K3.3.C.UT	EN-GJS-700-2	265	24	20	17	18	15	13	18	15	13
	K3.5.C.UT	EN-GJSA-XNiCr20-2	190	24	20	17	18	15	13	18	15	13
	K5.1.C.NS	EN-GJS-800-8; EN-GJS-1000-5	300	16	13	11	10	8	7	10	8	7
S		Aluminium alloys										
	N1.2.Z.UT	EN AW-7075	60	49	40	34				43	35	30
	N1.2.Z.AG	AlMgSi1	100	49	40	34				43	35	30
	N1.3.C.UT	G-AlMg5	75	49	40	34				43	35	30
	N1.3.C.AG	GD-AlSi8Cu3	90	31	25	21				24	20	17
	N1.4.C.NS	AlSi21CuNiMg	130	21	18	15				18	15	13
		Copper-based alloys										
	N3.3.U.UT	CuZn39Pb3	110	46	38	32				37	30	26
S		Brass, copper	100	18	15	13				15	12	10
		Iron-based super alloys										
	S1.0.U.AN	TMG 1.7.3	200	9	8	6				6	5	4
		Nickel-based super alloys										
	S2.0.Z.UT	TMG 2.1; PMG 4.3	275	9	8	6				6	5	4
	S2.0.Z.AN	Inconel, Hastelloy, Rene 41	250	9	8	6				6	5	4
S	S2.1.Z.AN	TMG 1.1.2; PMG 5.1	125	23	19	16				15	12	10
		Titanium-based alloy										
	S4.1.Z.UT	TiAl6V4	200	21	18	15				18	15	13

= only valid for CoroTap™ 200

CoroTap™ 400-XM

Applications

- Can be used for both through holes and blind holes
- Available in many thread shapes and standards
- Depths up to $3.5 \times D$



Features and advantages

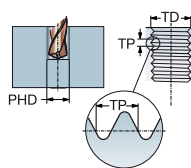
- Chamfer C (2–3 threads) and chamfer E (1.5–2 threads). Chamfer E especially for blind holes with little clearance
- HSS-E thread former for greater wear resistance
- Threading tools that form the thread rather than cutting it
- A chip-free solution
- Not suitable for all materials, since a certain degree of ductility is required. Recommended maximum tensile strength is 1200 N/mm^2
- For both through holes and blind holes
- Available with and without lubricating grooves and internal cooling



ISO application range

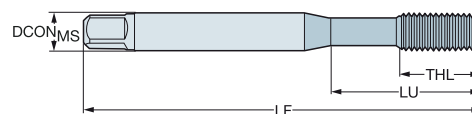
CoroTap™ 400 thread former

Thread form: Metric
DIN 2174



ULDR
SUBSTRATE
COATING

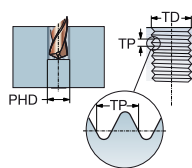
3.0
HSS-E
PVD TIN



TDZ	CZC _{MS}		Order number		Dimensions, mm						Discount group 781
	Shank	Square			TD	LF	LU	THL	NOF	BSG	
M 1 *	2.50	x 2.10	T400-XM100DA-M1	B125	1.00	40.0	20.00	5.5	3	DIN 2174	
M 1.2 *	2.50	x 2.10	T400-XM100DA-M1.2	B125	1.20	40.0	20.00	5.5	3	DIN 2174	
M 1.4 *	2.50	x 2.10	T400-XM100DA-M1.4	B125	1.40	40.0	20.00	7.0	3	DIN 2174	
M 1.6	2.50	x 2.10	T400-XM100DA-M1.6	B125	1.60	40.0	20.00	8.0	3	DIN 2174	
M 1.7	2.50	x 2.10	T400-XM100DA-M1.7	B125	1.70	40.0	20.00	8.0	3	DIN 2174	
M 1.8	2.50	x 2.10	T400-XM100DA-M1.8	B125	1.80	40.0	20.00	8.0	3	DIN 2174	
M 2	2.80	x 2.10	T400-XM100DA-M2	B125	2.00	45.0	11.00	6.0	3	DIN 2174	
M 2.2	2.80	x 2.10	T400-XM100DA-M2.2	B125	2.20	45.0	12.00	7.0	3	DIN 2174	
M 2.3	2.80	x 2.10	T400-XM100DA-M2.3	B125	2.30	45.0	12.00	7.0	3	DIN 2174	
M 2.5	2.80	x 2.10	T400-XM100DA-M2.5	B125	2.50	50.0	14.00	8.0	3	DIN 2174	
M 2.6	2.80	x 2.10	T400-XM100DA-M2.6	B125	2.60	50.0	14.00	8.0	3	DIN 2174	
M 3	3.50	x 2.70	T400-XM100DA-M3	B125	3.00	56.0	18.00	9.0	4	DIN 2174	
M 3.5	4.00	x 3.00	T400-XM100DA-M3.5	B125	3.50	56.0	20.00	11.0	4	DIN 2174	
M 4	4.50	x 3.40	T400-XM100DA-M4	B125	4.00	63.0	21.00	12.0	5	DIN 2174	
M 5	6.00	x 4.90	T400-XM100DA-M5	B125	5.00	70.0	25.00	13.0	5	DIN 2174	
M 6	6.00	x 4.90	T400-XM100DA-M6	B125	6.00	80.0	30.00	15.0	5	DIN 2174	
M 8	8.00	x 6.20	T400-XM100DA-M8	B125	8.00	90.0	35.00	18.0	5	DIN 2174	
M 10	10.00	x 8.00	T400-XM100DA-M10	B125	10.00	100.0	39.00	20.0	5	DIN 2174	
M 12	9.00	x 7.00	T400-XM101DA-M12	B125	12.00	110.0	83.00	23.0	5	DIN 2174	
M 16	12.00	x 9.00	T400-XM101DA-M16	B125	16.00	110.0	68.00	25.0	6	DIN 2174	
M 20	16.00	x 12.00	T400-XM101DA-M20	B125	20.00	140.0	70.00	30.0	7	DIN 2174	
M 24	18.00	x 14.50	T400-XM101DA-M24	B125	24.00	160.0	80.00	36.0	8	DIN 2174	

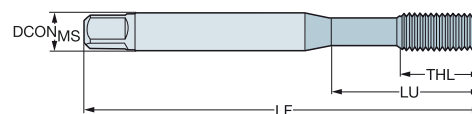
CoroTap™ 400 thread former

Thread form: Metric
DIN 2174

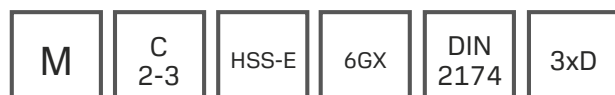


ULDR
SUBSTRATE
COATING

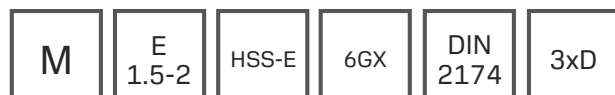
3.0
HSS-E
PVD TIN



TDZ	CZC _{MS}		Order number		Dimensions, mm						Discount group 781
	Shank	Square			TD	LF	LU	THL	NOF	BSG	
M 3	3.50	x 2.70	T400-XM102DA-M3	B125	3.00	56.0	18.00	9.0	4	DIN 2174	
M 4	4.50	x 3.40	T400-XM102DA-M4	B125	4.00	63.0	21.00	12.0	5	DIN 2174	
M 5	6.00	x 4.90	T400-XM102DA-M5	B125	5.00	70.0	25.00	13.0	5	DIN 2174	
M 6	6.00	x 4.90	T400-XM102DA-M6	B125	6.00	80.0	30.00	15.0	5	DIN 2174	
M 8	8.00	x 6.20	T400-XM102DA-M8	B125	8.00	90.0	35.00	18.0	5	DIN 2174	
M 10	10.00	x 8.00	T400-XM102DA-M10	B125	10.00	100.0	39.00	20.0	5	DIN 2174	



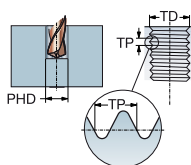
M 3	3.50	x 2.70	T400-XM112DA-M3	B125	3.00	56.0	18.00	9.0	4	DIN 2174	
M 3.5	4.00	x 3.00	T400-XM112DA-M3.5	B125	3.50	56.0	20.00	11.0	4	DIN 2174	
M 4	4.50	x 3.40	T400-XM112DA-M4	B125	4.00	63.0	21.00	12.0	5	DIN 2174	
M 5	6.00	x 4.90	T400-XM112DA-M5	B125	5.00	70.0	25.00	13.0	5	DIN 2174	
M 6	6.00	x 4.90	T400-XM112DA-M6	B125	6.00	80.0	30.00	15.0	5	DIN 2174	
M 8	8.00	x 6.20	T400-XM112DA-M8	B125	8.00	90.0	35.00	18.0	5	DIN 2174	
M 10	10.00	x 8.00	T400-XM112DA-M10	B125	10.00	100.0	39.00	20.0	5	DIN 2174	
M 12	9.00	x 7.00	T400-XM113DA-M12	B125	12.00	110.0	83.00	23.0	5	DIN 2174	



M 3	3.50	x 2.70	T400-XM116DA-M3	B125	3.00	56.0	18.00	9.0	4	DIN 2174	
M 4	4.50	x 3.40	T400-XM116DA-M4	B125	4.00	63.0	21.00	12.0	5	DIN 2174	
M 5	6.00	x 4.90	T400-XM116DA-M5	B125	5.00	70.0	25.00	13.0	5	DIN 2174	
M 6	6.00	x 4.90	T400-XM116DA-M6	B125	6.00	80.0	30.00	15.0	5	DIN 2174	
M 8	8.00	x 6.20	T400-XM116DA-M8	B125	8.00	90.0	35.00	18.0	5	DIN 2174	
M 10	10.00	x 8.00	T400-XM116DA-M10	B125	10.00	100.0	39.00	20.0	6	DIN 2174	

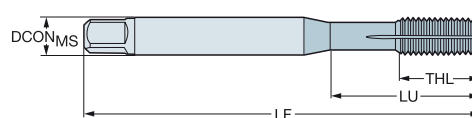
CoroTap™ 400 thread former

Thread form: Metric
DIN 2174



ULDR
SUBSTRATE
COATING

3.5
HSS-E
PVD TIN



TDZ CZC_{MS} Order number Dimensions, mm Discount group 781

	Shank		Square			TD	LF	LU	THL	NOF	BSG
M 3	3.50	x	2.70	T400-XM150DA-M3	B125	3.00	56.0	18.00	9.0	4	DIN 2174
M 4	4.50	x	3.40	T400-XM150DA-M4	B125	4.00	63.0	21.00	12.0	5	DIN 2174
M 5	6.00	x	4.90	T400-XM150DA-M5	B125	5.00	70.0	25.00	13.0	5	DIN 2174
M 6	6.00	x	4.90	T400-XM150DA-M6	B125	6.00	80.0	30.00	15.0	5	DIN 2174
M 7	7.00	x	5.50	T400-XM150DA-M7	B125	7.00	80.0	30.00	15.0	5	DIN 2174
M 8	8.00	x	6.20	T400-XM150DA-M8	B125	8.00	90.0	35.00	18.0	5	DIN 2174
M 10	10.00	x	8.00	T400-XM150DA-M10	B125	10.00	100.0	39.00	20.0	5	DIN 2174
M 12	9.00	x	7.00	T400-XM151DA-M12	B125	12.00	110.0	83.00	23.0	5	DIN 2174
M 14	11.00	x	9.00	T400-XM151DA-M14	B125	14.00	110.0	81.00	25.0	6	DIN 2174
M 16	12.00	x	9.00	T400-XM151DA-M16	B125	16.00	110.0	68.00	25.0	6	DIN 2174
M 20	16.00	x	12.00	T400-XM151DA-M20	B125	20.00	140.0	95.00	30.0	7	DIN 2174
M 24	18.00	x	14.50	T400-XM151DA-M24	B125	24.00	160.0	113.00	36.0	8	DIN 2174

CoroTap™ 400 thread former

Thread form: Metric
DIN 2174



M

C
2-3

IC

HSS-E

6HX

DIN
2174

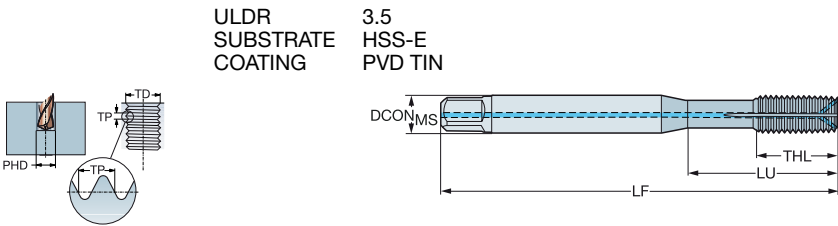
3.5xD

P

M

N

S

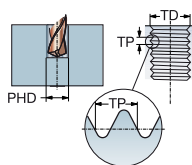


TDZ		CZC _{MS}		Order number		Dimensions, mm					Discount group 781	
Shank		Square				TD	LF	LU	THL	NOF	BSG	
M 5	6.00	x	4.90	T400-XM154DA-M5	B125	5.00	21.00	70.0	13.0	5	DIN 2174	
M 6	6.00	x	4.90	T400-XM154DA-M6	B125	6.00	26.00	80.0	15.0	5	DIN 2174	
M 8	8.00	x	6.20	T400-XM154DA-M8	B125	8.00	30.00	90.0	18.0	5	DIN 2174	
M 10	10.00	x	8.00	T400-XM154DA-M10	B125	10.00	33.00	100.0	20.0	5	DIN 2174	
M 12	9.00	x	7.00	T400-XM155DA-M12	B125	12.00	83.00	110.0	23.0	5	DIN 2174	

CXSC 2 = radial cooling lubricant discharge

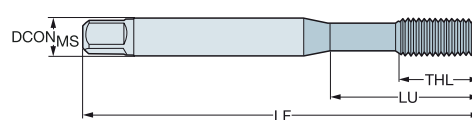
CoroTap™ 400 thread former

Thread form: Metric fine
DIN 2174



ULDR
SUBSTRATE
COATING

3.0
HSS-E
PVD TIN



TDZ		CZC _{MS}		Order number		Dimensions, mm						Discount group 781	
Shank		Square				TD	LF	LU	THL	NOF	BSG		
MF 5x0.5	6.00	x	4.90	T400-XM100DB-M5X050	B125	5.00	70.0	25.00	13.0	5	DIN 2174		
MF 6x0.75	6.00	x	4.90	T400-XM100DB-M6X075	B125	6.00	80.0	30.00	15.0	5	DIN 2174		
MF 7x0.75	7.00	x	5.50	T400-XM100DB-M7X075	B125	7.00	80.0	30.00	15.0	5	DIN 2174		
MF 8x0.75	6.00	x	4.90	T400-XM101DB-M8X075	B125	8.00	80.0	57.00	18.0	5	DIN 2174		
MF 8x1	7.00	x	5.50	T400-XM101DB-M8X100	B125	10.00	100.0	67.00	18.0	5	DIN 2174		
MF 10x1	7.00	x	5.50	T400-XM101DB-M10X100	B125	10.00	100.0	75.00	20.0	5	DIN 2174		
MF 10x1.25	7.00	x	5.50	T400-XM101DB-M10X125	B125	10.00	100.0	75.00	20.0	5	DIN 2174		
MF 12x1	9.00	x	7.00	T400-XM101DB-M12X100	B125	12.00	100.0	73.00	23.0	5	DIN 2174		
MF 12x1.25	9.00	x	7.00	T400-XM101DB-M12X125	B125	12.00	100.0	73.00	23.0	5	DIN 2174		
MF 12x1.5	9.00	x	7.00	T400-XM101DB-M12X150	B125	12.00	100.0	73.00	23.0	5	DIN 2174		
MF 14x1	11.00	x	9.00	T400-XM101DB-M14X100	B125	14.00	100.0	71.00	21.0	6	DIN 2174		
MF 14x1.25	11.00	x	9.00	T400-XM101DB-M14X125	B125	14.00	100.0	71.00	21.0	6	DIN 2174		
MF 14x1.5	11.00	x	9.00	T400-XM101DB-M14X150	B125	14.00	100.0	71.00	21.0	6	DIN 2174		
MF 16x1.5	12.00	x	9.00	T400-XM101DB-M16X150	B125	16.00	100.0	58.00	21.0	6	DIN 2174		

CoroTap 400 – universal

Recommended cutting speed

					ULDR (xTD)	1.5	2	3
ISO	MC no.	Material	N/mm2	HB	v _c m/min			
P	P1.1.Z.AN	Non-alloy carbon steel	428	125	33	27	23	
	P1.1.Z.HT		639	190	30	25	21	
	P1.2.Z.AN		639	190	27	22	19	
	P1.2.Z.HT		708	210	24	20	17	
	P1.3.Z.AN		639	190	27	22	19	
	P1.3.Z.HT		1013	300	12	10	8	
	P2.1.Z.AN	Low-alloy steel	591	175	27	22	19	
	P2.2.Z.AN		811	240	24	20	17	
	P2.3.Z.AN		867	260	12	10	8	
	P2.5.Z.HT.1		961	285	12	10	8	
	P3.0.Z.AN	High-alloy steel	674	200	24	20	17	
	P3.0.Z.HT.1		1282	380	-	-	-	
	P3.1.Z.AN		839	250	24	20	17	
	P1.5.C.UT	Cast steel	503	150	27	22	19	
	P2.6.C.UT		674	200	24	20	17	
P5.0.Z.HT.1	Ferritic/martensitic stainless steel	1114	330	27	20	17		
P5.0.Z.PH		1114	330	12	5	4		
M	M1.0.Z.AQ	Austenitic stainless steel	674	200	9	7	6	
	M1.0.C.UT		674	200	9	7	6	
	M2.0.Z.AQ	Super austenitic stainless steel	961	200	9	7	9	
	M2.0.C.AQ		674	200	9	7	6	
	M3.1.Z.AQ	Stainless (austenitic/ferritic) duplex steels	674	230	6	5	4	
	M3.1.C.AQ		778	230	6	5	4	
	M3.2.Z.AQ		867	260	6	5	4	
N	N1.2.Z.UT	Aluminium-based alloys	-	60	67	55	47	
	N1.2.Z.AG		-	100	67	55	47	
	N1.3.C.UT		-	75	67	55	47	
	N1.3.C.AG		-	90	49	40	34	
	N1.4.C.NS		-	130	31	25	21	
	N3.1.U.UT	Copper-based alloys	-	100	31	25	21	

Advantages of thread milling

- Production of different thread tolerances through radius compensation
- Low torque required
- Easy machining of long-chipping materials
- Machining of hard materials
- High level of process reliability
- Production of different threads with a single tool (with the same lead, e.g. M10x1.5, M12x1.5)

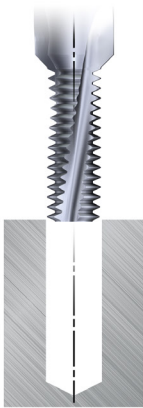
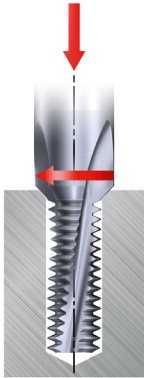
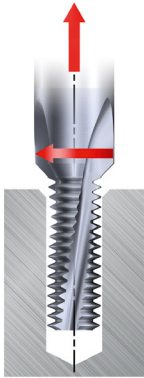
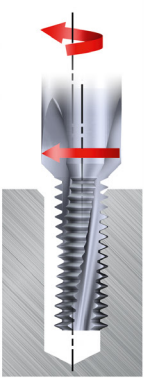
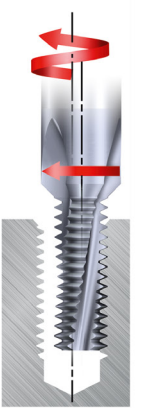
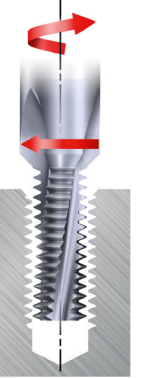
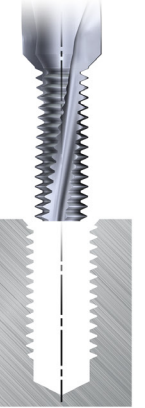
Application

- Left and right threads with a single tool
- Thread length up to 3xD
- For smaller thread diameters ≥ 3.2 mm
- Thread machining down to near the base of the hole



P M K N S H O
ISO areas of application

Thread milling

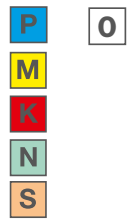
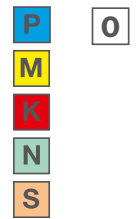
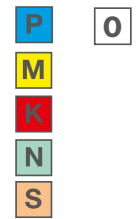
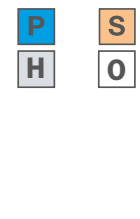
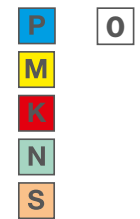
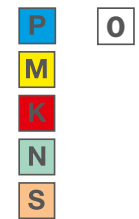
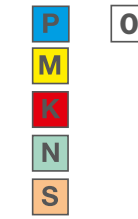
Machining process including chamfering						
						
1. Positioning	2. Chamfering	3. Thread positioning	4. 180° entering	5. Thread machining	6. 180° exit	7. Exit to start position

Machining process with multiple passes (helix machining)				
				
1. Positioning over the hole	2. Entering to the required thread depth	3. Radial plunging into the thread 180°/1/2 lead	4. Manufacturing of the thread by spiral extraction	5. Start to the initial position

You can find NC programs and cutting values in our CoroPlus® Tool Guide.



Thread milling cutters

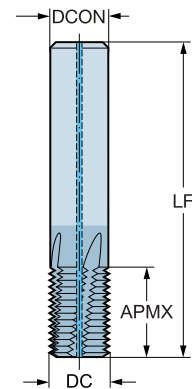
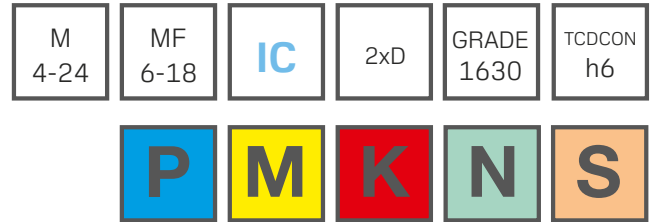
Metric/metric fine				UNC/UNF	NTP/NTPF	G
universal		ISO H		universal		
M 4–24/MF 6–18	MF 6–18/M 20–24	M 3–16	M 6–14/MF 12–14	1/4 - 3/4	1/8 - 1/2	1/8 - 1
with IC	without IC	with IC and bevel	without IC	with IC	without IC	without IC
						
R217.1xC..AC/K..N	R217.1x..AC..N	R217.1x..CC..K	R217.1x..AC..M	R217.3xC..AC..M	R217.5x..AC..N	R217.9x..BC..N
P.34	P.35	P.36	P.37	P.38	P.39	P.40
1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice
						
2xD	2xD	2xD	2xD	2xD	2xD	2xD
1630	1630	1630	1620	1630	1630	1630

Thread milling cutter for helix machining

Metric/metric fine			UNC/UNF	
universal		ISO H+S	universal	
M 1.6–12	TP 0.5–2	M 2–6	#1 - 5/16	1/4-5/16
without IC				
				
R217.3x..AC..P	326..VM-TH	R217.1x..AC..S	R217.3x..AC..P	A326..VM-TH
P.41	P.44	P.42	P.43	P.44
1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice	1st choice/2nd choice
				
2xD/3xD	2xD	2xD	3xD	2xD
1620	1025	1610	1620	1025

CoroMill® Plura – thread milling cutter

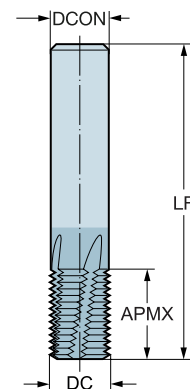
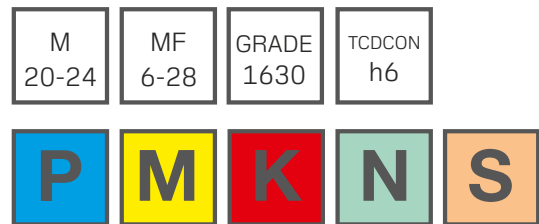
For cylindrical shank
internal thread



Thread	Order number	Grade	DC	APMX	Dimensions, mm			Discount group 730
FTDZ					IC	ZEPF	DCON	LF
M4x0.7	R217.13-032070AC08N	1630	3.20	8.40	without	3	6.00	57.00
M5x0.8	R217.13-041080AC11N	1630	4.10	11.20	without	3	6.00	57.00
M6x1.0	R217.14C045100AC13N	1630	4.50	13.00	with	4	6.00	57.00
M8x1.25	R217.14C060125AK17N	1630	6.00	17.50	with	4	6.00	65.00
M10x1.5	R217.14C075150AK21N	1630	7.50	21.00	with	4	8.00	72.00
M12x1.75	R217.14C095175AK26N	1630	9.50	26.25	with	4	10.00	80.00
M14x2.0	R217.15C100200AK30N	1630	10.00	30.00	with	5	10.00	83.00
M16x2.0	R217.15C120200AK34N	1630	12.00	34.00	with	5	12.00	92.00
M20x2.5	R217.15C160250AK42N	1630	16.00	42.50	with	5	16.00	105.00
M24x3.0	R217.15C190300AK50N	1630	19.00	50.00	with	5	20.00	125.00
MF6x0.5	R217.13C048050AC10N	1630	4.80	10.00	with	3	6.00	57.00
MF8x0.75	R217.13C060075AC12N	1630	6.00	12.00	with	3	6.00	57.00
MF10x1.0	R217.14C080100AC16N	1630	8.00	16.00	with	4	8.00	63.00
MF14x1.5	R217.14C120150AC22N	1630	12.00	22.50	with	4	12.00	83.00
MF18x1.5	R217.15C160150AC30N	1630	16.00	30.00	with	5	16.00	92.00

CoroMill® Plura – thread milling cutter

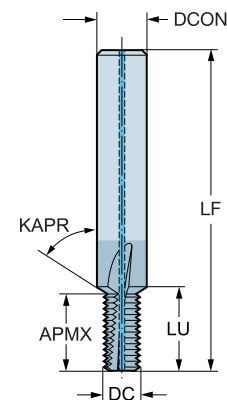
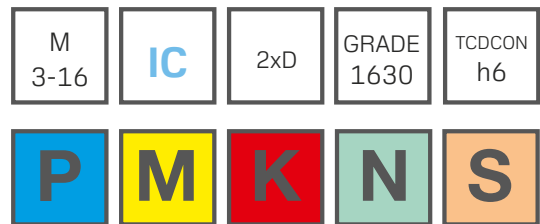
For cylindrical shank
internal thread



Thread	Order number	Dimensions, mm					Discount group 730
		DC	APMX	ZEFP	DCON	LF	
FTDZ							
MF 6x0.5	R217.13-048050AC10N 1630	4.80	10.00	3	6.00	57.00	
MF 8x0.75	R217.13-060075AC12N 1630	6.00	12.00	3	6.00	57.00	
MF 8x1.0	R217.13-060100AC12N 1630	6.00	12.00	3	6.00	57.00	
MF 10x1	R217.14-080100AC16N 1630	8.00	16.00	4	8.00	63.00	
MF 12x1	R217.14-100100AC20N 1630	10.00	20.00	4	10.00	72.00	
MF 14x1	R217.14-120100AC22N 1630	12.00	22.00	4	12.00	83.00	
MF 16x1	R217.15-140100AC26N 1630	14.00	26.00	5	14.00	83.00	
MF 12x1.5	R217.14-100150AC20N 1630	10.00	21.00	4	10.00	72.00	
MF 14x1.5	R217.14-120150AC22N 1630	12.00	22.50	4	12.00	83.00	
MF 16x1.5	R217.15-140150AC26N 1630	14.00	27.00	5	14.00	83.00	
MF 20x2	R217.15-160200AC30N 1630	16.00	30.00	5	16.00	92.00	
MF 24x2	R217.15-200200AC35N 1630	20.00	36.00	5	20.00	104.00	
MF 28x2	R217.16-250200AC46N 1630	25.00	46.00	6	25.00	121.00	
M 20x2.5	R217.15-160250AC42N 1630	16.00	42.50	5	16.00	105.00	
M 24x3	R217.15-190300AC50N 1630	19.00	50.00	5	20.00	125.00	

CoroMill® Plura – thread milling cutter with bevel

For cylindrical shank
internal thread



Thread FTDZ	Order number	Dimensions, mm							Discount group 730
		DC	APMX	LU	IC	ZEFP	DCON	LF	
M3X0.5	R217.13-023050CC06K 1630	2.30	5.00	6.00	without	3	6.00	52.00	
M4X0.70	R217.13C032070CC08K 1630	3.20	8.80	9.50	with	3	6.00	48.20	
M5X0.80	R217.13C041080CC11K 1630	4.10	10.72	11.67	with	3	6.00	46.28	
M6x1.0	R217.13C048100CC13K 1630	4.80	12.78	13.58	with	3	8.00	50.22	
M8x1.25	R217.13C065125CC17K 1630	6.50	17.35	18.24	with	3	10.00	54.65	
M10x1.5	R217.13C082150CC21K 1630	8.20	22.41	23.41	with	3	12.00	60.59	
M12x1.75	R217.14C099175CC26K 1630	9.90	26.00	27.00	with	4	14.00	57.00	
M14x2.0	R217.14C116200CC30K 1630	11.60	31.30	32.40	with	4	16.00	60.70	
M16X2.0	R217.14C136200CC34K 1630	13.60	33.30	34.40	with	4	18.00	58.70	

KAPR: 45°

CoroMill® Plura – thread milling cutter for hard machining

For cylindrical shank
internal thread



M
6-14

MF
12-14

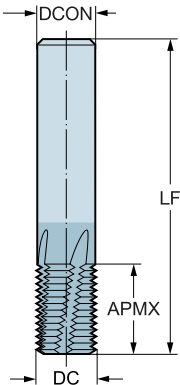
1.5xD

GRADE
1620

TCDCON
h6

P

H



Thread	Order number	Dimensions, mm					Discount group 730
		DC	APMX	ZEPF	DCON	LF	
M6x1.0	R217.14-045100AC10M 1620	4.50	10.00	4	6.00	57.00	
M8x1.25	R217.15-060125AC12M 1620	6.00	12.50	5	6.00	57.00	
M10x1.5	R217.15-080150AC16M 1620	8.00	16.50	5	8.00	63.00	
M12x1.75	R217.15-090175AC19M 1620	9.00	19.25	5	10.00	72.00	
M14x2.0	R217.15-120200AC26M 1620	12.00	26.00	5	12.00	83.00	
MF12x1	R217.15-100100AC20M 1620	10.00	20.00	5	10.00	72.00	
MF14x1.5	R217.16-120150AC27M 1620	12.00	27.00	6	12.00	83.00	

CoroMill® Plura – thread milling cutter

For cylindrical shank
internal thread



UNC
1/4- 3/4

UNF
1/4- 3/4

IC

2xD

GRADE
1630

TCDCON
h6

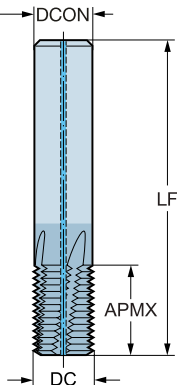
P

M

K

N

S



Thread	Order number	Dimensions, inches					Discount group 730
		DC	APMX	ZEPF	DCON	LF	
FTDZ							
1/4-20 UNC	R217.33C048200AC13N 1630	.189	.551	3	.236	2.244	
5/16-18 UNC	R217.33C055180AC14N 1630	.217	.556	3	.236	2.244	
3/8-16 UNC	R217.34C075160AC19N 1630	.295	.750	4	.315	2.480	
7/16-14 UNC	R217.34C080140AC19N 1630	.315	.785	4	.315	2.480	
1/2-13 UNC	R217.34C100130AC21N 1630	.394	.846	4	.394	2.835	
9/16-12 UNC	R217.34C100120AC21N 1630	.394	.833	4	.315	2.835	
5/8-11 UNC	R217.34C120110AC25N 1630	.472	1000	4	.472	3.268	
3/4-10 UNC	R217.35C140100AC33N 1630	.551	1300	5	.551	3.268	
1/4-28 UNF	R217.33C048280AC13N 1630	.189	.536	3	.236	2.244	
5/16-24 UNF	R217.33C060240AC13N 1630	.236	.541	3	.236	2.244	
7/16-20 UNF	R217.34C080200AC19N 1630	.315	.750	4	.315	2.480	
9/16-18 UNF	R217.34C100180AC22N 1630	.394	.889	4	.394	2.835	
3/4-16 UNF	R217.35C140160AC31N 1630	.551	1250	5	.551	3.268	

CoroMill® Plura – thread milling cutter

For Weldon
internal thread



NTP
1/8 - 1/2

NPTF
1/8 - 1/2

2xD

GRADE
1630

TCDCON
h6

6535
HB

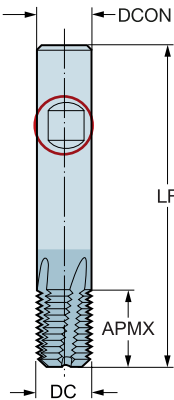
P

M

K

N

S



Thread	Order number	Dimensions, inches					Discount group 730
		DC	APMX	ZEPF	DCON	LF	
FTDZ							
1/8-27 NPT	R217.53-079270AC11N 1630	.311	.453	3	.315	2.284	
1/4-18 NPT	R217.53-099180AC15N 1630	.390	.627	3	.394	2.598	
1/2-14 NPT	R217.54-159140AC20N 1630	.626	.806	4	.630	3.228	
1/2-14 NPT	R217.55-199115AC27N 1630	.784	1.068	5	.787	3.622	
1/8-27 NPTF	R217.73-079270AC11N 1630	.311	.453	3	.315	2.284	
1/4-18 NPTF	R217.73-099180AC15N 1630	.390	.627	3	.394	2.598	
1/2-14 NPTF	R217.74-159140AC20N 1630	.626	.806	4	.630	3.228	

CoroMill® Plura – thread milling cutter

For Weldon internal and external machining



G
1/8- 3"

2xD

GRADE
1630

TCDCON
h6

6535
HB

P

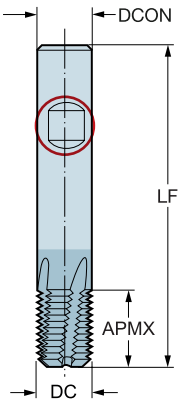
M

K

N

S

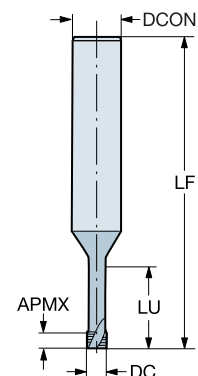
H



Thread	Order number	Dimensions, mm					Discount group 730
		DC	APMX	ZEPF	DCON	LF	
G1/8	R217.93-060280BC15N 1630	6.00	15.40	3	6.00	57.00	
G1/4	R217.94-100190BC20N 1630	10.00	20.00	4	10.00	72.00	
G3/8	R217.95-140190BC26N 1630	14.00	26.70	5	14.00	83.00	
G1/2 5/8	R217.95-160140BC30N 1630	16.00	30.80	5	16.00	92.00	
G5/8 3/4 7/8	R217.95-200140BC35N 1630	20.00	36.20	4	20.00	104.00	
G1"-3"	R217.95-250110BC45N 1630	25.00	46.15	5	25.00	121.00	

CoroMill® Plura – thread milling cutter for helix machining

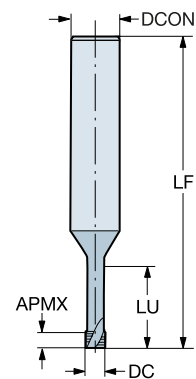
For cylindrical shank
internal thread



Thread	Fine	Lead	Order number	Dimensions, mm						Discount
FTDZ	Thread	TP		DC	APMX	LU	ZEFP	DCON	LF	group 730
M 1.6	MF 2.5-3.5	0.35	R217.13-012035AC03P 1620	1.20	0.53	3.73	3	3.00	37.82	
M 2		0.4	R217.13-015040AC04P 1620	1.55	1.00	4.60	3	6.00	56.80	
M 2.5		0.45	R217.13-019045AC05P 1620	1.95	1.13	5.68	3	6.00	56.77	
M 3	MF 4-8	0.5	R217.13-023050AC06P 1620	2.30	1.25	6.75	3	6.00	56.75	
M 4		0.7	R217.13-031070AC08P 1620	3.10	1.75	9.05	3	6.00	56.65	
M 5		0.8	R217.13-040080AC10P 1620	4.00	2.00	11.20	3	6.00	56.60	
M 6	MF 8-30	1.00	R217.13-048100AC12P 1620	4.80	2.50	13.50	3	6.00	56.50	
M 8	MF 10-16	1.25	R217.13-064125AC16P 1620	6.40	3.13	17.90	3	8.00	63.00	
M 10	MF 12-36	1.5	R217.14-082150AC20P 1620	8.20	3.75	22.30	4	10.00	71.25	
M 12		1.75	R217.15-095175AC24P 1620	9.50	4.38	26.70	5	10.00	71.12	
M 1.6	MF 2.5-3.5	0.35	R217.13-012035AC05P H07F	1.20	0.53	5.33	3	3.00	37.82	
M 2		0.4	R217.13-015040AC06P H07F	1.55	1.00	6.60	3	6.00	56.80	
M 2.5		0.45	R217.13-019045AC07P H07F	1.95	1.13	8.18	3	6.00	56.77	
M 3	MF 4-8	0.5	R217.13-023050AC09P H07F	2.30	1.25	9.75	3	6.00	56.75	
M 4		0.7	R217.13-031070AC12P H07F	3.10	1.75	13.05	3	6.00	56.65	
M 5		0.8	R217.13-040080AC15P H07F	4.00	2.00	16.20	3	6.00	56.60	
M 6	MF 10-30	1.00	R217.13-048100AC18P H07F	4.80	2.50	19.50	3	6.00	59.50	

CoroMill® Plura – thread milling cutter for hard machining

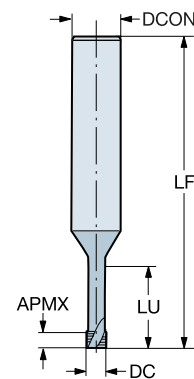
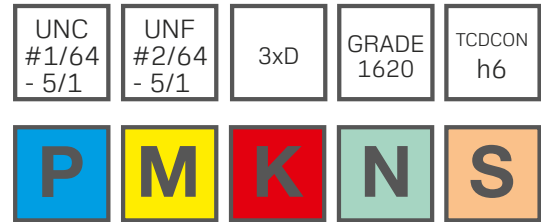
For cylindrical shank
internal thread



Thread	Fine Thread	Lead TP	Order number	Dimensions, mm						Discount group 730
				DC	APMX	LU	ZEFP	DCON	LF	
M 2	MF 2.5-3.5	0.40	R217.13-015040AC04S 1610	1.50	0.60	4.60	3	6.00	56.80	
M 2.5		0.45	R217.13-019045AC05S 1610	1.95	0.68	5.68	3	6.00	56.77	
M 3	MF 4-8	0.50	R217.13-023050AC06S 1610	2.30	0.75	6.75	3	6.00	56.75	
M 4		0.70	R217.13-031070AC08S 1610	3.10	1.05	9.05	3	6.00	56.65	
M 5		0.80	R217.14-040080AC10S 1610	4.00	1.20	11.20	4	6.00	56.60	
M 6	MF 8-30	1.00	R217.14-048100AC12S 1610	4.80	1.50	13.50	4	6.00	56.50	

CoroMill® Plura – thread milling cutter for helix machining

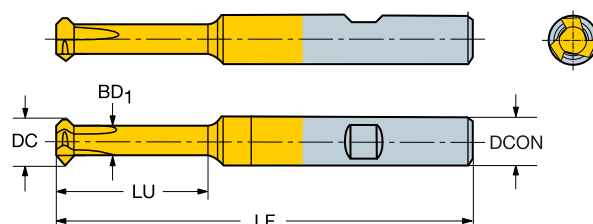
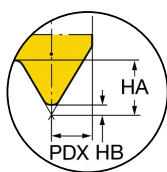
For cylindrical shank
internal thread



Thread	Lead	Order number	Dimensions, inches						Discount group 730
FTDZ	TP		DC	APMX	LU	ZEFP	DCON	LF	
UNC # 1-64	64.0	R217.33-013640AC05P 1620	.053	.023	.244	3	.236	23	
UNC #2-56	56.0	R217.33-016560AC06P 1620	.063	.027	.285	3	.236	236	
UNC #4-40	40.0	R217.33-021400AC08P 1620	.083	.062	.374	3	.236	236	
UNC #6-32	32.0	R217.33-026320AC10P 1620	.102	.078	.463	3	.236	236	
UNC #8-32	32.0	R217.33-032320AC12P 1620	.128	.078	.539	3	.236	236	
UNC #10-24	24.0	R217.33-035240AC14P 1620	.140	.104	.634	3	.236	2223	
UNC 1/4	20.0	R217.33-048200AC19P 1620	.191	.125	.827	3	.236	2219	
UNC 5/16	18.0	R217.33-062180AC24P 1620	.244	.139	1.022	3	.315	2453	
UNF #6-40	40.0	R217.33-027400AC10P 1620	.108	.037	.453	3	.236	2230	
UNF #10-32	32.0	R217.33-038320AC14P 1620	.152	.047	.618	3	.236	2228	
UNF 1/4	28.0	R217.33-052280AC19P 1620	.207	.054	.805	3	.236	2226	
UNF 5/16	24.0	R217.33-065240AC24P 1620	.258	.062	1.000	3	.315	2459	

CoroMill® Plura – thread milling cutter for helix machining

For cylindrical shank
internal thread



Metric version

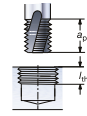
Order number		Lead, mm		Dimensions, mm									Discount group 730
DC		Min.	Max.	APMX	LU	ZEFP	DCON	LF	DN	HA	HB	BD	
5.80	326R06-B15050VM-TH 1025	0.5	1.5	1.94	15.00	3	6.00	58.00	3.5	0.97	0.06	5.00	
7.80	326R08-B25050VM-TH 1025	0.5	1.5	1.94	25.00	3	8.00	68.00	5.5	0.97	0.06	5.50	
7.80	326R08-B25100VM-TH 1025	1.0	2.0	2.62	25.00	3	8.00	68.00	5	1.31	0.12	5.00	

Inch version

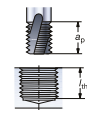
Order number		Lead, mm		Dimensions, inches									Discount group 730
DC		Min.	Max.	APMX	LU	ZEFP	DCON	LF	DN	HA	HB	BD	
.228	A326R06-M15050VM-TH 1025	16	50	.076	.591	3	.250	2.284	.138	.038	.002	.197	
.307	A326R08-M25050VM-TH 1025	16	50	.076	.984	3	.312	2.677	.216	.038	.002	.217	
.307	A326R08-M25100VM-TH 1025	12	24	.103	.984	3	.312	2.677	.197	.051	.004	.197	

Cutting data for the CoroMill® Plura thread milling cutter

Cutting speed and feed recommendations



$$/t_h = 0.5 \times a_p$$

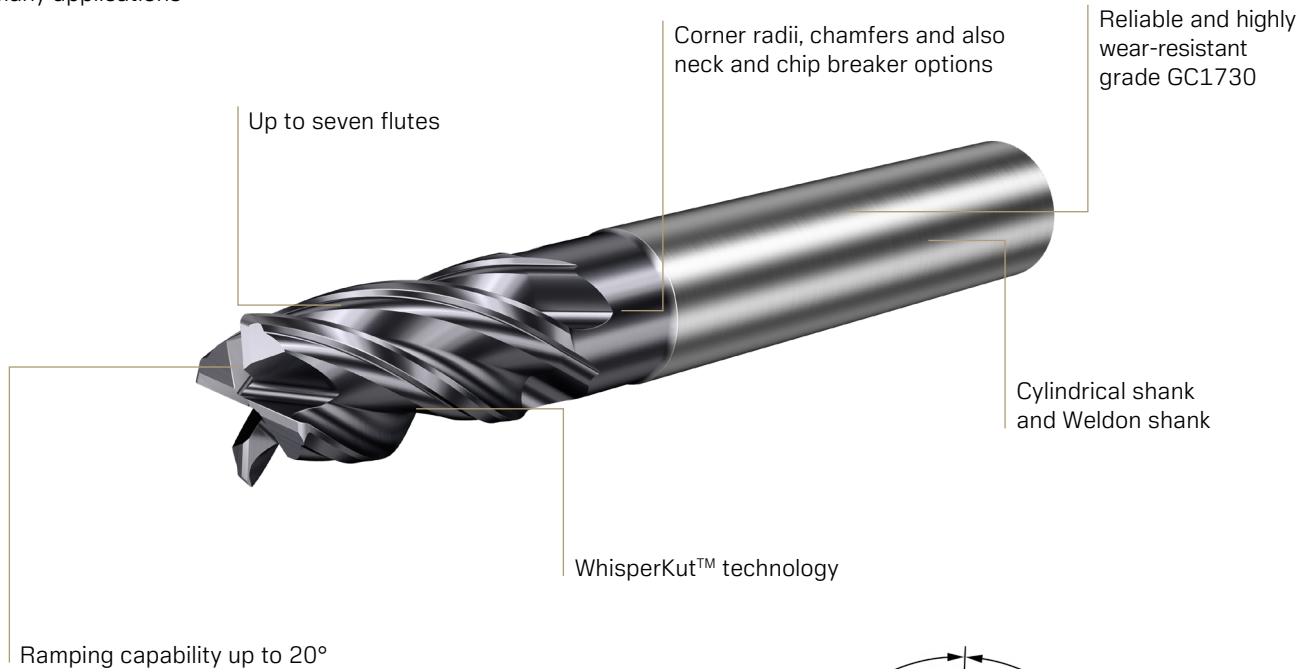


$$/t_h = a_p$$

ISO	MC no.	Material	Hardness		Thread	Dimensions, mm		Cutting speed v_c m/min	Feed/tooth f_z mm	Cutting speed v_c m/min	Feed/tooth f_z mm
			HB	HRC		DC	ZEFP				
P	Non-alloy carbon steel P1.1.Z.AN	S235JR G2; C15; 17MnV7; St37	125		M4	3.2	3	152	0.030	141	0.018
					M10	8.2	4	132	0.052	124	0.029
					M20	16	5	141	0.130	131	0.069
	Low-alloy steel P2.5.Z.HT	34CrNiMo6 V; 51CrV4 V; 41CrAlMo7 V	300		M4	3.2	3	147	0.012	137	0.006
					M10	8.2	4	164	0.086	153	0.050
					M20	16	5	173	0.089	162	0.118
	High-alloy steel P3.0.Z.HT	See hardened above	450		M4	3.2	3	163	0.035	151	0.015
					M10	8.2	4	164	0.061	153	0.049
					M20	16	5	173	0.012	162	0.118
M	Stainless steel P5.0.Z.AN	X6Cr17; X6CrMo17-1; X20CrMoV12-1	200		M4	3.2	3	81	0.024	75	0.009
					M10	8.2	4	82	0.052	76	0.036
					M20	16	5	86	0.089	93	0.089
	M1.0.Z.AQ	1.4301; 1.4404	200		M4	3.2	3	53	0.018	49	0.007
					M10	8.2	4	53	0.052	50	0.027
					M20	16	5	56	0.089	53	0.072
	M3.1.Z.AQ	X2CrNiN23-4; X8CrNiMo27-5; 1.4362	230		M4	3.2	3	53	0.018	49	0.007
					M10	8.2	4	53	0.052	50	0.027
					M20	16	5	56	0.131	53	0.074
K	Malleable cast iron K1.1.C.NS	EN-GJMB350-10; EN-GJMB550-4; EN-GJMB700-2			M4	3.2	3	80	0.020	77	0.016
					M10	8.2	4	89	0.061	83	0.036
					M20	16	5	82	0.084	83	0.089
	Grey cast iron K2.2.C.UT	EN-GJL-300; EN-GJL-350			M4	3.2	3	76	0.018	73	0.014
					M10	8.2	4	86	0.038	79	0.034
					M20	16	5	79	0.075	80	0.080
	Ductile cast iron K3.1.C.UT	EN-GJS-400-15; N-GJS-800-7; EN-GJS-400-18-LT (GGG40) EN-GJS-600-3 (GGG50) EN-GJS-700-2			M4	3.2	3	101	0.027	97	0.020
					M10	8.2	4	104	0.047	105	0.048
					M20	16	5	104	0.089	97	0.067
N	Aluminium N1.2.Z.UT	EN AW-7075	60		M4	3.2	3	503	0.040	503	0.035
					M10	8.2	4	1120	0.089	1060	0.061
					M20	16	5	1130	0.089	1060	0.089
	N1.3.C.UT	G-AlMg5	95		M4	3.2	3	434	0.040	404	0.018
					M10	8.2	4	461	0.061	432	0.061
					M20	16	5	467	0.089	436	0.089
			150		M4	3.2	3	273	0.028	262	0.021
					M10	8.2	4	278	0.053	260	0.026
					M20	16	5	282	0.089	263	0.071
S	Heat-resistant alloys S1.0.U.AN	TMG 1.7.3	200		M4	3.2	3	35	0.006	35	0.003
					M10	8.2	4	37	0.023	35	0.013
					M20	16	5	38	0.066	38	0.063
	Titanium alloys S2.0.Z.AG	TiAl6V4; TiAl4Mo4Sn2Si0,5	300		M4	3.2	3	30	0.030	29	0.020
					M10	8.2	4	32	0.013	30	0.007
					M20	16	5	32	0.037	30	0.018
	S4.2.Z.AN	Inconel, Hastelloy, Rene 41	300		M4	3.2	3	55	0.012	51	0.060
					M10	8.2	4	58	0.037	54	0.020
					M20	12	6	59	0.089	55	0.051
H	H1.3.Z.HA	40CrMnMo7; 55NiCrMoV6; X42Cr13		55	M4	4.5	4	43	0.010	40	0.005
					M10	8.2	5	42	0.022	45	0.035
					M20	12	5	45	0.042	42	0.021
	H1.3.Z.HA	100Cr6; 1.3505		60	M4	4.5	4	30	0.005	30	0.003
					M10	8.2	5	29	0.011	28	0.006
					M20	12	5	30	0.022	28	0.010

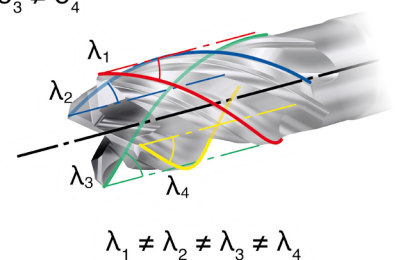
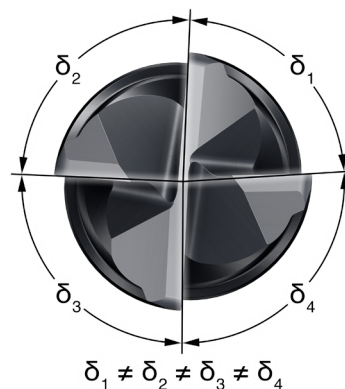
Tool features

- 2–7 flutes
- 1–4×D cutting length
- With and without chip breaker
- Robust and light-cutting geometries suitable for many applications
- Easy to choose, easy to use.
- Can be reground up to three times according to original specifications



WhisperKut™ technology

- Advanced design in which each flute is arranged at a different helix angle
- In addition, all cutting edges are differentially divided, so that each flute is arranged differently from the others, which reduces the constant vibrations that typically occur with conventional end mills.
- The design provides excellent stability and effectively eliminates and prevents vibrations
- The result is quiet, safe and efficient processing



Applications

- Roughing to finishing with a wide range of application options
- A universal tool concept for all applications and materials
- Suitable for general mechanical engineering in all industrial segments

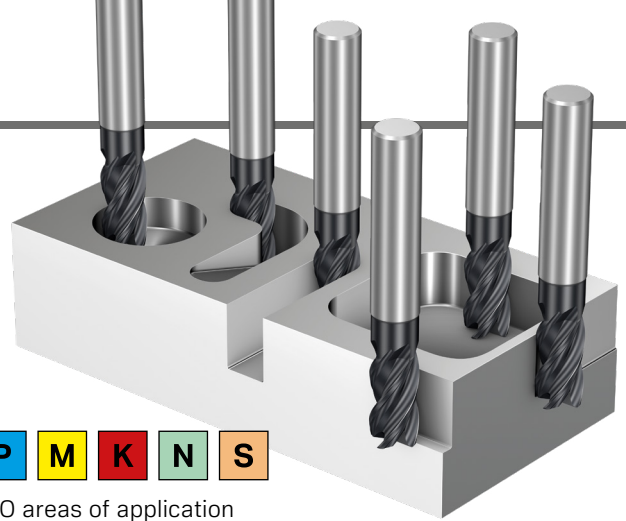
Tool selection: CoroMill® Dura

First choice
tool:
1K334

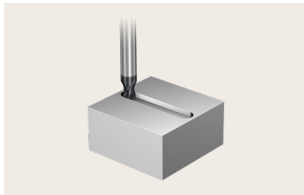
1K334 (number of teeth $z=4$,
cutting length, max. (APMX) = $2 \times DC$)
1K324 (number of teeth $z=4$,
cutting length, max. (APMX) = $1.5 \times DC$)



ISO areas of application

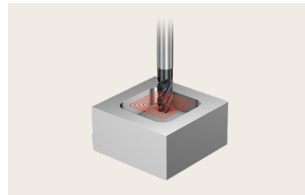


Do you require something more specific?

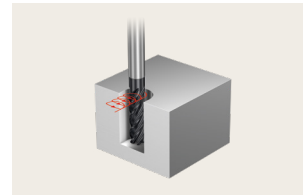


Keyway or
for driven units

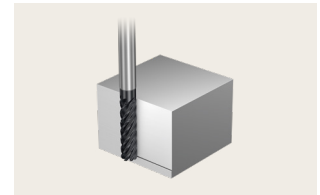
1K212 ($z = 2$, APMX = $1 \times DC$)
1K232 ($z = 2$, APMX = $2 \times DC$)
1K313 ($z = 3$, APMX = $1 \times DC$)
1K333 ($z = 3$, APMX = $2 \times DC$)



Dynamic milling/
medium engagement widths
1K325 ($z = 5$, APMX = $1.5 \times DC$)
1K335 ($z = 5$, APMX = $2 \times DC$)

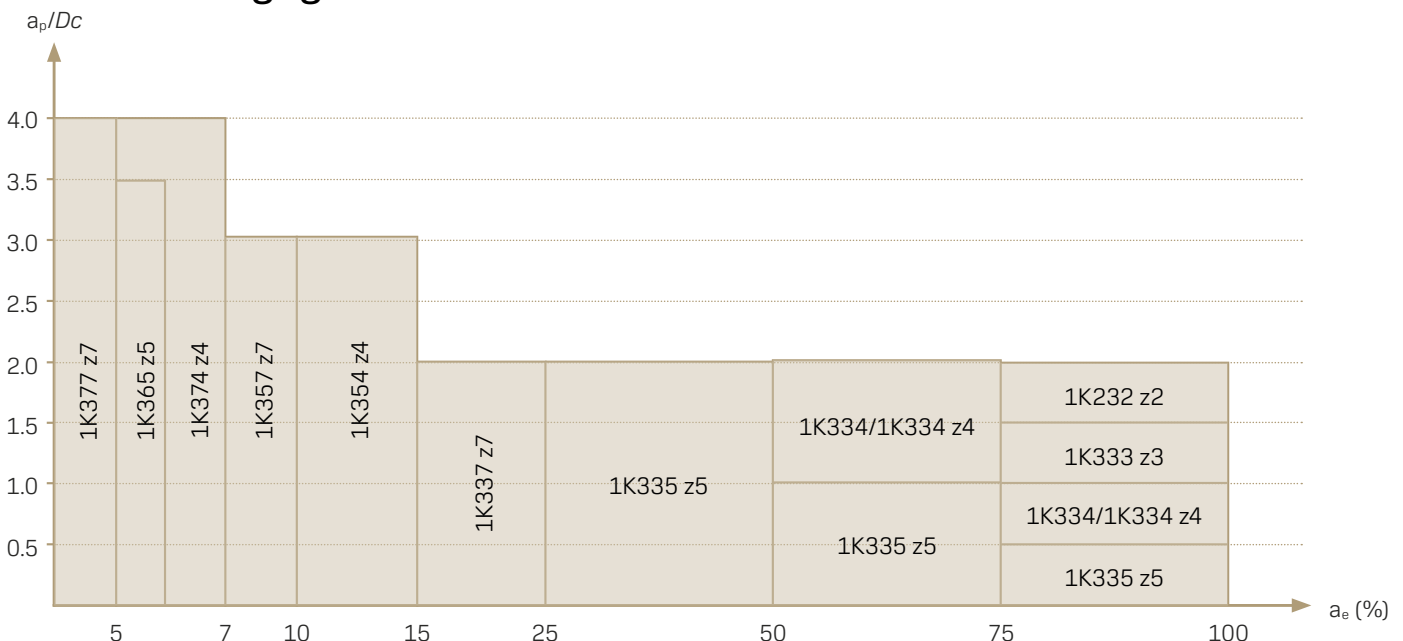


Dynamic milling/
small engagement widths
1K354 ($z = 4$, APMX = $3 \times DC$)
1K365 ($z = 5$, APMX = $3.5 \times DC$)
1K374 ($z = 4$, APMX = $4 \times DC$)



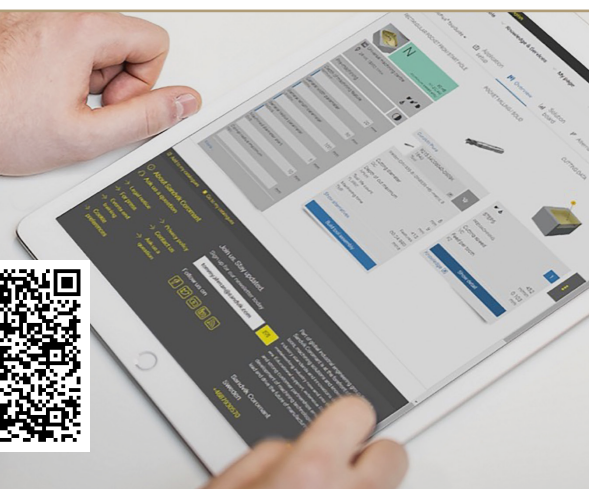
Finishing/pre-finishing
1K337 ($z = 7$, APMX = $2 \times DC$)
1K357 ($z = 7$, APMX = $3 \times DC$)
1K377 ($z = 7$, APMX = $4 \times DC$)
1K273 ($z = 3$, APMX = $4 \times DC$)
1K283 ($z = 3$, APMX = $4 \times DC$)

Maximum engagement widths



CoroMill® Dura tool selection

- Online tool selection based on the CoroPlus® Tool Guide
- Select the right tool and the right parameters for your application
- Easy to choose and use correctly
- Supports the following areas of application for CoroMill® Dura:
Groove milling, shoulder milling, pocket milling, helical interpolation



Recommendations for cutting speed

Multi-material – CoroMill® Dura 1-2 x D

 f_z increase +20% for end mills with shorter length 1.5 x D f_z feed reduction -50% for 1K337 end mills (-50%) f_z increase +30% for Z3 and Z2 end mills $a_{p,max}=1xD$

ISO	MC no.	CMC	Material	HB									
					$a_e = 1.0 \times DC$			$a_e = 0.5 \times DC$			$a_e = 0.1 \times DC$		
					$a_p = 0.5 \times DC$			$a_p = 1.0 \times DC$			$a_p = 1.5 \times DC$		
					f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min
P	P1.2.Z.AN	01.2	Non-alloy carbon steel	190	F01	145	475	F04	175	574	F06	290	951
	P2.2.Z.AN	02.2	Low-alloy steel	240	F01	110	361	F04	135	443	F06	230	754
	P3.0.Z.HT	03.21	High-alloy steel	380	F02	80	262	F05	100	328	F06	200	656
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	F02	80	262	F05	90	295	F04	150	492
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	F01	70	230	F04	80	262	F06	120	393
	M3.2.Z.AQ	05.51	Stainless (austenitic/ferritic) duplex steels	260	F02	60	197	F05	70	230	F04	90	295
K	K1.1.C.NS	07.2	Malleable cast iron	200	F01	150	492	F04	180	590	F06	250	820
	K2.1.C.UT	08.2	Grey cast iron	180	F01	150	492	F04	180	590	F06	250	820
	K3.2.C.UT	09.2	Ductile cast iron	215	F01	160	525	F04	190	623	F06	270	885
N	N1.2.Z.AG	30.12	Aluminium alloys	100	F03	680	2230	F03	835	2738	F09	950	3115
	N1.3.C.UT	30.21	Aluminium alloys	75	F03	230	754	F03	305	1000	F09	410	1344
	N1.4.C.NS	30.42	Aluminium alloys	130	F03	100	328	F03	130	426	F09	195	639
	N3.2.C.UT	33.2	Copper and copper alloys	90	F03	130	426	F03	170	557	F09	245	803
S	S2.0.Z.AG	20.22	Iron-based high-temperature alloys	350	F02	25	82	F05	30	98	F07	40	131
	S4.2.Z.AN	23.22	Nickel-based high-temperature alloys	320	F02	40	131	F05	50	164	F07	70	230

Feed recommendations

mm/tooth

inch/tooth

DC	1.000	2.000	3.000	4.000	6.000	6.350	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	19.050	20.000	25.000	25.400
f_z	0.039	0.079	0.709	0.157	0.236	0.250	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.750	0.787	0.984	1.000
F01	0.008	0.012	0.016	0.021	0.029	0.030	0.037	0.044	0.046	0.054	0.057	0.062	0.070	0.071	0.083	0.087	0.108	0.110
	.0003	.0005	.0006	.0008	.0011	.0012	.0015	.0017	.0018	.0021	.0022	.0025	.0028	.0028	.0033	.0034	.0043	.0043
F02	0.008	0.011	0.015	0.018	0.025	0.026	0.032	0.037	0.038	0.045	0.047	0.052	0.058	0.058	0.069	0.072	0.089	0.090
	.0003	.0004	.0006	.0007	.0010	.0010	.0012	.0014	.0015	.0018	.0019	.0020	.0023	.0023	.0027	.0028	.0035	.0035
F03	0.020	0.027	0.033	0.040	0.053	0.055	0.066	0.076	0.079	0.092	0.097	0.105	0.118	0.118	0.138	0.145	0.177	0.180
	.0008	.0010	.0013	.0016	.0021	.0022	.0026	.0030	.0031	.0036	.0038	.0041	.0046	.0047	.0054	.0057	.0070	.0071
F04	0.020	0.025	0.029	0.034	0.044	0.045	0.053	0.060	0.062	0.072	0.075	0.081	0.090	0.091	0.105	0.110	0.133	0.135
	.0008	.0010	.0012	.0013	.0017	.0018	.0021	.0024	.0025	.0028	.0030	.0032	.0035	.0036	.0041	.0043	.0052	.0053
F05	0.020	0.023	0.027	0.030	0.037	0.039	0.044	0.050	0.051	0.058	0.061	0.065	0.072	0.072	0.083	0.086	0.104	0.105
	.0008	.0009	.0011	.0012	.0015	.0015	.0017	.0020	.0020	.0023	.0024	.0026	.0028	.0028	.0033	.0034	.0041	.0041
F06	0.022	0.028	0.035	0.041	0.054	0.057	0.067	0.077	0.080	0.093	0.098	0.106	0.118	0.119	0.139	0.145	0.177	0.180
	.0009	.0011	.0014	.0016	.0021	.0022	.0027	.0030	.0032	.0037	.0038	.0042	.0047	.0047	.0055	.0057	.0070	.0071
F07	0.020	0.025	0.031	0.036	0.047	0.049	0.057	0.065	0.068	0.079	0.082	0.089	0.099	0.100	0.116	0.121	0.148	0.150
	.0008	.0010	.0012	.0014	.0018	.0019	.0023	.0026	.0027	.0031	.0032	.0035	.0039	.0039	.0046	.0048	.0058	.0059
F08	0.030	0.038	0.046	0.053	0.069	0.072	0.085	0.096	0.100	0.116	0.121	0.131	0.146	0.147	0.171	0.178	0.217	0.220
	.0012	.0015	.0018	.0021	.0027	.0028	.0033	.0038	.0039	.0046	.0048	.0052	.0057	.0058	.0067	.0070	.0085	.0087

For optimised cutting data, see CoroPlus® ToolGuide and CoroMill® Dura Tool Selector.

Tool Guide:



<https://www.sandvik.coromant.com/en-gb/tools/digital-machining/coroplus-tool-guide>

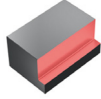
Tool Selector:

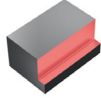


https://www.sandvik.coromant.com/de-de/products/toolguide/tool-recommendation?FocusAssortment=TG_DURA

Recommendations for cutting speed

Multi-material – CoroMill® Dura 3-4 x D

ISO	MC no.	CMC	Material	HB												
					1K354-XC/XD				1K357-XD				1K365-XC/XD			
					$a_p = 3.0 \times DC$				$a_p = 3.0 \times DC$				$a_p = 3.5 \times DC$			
					a_e	f_z	v_c m/min	v_c feet/min	a_e	f_z	v_c m/min	v_c feet/min	a_e	f_z	v_c m/min	v_c feet/min
P	P1.2.Z.AN	01.2	Non-alloy carbon steel	190	0.15xDC	F01	250	820	0.10xDC	F01	275	902	0.07xDC	F04	303	992
	P2.2.Z.AN	02.2	Low-alloy steel	240	0.15xDC	F01	240	787	0.10xDC	F02	264	866	0.07xDC	F04	290	952
	P3.0.Z.HT	03.21	High-alloy steel	320	0.15xDC	F02	140	459	0.10xDC	F02	154	505	0.07xDC	F05	169	555
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	0.15xDC	F02	120	393	0.10xDC	F02	132	433	0.07xDC	F05	145	476
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	0.15xDC	F02	150	492	0.10xDC	F02	165	541	0.07xDC	F05	182	595
	M3.2.Z.AQ	05.51	Stainless (austenitic/ferritic) duplex steels	260	0.15xDC	F02	130	426	0.10xDC	F02	143	469	0.07xDC	F05	157	516
K	K1.1.C.NS	07.2	Malleable cast iron	200	0.15xDC	F01	235	770	0.10xDC	F01	259	848	0.07xDC	F04	284	932
	K2.1.C.UT	08.2	Grey cast iron	180	0.15xDC	F01	240	787	0.10xDC	F01	264	866	0.07xDC	F04	290	952
	K3.2.C.UT	09.2	Ductile cast iron	215	0.15xDC	F01	245	803	0.10xDC	F01	270	884	0.07xDC	F04	296	972
N	N1.2.Z.AG	30.12	Aluminium alloys	100	0.15xDC	F04	950	3115	0.10xDC	F04	1140	3738	0.07xDC	F06	1140	3738
	N1.3.C.UT	30.21	Aluminium alloys	75	0.15xDC	F04	410	1344	0.10xDC	F04	492	1613	0.07xDC	F06	492	1613
	N1.4.C.NS	30.42	Aluminium alloys	130	0.15xDC	F04	195	639	0.10xDC	F04	234	767	0.07xDC	F06	234	767
	N3.2.C.UT	33.2	Copper and copper alloys	90	0.15xDC	F04	245	803	0.10xDC	F04	294	964	0.07xDC	F06	294	964
S	S2.0.Z.AG	20.22	Nickel-based super alloys	350	0.05xDC	F03	55	180	0.05xDC	F03	55	180	0.05xDC	F03	55	180
	S4.2.Z.AN	23.22	Titanium-based alloy	320	0.05xDC	F03	120	393	0.05xDC	F03	120	393	0.05xDC	F03	120	393

ISO	MC no.	CMC	Material	HB					Finishing			
					1K377-XD				all			
					$a_p = 4.0 \times DC$				$a_p = 2.0-4.0 \times DC$			
					a_p	f_z	v_c m/min	v_c feet/min	a_p	f_z	v_c m/min	v_c feet/min
P	P1.2.Z.AN	01.2	Non-alloy carbon steel	190	0.05xDC	F07	333	1091	0.10(0.05-0.2)	0.03	366	1200
	P2.2.Z.AN	02.2	Low-alloy steel	240	0.05xDC	F07	319	1048	0.10(0.05-0.2)	0.03	351	1152
	P3.0.Z.HT	03.21	High-alloy steel	320	0.05xDC	F02	186	611	0.10(0.05-0.2)	0.03	205	672
M	P5.0.Z.AN	05.11	Ferritic/martensitic stainless steel	200	0.05xDC	F08	160	524	0.10(0.05-0.2)	0.03	176	576
	M1.0.Z.AQ	05.21	Austenitic stainless steel	200	0.05xDC	F08	200	655	0.10(0.05-0.2)	0.03	220	720
	M3.2.Z.AQ	05.51	Stainless (austenitic/ferritic) duplex steels	260	0.05xDC	F08	173	567	0.10(0.05-0.2)	0.03	190	624
K	K1.1.C.NS	07.2	Malleable cast iron	200	0.05xDC	F07	313	1026	0.10(0.05-0.2)	0.03	344	1128
	K2.1.C.UT	08.2	Grey cast iron	180	0.05xDC	F07	319	1048	0.10(0.05-0.2)	0.03	351	1152
	K3.2.C.UT	09.2	Ductile cast iron	215	0.05xDC	F07	326	1069	0.10(0.05-0.2)	0.03	359	1176
N	N1.2.Z.AG	30.12	Aluminium alloys	100	0.05xDC	F03	1140	3738	0.10(0.05-0.2)	0.03	1140	3738
	N1.3.C.UT	30.21	Aluminium alloys	75	0.05xDC	F03	492	1613	0.10(0.05-0.2)	0.03	492	1613
	N1.4.C.NS	30.42	Aluminium alloys	130	0.05xDC	F03	234	767	0.10(0.05-0.2)	0.03	234	767
	N3.2.C.UT	33.2	Copper and copper alloys	90	0.05xDC	F03	294	964	0.10(0.05-0.2)	0.03	294	964
S	S2.0.Z.AG	20.22	Nickel-based super alloys	350	0.05xDC	F08	55	180	0.10(0.05-0.2)	0.03	50	164
	S4.2.Z.AN	23.22	Titanium-based alloy	320	0.05xDC	F08	120	393	0.10(0.05-0.2)	0.03	105	344

DC	2.000	3.000	4.000	6.000	6.350	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	19.050	20.000	25.000	25.400
f_z	0.079	0.118	0.157	0.236	0.250	0.315	0.375	0.394	0.472	0.500	0.551	0.625	0.630	0.750	0.787	0.984	1.000
F01	0.010 .0004	0.015 .0006	0.020 .0008	0.030 .0012	0.032 .0013	0.040 .0016	0.048 .0019	0.050 .0020	0.060 .0024	0.064 .0025	0.070 .0028	0.079 .0031	0.080 .0031	0.095 .0038	0.100 .0039	0.125 .0049	0.127 .0050
F02	0.008 .0003	0.012 .0005	0.015 .0006	0.023 .0009	0.024 .0010	0.031 .0012	0.036 .0014	0.038 .0015	0.046 .0018	0.049 .0019	0.054 .0021	0.061 .0024	0.061 .0024	0.073 .0029	0.076 .0030	0.095 .0038	0.097 .0038
F03	0.010 .0004	0.014 .0006	0.019 .0007	0.028 .0011	0.030 .0012	0.037 .0015	0.044 .0017	0.046 .0018	0.055 .0022	0.058 .0023	0.064 .0025	0.073 .0029	0.073 .0029	0.087 .0034	0.092 .0036	0.114 .0045	0.116 .0046
F04	0.013 .0005	0.020 .0008	0.027 .0011	0.040 .0016	0.042 .0017	0.053 .0021	0.063 .0025	0.067 .0026	0.080 .0031	0.085 .0033	0.093 .0037	0.106 .0042	0.106 .0042	0.127 .0050	0.133 .0052	0.166 .0065	0.169 .0067
F05	0.011 .0004	0.017 .0007	0.023 .0009	0.035 .0014	0.037 .0015	0.047 .0018	0.056 .0022	0.059 .0023	0.071 .0028	0.075 .0029	0.082 .0032	0.094 .0037	0.094 .0037	0.112 .0044	0.118 .0046	0.148 .0058	0.150 .0059
F06	0.021 .0008	0.028 .0011	0.036 .0014	0.050 .0020	0.053 .0021	0.064 .0025	0.075 .0030	0.079 .0031	0.093 .0037	0.098 .0039	0.108 .0042	0.121 .0048	0.122 .0048	0.144 .0057	0.151 .0059	0.187 .0074	0.190 .0075
F07	0.014 .0006	0.016 .0006	0.018 .0007	0.021 .0008	0.022 .0008	0.024 .0010	0.027 .0011	0.028 .0011	0.031 .0012	0.032 .0013	0.034 .0013	0.037 .0015	0.037 .0015	0.043 .0017	0.044 .0017	0.052 .0021	0.053 .0021
F08	0.003 .0001	0.005 .0002	0.007 .0003	0.010 .0004	0.011 .0004	0.013 .0005	0.016 .0006	0.017 .0007	0.020 .0008	0.021 .0008	0.023 .0009	0.026 .0010	0.026 .0010	0.032 .0012	0.033 .0013	0.041 .0016	0.042 .0017

For optimised cutting data, see CoroPlus® ToolGuide and CoroMill® Dura Tool Selector.