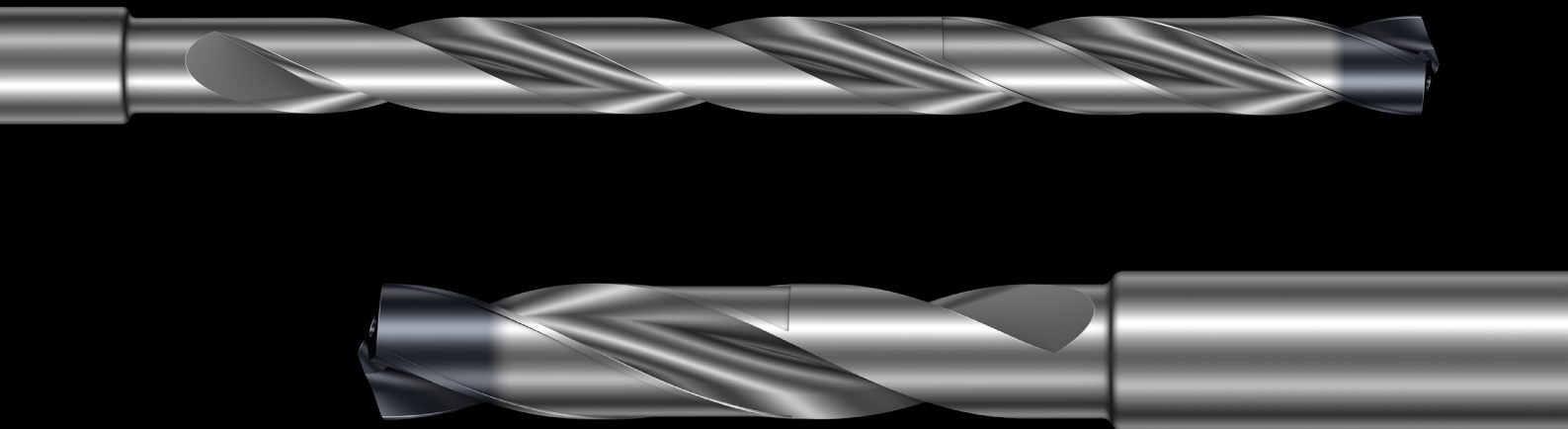


# CoroDrill® 860 with -SD geometry Short hole drilling in HRSA



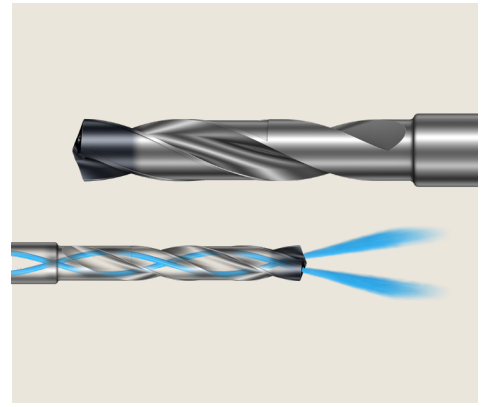
CoroDrill® 860 with -SD geometry is a reliable drill that guarantees the highest performance and process security in heat resistant super alloys.

This tool offers consistent and predictable tool life with high hole integrity, which is of utmost importance in industries with extremely high demands and with processes in place to safeguard quality.

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# Benefits

- Offers excellent machining stability and process security
- Increased flute volume with polished flutes resulting in excellent chip evacuation
- A robust design and excellent dimensional accuracy help improve the finished hole tolerance
- Unique grade and coating significantly improves tool life which means reduced cost per hole
- Standard drilling depth capability up to 8xD



# Application

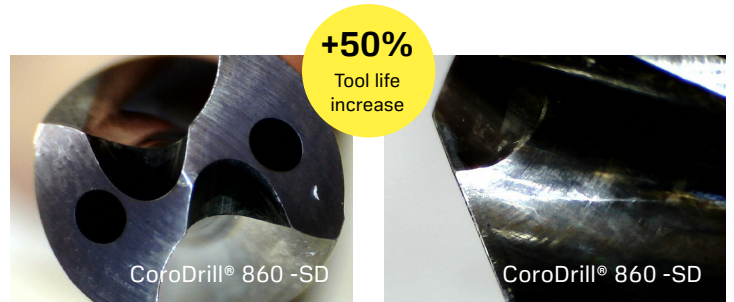
- Optimized for short-hole drilling in heat resistant super alloys, HRSA's
- Diameter range 3.00–16.00 mm with a drill depth of up to 8xDC
- Aerospace components and features such as bosses, scallop/flange faces, casings, low- and high-pressure turbine discs and blisks
- Oil and gas components such as valves



# Customer case

**Component:** Engine shaft  
**Workpiece material:** Nickel-based alloy, S2.0.C.NS (IN-100), HB 353  
**Operation:** Drilling  
**Machine:** Multi-task machine

	CoroDrill® R846	CoroDrill® 860 -SD
Tool	R846-1550-30-A1A 1220	860.1-1550-044A1 S2BM
n rpm	450	450
$v_c$ , m/min	22	22
$f_z$ , mm/z	0.124	0.225
Hole depth, mm	24	24
<b>Result, no of holes</b>	<b>24</b>	<b>36</b>



**Result:** CoroDrill® 860 with -SD geometry outperformed CoroDrill® R846 and the customer could increase tool life and reduce the cost per part while maintaining process security and surface integrity.

Read more about CoroDrill® 860 -SD:  
[sandvik.coromant.com/corodril860](https://sandvik.coromant.com/corodril860)



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