

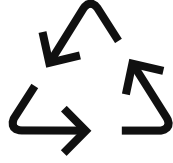
CoroMill® Plura ball nose Assortment and application



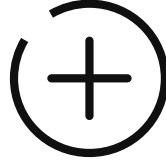
Service offer



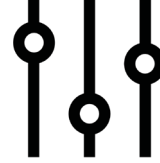
Reconditioning
DC ≥ 6 mm (0.236 inch)



Recycling



CoroPlus®
Tool Guide



Tailor Made™



Advanced
engineered

HRSA machining (secondary material: ISO H)

S2 H

Standard assortment

Code	Grade	DC	DCON	APMX	RE	LU	LB1	Neck	ZEFP	OHX	LF	Shank
2B255-0300-RA R2AH (mm)	R2AH	3	6	4.5	1.5	4.5	10.5	No	5	21	57	Cylindrical
2B256-0400-RA R2AH (mm)	R2AH	4	6	6	2	6	13	No	6	21	57	Cylindrical
2B256-0500-RA R2AH (mm)	R2AH	5	6	7.5	2.5	7.5	16	No	6	21	57	Cylindrical
2B256-0600-RA R2AH (mm)	R2AH	6	6	9	3	9	-	No	6	21	57	Cylindrical
2B256-0800-RA R2AH (mm)	R2AH	8	8	12	4	12	-	No	6	27	63	Cylindrical
2B256-1000-RA R2AH (mm)	R2AH	10	10	15	5	15	-	No	6	32	72	Cylindrical
2B256-1200-RA R2AH (mm)	R2AH	12	12	18	6	18	-	No	6	38	83	Cylindrical
2B256-1600-RA R2AH (mm)	R2AH	16	16	24	8	24	-	No	6	44	92	Cylindrical
2B256-2000-RA R2AH (mm)	R2AH	20	20	30	10	30	-	No	6	54	104	Cylindrical
2B255-0318-RA R2AH (inch)	R2AH	0.125	0.25	0.1875	0.0625	0.1875	0.4375	No	5	0.8327	2.25	Cylindrical
2B256-0476-RA R2AH (inch)	R2AH	0.1875	0.25	0.2813	0.0938	0.2813	0.625	No	6	0.8327	2.25	Cylindrical
2B256-0635-RA R2AH (inch)	R2AH	0.25	0.25	0.375	0.125	0.375	-	No	6	0.8327	2.25	Cylindrical
2B256-0794-RA R2AH (inch)	R2AH	0.3125	0.3125	0.4688	0.1563	0.4688	-	No	6	1.0827	2.5	Cylindrical
2B256-0953-RA R2AH (inch)	R2AH	0.375	0.375	0.5625	0.1875	0.5625	-	No	6	1.4370	3	Cylindrical
2B256-1270-RA R2AH (inch)	R2AH	0.5	0.5	0.75	0.25	0.75	-	No	6	1.7165	3.5	Cylindrical
2B256-1588-RA R2AH (inch)	R2AH	0.625	0.625	0.9375	0.3125	0.9375	-	No	6	1.5945	3.5	Cylindrical
2B256-1905-RA R2AH (inch)	R2AH	0.75	0.75	1.125	0.375	1.125	-	No	6	1.9685	4	Cylindrical

Code	Grade	DC	DCON	APMX	RE	LU	LB1	Neck	ZEFP	OHX	LF	Shank
2B285-0300-RA R2AH (mm)	R2AH	3	6	4.5	1.5	4.5	15	No	5	34	70	Cylindrical
2B286-0400-RA R2AH (mm)	R2AH	4	6	6	2	6	20	No	6	34	70	Cylindrical
2B286-0500-RA R2AH (mm)	R2AH	5	6	7.5	2.5	7.5	25	No	6	44	80	Cylindrical
2B286-0600-RA R2AH (mm)	R2AH	6	6	9	3	9	-	No	6	44	80	Cylindrical
2B286-0800-RA R2AH (mm)	R2AH	8	8	12	4	12	-	No	6	44	80	Cylindrical
2B286-1000-RA R2AH (mm)	R2AH	10	10	15	5	15	-	No	6	60	100	Cylindrical
2B286-1200-RA R2AH (mm)	R2AH	12	12	18	6	18	-	No	6	60	105	Cylindrical
2B286-1600-RA R2AH (mm)	R2AH	16	16	24	8	24	-	No	6	77	125	Cylindrical
2B286-2000-RA R2AH (mm)	R2AH	20	20	30	10	30	-	No	6	100	150	Cylindrical
2B285-0318-RA R2AH (inch)	R2AH	0.125	0.25	0.1875	0.0625	0.1875	0.625	No	5	1.5827	3	Cylindrical
2B286-0476-RA R2AH (inch)	R2AH	0.1875	0.25	0.2813	0.0938	0.2813	1	No	6	1.5827	3	Cylindrical
2B286-0635-RA R2AH (inch)	R2AH	0.25	0.25	0.375	0.125	0.375	-	No	6	1.5827	3	Cylindrical
2B286-0794-RA R2AH (inch)	R2AH	0.3125	0.3125	0.4688	0.1563	0.4688	-	No	6	2.0827	3.5	Cylindrical
2B286-0953-RA R2AH (inch)	R2AH	0.375	0.375	0.5625	0.1875	0.5625	-	No	6	2.4370	4	Cylindrical
2B286-1270-RA R2AH (inch)	R2AH	0.5	0.5	0.75	0.25	0.75	-	No	6	2.7165	4.5	Cylindrical
2B286-1588-RA R2AH (inch)	R2AH	0.625	0.625	0.9375	0.3125	0.9375	-	No	6	3.0945	5	Cylindrical
2B286-1905-RA R2AH (inch)	R2AH	0.75	0.75	1.125	0.375	1.125	-	No	6	3.4685	5.5	Cylindrical



SANDVIK
COROMANT

Titanium machining (secondary material: ISO M)

S4 M

Standard assortment

Code	Grade	DC	DCON	APMX	RE	LU	LB1	Neck	ZEFP	OHX	LF	Shank
2B255-0300-TA T2CH (mm)	T2CH	3	6	4.5	1.5	4.5	10.5	No	5	21	57	Cylindrical
2B256-0400-TA T2CH (mm)	T2CH	4	6	6	2	6	13	No	6	21	57	Cylindrical
2B256-0500-TA T2CH (mm)	T2CH	5	6	7.5	2.5	7.5	16	No	6	21	57	Cylindrical
2B256-0600-TA T2CH (mm)	T2CH	6	6	9	3	9	-	No	6	21	57	Cylindrical
2B256-0800-TA T2CH (mm)	T2CH	8	8	12	4	12	-	No	6	27	63	Cylindrical
2B256-1000-TA T2CH (mm)	T2CH	10	10	15	5	15	-	No	6	32	72	Cylindrical
2B256-1200-TA T2CH (mm)	T2CH	12	12	18	6	18	-	No	6	38	83	Cylindrical
2B256-1600-TA T2CH (mm)	T2CH	16	16	24	8	24	-	No	6	44	92	Cylindrical
2B256-2000-TA T2CH (mm)	T2CH	20	20	30	10	30	-	No	6	54	104	Cylindrical
2B255-0318-TA T2CH (inch)	T2CH	0.125	0.25	0.1875	0.0625	0.1875	0.4375	No	5	0.8327	2.25	Cylindrical
2B256-0476-TA T2CH (inch)	T2CH	0.1875	0.25	0.2813	0.0938	0.2813	0.625	No	6	0.8327	2.25	Cylindrical
2B256-0635-TA T2CH (inch)	T2CH	0.25	0.25	0.375	0.125	0.375	-	No	6	0.8327	2.25	Cylindrical
2B256-0794-TA T2CH (inch)	T2CH	0.3125	0.3125	0.4688	0.1563	0.4688	-	No	6	1.0827	2.5	Cylindrical
2B256-0953-TA T2CH (inch)	T2CH	0.375	0.375	0.5625	0.1875	0.5625	-	No	6	1.4370	3	Cylindrical
2B256-1270-TA T2CH (inch)	T2CH	0.5	0.5	0.75	0.25	0.75	-	No	6	1.7165	3.5	Cylindrical
2B256-1588-TA T2CH (inch)	T2CH	0.625	0.625	0.9375	0.3125	0.9375	-	No	6	1.5945	3.5	Cylindrical
2B256-1905-TA T2CH (inch)	T2CH	0.75	0.75	1.125	0.375	1.125	-	No	6	1.9685	4	Cylindrical

Code	Grade	DC	DCON	APMX	RE	LU	LB1	Neck	ZEFP	OHX	LF	Shank
2B285-0300-TA T2CH (mm)	T2CH	3	6	4.5	1.5	4.5	15	No	5	34	70	Cylindrical
2B286-0400-TA T2CH (mm)	T2CH	4	6	6	2	6	20	No	6	34	70	Cylindrical
2B286-0500-TA T2CH (mm)	T2CH	5	6	7.5	2.5	7.5	25	No	6	44	80	Cylindrical
2B286-0600-TA T2CH (mm)	T2CH	6	6	9	3	9	-	No	6	44	80	Cylindrical
2B286-0800-TA T2CH (mm)	T2CH	8	8	12	4	12	-	No	6	44	80	Cylindrical
2B286-1000-TA T2CH (mm)	T2CH	10	10	15	5	15	-	No	6	60	100	Cylindrical
2B286-1200-TA T2CH (mm)	T2CH	12	12	18	6	18	-	No	6	60	105	Cylindrical
2B286-1600-TA T2CH (mm)	T2CH	16	16	24	8	24	-	No	6	77	125	Cylindrical
2B286-2000-TA T2CH (mm)	T2CH	20	20	30	10	30	-	No	6	100	150	Cylindrical
2B285-0318-TA T2CH (inch)	T2CH	0.125	0.25	0.1875	0.0625	0.1875	0.625	No	5	1.5827	3	Cylindrical
2B286-0476-TA T2CH (inch)	T2CH	0.1875	0.25	0.2813	0.0938	0.2813	1	No	6	1.5827	3	Cylindrical
2B286-0635-TA T2CH (inch)	T2CH	0.25	0.25	0.375	0.125	0.375	-	No	6	1.5827	3	Cylindrical
2B286-0794-TA T2CH (inch)	T2CH	0.3125	0.3125	0.4688	0.1563	0.4688	-	No	6	2.0827	3.5	Cylindrical
2B286-0953-TA T2CH (inch)	T2CH	0.375	0.375	0.5625	0.1875	0.5625	-	No	6	2.4370	4	Cylindrical
2B286-1270-TA T2CH (inch)	T2CH	0.5	0.5	0.75	0.25	0.75	-	No	6	2.7165	4.5	Cylindrical
2B286-1588-TA T2CH (inch)	T2CH	0.625	0.625	0.9375	0.3125	0.9375	-	No	6	3.0945	5	Cylindrical
2B286-1905-TA T2CH (inch)	T2CH	0.75	0.75	1.125	0.375	1.125	-	No	6	3.4685	5.5	Cylindrical

Titanium machining (secondary material: ISO M)

S4 M

Standard assortment

Code	Grade	DC	DCON	APMX	RE	LU	LB1	Neck	ZEFP	OHX	LF	Shank
2B284-0300-TA T2CH (mm)	T2CH	3	6	4.5	1.5	4.5	15	No	4	34	70	Cylindrical
2B284-0400-TA T2CH (mm)	T2CH	4	6	6	2	6	20	No	4	34	70	Cylindrical
2B284-0500-TA T2CH (mm)	T2CH	5	6	7.5	2.5	7.5	25	No	4	44	80	Cylindrical
2B284-0600-TA T2CH (mm)	T2CH	6	6	9	3	9	-	No	4	44	80	Cylindrical
2B284-0800-TA T2CH (mm)	T2CH	8	8	12	4	12	-	No	4	44	80	Cylindrical
2B284-1000-TA T2CH (mm)	T2CH	10	10	15	5	15	-	No	4	60	100	Cylindrical
2B284-1200-TA T2CH (mm)	T2CH	12	12	18	6	18	-	No	4	60	105	Cylindrical
2B284-1600-TA T2CH (mm)	T2CH	16	16	24	8	24	-	No	4	77	125	Cylindrical
2B284-2000-TA T2CH (mm)	T2CH	20	20	30	10	30	-	No	4	100	150	Cylindrical
2B284-0318-TA T2CH (inch)	T2CH	0.125	0.25	0.1875	0.0625	0.1875	0.625	No	4	1.5827	3	Cylindrical
2B284-0476-TA T2CH (inch)	T2CH	0.1875	0.25	0.2813	0.0938	0.2813	1	No	4	1.5827	3	Cylindrical
2B284-0635-TA T2CH (inch)	T2CH	0.25	0.25	0.375	0.125	0.375	-	No	4	1.5827	3	Cylindrical
2B284-0794-TA T2CH (inch)	T2CH	0.3125	0.3125	0.4688	0.1563	0.4688	-	No	4	2.0827	3.5	Cylindrical
2B284-0953-TA T2CH (inch)	T2CH	0.375	0.375	0.5625	0.1875	0.5625	-	No	4	2.4370	4	Cylindrical
2B284-1270-TA T2CH (inch)	T2CH	0.5	0.5	0.75	0.25	0.75	-	No	4	2.7165	4.5	Cylindrical
2B284-1588-TA T2CH (inch)	T2CH	0.625	0.625	0.9375	0.3125	0.9375	-	No	4	3.0945	5	Cylindrical
2B284-1905-TA T2CH (inch)	T2CH	0.75	0.75	1.125	0.375	1.125	-	No	4	3.4685	5.5	Cylindrical

Cutting data recommendations

Optimized CoroMill® Plura ball nose for ISO S

ISO	MC code	Material description	HB	Semi-finishing ($a_e = 0.05 \times DC$)			Finishing ($a_e = 0.01 \times DC$)			
				v_c m/min	v_c feet/min	f_z	v_c m/min	v_c feet/min	f_z mm	f_z inch
S	S1.0.U.AG	Iron-based alloys	280	50	164	$0.004 \times DC$	70	230	0.05 - 0.03 - 0.01	0.002 - 0.0012 - 0.0004
	S2.0.Z.AN	Nickel-based alloys	250	50	164	$0.004 \times DC$	130	427		
	S2.0.Z.AG	Nickel-based alloys	350	65	213	$0.004 \times DC$	90	295		
	S4.3.Z.AN	Titanium-based alloys	330	110	361	$0.005 \times DC$	200	656		
	S4.4.Z.AN	Titanium-based alloys	410	55	180	$0.005 \times DC$	100	328		
M	P5.0.Z.AN	Ferritic/martensitic stainless steel	200	90	295	$0.008 \times DC$	100	328		
	M1.0.Z.AQ	Austenitic stainless steel	200	110	361	$0.008 \times DC$	130	427		
	M3.2.Z.AQ	Duplex (austenitic/ferritic) stainless steel	260	90	295	$0.008 \times DC$	100	328		
H	H1.1.Z.HA	Steel – hardness level 50	50HRC	145	476	$0.003 \times DC$	175	574		
	H1.2.Z.HA	Steel – hardness level 55	55HRC	145	476	$0.002 \times DC$	175	574		
	H1.3.Z.HA	Steel – hardness level 60	60HRC	85	279	$0.002 \times DC$	100	328		

For optimized cutting data, see CoroPlus® Tool Guide.

Learn more about CoroMill® Plura ball nose:
sandvik.coromant.com/coromillpluraballnose



Authorized distributor



1-800-923-6255
www.dgisupply.com

