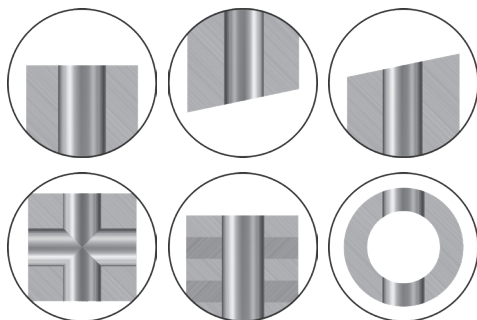


Application area

- Designed for short-hole drilling between diameters 9.00–17.90 mm (0.354–0.705 inch) across all material groups
- For high-volume hole-making across all industries
- Typical components are heat exchanger plates, automotive components, shafts, pump and valves, flanges and structural I & H steel beams
- Hole tolerance H9/H10
- Can be used in a variety of drilling applications



ISO application areas

Drill diameter, mm (inch)	Hole tolerance, ISO286	
	H9	H10
9.0 < DC ≤ 10.0 (0.354 < DC ≤ 0.394)	0/+0.036 (0/+0.0014)	0/+0.058 (0/+0.0023)
10.0 < DC ≤ 18.0 (0.394 < DC ≤ 0.708)	0/+0.043 (0/+0.0017)	0/+0.070 (0/+0.0028)

Assortment overview, drill bodies

Drill diameter, mm (inch)	Shank type	Drill depth (×DC)
9.00–9.9 (0.354–0.390)	Cylindrical (mm and inch)	3, 5, 8
10.00–17.90 (0.394–0.705)	Cylindrical with flat according to ISO 9766 (mm and inch)	3, 5, 8

Assortment overview, drill tips

Drill dimension, mm (inch)	Geometry	Grade
9.00–17.90 (0.354–0.705) DC available in 0.1 mm increments	-M5	GC4334
9.00–17.90 (0.354–0.705) DC available in 0.1 mm increments	-M5	GC2334

Features and benefits

- High-feed capabilities allow for higher penetration rate, increasing productivity and reducing cost per hole
- Patented pre-tension clamping interface and strong drill tip geometry enable secure and robust drilling
- Interface design offers good centering capabilities leading to straighter holes and tighter tolerance
- One geometry for all materials and no pilot drill needed means less stock inventory
- Easy plug-and-play with recommended cutting data
- Optimized chip flute geometry with two twisted coolant holes for good chip evacuation and hole quality

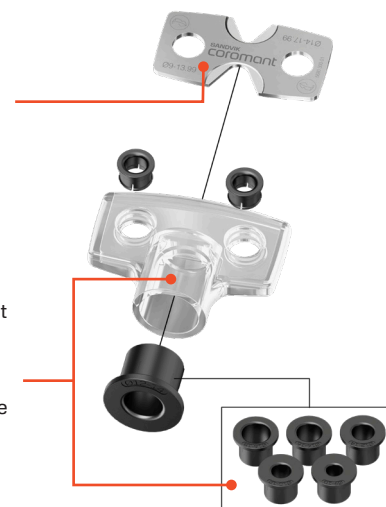
Productive sustainability

- Run with higher feed to improve machine utilization and reduce energy consumption, hence reducing the overall carbon footprint
- Lower cutting forces during drilling reduce the spindle load and energy consumption
- Higher edge-line security and a more predictable wear pattern of the drill tip ensure an overall reduction in carbide consumption
- Recyclable mounting key with plastic cover for safety

Spare parts

Stainless steel key included in each drill box.
Order no: 5680 300-01

Plastic handle with collar set to be ordered separately. Improves ergonomics and avoids splinter risks of carbide. Collars for guidance and improved assembly.
Order no: 5680 300-20

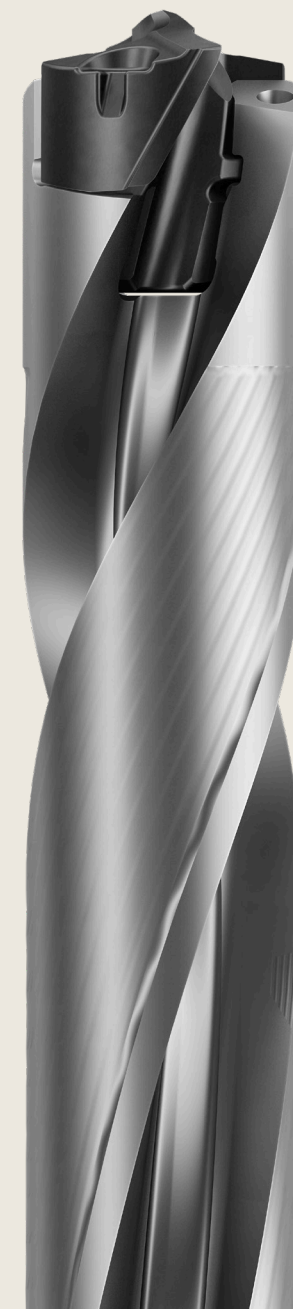


Scan to learn more about CoroDrill® DE10:



C-1040:363 en-GB – Pocket guide
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CoroDrill® DE10



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Cutter body

- Variable helix angle/chip flute designed for trouble-free chip evacuation, whilst optimizing bending/ torsional rigidity
- The chip flute exit is designed for good evacuation of chips, even in long-chipping materials and full drill depth
- Twisted coolant channels for the complete assortment. Exit is close to the cutting zone for sufficient coolant flow and cooling effect



Pre-tension interface

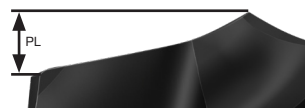
- Inclined axial contact surfaces provide strength and high clamping forces
- Contact faces between drill tip and drill body improves strength and prolongs interface lifetime
- Axial lock feature ensures the drill tip is not detaching from the drill body when retracting from a drilled hole

-M5 geometry

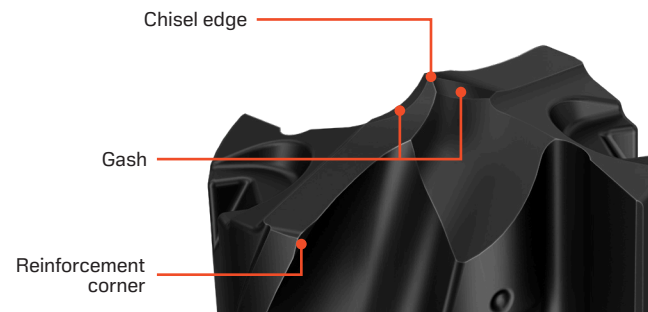
- Gash and chisel edge improves clearance in the centre, provides perfect centering capabilities and gives a perfect balance of strength and low cutting forces
- Reinforcement corner gives a superior edge strength and better wear resistance

-M5 geometry, point length (PL)

For through holes, use PL + 1 mm (0.039 inch) to ensure the drill tip is completely through the hole exit and achieve the correct hole tolerance.



Drill tip interface size	DC min-max, mm	PL min-max	
		mm	inch
090	09.00-09.49	1.27-1.31	0.050-0.052
095	09.50-09.99	1.34-1.38	0.053-0.054
100	10.00-10.49	1.41-1.45	0.056-0.057
105	10.50-10.99	1.48-1.52	0.058-0.060
110	11.00-11.49	1.55-1.59	0.061-0.063
115	11.50-11.99	1.62-1.66	0.064-0.065
120	12.00-12.49	1.69-1.73	0.067-0.068
125	12.50-12.99	1.76-1.80	0.069-0.071
130	13.00-13.49	1.83-1.87	0.072-0.074
135	13.50-13.99	1.90-1.94	0.075-0.076
140	14.00-14.99	1.99-2.07	0.078-0.081
150	15.00-15.99	2.13-2.21	0.084-0.087
160	16.00-16.99	2.27-2.34	0.089-0.092
170	17.00-17.99	2.41-2.49	0.095-0.098



Grade and geometry recommendations

-M5 geometry

One geometry for all materials.

Grade GC4334



- Tough, high Cr content and fine-grained substrate with PVD coating (AlTiN) produced with Zertivo® technology
- High reliability with high edge security provides resistance against built-up edge and chipping

Grade GC2334



- Tough, high Cr content and fine-grained substrate with thin multi-layer PVD coating (AlTiCrN) produced with Zertivo® technology
- For high reliability and improved resistance against chipping and flaking on land margin



Run-out recommendations

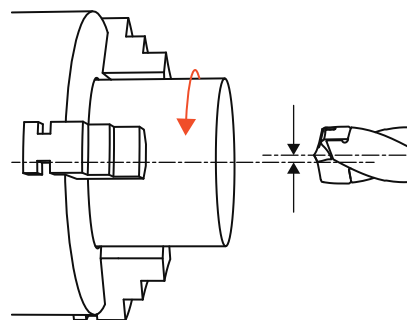
Preferable: ≤ 0.03 mm (0.0012 inch)
Acceptable: ≤ 0.06 mm (0.0024 inch)
Not acceptable: > 0.06 mm (0.0024 inch)

Turning applications, misalignment recommendations

Preferable
 ≤ 0.10 mm (0.0039 inch)

Acceptable
 ≤ 0.20 mm (0.0079 inch)

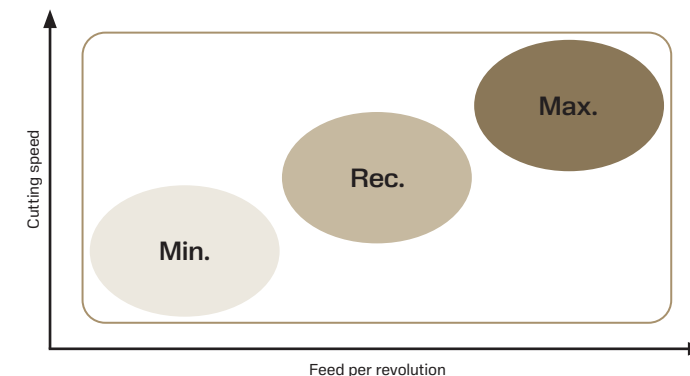
Not acceptable
 > 0.20 mm (0.0079 inch)



Cutter body

- There is NO difference in applying 3xD or 8xD regarding feed recommendations
- The applied cutting data should be within recommendations
- No pilot drilling

Note: If applying too low feed with 8xD drill, it can lead to a slightly larger entry diameter of the hole



Cutting data

- Latest updated cutting data (metric and inch) for all material groups and articles is found in CoroPlus® Tool Guide
- Start values to be found on each article web page



Coolant recommendations

- Internal coolant is recommended for safe chip evacuation
- Apply sufficient coolant flow and follow the recommendation on emulsion concentration from your supplier
- When drilling deep holes, sufficient coolant flow is crucial to enable proper chip evacuation

