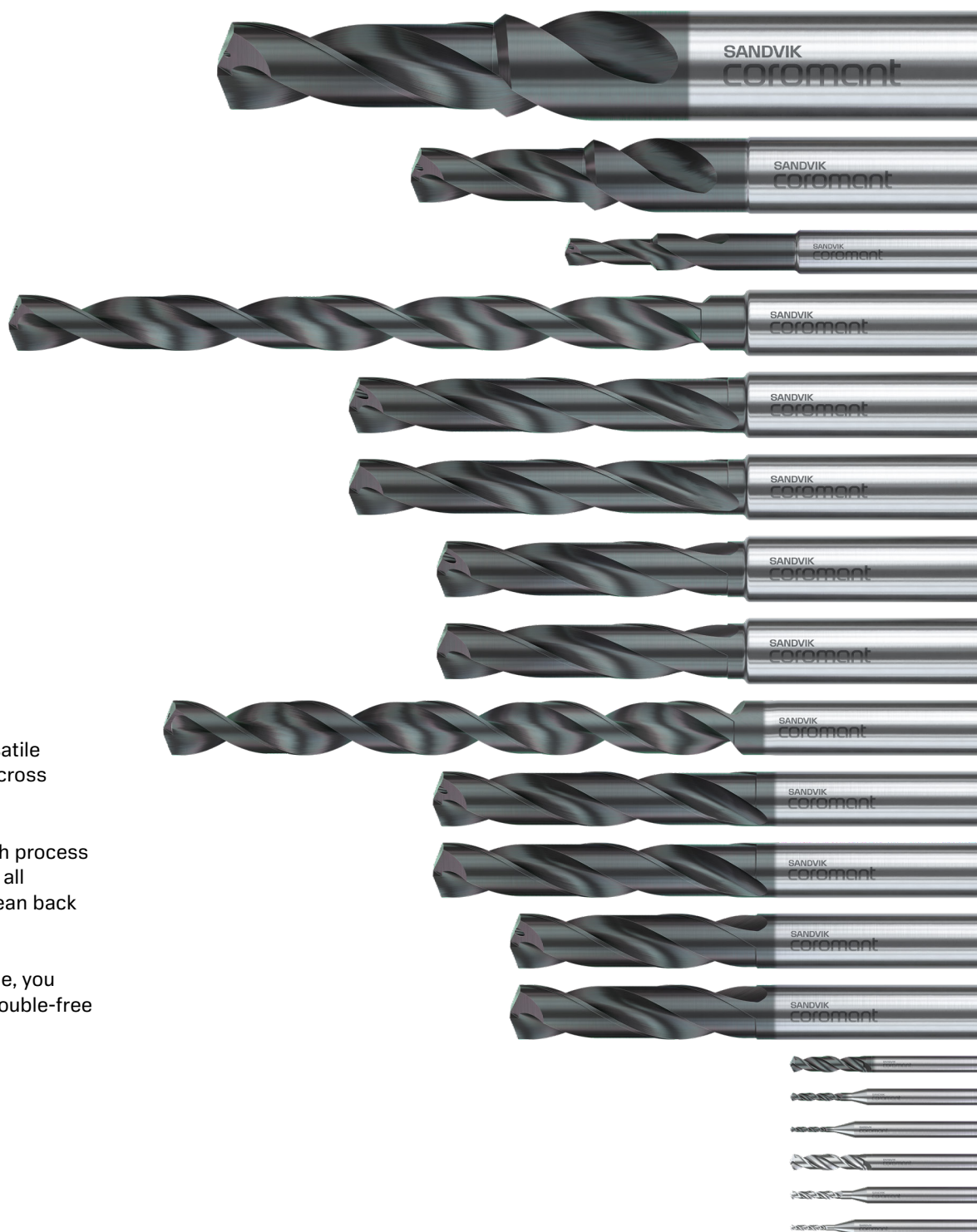


CoroDrill® Dura 462

Drill with ease in all materials



CoroDrill® Dura 462 is your versatile ally for effortless hole making across multi-material applications.

This short-hole drill delivers high process security and superior tool life in all materials so you can ramp up, lean back and save big.

With a wide assortment available, you can count on predictable and trouble-free drilling in every operation.

SANDVIK
coromant



Made for durable drilling

When you use CoroDrill® Dura 462 with the right setup and cutting data from CoroPlus® Tool Guide, you can expect a 100% tool life increase or more*.

Our Zertivo® 2.0 PVD coating and micro-grained cemented carbide substrate are the true enablers, building resistance to high feeds and speeds.

The result? Reliable productivity and reduced cost per hole.

*Recorded against competitors in benchmarking tests.

Versatile geometry

Clearance angles
Improves the point strength.

Cutting edge preparation
Strengthens the edge for increased tool life.

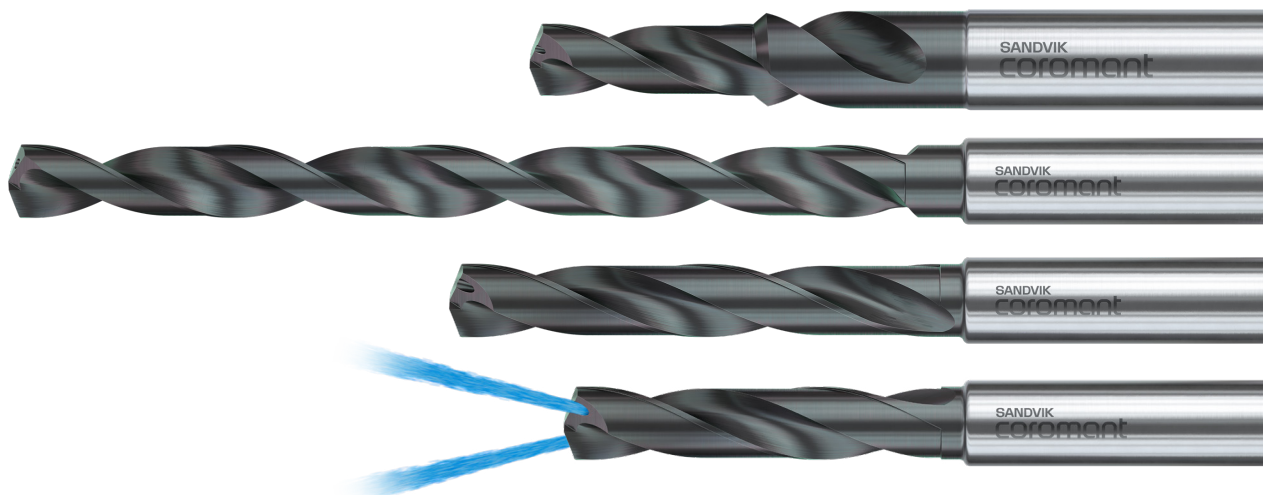
Versatile point geometry
Leads to reduced cutting forces and excellent positional accuracy.

Flute shape
Large flute volume to aid chip evacuation.

Single margin
Reduces heat generation and improves stability.

Unique grade X2BM

- Versatile geometry for multi-material drilling applications
- Features a fine-grained cemented carbide substrate with a very well-controlled microstructure to guarantee the highest performance in a wide range of applications
- New versatile multi-layer PVD coating with our new Zertivo® 2.0 technology
- All drills are fully coated
- Tailored post-treatment for enhanced surface smoothness



Features and benefits

- Features a geometry designed to gain excellent machining stability and process security
- Maximum productivity thanks to the new grade X2BM
- Fully-coated drills ensure high wear resistance
- A robust design ensures good centering and hole straightness securing best possible pre-hole conditions for subsequent operations like tapping or reaming
- Reduced cost per hole and significantly improved tool life
- Features a wide assortment, including type 1 and type 2 drills, stocked and ready to go

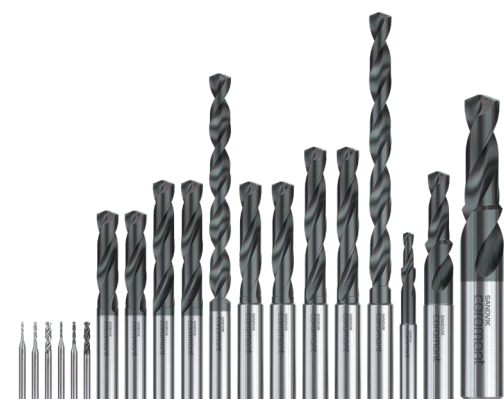
Application

- Diameter range 3.00–20.00 mm (0.118–0.787 inch)
- Drill depth up to 8×DC
- Main industry segments:
 - General engineering, automotive, aerospace, oil and gas, pump and valve
- Typical components:
 - Flanges, castings, sieves, hubs, valve bodies, pump bodies



Application – micro drills

- Diameter range 0.030–3.00 mm (0.001–0.118 inch)
- Drill depth up to 6×DC
- Coated and uncoated tools available
- Main industry segments:
 - Medical, electronics, general engineering, watch-making, automotive, oil and gas, aerospace
- Typical components:
 - Hydraulic valve, watch case, medical devices and surgical instruments, electrical connectors, electronics, mould-making, actuators, sensors, navigational systems



Assortment information

CoroDrill® Dura 462 replaces the CoroDrill® 460 -XM product family. The previously named CoroDrill® 462 -XM micro drills (579 items) are now part of the CoroDrill® Dura 462 range, featuring the same geometry, coating and substrate but have an updated product code.

Cutting data recommendations, ISO P

ISO	MC Code	Material	Hardness HB	Cutting speed (v _c), m/min (ft/min)			Drill diameter, mm (inch)				
							3.00-6.00 (0.118-0.236)	6.01-10.00 (0.237-0.393)	10.01-13.00 (0.394-0.511)	13.01-16.00 (0.512-0.629)	16.01-20.00 (0.630-0.787)
				A1 (3-5xD)	A1 (8xD)	A0 (3-5xD)	Feed (f _n), mm/r (in/rev)*				
P	Steel										
	P1.1.Z.AN	Unalloyed C=0.1-0.25%	200	125-190 (410-623)	115-190 (377-623)	96-150 (315-492)	0.16-0.24 (0.0063-0.0094)	0.16-0.26 (0.0063-0.0102)	0.21-0.30 (0.0082-0.0118)	0.25-0.40 (0.0098-0.0157)	0.35-0.45 (0.0137-0.0177)
	P1.2.Z.AN	Unalloyed C=0.25-0.55%	300	125-190 (410-623)	125-190 (410-623)	85-130 (278-426)	0.16-0.24 (0.0063-0.0094)	0.16-0.26 (0.0063-0.0102)	0.21-0.30 (0.0082-0.0118)	0.25-0.40 (0.0098-0.0157)	0.35-0.45 (0.0137-0.0177)
	P1.3.Z.AN	Unalloyed C>0.55%	200	105-160 (344-525)	105-160 (344-525)	80-130 (262-426)	0.09-0.15 (0.0035-0.0060)	0.120-0.22 (0.0047-0.0086)	0.20-0.28 (0.0078-0.0110)	0.25-0.32 (0.0098-0.0126)	0.32-0.45 (0.0125-0.0177)
	P2.1.Z.AN	Low alloyed (alloying elements≤5%)	200	120-150 (393-492)	120-150 (393-492)	80-130 (262-426)	0.09-0.18 (0.0035-0.0070)	0.16-0.24 (0.0063-0.0094)	0.20-0.33 (0.0078-0.0129)	0.24-0.38 (0.0095-0.0149)	0.30-0.42 (0.0118-0.0165)
	P2.2.Z.AN	Low alloy annealed	200	80-132 (264-433)	80-132 (265-433)	70-104 (229-341)	0.12-0.18 (0.0047-0.0070)	0.15-0.24 (0.0059-0.0094)	0.22-0.32 (0.0086-0.0126)	0.3-0.45 (0.0118-0.0177)	0.35-0.50 (0.0137-0.0196)
	P2.5.Z.HT	Low alloy hardened + tempered	200	70-90 (230-295)	70-90 (230-295)	40-60 (131-197)	0.09-0.15 (0.0035-0.0059)	0.20-0.30 (0.0078-0.0118)	0.22-0.40 (0.0078-0.0157)	0.26-0.33 (0.0102-0.0129)	0.30-0.48 (0.0118-0.0188)
	P3.0.Z.AN	High alloy annealed	200	90-140 (295-459)	90-140 (295-459)	60-95 (197-311)	0.09-0.140 (0.0035-0.055)	0.16-0.24 (0.0063-0.0094)	0.20-0.30 (0.0079-0.0118)	0.22-0.336 (0.0086-0.0132)	0.32-0.41 (0.0126-0.0161)
	P3.0.Z.HT	High alloy hardened + tempered	200	45-75 (147-246)	45-75 (147-246)	40-60 (131-197)	0.06-0.10 (0.0023-0.0039)	0.1-0.17 (0.0039-0.0067)	0.13-0.20 (0.0051-0.0078)	0.22-0.28 (0.0086-0.0110)	0.25-0.32 (0.0098-0.0126)
P5.0.Z.PH	Precipitation hardened	230	40-60 (131-197)	40-60 (131-197)		0.10-0.18 (0.0039-0.0070)	0.16-0.25 (0.0063-0.0098)	0.15-0.30 (0.0059-0.0118)	0.15-0.30 (0.0059-0.0118)	0.25-0.4 (0.0098-0.0157)	

*Note! For A0 tools below 16 mm (0.629 inch), reduce feed by 50%.

Cutting data recommendations, ISO M

ISO	MC Code	Material	Hardness HB	Cutting speed (v _c), m/min (ft/min)			Drill diameter, mm (inch)				
							3.00-6.00 (0.118-0.236)	6.01-10.00 (0.237-0.393)	10.01-13.00 (0.394-0.511)	13.01-16.00 (0.512-0.629)	16.01-20.00 (0.630-0.787)
				A1 (3-5xD)	A1 (8xD)	A0 (3-5xD)	Feed (f _n), mm/r (in/rev)				
M	Stainless steel										
	M1.0.Z.AQ	Austenitic	200	30-90 (98-295)	30-90 (98-295)		0.07-0.15 (0.0027-0.0059)	0.10-0.20 (0.0039-0.0078)	0.13-0.20 (0.0051-0.0078)	0.15-0.3 (0.0059-0.0118)	0.25-0.40 (0.0098-0.0157)
	M2.0.Z.AQ	Super austenitic Ni≥20%	300	30-50 (98-164)	30-50 (98-164)		0.07-0.14 (0.0027-0.0055)	0.10-0.17 (0.0039-0.0067)	0.12-0.20 (0.0047-0.0078)	0.14-0.25 (0.0055-0.0098)	0.22-0.35 (0.0086-0.0137)
M3.2.Z.A	Austenitic/ferritic (Duplex)	260	40-80 (131-262)	40-80 (131-262)		0.06-0.11 (0.0023-0.0043)	0.10-0.15 (0.0039-0.0059)	0.12-0.18 (0.0047-0.0070)	0.16-0.32 (0.0063-0.0126)	0.25-0.36 (0.0098-0.0141)	

Cutting data recommendations, ISO K

ISO	MC Code	Material	Hardness HB	Cutting speed (v _c), m/min (ft/min)			Drill diameter, mm (inch)				
							3.00-6.00 (0.118-0.236)	6.01-10.00 (0.237-0.393)	10.01-13.00 (0.394-0.511)	13.01-16.00 (0.512-0.629)	16.01-20.00 (0.630-0.787)
				A1 (3-5xD)	A1 (8xD)	A0 (3-5xD)	Feed (f _n), mm/r (in/rev)				
K	Malleable cast iron										
	K1.1.C.NS	Ferritic pearlitic	200	70-110 (230-360)	70-110 (230-360)	55-85 (180-278)	0.1-0.14 (0.0039-0.0066)	0.12-0.20 (0.0047-0.0078)	0.21-0.30 (0.0082-0.0118)	0.25-0.4 (0.0098-0.0157)	0.3-0.5 (0.0118-0.0196)
	Grey cast iron										
	K2.1.C.UT	Low tensile strength	180	80-130 (262-426)	70-125 (230-410)		0.12-0.2 (0.0047-0.0078)	0.18-0.25 (0.0070-0.0098)	0.24-0.35 (0.0094-0.0137)	0.3-0.5 (0.0118-0.0196)	0.4-0.6 (0.0157-0.0236)
	K2.2.C.UT	High tensile strength	245	80-130 (263-426)	70-125 (230-410)		0.12-0.2 (0.0047-0.0051)	0.18-0.25 (0.0070-0.0098)	0.24-0.35 (0.0094-0.0137)	0.3-0.5 (0.0118-0.0196)	0.4-0.6 (0.0157-0.0236)
	Nodular cast iron										
	K3.1.C.UT	Ferritic	155	75-130 (246-426)	65-120 (213-394)	60-90 (197-295)	0.12-0.25 (0.0047-0.0098)	0.18-0.3 (0.0070-0.0118)	0.25-0.38 (0.0098-0.0149)	0.28-0.5 (0.0110-0.0197)	0.40-0.65 (0.0157-0.0255)
	K3.3.C.UT	Pearlitic	265	75-130 (246-426)	65-120 (213-394)	60-90 (197-295)	0.1-0.2 (0.0039-0.0078)	0.16-0.24 (0.0063-0.0094)	0.20-0.30 (0.0078-0.0118)	0.25-0.38 (0.0098-0.0149)	0.3-0.45 (0.0118-0.0177)
	K4.2.C.UT	CGI	230	75-130 (246-426)	65-120 (213-394)	60-90 (197-295)	0.12-0.30 (0.0047-0.0118)	0.18-0.32 (0.0070-0.0125)	0.25-0.38 (0.0098-0.0149)	0.28-0.45 (0.0110-0.0177)	0.35-0.5 (0.0137-0.0196)
K5.1.C.NS	ADI	300	45-90 (148-295)	45-90 (148-295)	40-60 (131-197)	0.10-0.16 (0.0039-0.0063)	0.16-0.26 (0.0062-0.0102)	0.20-0.30 (0.0078-0.0118)	0.28-0.35 (0.0110-0.0137)	0.30-0.40 (0.0118-0.0157)	

Find the latest updated cutting data in [CoroPlus® Tool Guide](#).

Cutting data recommendations, ISO N

ISO	MC Code	Material	Hardness HB	Cutting speed (v_c), m/min (ft/min)			Drill diameter, mm (inch)				
							3.00–6.00 (0.118–0.236)	6.01–10.00 (0.237–0.393)	10.01–13.00 (0.394–0.511)	13.01–16.00 (0.512–0.629)	16.01–20.00 (0.630–0.787)
				A1 (3–5xD)	A1 (8xD)	A0 (3–5xD)	Feed (f_z), mm/r (in/rev)				
N	Aluminium based alloys										
	N1.2.Z.UT	AlSi alloys Si \leq 1% untreated	60	250–360 (820–360)	250–360 (820–360)	190–284 (623–931)	0.12–0.18 (0.0047–0.0070)	0.21–0.31 (0.0082–0.0122)	0.30–0.45 (0.0118–0.0177)	0.35–0.51 (0.0137–0.0201)	0.36–0.55 (0.0141–0.0216)
	N1.2.Z.AG	AlSi alloys Si \leq 1%	100	250–360 (820–1180)	250–360 (820–1180)	180–300 (590–984)	0.20–0.30 (0.0078–0.0118)	0.24–0.38 (0.0094–0.0147)	0.30–0.45 (0.0118–0.0177)	0.30–0.45 (0.0118–0.0177)	0.35–0.55 (0.0137–0.0216)
	N1.3.C.AG	AlSi alloys 1% \leq Si \leq 13%	90	190–285 (623–935)	190–285 (623–935)	152–228 (499–747)	0.10–0.18 (0.0078–0.0118)	0.16–0.24 (0.0063–0.0094)	0.25–0.45 (0.0098–0.0177)	0.30–0.43 (0.0118–0.0169)	0.40–0.70 (0.0157–0.0275)
N1.4.C.NS	AlSi cast alloys Si \geq 13%	130	145–220 (475–721)	145–220 (475–721)	120–170 (394–557)	0.090–0.14 (0.0035–0.0055)	0.16–0.24 (0.0063–0.0094)	0.20–0.30 (0.0078–0.0118)	0.22–0.34 (0.0086–0.0133)	0.27–0.45 (0.0106–0.0177)	

Cutting data recommendations, ISO S

ISO	MC Code	Material	Hardness HB	Cutting speed (v_c), m/min (ft/min)			Drill diameter, mm (inch)				
							3.00–6.00 (0.118–0.236)	6.01–10.00 (0.237–0.393)	10.01–13.00 (0.394–0.511)	13.01–16.00 (0.512–0.629)	16.01–20.00 (0.630–0.787)
				A1 (3–5xD)	A1 (8xD)	A0 (3–5xD)	Feed (f_z), mm/r (in/rev)				
S	Titanium based alloys										
	S4.1.Z.UT	Commercially pure ($>$ 99.5% Ti)	200	45–70 (147–230)			0.13–0.18 (0.0051–0.0110)	0.15–0.20 (0.0059–0.0078)	0.17–0.22 (0.0066–0.0086)	0.23–0.32 (0.0090–0.0125)	0.35–0.42 (0.0137–0.0165)
	S4.2.Z.AN	Alpha- and near alpha alloys	330	38–58 (125–190)			0.10–0.15 (0.0039–0.0059)	0.11–0.18 (0.0043–0.0070)	0.11–0.22 (0.0043–0.0086)	0.16–0.28 (0.0063–0.0110)	0.3–0.38 (0.0118–0.0147)

Cutting data recommendations, ISO H

ISO	MC Code	Material	Hardness HRc	Cutting speed (v_c), m/min (ft/min)			Drill diameter, mm (inch)				
							3.00–6.00 (0.118–0.236)	6.01–10.00 (0.237–0.393)	10.01–13.00 (0.394–0.511)	13.01–16.00 (0.512–0.629)	16.01–20.00 (0.630–0.787)
				A1 (3–5xD)	A1 (8xD)	A0 (3–5xD)	Feed (f_z), mm/r (in/rev)				
H	Extra hard steel										
	H1.1.Z.HA	Hardened and tempered	50	20–30 (65–98)			0.06–0.1 (0.0023–0.0039)	0.08–0.12 (0.0031–0.0047)	0.13–0.20 (0.0051–0.0078)	0.16–0.24 (0.0063–0.0094)	0.18–0.27 (0.0070–0.0106)
	H1.2.Z.HA	Hardened and tempered	55	18–25 (59–82)			0.06–0.1 (0.0023–0.0039)	0.08–0.12 (0.0031–0.0047)	0.13–0.20 (0.0051–0.0078)	0.16–0.24 (0.0063–0.0094)	0.18–0.27 (0.0070–0.0106)
	H2.0.C.UT	Chilled cast iron	55	22–36 (72–118)			0.06–0.1 (0.0023–0.0039)	0.08–0.12 (0.0031–0.0047)	0.13–0.20 (0.0051–0.0078)	0.16–0.24 (0.0063–0.0094)	0.18–0.27 (0.0070–0.0106)

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