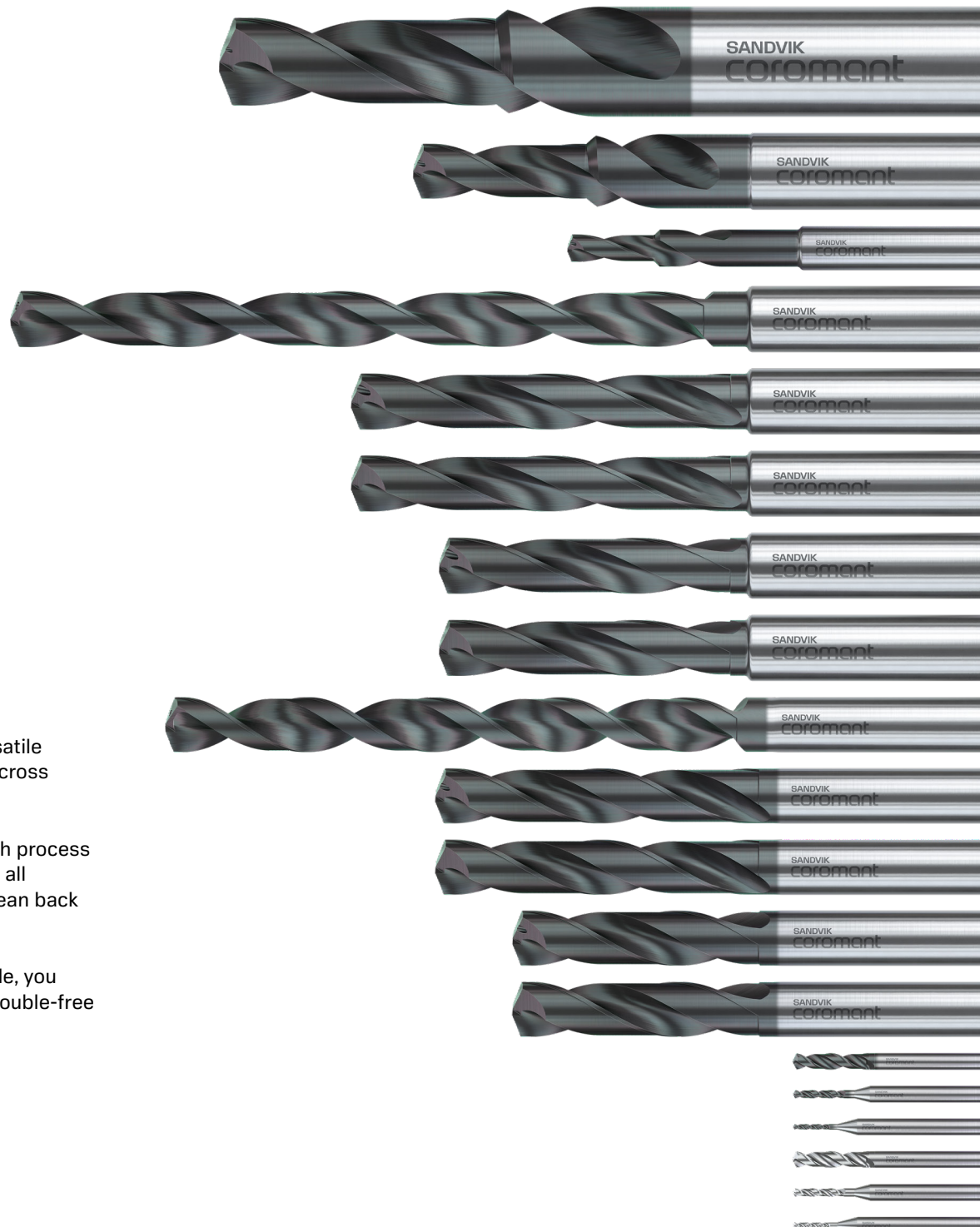


# CoroDrill® Dura 462

## 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.

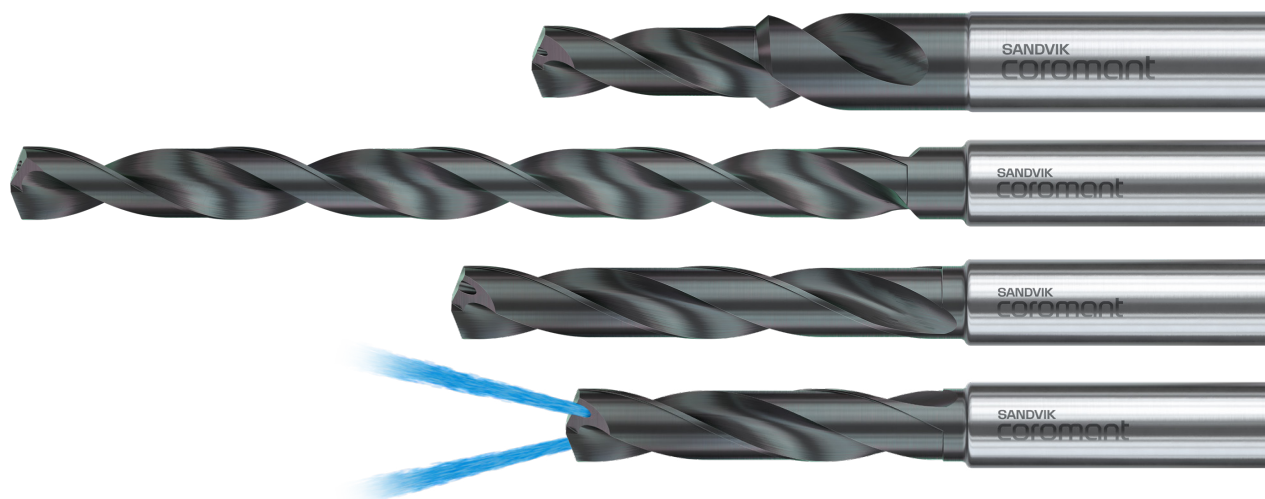
**Versatile point geometry**  
Leads to reduced cutting forces and excellent positional accuracy.

**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

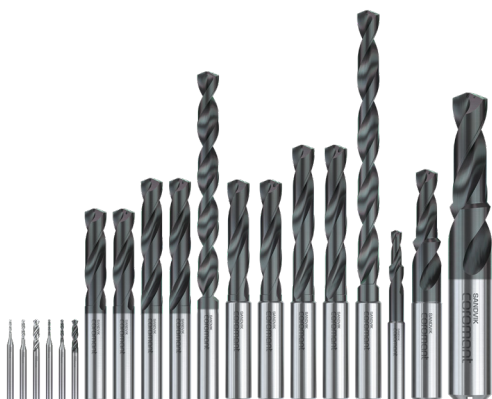
## Application

- 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

Corodur® Dura 462 replaces the Corodur® 460 -XM product family. The previously named Corodur® 462 -XM micro drills (579 items) are now part of the Corodur® 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<br>HB | Cutting speed (v <sub>c</sub> ), m/min (ft/<br>min) |                      |                                                                                   | Drill diameter, mm (inch)              |                               |                              |                               |                              |
|-----|-----------|---------------------------------------|----------------|-----------------------------------------------------|----------------------|-----------------------------------------------------------------------------------|----------------------------------------|-------------------------------|------------------------------|-------------------------------|------------------------------|
|     |           |                                       |                |                                                     |                      |                                                                                   | 3.00–6.00<br>(0.118–0.236)             | 6.01–10.00<br>(0.237–0.393)   | 10.01–13.00<br>(0.394–0.511) | 13.01–16.00<br>(0.512–0.629)  | 16.01–20.00<br>(0.630–0.787) |
|     |           |                                       |                | A1 (3–5xD)                                          | A1 (8xD)             | A0 (3–5xD)                                                                        | Feed (f <sub>n</sub> ), mm/r (in/rev)* |                               |                              |                               |                              |
| P   | Steel     |                                       |                |                                                     |                      |                                                                                   |                                        |                               |                              |                               |                              |
|     | P1.1.Z.AN | Unalloyed<br>C=0.1–0.25%              | 200            | 125–190<br>(410–623)                                | 115–190<br>(377–623) | 96–150<br>(315–492)                                                               | 0.16–0.24<br>(0.0063–0.0094)           | 0.16–0.26<br>(0.0063–0.0102)  | 0.21–0.30<br>(0.0082–0.0118) | 0.25–0.40<br>(0.0098–0.0157)  | 0.35–0.45<br>(0.0137–0.0177) |
|     | P1.2.Z.AN | Unalloyed<br>C=0.25–0.55%             | 300            | 125–190<br>(410–623)                                | 125–190<br>(410–623) | 85–130<br>(278–426)                                                               | 0.16–0.24<br>(0.0063–0.0094)           | 0.16–0.26<br>(0.0063–0.0102)  | 0.21–0.30<br>(0.0082–0.0118) | 0.25–0.40<br>(0.0098–0.0157)  | 0.35–0.45<br>(0.0137–0.0177) |
|     | P1.3.Z.AN | Unalloyed<br>C>0.55%                  | 200            | 105–160<br>(344–525)                                | 105–160<br>(344–525) | 80–130<br>(262–426)                                                               | 0.09–0.15<br>(0.0035–0.0060)           | 0.120–0.22<br>(0.0047–0.0086) | 0.20–0.28<br>(0.0078–0.0110) | 0.25–0.32<br>(0.0098–0.0126)  | 0.32–0.45<br>(0.0125–0.0177) |
|     | P2.1.Z.AN | Low alloyed (alloying<br>elements≤5%) | 200            | 120–150<br>(393–492)                                | 120–150<br>(393–492) | 80–130<br>(262–426)                                                               | 0.09–0.18<br>(0.0035–0.0070)           | 0.16–0.24<br>(0.0063–0.0094)  | 0.20–0.33<br>(0.0078–0.0129) | 0.24–0.38<br>(0.0095–0.0149)  | 0.30–0.42<br>(0.0118–0.0165) |
|     | P2.2.Z.AN | Low alloy annealed                    | 200            | 80–132<br>(264–433)                                 | 80–132<br>(265–433)  | 70–104<br>(229–341)                                                               | 0.12–0.18<br>0.0047–0.0070             | 0.15–0.24<br>0.0059–0.0094    | 0.22–0.32<br>0.0086–0.0126   | 0.3–0.45<br>0.0118–0.0177     | 0.35–0.50<br>0.0137–0.0196   |
|     | P2.5.Z.HT | Low alloy hardened +<br>tempered      | 200            | 70–90<br>(230–295)                                  | 70–90<br>(230–295)   | 40–60<br>(131–197)                                                                | 0.09–0.15<br>(0.0035–0.0059)           | 0.20–0.30<br>(0.0078–0.0118)  | 0.22–0.40<br>(0.0078–0.0157) | 0.26–0.33<br>(0.0102–0.0129)  | 0.30–0.48<br>(0.0118–0.0188) |
|     | P3.0.Z.AN | High alloy<br>annealed                | 200            | 90–140<br>(295–459)                                 | 90–140<br>(295–459)  | 60–95<br>(197–311)                                                                | 0.09–0.140<br>(0.0035–0.055)           | 0.16–0.24<br>(0.0063–0.0094)  | 0.20–0.30<br>(0.0079–0.0118) | 0.22–0.336<br>(0.0086–0.0132) | 0.32–0.41<br>(0.0126–0.0161) |
|     | P3.0.Z.HT | High alloy hardened<br>+ tempered     | 200            | 45–75<br>(147–246)                                  | 45–75<br>(147–246)   | 40–60<br>(131–197)                                                                | 0.06–0.10<br>(0.0023–0.0039)           | 0.1–0.17<br>(0.0039–0.0067)   | 0.13–0.20<br>(0.0051–0.0078) | 0.22–0.28<br>(0.0086–0.0110)  | 0.25–0.32<br>(0.0098–0.0126) |
|     | P5.0.Z.PH | Precipitation<br>hardened             | 230            | 40–60<br>(131–197)                                  | 40–60<br>(131–197)   |  | 0.10–0.18<br>(0.0039–0.0070)           | 0.16–0.25<br>(0.0063–0.0098)  | 0.15–0.30<br>(0.0059–0.0118) | 0.15–0.30<br>(0.0059–0.0118)  | 0.25–0.4<br>(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<br>HB | Cutting speed (v <sub>c</sub> ), m/min (ft/min) |                    |            | Drill diameter, mm (inch)             |                              |                              |                              |                              |
|-----|-----------------|---------------------------------|----------------|-------------------------------------------------|--------------------|------------|---------------------------------------|------------------------------|------------------------------|------------------------------|------------------------------|
|     |                 |                                 |                |                                                 |                    |            | 3.00–6.00<br>(0.118–0.236)            | 6.01–10.00<br>(0.237–0.393)  | 10.01–13.00<br>(0.394–0.511) | 13.01–16.00<br>(0.512–0.629) | 16.01–20.00<br>(0.630–0.787) |
|     |                 |                                 |                | A1 (3–5xD)                                      | A1 (8xD)           | A0 (3–5xD) | Feed (f <sub>a</sub> ), mm/r (in/rev) |                              |                              |                              |                              |
| M   | Stainless steel |                                 |                |                                                 |                    |            |                                       |                              |                              |                              |                              |
|     | M1.0.Z.AQ       | Austenitic                      | 200            | 30–90<br>(98–295)                               | 30–90<br>(98–295)  |            | 0.07–0.15<br>(0.0027–0.0059)          | 0.10–0.20<br>(0.0039–0.0078) | 0.13–0.20<br>(0.0051–0.0078) | 0.15–0.3<br>(0.0059–0.0118)  | 0.25–0.40<br>(0.0098–0.0157) |
|     | M2.0.Z.AQ       | Super austenitic<br>Ni≥20%      | 300            | 30–50<br>(98–164)                               | 30–50<br>(98–164)  |            | 0.07–0.14<br>(0.0027–0.0055))         | 0.10–0.17<br>(0.0039–0.0067) | 0.12–0.20<br>(0.0047–0.0078) | 0.14–0.25<br>(0.0055–0.0098) | 0.22–0.35<br>(0.0086–0.0137) |
|     | M3.2.Z.A        | Austenitic/ferritic<br>(Duplex) | 260            | 40–80<br>(131–262)                              | 40–80<br>(131–262) |            | 0.06–0.11<br>(0.0023–0.0043)          | 0.10–0.15<br>(0.0039–0.0059) | 0.12–0.18<br>(0.0047–0.0070) | 0.16–0.32<br>(0.0063–0.0126) | 0.25–0.36<br>(0.0098–0.0141) |

Cutting data recommendations, ISO K

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

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

Cutting data recommendations, ISO N

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

Cutting data recommendations, ISO S

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

Cutting data recommendations, ISO H

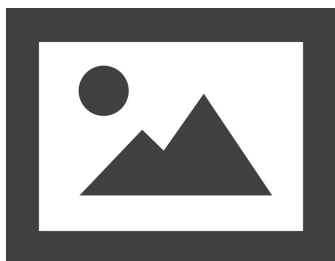
| ISO | MC Code          | Material              | Hardness<br>HRc | Cutting speed (v <sub>c</sub> ), m/min (ft/min) |          |            | Drill diameter, mm (inch)             |                              |                              |                              |                         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

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