



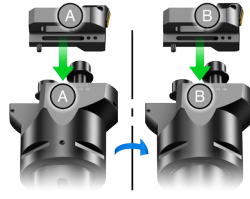
Handling instruction for CoroBore® BR10, 20, 20D, 30



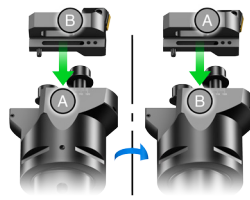
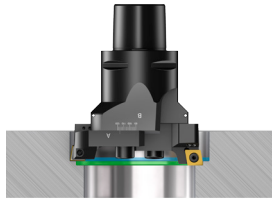
CoroBore® 20/20D



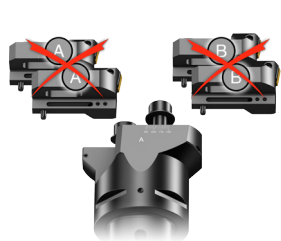
Twin-edge productive boring



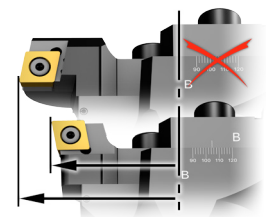
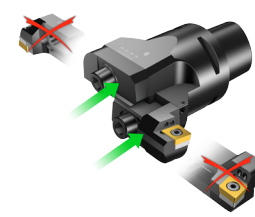
Step boring



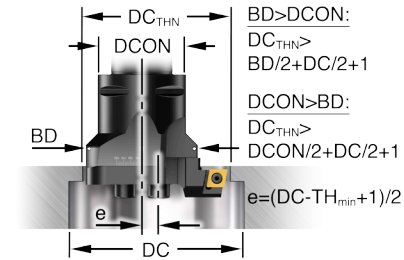
Not recommended



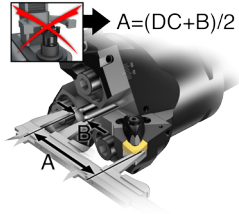
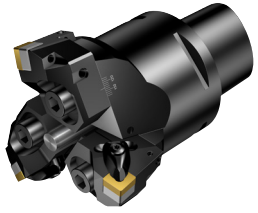
CoroBore® BR10



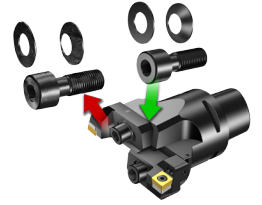
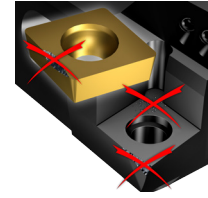
Size	DCN	DCX	CZC	BD1	Through hole, TH	Insert 90°	CZCms
A	32	38	20	20	27	CC06	EH20
B	37	45	25	24	32	CC06	EH25
C	44	54	32	30	39	CC06	C3
D	53	65	40	39	47.5	CC06	C4
DX	64	76	40	39	53	CC09	C4
E	75	91	50	50	63.5	CC12	C5
F	90	110	50	63	77.5	CC12	C5
G	109	136	63	82	96.5	CC12	C6
H	135	170	63	108	122.5	CC12	C6



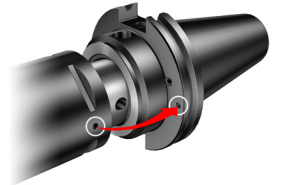
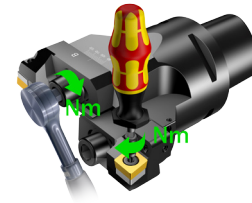
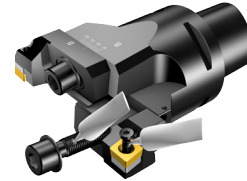
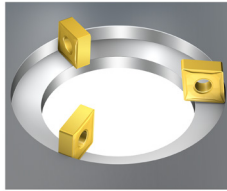
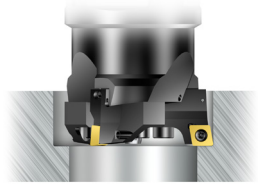
CoroBore® BR30



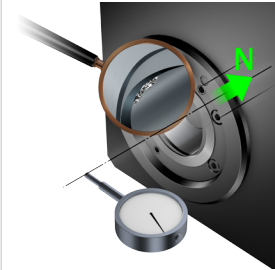
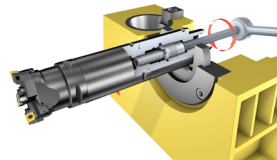
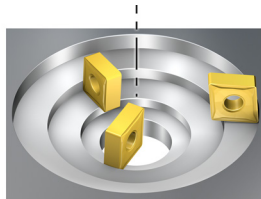
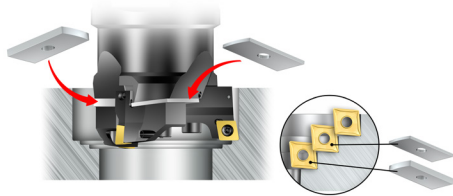
Handling and Care



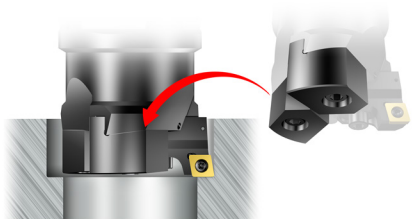
Multi-edge productive boring



Step boring



Single-edge boring



Coromant Capto®

Size	Nm	Ft/lbs
C3	40– 50	30– 37
C4	50– 60	37– 44
C5	90–100	67– 74
C6–C8	160–180	118–133
C10	380	283



ISO	ANSI	Non ISO	Code	Size	Torx Plus	Nm	Ft/lbs
CC06	CC2(1.5)		5513 020-03	M2,5	7IP	0.9	0.7
CC09	CC09		5513 020-09	M3,5	15IP	3.0	2.2
CC12	CC43		5513 020-17	M4x0,5	15IP	3.0	2.2
		SP06	5513 020-33	M2,2	7IP	0.8	0.59
		SP08	5513 020-57	M3	9IP	1.7	1.25
		SP12	416.1-833	M3,5	10IP	2	1.48
		SP18	5513 020-25	M4	15IP	3	2.2
SN15	SN54		5512 086-03	M6	20IP	6.4	4.7
CN16	CN54		5512 086-03	M6	20IP	6.4	4.7

CoroBore® BR20/CoroBore® BR20 with Silent Tools™ technology

			Insert 90°					Insert 84°			
Size	DCN (mm)	DCX (mm)	ISO	ANSI	Nm	Ft/lbs	Screw size	Non-ISO	Nm	Ft/lbs	Screw size
A	23	29	CC06	CC2(1.5)	4.8	3.5	M 4	SP06	4.8	3.5	M 4
B	28	36	CC06	CC2(1.5)	4.8	3.5	M 4	SP06	4.8	3.5	M 4
C	35	45	CC09	CC3(2.5)	9	6,6	M 5	SP08	9	6,6	M 5
D	44	56	CC09	CC3(2.5)	16.0	11.8	M 6	SP08	16.0	11.8	M 6
E	55	71	CC12	CC43	38.0	28.0	M 8	SP12	38.0	28.0	M 8
F	70	90	CC12	CC43	75	55	M 10	SP12	75	55	M 10
G	89	116	CC12	CC43	75	55	M 10	SP12	75	55	M 10
H	115	150	CC12	CC43	75	55	M 10	SP12	75	55	M 10

CoroBore® BR30

			Insert 90°					Insert 84°						
Size	DCN (mm)	DCX (mm)	ISO	ANSI	Nm	Ft/lbs	Screw size	ISO	ANSI	Non-ISO	Nm	Ft/lbs	Screw size	
A	35	40.5	CC06	CC2(1.5)	4.8	3.5	M 4			SP06	4.8	3.5	M 4	
	39.5	45	CC06	CC2(1.5)	4.8	3.5	M 4				4.8	3.5	M 4	
B	44	50.5	CC06	CC2(1.5)	9	6.6	M 4				SP06	9	6.6	M 4
	49.5	56	CC06; CC09	CC2(1.5); CC3(2.5)	9	6.6	M 5				SP08	9	6.6	M 5
C	55	63	CC09	CC3(2.5)	16	11.8	M 6				SP08	16	11.8	M 6
	62	70	CC09; CC12	CC3(2.5); CC43	16	11.8	M 6				SP12	16	11.8	M 6
D	69	78.5	CC12	CC43	16	11.8	M 6				SP12	16	11.8	M 6
	77.5	87	CC12	CC43	16	11.8	M 6				SP12	16	11.8	M 6
E	86	97	CC12	CC43	38	28	M 8	SP12	38	28	M 8			
	96	107	CC12	CC43	38	28	M 8	SP12	38	28	M 8			
F	106	122	CC12	CC43	75	55.3	M 10	SN12	SN43	SP13	75	55.3	M 10	
	121	137	CC12	CC43	75	55.3	M 10	SN13	SN44	SP14	75	55.3	M 10	
G	136	152	CC12	CC43	75	55.3	M 10	SN14	SN45	SP15	75	55.3	M 10	
	151	167	CC12	CC43	75	55.3	M 10	SN15	SN46	SP16	75	55.3	M 10	
H	166	191	CC12; CN16	CC43; CN54	75.0; 120.0	55.3; 88.5	M 10; M 12	SN15	SN54	SP17	75.0; 120.0	55.3; 88.5	M 10; M 12	
	189	214	CC12; CN16	CC43; CN54	75.0; 120.0	55.3; 88.5	M 10; M 12	SN16	SN55	SP18	75.0; 120.0	55.3; 88.5	M 10; M 12	
I	212	237	CC12; CN16	CC43; CN54	75.0; 120.0	55.3; 88.5	M 10; M 12	SN17	SN56	SP19	75.0; 120.0	55.3; 88.5	M 10; M 12	
	235	260	CC12; CN16	CC43; CN54	75.0; 120.0	55.3; 88.5	M 10; M 12	SN18	SN57	SP20	75.0; 120.0	55.3; 88.5	M 10; M 12	
IX	258	283	CC12; CN16	CC43; CN54	75.0; 120.0	55.3; 88.5	M 10; M 12	SN19	SN58	SP21	75.0; 120.0	55.3; 88.5	M 10; M 12	
	281	306	CC12; CN16	CC43; CN54	75.0; 120.0	55.3; 88.5	M 10; M 12	SN20	SN59	SP22	75.0; 120.0	55.3; 88.5	M 10; M 12	

CoroBore® BR10

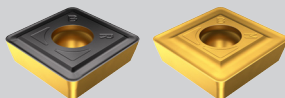
			Insert 90°				
Size	DCN (mm)	DCX (mm)	ISO	ANSI	Nm	Ft/lbs	Screw size
A	32	38	CC06	CC2(1.5)	4.8	3.5	M 4
B	37	45	CC06	CC2(1.5)	4.8	3.5	M 4
C	44	54	CC06	CC2(1.5)	9	6.6	M 5
D	53	65	CC06	CC2(1.5)	16	11.8	M 6
DX	64	76	CC09	CC3(2.5)	16.0	11.8	M 6
E	75	91	CC12	CC43	38.0	28.0	M 8
F	90	110	CC12	CC43	75	55.3	M 10
G	109	136	CC12	CC43	75	55.3	M 10
H	135	170	CC12	CC43	75	55.3	M 10

CoroBore® 111

Order code	Grade	Feed range (f_n)			Depth of cut (a_p)			Cutting speed (v_c)		
		Min	Max	*)	Min	Max	*)	Min	Max	*)
SPMT0606-BR	4325	0.10	0.25	0.20	0.6	4.5	2.0	365	460	395
SPMT0606-BM	2025	0.10	0.15	0.10	0.6	4.5	1.8	260	265	265
SPMT0606-BR	3210	0.15	0.30	0.25	0.6	4.5	2.0	285	330	300
SPMT0606-BM	1145	0.10	0.15	0.10	0.6	4.5	1.8	15	20	20
SPMT0808-BR	4325	0.15	0.35	0.20	0.8	6.5	2.5	325	425	395
SPMT0808-BM	2025	0.10	0.25	0.20	0.8	6.5	2.2	225	265	240
SPMT0808-BR	3210	0.20	0.50	0.30	0.8	6.5	2.5	235	315	285
SPMT0808-BM	1145	0.10	0.15	0.10	0.8	6.5	2.2	15	20	20
SPMT1212-BR	4325	0.15	0.40	0.25	1.2	9.0	3.0	305	425	365
SPMT1210-BM	2025	0.10	0.30	0.20	1.0	9.0	2.5	205	265	240
SPMT1212-BR	3210	0.20	0.50	0.30	1.2	9.0	3.0	235	315	285
SPMT1210-BM	1145	0.10	0.20	0.15	1.0	9.0	2.5	10	20	15
SPMT1812-BR	4325	0.20	0.40	0.30	1.2	12.0	3.8	305	395	345
SPMT1810-BM	2025	0.20	0.30	0.25	1.0	12.0	3.0	205	240	225
SPMT1812-BR	3210	0.25	0.50	0.30	1.2	12.0	3.8	235	300	285
SPMT1810-BM	1145	0.10	0.20	0.15	1.0	12.0	3.0	10	20	15

*) Recommended

- P** = Steel
- M** = Stainless steel
- K** = Cast iron
- S** = Heat resistant alloys



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