

Tools for sliding head machines

GENERAL TURNING
PARTING AND GROOVING
THREAD TURNING
TURNING TOOL ADAPTORS
MILLING
DRILLING
REAMING
ROTATING TOOL ADAPTORS



Let us introduce our new catalogues

When you face the task of producing thousands upon thousands of small and tricky parts, Sandvik Coromant has the tools to tackle the job. This catalogue guides you through our comprehensive range of high precision tools for machining small diameter components in sliding head machines.

To help you find and select the tools that fit your specific machine type, the tools in this catalogue are grouped by shank size and coupling type within each area.








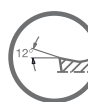





Please note that solid round tools are not included in this catalogue. You find them in the Solid round tools catalogue.

Our total offer of approximately 50,000 standard products can be found at www.sandvik.coromant.com. If your requirements are particularly demanding, we have a wide range of products that can be tailored upon your request.

Please visit www.sandvik.coromant.com to be sure of getting the latest measurements and tolerances, get detailed cutting data, and order all available products and spare parts.



Explanation of reference symbols:

 Inserts	 External tools	 Internal tools	 Adaptors	 Accessories
 Cutting data	 Grade description	 Geometry designation	 Parameter explanation	 Tailor Made
 Code keys	 Coolant information	 Information		

	First choice
	Good choice
	Not available

Our first choice recommendation is a good starting point for most operations, from which you can choose a grade with other attributes if needed.

A	A	General turning
B	B	Parting and grooving
	C	Thread turning
	D	Turning tool adaptors
C	E	Milling
	F	Drilling
	G	Reaming
D	H	Rotating tool adaptors
	I	Accessories
E	J	General information

General turning

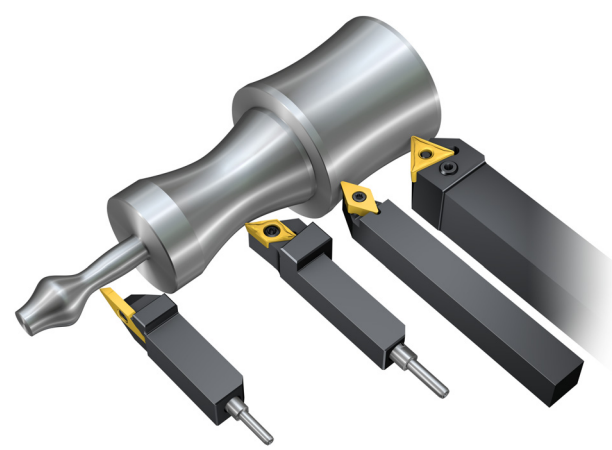
External turning

B

T-Max® P
 Turning
 Ø12 – 40 mm (.472 – 1.575 inch)
 RE ≥ 0.2 mm (.0008 inch)



CoroTurn® 107
 Turning, profiling, back turning
 Ø6 – 40 mm (.236 – 1.575 inch)
 RE ≥ 0.02 mm (.0008 inch)
 Wiper technology



E

CoroCut® XS
 Turning, profiling, backturning
 Ø1-8 mm (.040 – .315 inch)
 RE ≥ 0.03 mm (.001 inch)



CoroTurn® TR
 Turning, profiling
 Ø6 – 40 mm (.236 – 1.575 inch)
 RE ≥ 0.4 mm (.016 inch)
 iLock™



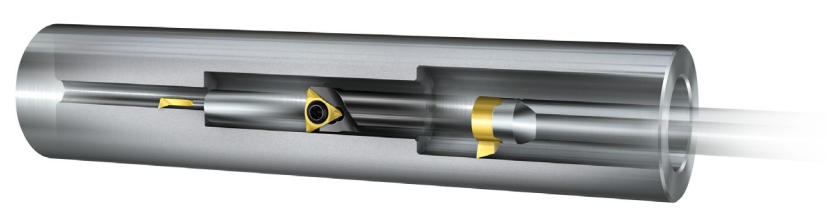
F Internal turning

G

CoroTurn® XS
 Turning, profiling, back boring
 DMIN 0.3 mm (.012 inch)



CoroCut® MB
 Turning, profiling, back boring
 DMIN 10 mm (.394 inch)



I

CoroTurn® 107
 Turning
 DMIN 6 mm (.236 inch)



CoroTurn® 107	A6
Inserts	A7-A22
External tools	A31-A52
Internal tools	A53-A93
T-Max® P	A23
Inserts	A24-A26
External tools	A31-A52
Internal tools	A55-A91
CoroTurn® TR	A27
Inserts	A28
External tools	A31-A52
Internal tools	A54-A55
CoroCut® XS	A29
Inserts	A30
External tools	B47-B64
CoroTurn® XS	A94
Cutting tools	A96-A104
Adaptors	D2
CoroCut® MB	A95
Cutting tools	A105
Adaptors	D2

B

C

D

E

F

G







H

I




J






Tool overview

External tools




		CoroTurn® 107			T-Max® P		CoroTurn® TR
		QS™-HP shank tools	QS™ shank tools	Rectangular shank tools	QS™ shank tools	Rectangular shank tools	Rectangular shank tools
							
CZC _{MS}			A31	A32			
Metric	8 x 8			A32			
	8 x 10			A32			
	10 x 12	A33					
	10 x 10		A34	A35			
	12 x 12	A36	A37	A38-A39		A39	
	16 x 16	A40	A41	A42-A43	A41		A43
Inch	3/8 x 3/8	A44	A44	A45			
	3/8 x 1/2	A44					
	1/2 x 1/2	A46	A47	A48-A49			
	5/8 x 5/8	A49	A50	A51-A52			A51-A52

Internal tools

		CoroTurn® 107	T-Max® P	CoroTurn® TR
		CoroTurn® SL head		
				
CZC _{MS}				
Metric	16	A53		
	20	A53		
	25	A54-A55	A55	A54-A55

		CoroTurn® 107				T-Max® P
		Cylindrical shank without clamping features		Cylindrical shank with 3 flats		Cylindrical shank with 3 flats
		Boring bar	Solid carbide boring bar	Boring bar	Solid carbide boring bar	Boring bar
						
CZC _{MS}						
Metric	5	A56				
	6	A56	A56	A57		
	8	A58	A58	A57		
	10	A59-A60	A59	A60		
	12	A61-A62	A61-A62	A63		
	16	A64-A65	A64	A66-A67		A67
	20	A68-A69	A68	A70-A71		A71
	25	A72		A73		A73-A74
Inch	1/4	A75	A75	A75		
	5/16	A76	A76	A76		
	3/8	A77	A77	A78	A78	
	1/2	A79	A79	A80	A80	
	5/8	A81-A82	A81	A83-A84	A84	A83-A84
	3/4	A85	A85-A86	A87-A89	A89	A88
	1	A90	A90	A91-A92	A93	A91

Cutting tools

		CoroTurn® XS		CoroCut® MB
		Solid carbide tool	Carbide blank	Solid carbide head
				
CZC _{MS}				
Metric	4	A96-A98	A104	
	5	A99-A100	A104	
	6	A101-A102	A104	
	7	A103	A104	A105

Inserts overview

CoroTurn® 107

Finishing



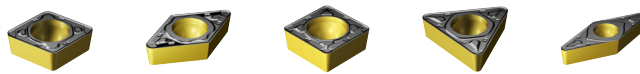
Page	CC.. A7	DC.. A10	SC.. A14	TC.. A15	VB.. A19	VC.. A19
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Medium



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Roughing



Page	CC.. A7	DC.. A10	SC.. A14	TC.. A15	VB.. A19
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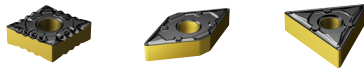
Polycrystalline diamond (PCD)



Page	VC.. A22
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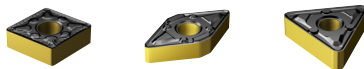
T-Max® P

Finishing



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Medium



Page	CN.. A24	DN.. A25	TN.. A26
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Roughing



Page	CN.. A24	DN.. A25
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CoroTurn® TR



Page	TR-DC.. A28	TR-VB.. A28
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CoroCut® XS



A30

CoroTurn® 107

B For external and internal turning

C **Excellent surface finish**

When turning internally or machining slender components, you can rely on the super sharp cutting edges of CoroTurn 107. With a broad range of inserts CoroTurn 107 is the first choice for small part turning, combining low cutting forces with high precision coolant. This combination ensures good chip control resulting in an excellent surface finish of the machined component.

D **ISO application area:**



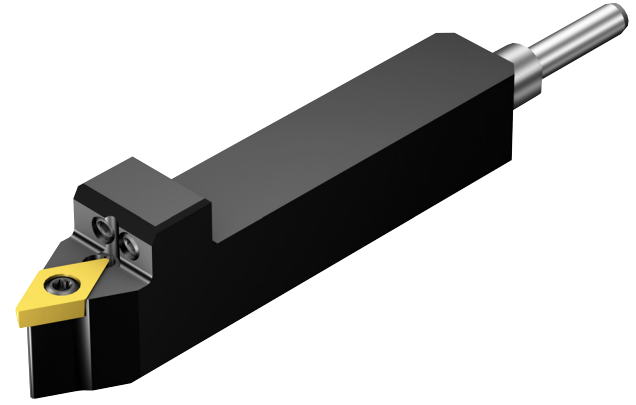
E **Application**

- Back turning
- Profiling
- Medium to finishing

F **Wide range of inserts (Benefits and features)**

- Available in all insert geometries, grades, shapes and entering angles
- Wiper geometries available for high feeds and excellent surface finish
- VCET and VCEX, grounded wiper inserts with extra sharp cutting edges for high precision at small feed and big depth of cut
- High precision -UM geometry with E- and G tolerances ensuring precision indexing of inserts
- For corner radii down to 0.02 mm (.0008 inch)

www.sandvik.coromant.com/coroturn107



G **Positive insert shape**

- 5°, 7° clearance angle
- All types of insert shapes and sizes
- Geometries and grades for all application areas
- Insert grades also in advanced cutting materials PCD, CBN and ceramics

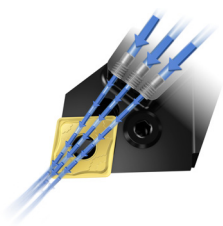
Tools

- QS Shank tools
- Shank tools
- Boring bars
- CoroTurn® SL heads

Tools with EasyFix™ and Silent Tools™ available.

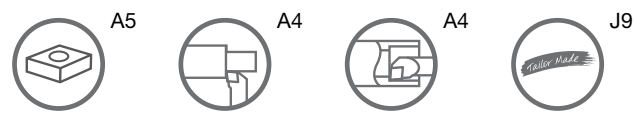
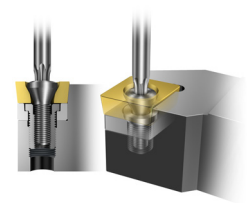
H **Designed for precision coolant**

Holders are available with precision nozzles for excellent chip control.



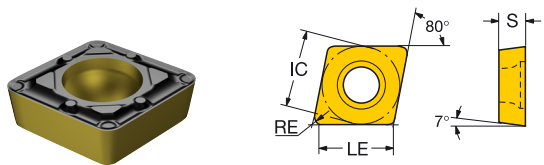
Screw clamping

Adds stability and unobstructed chip flow



CoroTurn® 107 insert for turning

C-style insert (Rhombic 80°)

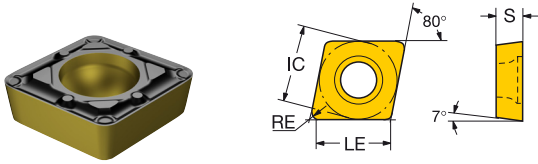


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	IC	IC						1125	1515	1525	4315	4325	4335	5015	H13A	1105	1115	1125	1515	1525	2220	H13A	1525	4315	4325	5015	H13A	1125	H10	H13A	1105	1115		1125	H10	H13A	SOBF						
SMC	09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-SMC																															*			CCMT 3(2.5)1-SMC			
			.365	.156	.016																																*		CCMT 3(2.5)2-SMC				
			8.9	3.97	0.79	CCMT 09 T3 08-SMC																																					
PMC	09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-PMC					*	*											*	*																CCMT 3(2.5)1-PMC			
			.365	.156	.016																				*	*														CCMT 3(2.5)2-PMC			
			8.9	3.97	0.79	CCMT 09 T3 08-PMC					*	*												*	*																		
PM	06	1/4	6.0	2.38	0.40	CCMT 06 02 04-PM	*	*	*	*	*	*					*	*				*	*	*	*															CCMT 2(1.5)1-PM			
			.238	.094	.016													*	*				*	*	*	*														CCMT 2(1.5)2-PM			
			5.6	2.38	0.79	CCMT 06 02 08-PM	*	*	*	*	*	*					*	*					*	*	*	*																	
PM	09	3/8	9.3	3.97	0.40	CCMT 09 T3 04-PM	*	*	*	*	*	*					*	*				*	*	*	*																CCMT 3(2.5)1-PM		
			.365	.156	.016						*	*					*	*				*	*	*	*															CCMT 3(2.5)2-PM			
			8.9	3.97	0.79	CCMT 09 T3 08-PM	*	*	*	*	*	*					*	*				*	*	*	*																		
PM	12	1/2	12.5	4.76	0.40	CCMT 12 04 04-PM					*	*	*	*				*	*			*	*	*	*																CCMT 431-PM		
			.492	.188	.016						*	*	*	*				*	*			*	*	*	*																CCMT 432-PM		
			12.1	4.76	0.79	CCMT 12 04 08-PM			*	*	*	*	*				*	*				*	*	*	*																	CCMT 433-PM	
PM	11.7	4.76	1.19			CCMT 12 04 12-PM	*		*	*	*						*	*				*	*																				
			.460	.188	.047													*	*				*	*																			
			6.0	2.38	0.10	CCET 06 02 01-UM	*								*	*	*							*	*				*	*	*	*	*	*	*	*	*	*		CCET 2(1.5)03-UM			
UM			.250	.094	.004		*								*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*		CCET 2(1.5)0-UM			
			6.2	2.38	0.20	CCET 06 02 02-UM	*								*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*	*		CCET 2(1.5)1-UM		
			.246	.094	.008		*								*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*	*		CCET 2(1.5)1-UM		
UM			6.0	2.38	0.40	CCET 06 02 04-UM	*								*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*	*	*		CCET 2(1.5)1-UM	
			.238	.094	.016										*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*	*	*			
			6.2	2.38	0.20	CCGX 06 02 02-AL									*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 2(1.5)0-AL	
AL			.246	.094	.008									*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 2(1.5)1-AL	
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			.238	.094	.016									*	*	*						*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 3(2.5)2-AL
AL	09	3/8	9.3	3.97	0.40	CCGX 09 T3 04-AL							*	*	*							*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 431-AL	
			.365	.156	.016								*	*	*							*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 432-AL
			8.9	3.97	0.79	CCGX 09 T3 08-AL							*	*	*							*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 431-AL
AL			.349	.156	.031							*	*	*							*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 432-AL
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			.492	.188	.016								*	*	*							*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 432-AL
		12.1	4.76	0.79	CCGX 12 04 08-AL							*	*	*							*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 432-AL
		.476	.188	.031								*	*	*							*	*				*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		CCGX 432-AL



CoroTurn[®] 107 insert for turning

C-style insert (Rhombic 80°)

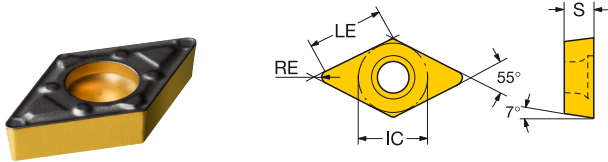


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Medium	UM	06 1/4	6.3	2.38	0.10	CCGT 06 02 01-UM	☆														★	★	★	★	★	★	★	★	★	★	★	★	★	★	CCGT 2(1.5)03-UM			
			.250	.094	.004	CCGT 06 02 02-UM	☆	☆															★	★	★	★	★	★	★	★	★	★	★	★	★	CCGT 2(1.5)0-UM		
		6.2	2.38	0.20																																	CCGT 2(1.5)1-UM	
			.246	.094	.008						★	★	★	★	★	★																						
			6.0	2.38	0.40																	☆	★	★	★	★	★	★	★	★	★	★	★	★	★	★		
	09 3/8	9.6	3.97	0.10																																	CCGT 3(2.5)03-UM	
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		.373	.156	.008																																		
		9.3	3.97	0.40																																		
UM	06 1/4	6.0	2.38	0.40	CCMT 06 02 04-UM	☆	☆	☆	☆	★	☆	☆		★	☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆			☆	★			CCMT 2(1.5)1-UM			
		.238	.094	.016	CCMT 06 02 08-UM	☆	☆			★					★	☆	☆				☆	☆			☆						☆	★			CCMT 2(1.5)2-UM			
	5.6	2.38	0.79																																			
	.222	.094	.031																																			
	09 3/8	9.3	3.97	0.40	CCMT 09 T3 04-UM	☆	☆	☆	☆	★			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	CCMT 3(2.5)1-UM	
.365	.156	.016	CCMT 09 T3 08-UM	☆	☆	☆	☆	★	☆	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	CCMT 3(2.5)2-UM		
8.9	3.97	0.79																																				
.349	.156	.031																																				
Roughing	UR	06 1/4	6.0	2.38	0.40	CCMT 06 02 04-UR			☆	★										☆	☆															CCMT 2(1.5)1-UR		
			.238	.094	.016																																	
09 3/8	9.3	3.97	0.40	CCMT 09 T3 04-UR			☆	☆	★											☆	☆																CCMT 3(2.5)1-UR	
.365	.156	.016																																				



CoroTurn® 107 insert for turning

D-style insert (Rhombic 55°)

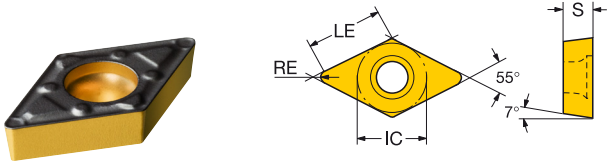


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Finishing	WF	07	1/4	7.6	2.38	0.20	0.4	DCMX 07 02 02-WF	☆								★														DCMX 2(1.5)0-WF	
				.297	.094	.008	.014	DCMX 07 02 04-WF	☆	☆	☆	★	☆						☆	☆	☆	☆						☆				DCMX 2(1.5)1-WF
				.289	.094	.016	.022	DCMX 07 02 08-WF	☆	☆	☆	★	☆						☆	☆	☆							☆				DCMX 2(1.5)2-WF
				.274	.094	.031	.024																									
				.450	.156	.008	.014	DCMX 11 T3 02-WF	☆					★																		DCMX 3(2.5)0-WF
				.442	.156	.016	.020	DCMX 11 T3 04-WF	☆	☆	☆	★	☆	☆						☆	☆	☆	☆							★	☆	
			.426	.156	.031	.028	DCMX 11 T3 08-WF	☆	☆	☆	★	☆	☆						☆	☆	☆	☆							★	☆		DCMX 3(2.5)2-WF
		PF	07	1/4	7.6	2.38	0.20	DCMT 07 02 02-PF	☆					★																	DCMT 2(1.5)0-PF	
				.297	.094	.008	DCMT 07 02 04-PF	☆					★	☆							☆	☆	☆									DCMT 2(1.5)1-PF
				.289	.094	.016																										
				.450	.156	.008	DCMT 11 T3 02-PF	☆						★																		DCMT 3(2.5)0-PF
				.442	.156	.016	DCMT 11 T3 04-PF	☆					★	☆							☆	☆	☆									DCMT 3(2.5)1-PF
			.426	.156	.031	DCMT 11 T3 08-PF	☆					★	☆								☆	☆	☆								DCMT 3(2.5)2-PF	
	MF	07	1/4	7.6	2.38	0.20	DCMT 07 02 02-MF	☆																			★	☆	☆	DCMT 2(1.5)0-MF		
			.297	.094	.008	DCMT 07 02 04-MF	☆																					★	☆	☆	DCMT 2(1.5)1-MF	
			.289	.094	.016																											
			.450	.156	.008	DCMT 11 T3 02-MF	☆																								DCMT 3(2.5)0-MF	
			.442	.156	.016	DCMT 11 T3 04-MF	☆																								DCMT 3(2.5)1-MF	
			.426	.156	.031	DCMT 11 T3 08-MF	☆																							☆	DCMT 3(2.5)2-MF	
	UF	07	1/4	7.6	2.38	0.20	DCMT 07 02 02-UF	☆	☆				★																★	DCMT 2(1.5)0-UF		
			.297	.094	.008	DCMT 07 02 04-UF	☆	☆																						★	DCMT 2(1.5)1-UF	
			.289	.094	.016																											
			.450	.156	.008	DCMT 11 T3 02-UF	☆	☆																							DCMT 3(2.5)0-UF	
			.442	.156	.016	DCMT 11 T3 04-UF	☆	☆																							DCMT 3(2.5)1-UF	
			.426	.156	.031	DCMT 11 T3 08-UF	☆	☆																							DCMT 3(2.5)2-UF	



CoroTurn® 107 insert for turning

D-style insert (Rhombic 55°)

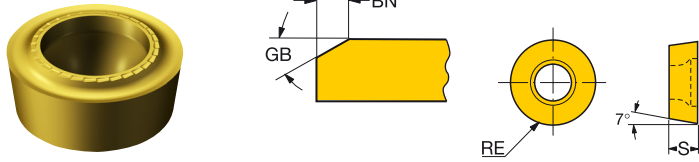


		LE		RE	BS	ISO CODE	P							M					K			N			S					ANSI CODE							
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Medium	AL	07	1/4	7.6	2.38	0.20	DCGX 07 02 02-AL																	*		*								DCGX 2(1.5)0-AL			
				.297	.094	.008	DCGX 07 02 04-AL																	*		*								DCGX 2(1.5)1-AL			
				7.4	2.38	0.40	DCGX 11 T3 02-AL																		*		*								DCGX 3(2.5)0-AL		
				.289	.094	.016	DCGX 11 T3 04-AL																		*		*								DCGX 3(2.5)1-AL		
				11.2	3.97	0.40	DCGX 11 T3 08-AL																		*		*								DCGX 3(2.5)2-AL		
				.426	.156	.031																			*		*										
Medium	UM	07	1/4	7.4	2.38	0.40	DCMT 07 02 04-UM	*	*	*	*	*	*						*	*	*	*	*	*	*	*	*					*	*	DCMT 2(1.5)1-UM			
				.289	.094	.016	DCMT 07 02 08-UM	*	*	*	*	*	*	*						*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	DCMT 2(1.5)2-UM		
				7.0	2.38	0.79	DCMT 11 T3 04-UM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	DCMT 3(2.5)1-UM	
				.274	.094	.031	DCMT 11 T3 08-UM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	DCMT 3(2.5)2-UM	
				11.2	3.97	0.40	DCMT 11 T3 04-UR	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	DCMT 3(2.5)1-UR
				.442	.156	.016																			*	*	*	*	*	*	*	*	*	*			
		10.8	3.97	0.79																		*	*	*	*	*	*	*	*	*	*	*					
		.426	.156	.031																		*	*	*	*	*	*	*	*	*	*	*					
Roughing	UR	11	3/8	11.2	3.97	0.40	DCMT 11 T3 04-UR				*	*									*	*															
				.442	.156	.016																*	*														



CoroTurn® 107 insert for turning

R-style insert (Round)



Metric version

		S	RE	GB	BN	ISO CODE	P					M				K			N			S							
							1125	1515	4315	4325	4335	5015	H13A	1105	1115	1125	1515	H13A	4315	4325	5015	H13A	1125	H10	H13A	1105	1115	1125	H10
Medium	M0	05	2.38	2.50	0°	0.10	RCMT 05 02 M0	☆			★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	★	☆	☆	☆	☆	☆	
		06	2.38	3.00	0°	0.10	RCMT 06 02 M0	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	★					☆	☆	
		08	3.18	4.00	0°	0.10	RCMT 08 03 M0		☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆					★	☆
		10	3.97	5.00	15°	0.10	RCMT 10 T3 M0			☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		★					★	☆
		10	3.97	5.00	15°	0.10	RCMT 10 T3 M0-SM									☆	★	☆	☆	☆					★	☆	☆	☆	☆
	AL	06	2.38	3.00			RCGX 06 02 M0-AL																★				☆	☆	
		08	3.18	4.00			RCGX 08 03 M0-AL																★				☆	☆	
		10	3.97	5.00			RCGX 10 T3 M0-AL									☆										★	☆	☆	

Inch version

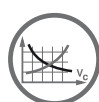
		S	RE	GB	BN	ISO CODE	P		M		K		S			ANSI CODE
							4315	4325	H13A	1115	1125	H13A	4315	4325	H13A	
Medium	SM	1/4	.125	.125		RCMT 06 03 00-SM				★	☆	☆	☆	☆	☆	RCMT 22-SM
		1/4	.125	.125	0°	.004	RCMT 06 03 00	☆	★	☆		☆	☆	★		RCMT 22



A4



A4



A108



A122



J19



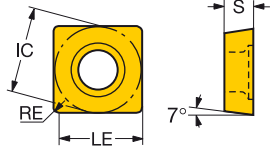
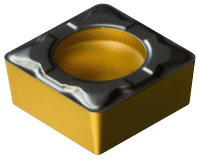
J5



A

CoroTurn® 107 insert for turning

S-style insert (Square)



B

C

D

E


F

G

H

I

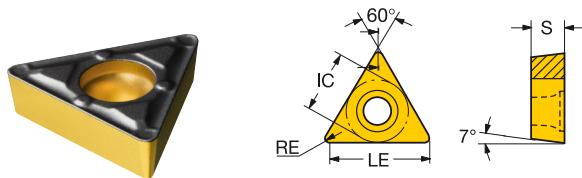
J

					ISO CODE	P					M				K			N		S			ANSI CODE											
		LE	S	RE		1125	1515	1525	4315	4325	4335	5015	1105	1115	1125	1515	1525	2220	1525	4315	4325	5015	1125	H10	1105	1115	1125	H10						
Finishing	PF	09 3/8	9.1	3.97	0.40	SCMT 09 T3 04-PF	☆			★	☆	☆								☆	☆	☆								SCMT 3(2.5)1-PF				
			.359	.156	.016																										SCMT 3(2.5)2-PF			
			.344	.156	.031																													
	MF	09 3/8	9.1	3.97	0.40	SCMT 09 T3 04-MF	☆								☆	☆											★	☆		SCMT 3(2.5)1-MF				
			.359	.156	.016																											SCMT 3(2.5)2-MF		
			.344	.156	.031																													
	UF	09 3/8	8.7	3.97	0.79	SCMT 09 T3 08-UF				★	☆										☆	☆									SCMT 3(2.5)2-UF			
			.344	.156	.031																													
Medium	SMC	09 3/8	9.1	3.97	0.40	SCMT 09 T3 04-SMC																					★			SCMT 3(2.5)1-SMC				
			.359	.156	.016																												SCMT 3(2.5)2-SMC	
			.344	.156	.031																													
	PMC	09 3/8	9.1	3.97	0.40	SCMT 09 T3 04-PMC				☆	★										☆	☆										SCMT 3(2.5)1-PMC		
			.359	.156	.016																													SCMT 3(2.5)2-PMC
			.344	.156	.031																													
	PM	09 3/8	9.1	3.97	0.40	SCMT 09 T3 04-PM			☆	☆	★	☆	☆								☆	☆	☆	☆								SCMT 3(2.5)1-PM		
			.359	.156	.016																													SCMT 3(2.5)2-PM
			.344	.156	.031																													
	MM	09 3/8	9.1	3.97	0.40	SCMT 09 T3 04-MM	☆								☆	☆	☆											★	☆	☆		SCMT 3(2.5)1-MM		
			.359	.156	.016																													SCMT 3(2.5)2-MM
			.344	.156	.031																													
	AL	09 3/8	8.7	3.97	0.79	SCGX 09 T3 08-AL																					★					SCGX 3(2.5)2-AL		
			.344	.156	.031																													
	UM	09 3/8	8.7	3.97	0.79	SCMT 09 T3 08-UM	☆	☆		☆	★	☆			☆	☆	☆				☆	☆	☆					☆	★			SCMT 3(2.5)2-UM		
			.344	.156	.031																													



CoroTurn® 107 insert for turning

T-style insert (Triangular)

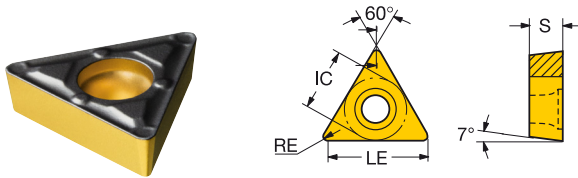


C	LE	S	RE	BS	ISO CODE	P						M				K			N		S			ANSI CODE											
						1125	1515	1525	4315	4325	4335	5015	H13A	1105	1115	1125	1515	1525	2220	H13A	1525	4315	4325		5015	H13A	1125	H10	H13A	1105	1115	1125	H10	H13A	
L	05 1/8	5.6	1.40	0.02	TCEX 05 01 00R/L-F	☆											☆	★						☆			★	☆				TCEX 1(1)00L-F			
		.219	.055	.001	TCEX 05 01 01R/L-F	☆												☆	★						☆			★	☆				TCEX 1(1)03L-F		
	06 5/32	6.6	1.98	0.02	TCEX 06 T1 00R/L-F	☆												☆	★						☆			★	☆				TCEX 1.2(1.2)00L-F		
		.261	.078	.001	TCEX 06 T1 01R/L-F	☆												☆	★						☆			★	☆				TCEX 1.2(1.2)03L-F		
	06 5/32	6.5	1.98	0.10	TCEX 06 T1 02L-F	☆												☆	★						☆			★	☆				TCEX 1.2(1.2)02L-F		
		.257	.078	.004	TCEX 06 T1 02L-F	☆												☆	★						☆			★	☆				TCEX 1.2(1.2)02L-F		
	09 7/32	9.4	2.38	0.02	TCEX 09 02 00R/L-F	☆													☆	★						☆			★	☆				TCEX 1.8(1.5)00L-F	
		.369	.094	.001	TCEX 09 02 01R/L-F	☆													☆	★						☆			★	☆				TCEX 1.8(1.5)03L-F	
	09 7/32	9.3	2.38	0.10	TCEX 09 02 02L-F	☆													☆	★						☆			★	☆				TCEX 1.8(1.5)02L-F	
		.365	.094	.004	TCEX 09 02 02L-F	☆													☆	★						☆			★	☆				TCEX 1.8(1.5)02L-F	
	11 1/4	10.7	3.18	0.02	TCEX 11 03 00R/L-F	☆													☆	★						☆			★	☆				TCEX 22(00)L-F	
		.423	.125	.001	TCEX 11 03 01R/L-F	☆													☆	★						☆			★	☆				TCEX 22(03)L-F	
11 1/4	10.6	3.18	0.10	TCEX 11 03 02L-F	☆													☆	★						☆			★	☆				TCEX 220L-F		
	.419	.125	.004	TCEX 11 03 02L-F	☆													☆	★						☆			★	☆				TCEX 220L-F		
Finishing	06 5/32	6.4	1.98	0.20	TCGT 06 T1 02R/L-K	☆	☆											☆	☆	☆					☆			☆	☆				TCGT 1.2(1.2)0L-K		
		.253	.078	.008	TCGT 06 T1 04R/L-K	☆	☆												☆	☆	☆					☆			☆	☆				TCGT 1.2(1.2)1L-K	
	09 7/32	9.2	2.38	0.20	TCGT 09 02 02L-K			★			☆						☆				☆													TCGT 1.8(1.5)0L-K	
		.361	.094	.008	TCGT 09 02 02R/L-K	☆	☆												☆	☆	☆								★	☆				TCGT 1.8(1.5)0L-K	
	09 7/32	9.0	2.38	0.40	TCGT 09 02 04L-K			★			☆										☆					☆								TCGT 1.8(1.5)1L-K	
		.353	.094	.016	TCGT 09 02 04R/L-K	☆	☆															☆							★	☆				TCGT 1.8(1.5)1L-K	
	11 1/4	10.5	2.38	0.20	TCGT 11 02 02L-K			★			☆										☆					☆								TCGT 2(1.5)0L-K	
		.415	.094	.008	TCGT 11 02 02R/L-K	☆																☆							★					TCGT 2(1.5)0L-K	
	11 1/4	10.3	2.38	0.40	TCGT 11 02 04L-K			★			☆										☆					☆									TCGT 2(1.5)1L-K
		.407	.094	.016	TCGT 11 02 04R/L-K	☆																☆								★					TCGT 2(1.5)1L-K
	11 1/4	10.5	3.18	0.20	TCGT 11 03 02R/L-K	☆	☆														☆	☆	☆				☆			★	☆				TCGT 220L-K
		.415	.125	.008	TCGT 11 03 04R/L-K	☆	☆															☆	☆	☆				☆			★	☆			
11 1/4	10.3	3.18	0.40	TCGT 11 03 04R/L-K	☆	☆															☆	☆	☆				☆			★	☆				TCGT 221L-K
	.407	.125	.016	TCGX 06 T1 04R/L-WK	☆	☆															☆	☆	☆				☆			★	☆				TCGX 1.2(1.2)1L-WK
09 7/32	9.0	2.38	0.40	TCGX 09 02 04R/L-WK	☆	☆															☆	☆	☆				☆			★	☆				TCGX 1.8(1.5)1L-WK
	.353	.094	.016	TCGX 11 02 04R/L-WK	☆																☆	★					☆			★					TCGX 2(1.5)1L-WK
11 1/4	10.3	2.38	0.40	TCGX 11 03 04R/L-WK	☆	☆															☆	★					☆			★	☆				TCGX 221L-WK
	.407	.125	.016	TCGX 11 03 04R/L-WK	☆	☆															☆	★					☆			★	☆				TCGX 221L-WK

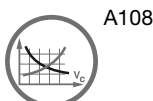


CoroTurn® 107 insert for turning

T-style insert (Triangular)

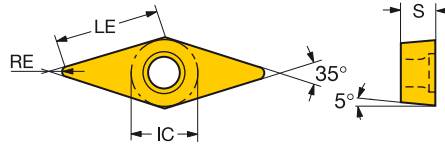
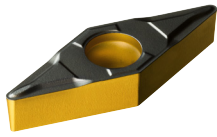


			LE	S	RE	BS	ISO CODE	P							M					K			N			S			ANSI CODE												
								1125	1515	1525	4315	4325	4335	5015	H13A	1105	1115	1125	1515	1525	2220	H13A	1525	4315	4325	5015	H13A	1125		H10	H13A	1105	1115	1125	H10	H13A					
Finishing	UF	06	5/32	6.4	1.98	0.20	TCMT 06 T1 02-UF																																		
				.253	.078	.008																	*																		
			6.2	1.98	0.40			TCMT 06 T1 04-UF									*	*	*																						
			.245	.078	.016																																				
			09	7/32	9.0	2.38	0.40	TCMT 09 02 04-UF														*	*	*																	
			.353	.094	.016																																				
		8.6	2.38	0.79			TCMT 09 02 08-UF																	*																	
		.337	.094	.031																																					
		11	1/4	10.5	2.38	0.20	TCMT 11 02 02-UF	*				*	*	*						*	*	*	*	*								*		*	*			*		*	
		.415	.094	.008																																					
		10.3	2.38	0.40			TCMT 11 02 04-UF	*			*	*	*	*	*					*	*	*	*	*	*						*		*	*	*	*	*	*	*	*	
		.407	.094	.016																																					
	9.9	2.38	0.79			TCMT 11 02 08-UF				*	*	*	*											*	*	*															
	.391	.094	.031																																						
	16	3/8	15.7	3.97	0.79	TCMT 16 T3 08-UF				*	*													*	*																
	.618	.156	.031																																						
Medium	PM	09	7/32	9.0	2.38	0.40	TCMT 09 02 04-PM		*	*	*	*	*		*					*	*	*	*																		
			.353	.094	.016																																				
		8.6	2.38	0.79			TCMT 09 02 08-PM		*	*	*	*	*		*					*	*	*	*																		
		.337	.094	.031																																					
		11	1/4	10.3	3.18	0.40	TCMT 11 03 04-PM	*	*	*	*	*	*	*		*				*	*	*	*	*																	
		.407	.125	.016																																					
	9.9	3.18	0.79			TCMT 11 03 08-PM	*	*	*	*	*	*	*		*				*	*	*	*	*																		
	.391	.125	.031																																						
	9.5	3.18	1.19			TCMT 11 03 12-PM		*	*	*	*	*	*						*	*	*	*	*																		
	.376	.125	.047																																						
	16	3/8	16.1	3.97	0.40	TCMT 16 T3 04-PM	*	*	*	*	*	*	*		*	*	*	*	*	*	*	*	*																		
	.634	.156	.016																																						
15.7	3.97	0.79			TCMT 16 T3 08-PM	*	*	*	*	*	*	*		*	*	*	*	*	*	*	*	*																			
.618	.156	.031																																							
15.3	3.97	1.19			TCMT 16 T3 12-PM	*	*	*	*	*	*	*		*				*	*	*	*	*																			
.602	.156	.047																																							
Finishing	MM	09	7/32	9.0	2.38	0.40	TCMT 09 02 04-MM	*							*	*	*	*	*								*	*	*	*	*	*	*	*	*	*	*	*			
			.353	.094	.016																																				
		8.6	2.38	0.79			TCMT 09 02 08-MM	*							*	*	*	*	*								*	*	*	*	*	*	*	*	*	*	*	*	*		
		.337	.094	.031																																					
		11	1/4	10.3	3.18	0.40	TCMT 11 03 04-MM	*							*	*	*	*	*								*	*	*	*	*	*	*	*	*	*	*	*	*		
		.407	.125	.016																																					
	9.9	3.18	0.79			TCMT 11 03 08-MM	*							*	*	*	*	*							*	*	*	*	*	*	*	*	*	*	*	*	*	*			
	.391	.125	.031																																						
	16	3/8	16.1	3.97	0.40	TCMT 16 T3 04-MM	*							*	*	*	*	*							*	*	*	*	*	*	*	*	*	*	*	*	*	*			
	.634	.156	.016																																						
	15.7	3.97	0.79			TCMT 16 T3 08-MM	*							*	*	*	*	*						*	*	*	*	*	*	*	*	*	*	*	*	*	*	*			
	.618	.156	.031																																						
15.3	3.97	1.19			TCMT 16 T3 12-MM	*							*										*	*	*	*	*	*	*	*	*	*	*	*	*	*	*				
.602	.156	.047																																							



CoroTurn® 107 insert for turning

V-style insert (Rhombic 35°)



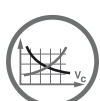
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PF	11	1/4	0.20	VCMT 11 03 02-PF	☆							★																					VCMT 220-PF					
				VCMT 11 03 04-PF	☆		★	☆						☆						☆	☆	☆												VCMT 221-PF				
				VBMT 11 03 02-PF	☆	★		☆						☆	☆					☆	☆	☆												VBMT 220-PF				
				VBMT 11 03 04-PF	☆	☆	★	☆							☆	☆					☆	☆	☆	☆											VBMT 221-PF			
				VBMT 11 03 08-PF	☆		★	☆							☆							☆	☆	☆											VBMT 222-PF			
				VBMT 11 03 12-PF				★	☆														☆	☆											VBMT 223-PF			
	16	3/8	0.20	VBMT 16 04 02-PF	☆								★									☆											VBMT 330-PF					
				VBMT 16 04 04-PF	☆		★	☆						☆							☆	☆	☆											VBMT 331-PF				
				VBMT 16 04 08-PF	☆		★	☆						☆								☆	☆	☆											VBMT 332-PF			
				VBMT 16 04 12-PF				★																☆											VBMT 333-PF			
MF	11	1/4	0.20	VCMT 11 03 02-MF	☆																											VCMT 220-MF						
				VCMT 11 03 04-MF	☆										☆																				VCMT 221-MF			
				VBMT 11 03 02-MF	☆									☆	★	☆											★	☆	☆						VBMT 220-MF			
				VBMT 11 03 04-MF	☆									☆	☆	☆		☆										★	☆	☆					VBMT 221-MF			
				VBMT 11 03 08-MF	☆									☆	☆	☆		☆										★	☆	☆					VBMT 222-MF			
				VBMT 11 03 12-MF																																		
	16	3/8	0.20	VBMT 16 04 02-MF	☆								☆	★	☆													★	☆	☆				VBMT 330-MF				
				VBMT 16 04 04-MF	☆									☆	☆	☆		☆											★	☆	☆				VBMT 331-MF			
				VBMT 16 04 08-MF	☆									☆	☆	☆		☆											★	☆	☆				VBMT 332-MF			
UF	11	1/4	0.20	VBMT 11 02 02-UF	☆	★	☆	☆	☆	☆	☆			★	☆						☆	☆	☆	★	☆	★			★	☆		VBMT 2(1.5)0-UF						
				VBMT 11 02 04-UF	☆		☆	★	☆	☆	☆	☆				★	☆																			VBMT 2(1.5)1-UF		
				VBMT 11 02 08-UF			☆	★	☆	☆	☆	☆				☆	☆																				VBMT 2(1.5)2-UF	



A4



A4



A108



A122



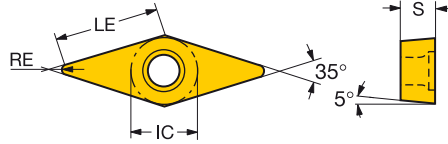
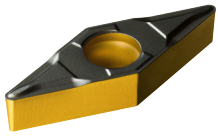
J19



J5

CoroTurn® 107 insert for turning

V-style insert (Rhombic 35°)



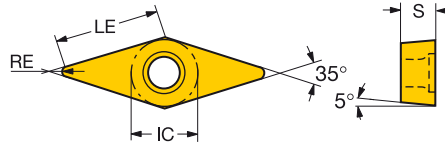
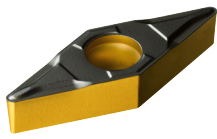
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		LE	S	RE	ISO CODE																														
Medium	SMC	16	3/8	16.2	4.76	0.40	VBMT 16 04 04-SMC																								★		VBMT 331-SMC		
				.638	.188	.016																											★	VBMT 332-SMC	
				.622	.188	.031	VBMT 16 04 08-SMC																												
				15.8	4.76	0.79																													
				.607	.188	.047	VBMT 16 04 12-SMC																										★		VBMT 333-SMC
				15.4	4.76	1.19																													
		PMC	16	3/8	16.2	4.76	0.40	VBMT 16 04 04-PMC				☆	★																						VBMT 331-PMC
					.638	.188	.016							☆	★																				VBMT 332-PMC
					.622	.188	.031	VBMT 16 04 08-PMC								☆	★																		
					15.4	4.76	1.19										☆	★																	VBMT 333-PMC
				.607	.188	.047	VBMT 16 04 12-PMC										☆	★																	
		PM	16	3/8	16.2	4.76	0.40	VBMT 16 04 04-PM			☆	☆	☆	☆	☆	★		☆																VBMT 331-PM	
				.638	.188	.016							☆	☆		☆	☆																VBMT 332-PM		
				.622	.188	.031	VBMT 16 04 08-PM									☆	☆																		
				15.4	4.76	1.19											☆	☆															VBMT 333-PM		
				.607	.188	.047	VBMT 16 04 12-PM											☆																	
				11.0	1.4	10.7	3.18	0.40	VCMT 11 03 04-PM				☆				☆																VCMT 221-PM		
			.420	.125	.016												☆															VCMT 222-PM			
			10.3	3.18	0.79													☆														VCMT 222-PM			
			.404	.125	.031	VCMT 11 03 08-PM						☆							☆																
	UM	16	3/8	16.2	4.76	0.40	VBMT 16 04 04-MM				☆																				★	☆	☆	VBMT 331-MM	
				.638	.188	.016							☆																		★	☆	☆	VBMT 332-MM	
				.622	.188	.031	VBMT 16 04 08-MM									☆	☆																		
				15.4	4.76	1.19											☆	☆															☆	★	VBMT 333-MM
			.607	.188	.047	VBMT 16 04 12-MM											☆																		
			11.0	1.4	10.7	3.18	0.40	VCMT 11 03 04-MM				☆					☆															★	VCMT 221-MM		
			.420	.125	.016													☆																	
			10.3	3.18	0.79																												★	VCMT 222-MM	
			.404	.125	.031	VCMT 11 03 08-MM																													
UM		16	3/8	16.5	4.76	0.10	VBGT 16 04 01-UM				☆					☆	☆	★	☆							★	☆		★	★	☆	☆	☆	☆	VBGT 3303-UM
				.650	.188	.004							☆	☆												★	☆		★	★	☆	☆	☆	VBGT 330-UM	
				16.4	4.76	0.20																					★	☆		★	★	☆	☆	☆	VBGT 331-UM
			.646	.188	.008	VBGT 16 04 04-UM										☆	☆	★	☆							★	☆		★	★	☆	☆	☆	VBGT 331-UM	
			16.2	4.76	0.40																					★	☆		★	★	☆	☆	☆	VBGT 332-UM	
			.638	.188	.016	VBGT 16 04 08-UM										☆	☆									★	☆		★	★	☆	☆	☆	VBGT 332-UM	
			15.8	4.76	0.79																					★	☆		★	★	☆	☆	☆	VBGT 332-UM	
			.622	.188	.031	VBGT 16 04 12-UM																				★	☆		★	★	☆	☆	☆	VBGT 332-UM	
			11.0	1.4	11.0	3.18	0.10	VCET 11 03 01-UM				☆					☆	★	☆							☆		★	☆	☆				VCET 22(03)-UM	
			.432	.125	.004																					☆		★	☆	☆				VCET 220-UM	
			10.9	3.18	0.20																					☆		★	☆	☆				VCET 220-UM	
			.428	.125	.008	VCGT 11 03 01-UM											☆		★	☆							☆		★	☆	★	☆			VCET 2203-UM
		11.0	3.18	0.10																					☆		★	☆	★	☆			VCET 2203-UM		
		.432	.125	.004	VCGT 11 03 02-UM																				☆		★	☆	★	☆			VCET 220-UM		
		10.9	3.18	0.20																					☆		★	☆	★	☆			VCET 220-UM		
		.428	.125	.008	VCGT 11 03 03-UM																				☆	☆		★	★	☆	☆		VCET 220-UM		
		10.7	3.18	0.40																					☆	☆		★	★	☆	☆		VCET 221-UM		
		.420	.125	.016	VCGT 11 03 04-UM																				☆	☆		★	★	☆	☆		VCET 221-UM		



ENG

CoroTurn® 107 insert for turning

V-style insert (Rhombic 35°)



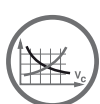
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Medium	AL	11	1/4	10.9	2.38	0.20	VCGX 11 02 02-AL																													VCGX 2(1.5)0-AL		
				.428	.094	.008	VCGX 11 02 04-AL																													VCGX 2(1.5)1-AL		
				10.7	2.38	0.40	VCGX 11 03 02-AL																													VCGX 220-AL		
				.420	.094	.016	VCGX 11 03 04-AL																														VCGX 221-AL	
				10.9	3.18	0.20	VCGX 16 04 04-AL																														VCGX 331-AL	
				.428	.125	.008	VCGX 16 04 08-AL																														VCGX 332-AL	
	UM		16	3/8	16.2	4.76	0.40	VCGX 16 04 12-AL																													VCGX 333-AL	
				.638	.188	.016	VBMT 16 04 04-UM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	VBMT 331-UM	
				15.8	4.76	0.79	VBMT 16 04 08-UM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	VBMT 332-UM
				.622	.188	.031	VBMT 16 04 12-UM	☆	☆		☆																											VBMT 333-UM
				15.4	4.76	1.19		☆																														
				.607	.188	.047																																
Roughing	UR	16	3/8	16.2	4.76	0.40	VBMT 16 04 04-UR				☆	☆	☆																							VBMT 331-UR		
				.638	.188	.016																																



A4



A4



A108



A122



J19



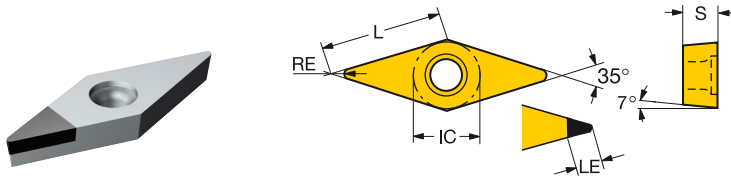
J5



CoroTurn® 107 insert for turning

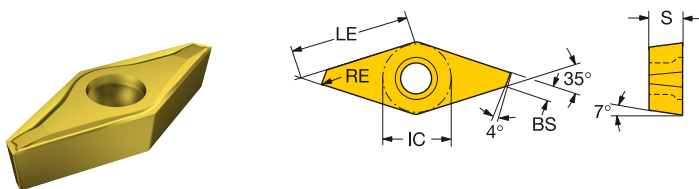
V-style insert (Rhombic 35°)

Advanced cutting materials



	LE	S	RE	ISO CODE	N		ANSI CODE		
					CD05	CD10			
Finishing	11	1/4	4.4	2.38	0.4	VCMW110204FP	☆	★	VCMW2(1.5)1FP
			.173	.094	.016				
			4.4	3.18	0.4	VCMW110304FP		★	VCMW221FP
			.173	.125	.016				
	16	3/8	4.4	4.76	0.4	VCMW160404FP	☆	★	VCMW331FP
			.173	.188	.016				
		3.5	4.76	0.8	VCMW160408FP	☆	★	VCMW332FP	
		.138	.188	.031					
		2.7	4.76	1.2	VCMW160412FP		★	VCMW333FP	
		.106	.188	.047					

Turning and back turning



	LE	S	RE	BS	ISO CODE	P		M			K	N	S			ANSI CODE			
						1020	1125	5015	1020	1105	1115	1125	5015	1125	1020		1105	1115	1125
Finishing	11	1/4	11.1	3.18	0.0	1.4	VCEX 11 03 00R/L-F	☆	☆	★	☆	☆	☆	☆	☆	★	☆	☆	VCEX 22(00)L-F
			.436	.125	.001	.054													
			11.0	3.18	0.1	1.2	VCEX 11 03 01R/L-F	☆	☆	★	☆	☆	☆	☆	☆	★	☆	☆	VCEX 22(03)L-F
			.432	.125	.004	.048													



T-Max® P

Optimized for external turning

Productive external turning of large to medium sized components

T-Max P offers high productivity in combination with good insert economy for medium to large components. The double sided inserts gives strength and double the number of edges compared to a single sided insert. Grades and geometries are available for all materials.

ISO application area:



Application

- Longitudinal turning
- Face turning
- Profiling
- Roughing to finishing
- Internal turning of large diameter bores from dia 50 mm (2 inch)



Benefits and features

- Productive solution with Wiper and Xcel technologies
- Reliable and secure machining, even in roughing applications
- Double sided inserts with strong edge

www.sandvik.coromant.com/tmaxp

Inserts

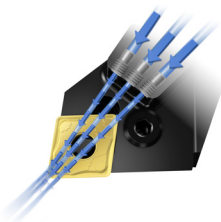
- All types of insert shapes and sizes
- Geometries and grades for all application areas
- Insert grades also in advanced cutting materials PCD, CBN and ceramic
- Inserts dedicated for precision coolant

Tools

- Shank tools
- Boring bars
- CoroTurn® SL heads

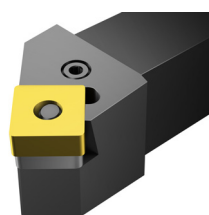
Precision coolant

HOLDERS ARE AVAILABLE WITH PRECISION NOZZLES FOR EXCELLENT CHIP CONTROL.

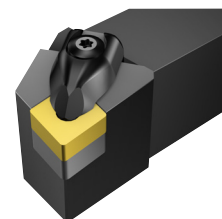


Different clamping solutions

Lever clamping



Rigid clamping



A5



A4



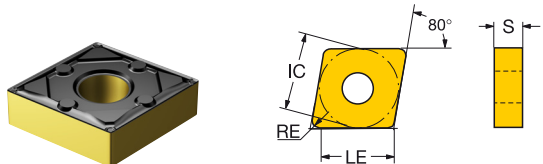
A4



J9

T-Max® P insert for turning

C-style insert (Rhombic 80°)



C

		IC	LE	S	RE	BS	ISO CODE	P				M		K		N	S	ANSI CODE			
								1125	1525	4315	4325	4335	5015	1115	1125	1525	2220		1525	4315	4325
Finishing	WF	09	3/8	9.3	3.18	0.40	CNMG 09 03 04-WF	☆					★						CNMG 321-WF		
				.365	.125	.016	.018														
				8.9	3.18	0.79	0.7	CNMG 09 03 08-WF	☆	★				★		☆				CNMG 322-WF	
				.349	.125	.031	.028														
				09	3/8	9.3	3.18	0.40	CNMG 09 03 04-PF	☆	★	☆	☆			☆	☆	☆	☆		CNMG 321-PF
				.365	.125	.016															
			8.9	3.18	0.79		CNMG 09 03 08-PF	☆	★	☆	☆			☆	☆	☆	☆		CNMG 322-PF		
			.349	.125	.031																
			09	3/8	9.3	3.18	0.40	CNMG 09 03 04-MF	☆				★	☆				☆	★	CNMG 321-MF	
			.365	.125	.016																
			8.9	3.18	0.79		CNMG 09 03 08-MF	☆				★	☆				☆	★	☆	CNMG 322-MF	
			.349	.125	.031																
Medium	PM	09	3/8	9.3	3.18	0.40	CNMG 09 03 04-PM			☆	★	☆				☆	☆		CNMG 321-PM		
				.365	.125	.016															
				8.9	3.18	0.79		CNMG 09 03 08-PM			☆	★	☆				☆	☆		CNMG 322-PM	
				.349	.125	.031															
				09	3/8	9.3	3.18	0.40	CNMG 09 03 04-MM	☆						☆	☆		☆	★	CNMG 321-MM
				.365	.125	.016															
			8.9	3.18	0.79		CNMG 09 03 08-MM	☆						☆	☆		☆	★	CNMG 322-MM		
			.349	.125	.031																
			09	3/8	9.3	3.18	0.40	CNMG 09 03 04-QM			☆	★					☆	☆		CNMG 321-QM	
			.365	.125	.016																
			8.9	3.18	0.79		CNMG 09 03 08-QM			☆	★	☆				☆	☆			CNMG 322-QM	
			.349	.125	.031																

G

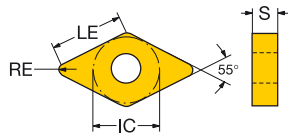
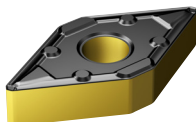
H

I



T-Max® P insert for turning

D-style insert (Rhombic 55°)



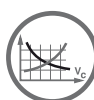
		LE	S	RE	BS	ISO CODE	P					M					K			N			S			ANSI CODE							
							1125	1525	4315	4325	4335	5015	1105	1115	1125	1525	2220	H13A	1525	4315	4325	5015	1125	1105	1115		1125	H13A	SD6F				
Finishing	WF	11	3/8	11.2	4.76	0.40	0.5	DNMX 11 04 04-WF	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 331-WF		
				.442	.188	.016	.020	DNMX 11 04 08-WF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 332-WF		
				.426	.188	.031	.024																										
				.426	.188	.031	.024																										
	PF	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-PF	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-PF		
				.442	.188	.016	.020	DNMG 11 04 08-PF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-PF		
				.426	.188	.031	.024	DNMG 11 04 12-PF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 333-PF		
				.411	.188	.047	.047																										
	MF	11	3/8	10.8	4.76	0.79	0.6	DNMG 11 04 08-MF	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-MF	
				.426	.188	.031	.024	DNMG 11 04 04-MF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-MF	
	LC	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-LC			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-LC		
				.442	.188	.016	.020	DNMG 11 04 08-LC			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-LC		
			.426	.188	.031	.024																											
SF	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-SF								☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-SF			
			.442	.188	.016	.020	DNMG 11 04 08-SF								☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-SF			
			.426	.188	.031	.024																											
Medium	SMC	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-SMC																							DNMG 331-SMC		
				.442	.188	.016	.020	DNMG 11 04 08-SMC																								DNMG 332-SMC	
				.426	.188	.031	.024																										
	PMC	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-PMC			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-PMC		
				.442	.188	.016	.020	DNMG 11 04 08-PMC			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-PMC		
	PM	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-PM			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-PM		
				.442	.188	.016	.020	DNMG 11 04 08-PM			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-PM		
				.426	.188	.031	.024	DNMG 11 04 12-PM			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 333-PM		
				.411	.188	.047	.047																										
	MM	11	3/8	10.8	4.76	0.79	0.6	DNMG 11 04 08-MM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-MM	
				.426	.188	.031	.024	DNMG 11 04 12-MM																								DNMG 333-MM	
				.411	.188	.047	.047																										
	QM	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-QM				☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-QM		
				.442	.188	.016	.020	DNMG 11 04 08-QM				☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-QM		
				.426	.188	.031	.024	DNMG 11 04 12-QM			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 333-QM		
				.411	.188	.047	.047																										
	SM	11	3/8	11.2	4.76	0.40	0.5	DNMG 11 04 04-SM								☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-SM		



A4



A4



A108



A122



J19

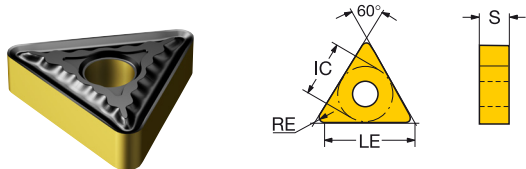


J5



T-Max® P insert for turning

T-style insert (Triangular)



					ISO CODE	P			K		ANSI CODE											
		LE	S	RE		4315	4325	4335	5015	4315		4325	5015									
Finishing	MF	11	1/4	10.8	3.18	0.20	★	☆	☆	☆	☆	☆	TNMG 11 03 02-MF	★	☆	☆	☆	☆	☆	TNMG 220-MF		
				.425	.125	.008								TNMG 11 03 04-MF	★	☆	☆	☆	☆	☆	TNMG 221-MF	
				10.6	3.18	0.40								TNMG 11 03 08-MF	★	☆	☆	☆	☆	☆	TNMG 222-MF	
				.417	.125	.016								TNMG 11 03 12-MF		★			☆		TNMG 223-MF	
				10.2	3.18	0.79																
				.402	.125	.031																
Medium	QM	11	1/4	10.6	3.18	0.40	☆	★	☆	☆	☆	☆	TNMG 11 03 04-QM	☆	★	☆	☆	☆	☆	TNMG 221-QM		
				.417	.125	.016								TNMG 11 03 08-QM	☆	★	☆	☆	☆	☆	TNMG 222-QM	
				10.2	3.18	0.79																
				.402	.125	.031																

E

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CoroTurn® TR

For stable external turning

Unmatched tolerances at high cutting data

CoroTurn TR provides stable machining in demanding operations. The stable and secure insert clamping reduces set-up times and allows for increased cutting data, perfect when working with mass production.

ISO application area:



Application

- Profiling
- Medium to finishing

Benefits and features

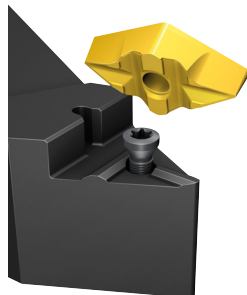
- Stable insert clamping (iLock) ensures good repeatability and accuracy while allowing for high cutting data



www.sandvik.coromant.com/coroturntr

iLock™ locking interface

The T-rail on the holder and corresponding groove on the insert lock the insert precisely and securely.



A5



A4



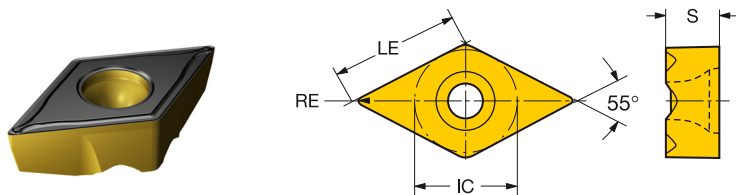
A4



J16

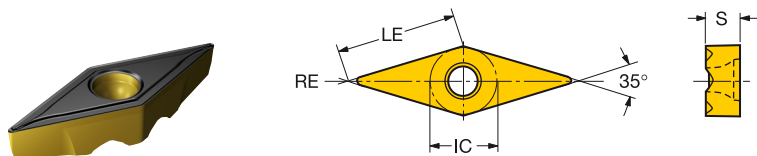
CoroTurn® TR insert for turning

D-style insert (Rhombic 55°)



		LE	S	RE	ISO CODE	P					M					K			S										
						1125	1515	1525	4315	4325	H13A	1105	1115	1125	1515	1525	2220	H13A	1525	4315	4325	H13A	1105	1115	1125	H13A			
Finishing	F	13	12.6	5.53	0.40	TR-DC1304-F	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			.496	.218	.016																								
			12.2	5.53	0.79	TR-DC1308-F	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			.480	.218	.031																								
Medium	M	13	12.2	5.53	0.79	TR-DC1308-M	☆			☆	★		☆			☆				☆	☆				☆	★			
			.480	.218	.031																								
			11.8	5.53	1.19	TR-DC1312-M	☆			☆	★		☆	☆											☆	★			
		.465	.218	.047																									

V-style insert (Rhombic 35°)



		LE	S	RE	ISO CODE	P					M					K			S											
						1125	1515	1525	4315	4325	H13A	1105	1115	1125	1515	1525	2220	H13A	1525	4315	4325	H13A	1105	1115	1125	H13A				
Finishing	F	13	12.8	4.53	0.20	TR-VB1302-F	☆					☆			★								☆							
			.504	.178	.008																									
			12.6	4.53	0.40	TR-VB1304-F	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
			.496	.178	.016																									
			12.2	4.53	0.79	TR-VB1308-F	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			.480	.178	.031																									
	11.8	4.53	1.19	TR-VB1312-F	☆			☆	★		☆	☆			☆									☆	★					
		.465	.178	.047																										



CoroCut® XS

For external machining of small and slender components

High precision components

CoroCut XS inserts offer low cutting forces thanks to the extremely sharp cutting edges. This means, at low feeds CoroCut XS is excellent for producing high precision components with close tolerances. As a bonus, all inserts fit the same tool holder keeping the tool inventory small.

ISO application area:

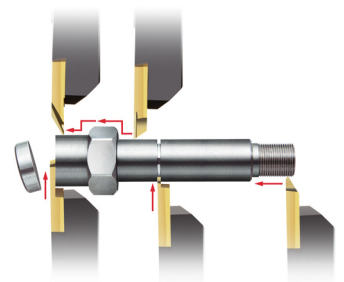
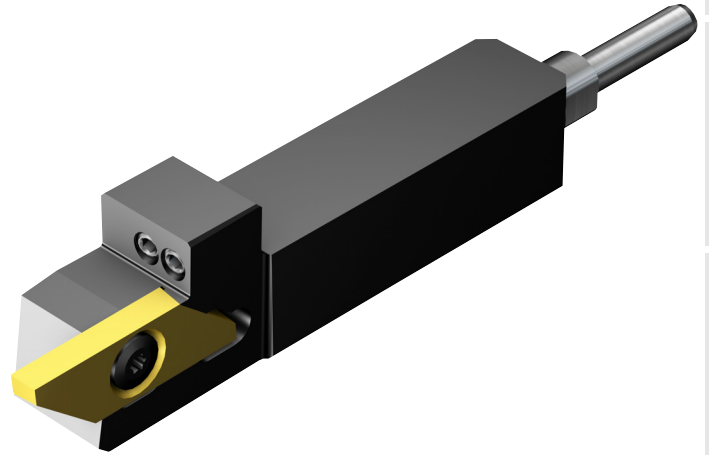


Application

- Parting off
- External threading
- External grooving
- Turning

Benefits and features

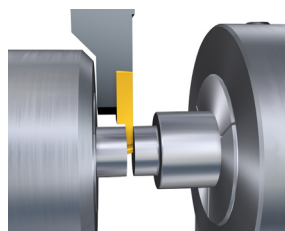
- High precision
- Close tolerances
- Good accessibility when changing inserts
- Wide variety of insert widths
- Sharp cutting edges
- All inserts fit into the same tool holder
- High quality ground inserts and holders
- Full profile inserts for high quality threads in one operation
- Designed to maintain the tool holder intact in case of insert breakage.
- Available with precision coolant



www.sandvik.coromant.com/corocutxs

Holders

Dedicated holders for parting off close to sub spindle are available in high precision square shank style.

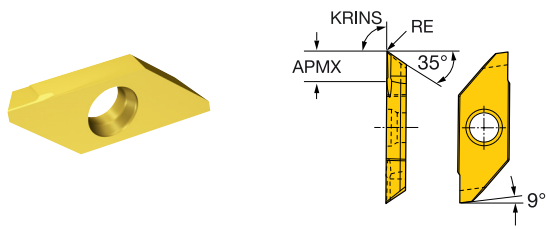


A30

CoroCut® XS insert for turning

Turning, front turning

B



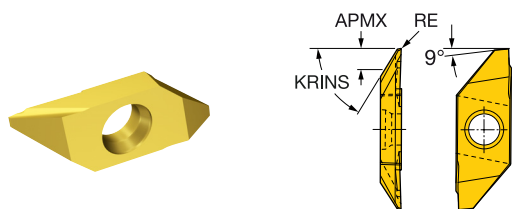
C

						P		M		K		N		S			
		SSC	S	RE	APMX	ISO CODE	1025	H13A	1025	H13A	1025	H13A	1025	H13A	1025	H13A	
Finishing		3	3.18	0.03	4.0	MABR/L 3 003	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
			.125	.001	.157												
			3.18	0.05	4.0	MABR/L 3 005	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			.125	.002	.157												
			3.18	0.10	4.0	MABR/L 3 010	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			.125	.004	.157												
	3.18	0.20	4.0	MABR/L 3 020	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		
		.125	.008	.157													

D

Turning, back turning

E



F

						P		M		K		N		S			
		SSC	S	RE	APMX	ISO CODE	1025	H13A	1025	H13A	1025	H13A	1025	H13A	1025	H13A	
Finishing		3	3.18	0.03	4.0	MABR/L 3 003	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
			.125	.001	.157												
			3.18	0.05	4.0	MABR/L 3 005	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			.125	.002	.157												
			3.18	0.10	4.0	MABR/L 3 010	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			.125	.004	.157												
	3.18	0.20	4.0	MABR/L 3 020	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		
		.125	.008	.157													

G

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand

H

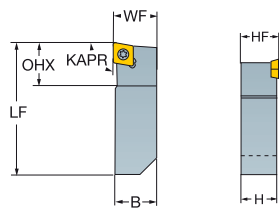
I

J



Shank tool for turning

QS shank coupling -metric: 8 x 8



B

C

		Dimensions, mm													
Image	CZC _{MS}	KAPR	RMPX	OHX	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MIID	
															06
	06	8 x 8	90°	0°	8.0	QS-SCACR0808C06	8.0	8.0	50.0	8.0	8.0	0.9	0.04	CoroTurn 107	CCMT 06 02 04
	06	8 x 8	95°	0°	8.0	QS-SCLCR0808C06	8.0	8.0	50.0	8.0	8.0	0.9	0.04	CoroTurn 107	CCMT 06 02 04
	07	8 x 8	93°	27°	12.7	QS-SDJCR0808C07	8.0	8.0	50.0	8.0	8.0	0.9	0.04	CoroTurn 107	DCMT 07 02 04
	11	8 x 8	72°	70°	21.0	QS-SVBN0808C11-B1	8.0	8.0	50.0	4.3	8.0	0.9	0.04	CoroTurn 107	VBMT 11 03 04

D

E

F

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand

G

H

I

J

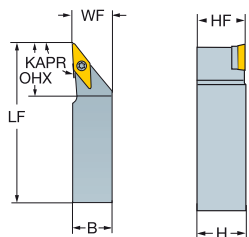


A

Shank tool for turning

Rectangular shank -metric: 8 x 8 - 8 x 10

B



C

		Dimensions, mm														
		CZC _{MS}	LU	KAPR	RMPX	OHX	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MID
	11	8 x 10		93°	50°	26.0	SVJBR/L 0810K 11-S-B1	10.0	8.0	125.0	10.0	8.0	0.9	0.12	CoroTurn 107	VBMT 11 03 04
	11	8 x 10		90°	53°	26.0	SVABR 0810K 11-S-B1	10.0	8.0	125.0	10.0	8.0	0.9	0.10	CoroTurn 107	VBMT 11 03 04
	06	8 x 8		95°	0°	8.0	SCLCR/L 0808K 06-S	8.0	8.0	125.0	8.0	8.0	0.9	0.08	CoroTurn 107	CCMT 06 02 04
	06	8 x 8		90°	0°	8.0	SCACR/L 0808K 06-S	8.0	8.0	125.0	8.0	8.0	0.9	0.08	CoroTurn 107	CCMT 06 02 04
	07	8 x 8		93°	27°	12.7	SDJCR/L 0808K 07-S	8.0	8.0	125.0	8.0	8.0	0.9	0.12	CoroTurn 107	DCMT 07 02 04
	07	8 x 8		90°	33°	12.7	SDACR/L 0808K 07-S	8.0	8.0	125.0	8.0	8.0	0.9	0.08	CoroTurn 107	DCMT 07 02 04
	11	8 x 8		72°	70°	21.0	SVBN 0808K 11-S-B1	8.0	8.0	125.0	4.3	8.0	0.9	0.08	CoroTurn 107	VBMT 11 03 04

D

E

F

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand

G

H

I

J



A5



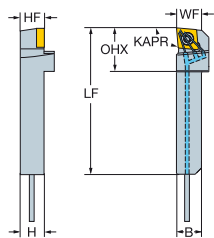
J19







J9

Shank tool for turning

QS-HP shank coupling -metric: 10 x 12



		Dimensions, mm															
		CZC _{MS}	KAPR	RMPX	OHX	CNSC	Ordering code	B	H	LF	WF	HF	BAR	NM	KG	PROFAM	MIID
	06	10 X 12	95°	0°	21.0	1	QS-SCLCR1012E06HP	12.0	10.0	70.0	12.0	10.0	80	0.9	0.10	CoroTurn 107	CCMT 06 02 04
	07	10 X 12	93°	27°	21.0	1	QS-SDJCR1012E07HP	12.0	10.0	70.0	10.0	10.0	80	0.9	0.09	CoroTurn 107	DCMT 07 02 04
	11	10 X 12	93°	50°	28.0	1	QS-SVJCR/L1012E11HP	12.0	10.0	70.0	10.0	10.0	80	0.9	0.08	CoroTurn 107	VCMT 11 03 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



J16

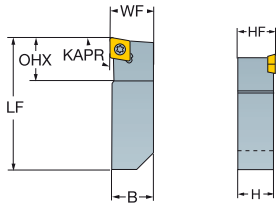


A

Shank tool for turning

QS shank coupling -metric: 10 x 10

B



C

							Dimensions, mm								
		CZC _{MS}	KAPR	RMPX	OHX	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MIID
	06	10 x 10	90°	0°	10.0	QS-SCACR1010E06	10.0	10.0	70.0	10.0	10.0	0.9	0.07	CoroTurn 107	CCMT 06 02 04
	11	10 x 10	93°	0°	16.0	QS-STJCR1010E11	10.0	10.0	70.0	10.0	10.0	0.9	0.07	CoroTurn 107	TCMT 11 02 04
	11	10 x 10	93°	50°	26.0	QS-SVJBR1010E11-B1	10.0	10.0	70.0	10.0	10.0	0.9	0.06	CoroTurn 107	VBMT 11 03 04
	11	10 x 10	72°	70°	21.0	QS-SWBN1010E11-B1	10.0	10.0	70.0	5.3	10.0	0.9	0.06	CoroTurn 107	VBMT 11 03 04

D

E

F

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand

G

H

I

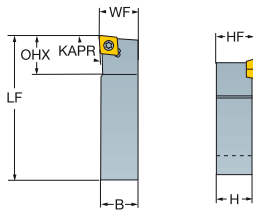
J



ENG

Shank tool for turning

Rectangular shank -metric: 10 x 10



		CZC _{MS}	LU	KAPR	RMPX	OHX	Ordering code	Dimensions, mm						PRODFAM	MID	
								B	H	LF	WF	HF	NM			KG
	06	10 x 10		95°	0°	10.0	SCLCR/L 1010K 06-S	10.0	10.0	125.0	10.0	10.0	0.9	0.12	CoroTurn 107	CCMT 06 02 04
	07	10 x 10		93°	27°	15.0	SDJCR/L 1010K 07-S	10.0	10.0	125.0	10.0	10.0	0.9	0.12	CoroTurn 107	DCMT 07 02 04
	07	10 x 10		90°	33°	15.0	SDACR/L 1010K 07-S	10.0	10.0	125.0	10.0	10.0	0.9	0.11	CoroTurn 107	DCMT 07 02 04
	07	10 x 10		62°	57°	15.0	SDNCN 1010K 07-S	10.0	10.0	125.0	5.2	10.0	0.9	0.12	CoroTurn 107	DCMT 07 02 04
	05	10 x 10	10.0		90°	14.0	SRDCN 1010E 05	10.0	10.0	70.0	7.5	10.0	0.9	0.06	CoroTurn 107	RCMT 05 02 M0
	11	10 x 10		93°	0°	16.0	STJCR/L 1010K 11-S	10.0	10.0	125.0	10.0	10.0	0.9	0.06	CoroTurn 107	TCMT 11 02 04
	11	10 x 10		93°	50°	26.0	SVJBR/L 1010K 11-S	10.0	10.0	125.0	10.0	10.0	0.9	0.06	CoroTurn 107	VBMT 11 02 04
	11	10 x 10		72°	70°	21.0	SWBN 1010K 11-S-B1	10.0	10.0	125.0	5.3	10.0	0.9	0.11	CoroTurn 107	VBMT 11 03 04
	11	10 x 10		93°	50°	26.0	SVJBR/L 1010K 11-S-B1	10.0	10.0	125.0	10.0	10.0	0.9	0.11	CoroTurn 107	VBMT 11 03 04
	11	10 x 10		90°	53°	26.0	SVABR/L 1010K 11-S-B1	10.0	10.0	125.0	10.0	10.0	0.9	0.12	CoroTurn 107	VBMT 11 03 04

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand

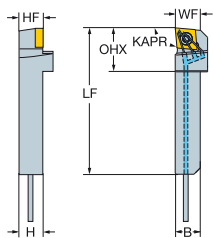


A

Shank tool for turning

QS-HP shank coupling -metric: 12 x 12

B



C

								Dimensions, mm									
		CZC _{MS}	KAPR	RMPX	OHX	CNSC	Ordering code	B	H	LF	WF	HF	BAR	NM	KG	PROFAM	MIID
	09	12 x 12	95°	0°	21.0	1	QS-SCLCR1212E09HP	12.0	12.0	70.0	12.0	12.0	80	3.0	0.12	CoroTurn 107	CCMT 09 T3 08
	07	12 x 12	93°	27°	22.0	1	QS-SDJCR1212E07HP-M	12.0	12.0	70.0	12.0	12.0	80	0.9	0.10	CoroTurn 107	DCMT 07 02 04
	07	12 x 12	62°	58°	22.0	1	QS-SDNCN1212E07HP	12.0	12.0	70.0	12.0	12.0	80	0.9	0.09	CoroTurn 107	DCMT 07 02 04
	11	12 x 12	93°	27°	27.5	1	QS-SDJCR1212E11HP-M	12.0	12.0	70.0	12.0	12.0	80	3.0	0.10	CoroTurn 107	DCMT 11 T3 08
	11	12 x 12	93°	0°	16.0	1	QS-STJCR1212E11HP	12.0	12.0	70.0	12.0	12.0	80	0.9	0.11	CoroTurn 107	TCMT 11 02 04
	11	12 x 12	93°	50°	29.0	1	QS-SVJCR/L1212E11HP-M	12.0	12.0	70.0	12.0	12.0	80	0.9	0.09	CoroTurn 107	VCMT 11 03 04
	11	12 x 12	72°	68°	30.0	1	QS-SWBN1212E11HP	12.0	12.0	70.0	6.4	12.7	80	0.9	0.10	CoroTurn 107	VBMT 11 03 04

H

For spare parts, visit www.sandvik.coromant.com

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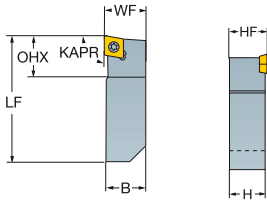
I

J



Shank tool for turning

QS shank coupling -metric: 12 x 12



		Dimensions, mm												
Image	CZC _{MS}	KAPR	RMPX	OHX	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MIID
	06	12 x 12	90°	0°	12.0	12.0	12.0	70.0	12.0	12.0	0.9	0.10	CoroTurn 107	CCMT 06 02 04
	09	12 x 12	95°	0°	12.0	12.0	70.0	12.0	12.0	3.0	0.10		CoroTurn 107	CCMT 09 T3 08
	07	12 x 12	93°	27°	15.0	12.0	12.0	70.0	12.0	12.0	0.9	0.09	CoroTurn 107	DCMT 07 02 04
	11	12 x 12	93°	27°	18.0	12.0	12.0	70.0	12.0	12.0	3.0	0.10	CoroTurn 107	DCMT 11 T3 08
	11	12 x 12	62°	57°	21.0	12.0	12.0	70.0	6.2	12.0	3.0	0.10	CoroTurn 107	DCMT 11 T3 08
	11	12 x 12	90°	53°	26.0	12.0	12.0	70.0	12.0	12.0	0.9	0.09	CoroTurn 107	VBMT 11 03 04
	11	12 x 12	93°	50°	26.0	12.0	12.0	70.0	12.0	12.0	0.9	0.08	CoroTurn 107	VBMT 11 03 04

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N = Neutral, R = Right hand, L = Left hand

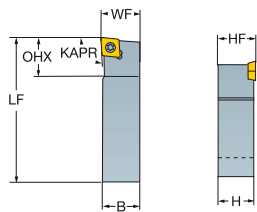


A

Shank tool for turning

Rectangular shank -metric: 12 x 12

B



C

		CZC _{MS}	LU	KAPR	RMPX	OHX	Ordering code	Dimensions, mm						PRODFAM	MIID	
								B	H	LF	WF	HF	NM			KG
	06	12 x 12		95°	0°	12.0	SCLCR/L 1212K 06-S	12.0	12.0	125.0	12.0	12.0	0.9	0.18	CoroTurn 107	CCMT 06 02 04
	09	12 x 12		90°	0°	12.0	SCACR/L 1212K 09-S	12.0	12.0	125.0	12.0	12.0	3.0	0.17	CoroTurn 107	CCMT 09 T3 08
	09	12 x 12		95°	0°	12.0	SCLCR/L 1212K 09-S	12.0	12.0	125.0	12.0	12.0	3.0	0.17	CoroTurn 107	CCMT 09 T3 08
	07	12 x 12		93°	27°	15.0	SDJCR/L 1212K 07-S	12.0	12.0	125.0	12.0	12.0	0.9	0.16	CoroTurn 107	DCMT 07 02 04
	11	12 x 12		93°	27°	18.0	SDJCR/L 1212K 11-S	12.0	12.0	125.0	12.0	12.0	3.0	0.17	CoroTurn 107	DCMT 11 T3 08
	11	12 x 12		90°	33°	18.0	SDACR/L 1212K 11-S	12.0	12.0	125.0	12.0	12.0	3.0	0.14	CoroTurn 107	DCMT 11 T3 08
	11	12 x 12		62°	57°	21.0	SDNCN 1212K 11-S	12.0	12.0	125.0	6.2	12.0	3.0	0.12	CoroTurn 107	DCMT 11 T3 08
	06	12 x 12	12.0		90°	12.0	SRDCN 1212F 06	12.0	12.0	80.0	9.0	12.0	0.9	0.09	CoroTurn 107	RCMT 06 02 M0
	11	12 x 12		93°	0°	16.0	STJCR/L 1212K 11-S	12.0	12.0	125.0	12.0	12.0	0.9	0.14	CoroTurn 107	TCMT 11 02 04
	11	12 x 12		93°	50°	26.0	SVJBR/L 1212K 11-S	12.0	12.0	125.0	12.0	12.0	0.9	0.14	CoroTurn 107	VBMT 11 02 04
	11	12 x 12		90°	53°	26.0	SVABR 1212K 11-S	12.0	12.0	125.0	12.0	12.0	0.9	0.14	CoroTurn 107	VBMT 11 02 04
	11	12 x 12		72°	70°	21.0	SVBN 1212K 11-S-B1	12.0	12.0	125.0	6.3	12.0	0.9	0.14	CoroTurn 107	VBMT 11 03 04
	11	12 x 12		93°	50°	26.0	SVJBR/L 1212K 11-S-B1	12.0	12.0	125.0	12.0	12.0	0.9	0.15	CoroTurn 107	VBMT 11 03 04

D

E

F

G

H

I

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand

J



A5



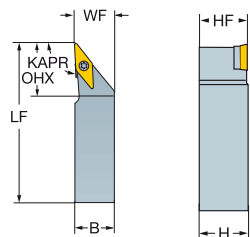
J19



J9

Shank tool for turning

Rectangular shank -metric: 12 x 12



		Dimensions, mm													
	CZC _{MS}	LU	KAPR	RMPX	OHX	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MIID
	16	12 x 12	93°	50°	30.0	SVJBR/L 1212K 16-S	12.0	12.0	125.0	12.0	12.0	3.0	0.18	CoroTurn 107	VBMT 16 04 08
	16	12 x 12	90°	53°	40.0	SVABR 1212K 16-S	12.0	12.0	125.0	12.0	12.0	3.0	0.16	CoroTurn 107	VBMT 16 04 08
	11	12 x 12	91°	0°	15.8	PTGNR 1212K11-S	12.0	12.0	125.0	12.0	12.0	2.0	0.16	T-Max P	TNMG 11 03 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

B

C

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A5



J19



J9

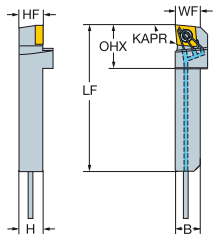


A

Shank tool for turning

QS-HP shank coupling -metric: 16 x 16

B



C

							Dimensions, mm									
		CZC _{MS}	KAPR	RMPX	OHX	CNSC	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MIID
	09	16 x 16	95°	0°	21.0	1	QS-SCLCR1616E09HP	16.0	16.0	70.0	16.0	16.0	3.0	0.17	CoroTurn 107	CCMT 09 T3 08
	11	16 x 16	93°	27°	27.5	1	QS-SDJCR1616E11HP	16.0	16.0	70.0	16.0	16.0	3.0	0.16	CoroTurn 107	DCMT 11 T3 08
	11	16 x 16	93°	0°	16.0	1	QS-STJCR1616E11HP	16.0	16.0	70.0	16.0	16.0	0.9	0.17	CoroTurn 107	TCMT 11 02 04
	11	16 x 16	93°	50°	28.0	1	QS-SVJCR/L1616E11HP	16.0	16.0	70.0	16.0	16.0	0.9	0.15	CoroTurn 107	VCMT 11 03 04

D

E

F

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

G

H

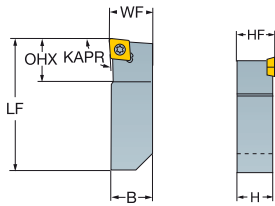
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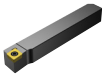
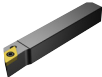
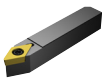
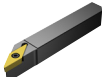
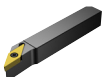
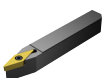
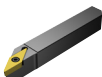


J



Shank tool for turning

QS shank coupling -metric: 16 x 16



					Ordering code	Dimensions, mm						PRODFAM	MIID		
						B	H	LF	WF	HF	NM			KG	
	09	CZ _{MS} 16 x 16	KAPR 95°	RMPX 0°	OHX 16.0	QS-SCLCR1616E09	16.0	16.0	70.0	16.0	16.0	3.0	0.16	CoroTurn 107	CCMT 09 T3 08
	11	16 x 16	93°	27°	20.0	QS-SDJCR1616E11	16.0	16.0	70.0	16.0	16.0	3.0	0.15	CoroTurn 107	DCMT 11 T3 08
	11	16 x 16	62°	57°	21.0	QS-SDNCN1616E11	16.0	16.0	70.0	8.5	16.0	3.0	0.15	CoroTurn 107	DCMT 11 T3 08
	11	16 x 16	90°	53°	26.0	QS-SVABR/L1616E11-B1	16.0	16.0	70.0	16.0	16.0	0.9	0.13	CoroTurn 107	VBMT 11 03 04
	11	16 x 16	93°	50°	26.0	QS-SVJBR/L1616E11-B1	16.0	16.0	70.0	16.0	16.0	0.9	0.14	CoroTurn 107	VBMT 11 03 04
	11	16 x 16	72°	70°	21.0	QS-SWBN1616E11-B1	16.0	16.0	70.0	8.3	16.0	0.9	0.14	CoroTurn 107	VBMT 11 03 04
	16	16 x 16	90°	53°	40.0	QS-SVABL1616E16	16.0	16.0	70.0	16.0	16.0	3.0	0.14	CoroTurn 107	VBMT 16 04 08
	16	16 x 16	93°	50°	40.0	QS-SVJBR1616E16	16.0	16.0	70.0	16.0	16.0	3.0	0.14	CoroTurn 107	VBMT 16 04 08
	11	16 x 16	91°	0°	15.8	QS-PTGNR 1616E11	16.0	16.0	70.0	16.0	16.0	2.0	0.15	T-Max P	TNMG 11 03 04

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand



A5



J19



J9

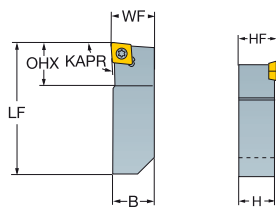
A

Shank tool for turning

Rectangular shank -metric: 16 x 16

ENG

B



C

		CZC _{MS}	LU	KAPR	RMPX	OHX	Ordering code	Dimensions, mm					PRODFAM	MIID		
								B	H	LF	WF	HF			NM	KG
		06	16 x 16	95°	0°	16.0	SCLCR/L 1616K 06-S	16.0	16.0	125.0	16.0	16.0	0.9	0.27	CoroTurn 107	CCMT 06 02 04
		09	16 x 16	90°	0°	16.0	SCACR/L 1616K 09-S	16.0	16.0	125.0	16.0	16.0	3.0	0.28	CoroTurn 107	CCMT 09 T3 08
		09	16 x 16	95°	0°	16.0	SCLCR/L 1616K 09-S	16.0	16.0	125.0	16.0	16.0	3.0	0.27	CoroTurn 107	CCMT 09 T3 08
		11	16 x 16	93°	27°	20.0	SDJCR/L 1616K 11-S	16.0	16.0	125.0	16.0	16.0	3.0	0.27	CoroTurn 107	DCMT 11 T3 08
		11	16 x 16	90°	33°	20.0	SDACR/L 1616K 11-S	16.0	16.0	125.0	16.0	16.0	3.0	0.27	CoroTurn 107	DCMT 11 T3 08
		11	16 x 16	62°	57°	21.0	SDNCN 1616K 11-S	16.0	16.0	125.0	8.5	16.0	3.0	0.25	CoroTurn 107	DCMT 11 T3 08
		08	16 x 16	16.0	90°	16.0	SRDCN 1616H 08	16.0	16.0	100.0	12.0	16.0	1.4	0.17	CoroTurn 107	RCMT 08 03 M0
		11	16 x 16	93°	0°	16.0	STJCR/L 1616K 11-S	16.0	16.0	125.0	16.0	16.0	0.9	0.27	CoroTurn 107	TCMT 11 02 04
		11	16 x 16	93°	50°	26.0	SVJBR/L 1616K 11-S	16.0	16.0	125.0	16.0	16.0	0.9	0.20	CoroTurn 107	VBMT 11 02 04
		11	16 x 16	72°	70°	21.0	SVBN 1616K 11-S-B1	16.0	16.0	125.0	8.3	16.0	0.9	0.24	CoroTurn 107	VBMT 11 03 04
		11	16 x 16	93°	50°	26.0	SVJBR/L 1616K 11-S-B1	16.0	16.0	125.0	16.0	16.0	0.9	0.25	CoroTurn 107	VBMT 11 03 04
		11	16 x 16	90°	53°	26.0	SVABR/L 1616K 11-S-B1	16.0	16.0	125.0	16.0	16.0	0.9	0.25	CoroTurn 107	VBMT 11 03 04

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N = Neutral, R = Right hand, L = Left hand

J



A5



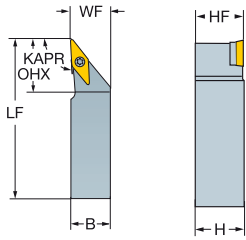
J19



J9

Shank tool for turning

Rectangular shank -metric: 16 x 16



		CZC _{MS}	LU	KAPR	RMPX	OHX	Ordering code	Dimensions, mm						PRODFAM	MID	
								B	H	LF	WF	HF	NM			KG
	16	16 x 16		93°	50°	40.0	SVJBR/L 1616K 16-S	16.0	16.0	125.0	16.0	16.0	3.0	0.28	CoroTurn 107	VBMT 16 04 08
	16	16 x 16		90°	53°	40.0	SVABR/L 1616K 16-S	16.0	16.0	125.0	16.0	16.0	3.0	0.26	CoroTurn 107	VBMT 16 04 08
	13	16 x 16		93°	27°	28.5	TR-D13JCR/L 1616K-S	16.0	16.0	125.0	16.0	16.0	3.0	0.27	CoroTurn TR	TR-DC1308
	13	16 x 16		62°	57°	26.0	TR-D13NCN1616K-S	16.0	16.0	125.0	8.3	16.0	3.0	0.30	CoroTurn TR	TR-DC1308
	13	16 x 16		93°	50°	32.0	TR-V13JBR/L 1616K-S	16.0	16.0	125.0	16.0	16.0	2.0	0.27	CoroTurn TR	TR-VB1308
	13	16 x 16		72°	70°	32.0	TR-V13VBN 1616K-S	16.0	16.0	125.0	8.3	16.0	2.0	0.26	CoroTurn TR	TR-VB1308

For spare parts, visit www.sandvik.coromant.com

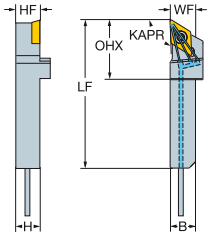
N = Neutral, R = Right hand, L = Left hand



A

Shank tool for turning

B



C

QS-HP shank coupling -inch: 3/8 x 3/8 - 3/8 x 1/2

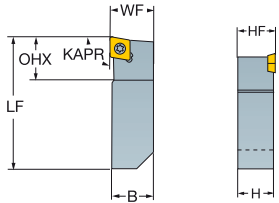
D

		CZC _{MS}	RMPX	KAPR	OHX	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID		
								B	H	LF	WF	HF	PSI			FT/LBS	LBS
	07	3/8 X 1/2	27°	93°	.827	1	QS-SDJCR06082XHP	.500	.375	2.756	.375	.375	1160	0.7	1.87	CoroTurn 107	DCMT 2(1.5)1
	11	3/8 X 1/2	50°	93°	1.102	1	QS-SVJCR/L06082XHP	.500	.375	2.756	.375	.375	1160	0.7	0.18	CoroTurn 107	VCMT 221
	06	3/8 x 3/8	0°	95°	.827	1	QS-SCLCR06082XHP	.375	.375	2.756	.500	.375	1160	0.7	0.21	CoroTurn 107	CCMT 2(1.5)1

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R = Right hand, L = Left hand

F



G

QS shank coupling -inch: 3/8 x 3/8

H

		CZC _{MS}	RMPX	KAPR	OHX	Ordering code	Dimensions, inch						PRODFAM	MIID	
							B	H	LF	WF	HF	FT/LBS			LBS
	06	3/8 x 3/8	0°	90°	.394	QS-SCACR 062X	.375	.375	2.756	.375	.375	0.7	0.14	CoroTurn 107	CCMT 2(1.5)1
	11	3/8 x 3/8	70°	72°	.827	QS-SWBN 062X-B1	.375	.375	2.756	.201	.375	0.7	0.13	CoroTurn 107	VBMT 221

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand

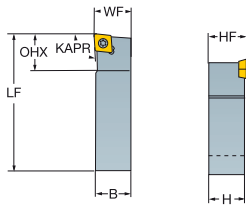
J



ENG

Shank tool for turning

Rectangular shank -inch: 3/8 x 3/8



		CZC _{MS}	LU	RMPX	KAPR	OHX	Ordering code	Dimensions, inch						PRODFAM	MID	
								B	H	LF	WF	HF	FT/LBS			LBS
	06	3/8 x 3/8		0°	95°	.375	SCLCR/L 062C-S	.375	.375	5.000	.375	.375	0.7	0.54	CoroTurn 107	CCMT 2(1.5)1
	06	3/8 x 3/8		0°	90°	.375	SCACR/L 062C-S	.375	.375	5.000	.375	.375	0.7	0.13	CoroTurn 107	CCMT 2(1.5)1
	07	3/8 x 3/8		27°	93°	.590	SDJCR/L 062C-S	.375	.375	5.000	.375	.375	0.7	0.31	CoroTurn 107	DCMT 2(1.5)1
	07	3/8 x 3/8		33°	90°	.500	SDACR/L 062C-S	.375	.375	5.000	.375	.375	0.7	0.26	CoroTurn 107	DCMT 2(1.5)1
	11	3/8 x 3/8		50°	93°	1.060	SVJBR 062C-S	.375	.375	5.000	.375	.375	0.7	0.23	CoroTurn 107	VBMT 2(1.5)1
	11	3/8 x 3/8		70°	72°	.830	SWBN 062C-S-B1	.375	.375	5.000	.190	.375	0.7	0.18	CoroTurn 107	VBMT 221
	11	3/8 x 3/8		50°	93°	.787	SVJBR/L 062C-S-B1	.375	.375	5.000	.375	.375	0.7	0.23	CoroTurn 107	VBMT 221

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand

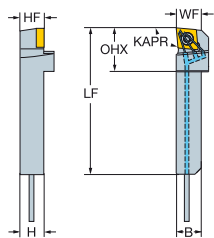


A

Shank tool for turning

QS-HP shank coupling -inch: 1/2 x 1/2

B



C

								Dimensions, inch										
		CZC _{MS}	RMPX	KAPR	OHX	CNSC	Ordering code	B	H	LF	WF	HF	PSI	FT/ LBS	LBS	PROFAM	MIID	
		09	1/2 x 1/2	0°	95°	.827	1	QS-SCLCR083XHP	.500	.500	2.756	.500	.500	1160	2.2	0.27	CoroTurn 107	CCMT 3(2.5)2
D																		
		07	1/2 x 1/2	58°	62°	.866	1	QS-SDNCN082XHP	.500	.500	2.756	.500	.500	1160	0.7	0.25	CoroTurn 107	DCMT 2(1.5)1
E																		
		11	1/2 x 1/2	27°	93°	1.083	1	QS-SDJCR083XHP-M	.500	.500	2.756	.500	.500	1160	2.2	0.24	CoroTurn 107	DCMT 3(2.5)2
		11	1/2 x 1/2	0°	93°	.630	1	QS-STJCR082XHP	.500	.500	2.756	.500	.500	1160	0.7	0.27	CoroTurn 107	TCMT 2(1.5)1
F																		
		11	1/2 x 1/2	50°	93°	1.142	1	QS-SVJCR/L082XHP-M	.500	.500	2.756	.500	.500	1160	0.7	0.21	CoroTurn 107	VCMT 221
G																		
		11	1/2 x 1/2	68°	72°	1.181	1	QS-SWBN082XHP	.500	.500	2.756	.250	.500	1160	0.7	0.21	CoroTurn 107	VCMT 221

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand

H

I

J



A5



J19



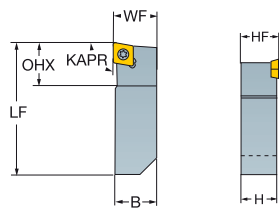
J9



J16

Shank tool for turning

QS shank coupling -inch: 1/2 x 1/2



B

		Dimensions, inch													
Image	CZC _{MS}	RMPX	KAPR	OHX	Ordering code	B	H	LF	WF	HF	FT/LBS		PRODFAM	MIID	
											LBS	LBS			
	09	1/2 x 1/2	0°	90°	.591	QS-SCACR 083X	.500	.500	2.756	.500	.500	2.2	0.30	CoroTurn 107	CCMT 3(2.5)2
	09	1/2 x 1/2	0°	95°	.591	QS-SCLCR 083X	.500	.500	2.756	.500	.500	2.2	0.24	CoroTurn 107	CCMT 3(2.5)2
	11	1/2 x 1/2	27°	93°	.787	QS-SDJCR 083X	.500	.500	2.756	.500	.500	2.2	0.23	CoroTurn 107	DCMT 3(2.5)2
	11	1/2 x 1/2	50°	93°	.787	QS-SVJBR 082X-B1	.500	.500	2.756	.500	.500	0.7	0.21	CoroTurn 107	VBMT 221

C

D

E

F

For spare parts, visit www.sandvik.coromant.com

R = Right hand

G

H

I

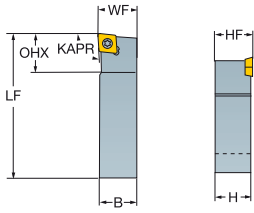
J













A

Shank tool for turning

Rectangular shank -inch: 1/2 x 1/2



C

		CZC _{MS}	LU	RMPX	KAPR	OHX	Ordering code	Dimensions, inch					FT/LBS	LBS	PRODFAM	MIID
								B	H	LF	WF	HF				
	06	1/2 x 1/2		0°	95°	.500	SCLCR/L 082C-S	.500	.500	5.000	.500	.500	0.7	0.35	CoroTurn 107	CCMT 2(1.5)1
	09	1/2 x 1/2		0°	95°	.500	SCLCR/L 083C-S	.500	.500	5.000	.500	.500	2.2	0.41	CoroTurn 107	CCMT 3(2.5)2
	09	1/2 x 1/2		0°	90°	.500	SCACR/L 083C-S	.500	.500	5.000	.500	.500	2.2	0.31	CoroTurn 107	CCMT 3(2.5)2
	07	1/2 x 1/2		27°	93°	.669	SDJCR/L 082C-S	.500	.500	5.000	.500	.500	0.7	0.44	CoroTurn 107	DCMT 2(1.5)1
	11	1/2 x 1/2		27°	93°	.940	SDJCR/L 083C-S	.500	.500	5.000	.500	.500	2.2	0.40	CoroTurn 107	DCMT 3(2.5)2
	11	1/2 x 1/2		33°	90°	.750	SDACR/L 083C-S	.500	.500	5.000	.500	.500	2.2	0.88	CoroTurn 107	DCMT 3(2.5)2
	11	1/2 x 1/2		57°	62°	.830	SDPCN 083C-S	.500	.500	5.000	.251	.500	2.2	0.44	CoroTurn 107	DCMT 3(2.5)2
	06	1/2 x 1/2	.500	90°		.500	SRDCN 08 2	.500	.500	3.500	.372	.500	0.7	0.26	CoroTurn 107	RCMT 22
	11	1/2 x 1/2		0°	93°	.630	STJCR/L 082C-S	.500	.500	5.000	.500	.500	0.7	0.39	CoroTurn 107	TCMT 2(1.5)1
	11	1/2 x 1/2		50°	93°	1.060	SVJBR/L 082C-S	.500	.500	5.000	.500	.500	0.7	0.37	CoroTurn 107	VBMT 2(1.5)1
	11	1/2 x 1/2		53°	90°	1.060	SVABR 082C-S	.500	.500	5.000	.500	.500	0.7	0.51	CoroTurn 107	VBMT 2(1.5)1
	11	1/2 x 1/2		70°	72°	.830	SVVBN 082C-S-B1	.500	.500	5.000	.260	.500	0.7	0.32	CoroTurn 107	VBMT 221
	11	1/2 x 1/2		50°	93°	.787	SVJBR/L 082C-S-B1	.500	.500	5.000	.500	.500	0.7	0.36	CoroTurn 107	VBMT 221

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand

J



A5

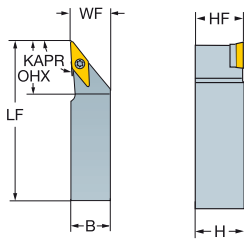


J19







J9

Shank tool for turning

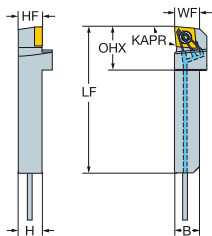


Rectangular shank -inch: 1/2 x 1/2





		CZC _{MS}	LU	RMPX	KAPR	OHX	Ordering code	Dimensions, inch						PRODFAM	MIID	
								B	H	LF	WF	HF	FT/LBS			LBS
	11	1/2 x 1/2		53°	90°	.790	SVABR/L 082C-S-B1	.500	.500	5.000	.500	.500	0.7	0.32	CoroTurn 107	VBMT 221
	16	1/2 x 1/2		50°	93°	1.610	SVJBR/L 083C-S	.500	.500	5.000	.500	.500	2.2	0.37	CoroTurn 107	VBMT 332
	16	1/2 x 1/2		53°	90°	1.610	SVABR 083C-S	.500	.500	5.000	.500	.500	2.2	0.55	CoroTurn 107	VBMT 332

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



QS-HP shank coupling -inch: 5/8 x 5/8

		CZC _{MS}	RMPX	KAPR	OHX	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID		
								B	H	LF	WF	HF	PSI			FT/LBS	LBS
	09	5/8 x 5/8	0°	95°	.827	1	QS-SCLCR103XHP	.625	.625	2.756	.625	.625	1160	2.2	0.36	CoroTurn 107	CCMT 3(2.5)2
	11	5/8 x 5/8	27°	93°	1.083	1	QS-SDJCR103XHP	.625	.625	2.756	.625	.625	1160	2.2	0.34	CoroTurn 107	DCMT 3(2.5)2
	11	5/8 x 5/8	50°	93°	1.102	1	QS-SVJCR/L102XHP	.625	.625	2.756	.625	.625	1160	0.7	0.32	CoroTurn 107	VCMT 221

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



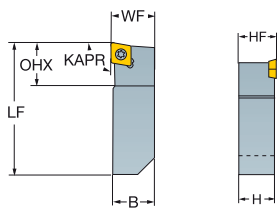
J16

A

Shank tool for turning

QS shank coupling -inch: 5/8 x 5/8

B



C

		Dimensions, inch													
		CZC _{MS}	RMPX	KAPR	OHX	Ordering code	B	H	LF	WF	HF	FT/LBS	LBS	PRODFAM	MIID
	09	5/8 x 5/8	0°	95°	.591	QS-SCLCR 103X	.625	.625	2.756	.625	.625	2.2	0.66	CoroTurn 107	CCMT 3(2.5)2
	11	5/8 x 5/8	27°	93°	.787	QS-SDJCR 103X	.625	.625	2.756	.625	.625	2.2	0.33	CoroTurn 107	DCMT 3(2.5)2
	11	5/8 x 5/8	50°	93°	.787	QS-SVJBR 102X-B1	.625	.625	2.756	.625	.625	0.7	0.18	CoroTurn 107	VBMT 221
	16	5/8 x 5/8	50°	93°	1.181	QS-SVJBR 103X	.625	.625	2.756	.625	.625	2.2	0.18	CoroTurn 107	VBMT 332

For spare parts, visit www.sandvik.coromant.com

R = Right hand

F

G

H

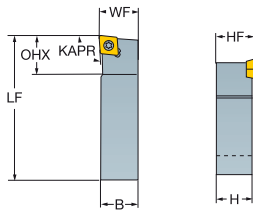
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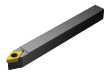
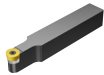
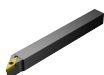
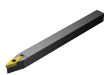
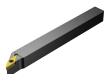


J



Shank tool for turning

Rectangular shank -inch: 5/8 x 5/8



		CZC _{MS}	LU	RMPX	KAPR	OHX	Ordering code	Dimensions, inch						PRODFAM	MID	
								B	H	LF	WF	HF	FT/LBS			LBS
	09	5/8 x 5/8		0°	95°	.625	SCLCR/L 103C-S	.625	.625	5.000	.625	.625	2.2	0.66	CoroTurn 107	CCMT 3(2.5)2
	09	5/8 x 5/8		0°	90°	.625	SCACR 103C-S	.625	.625	5.000	.625	.625	2.2	0.60	CoroTurn 107	CCMT 3(2.5)2
	11	5/8 x 5/8		27°	93°	.940	SDJCR/L 103C-S	.625	.625	5.000	.625	.625	2.2	0.58	CoroTurn 107	DCMT 3(2.5)2
	11	5/8 x 5/8		33°	90°	.750	SDACR 103C-S	.625	.625	5.000	.625	.625	2.2	0.44	CoroTurn 107	DCMT 3(2.5)2
	11	5/8 x 5/8		57°	62°	.830	SDPCN 103C-S	.625	.625	5.000	.331	.625	2.2	1.06	CoroTurn 107	DCMT 3(2.5)2
	09	5/8 x 5/8	.625	90°		.774	SRDCN 10 3	.625	.625	4.000	.497	.625	1.0	0.43	CoroTurn 107	RCMT 3(2.5)
	11	5/8 x 5/8		50°	93°	1.060	SVJBR/L 102C-S	.625	.625	5.000	.625	.625	0.7	0.65	CoroTurn 107	VBMT 2(1.5)1
	11	5/8 x 5/8		70°	72°	.830	SWBN 102C-S-B1	.625	.625	5.000	.363	.625	0.7	0.65	CoroTurn 107	VBMT 221
	11	5/8 x 5/8		50°	93°	.787	SVJBR/L 102C-S-B1	.625	.625	5.000	.625	.625	0.7	0.65	CoroTurn 107	VBMT 221
	16	5/8 x 5/8		50°	93°	1.610	SVJBR/L 103C-S	.625	.625	5.000	.625	.625	2.2	0.56	CoroTurn 107	VBMT 332
	16	5/8 x 5/8		53°	90°	1.610	SVABR/L 103C-S	.625	.625	5.000	.625	.625	2.2	0.71	CoroTurn 107	VBMT 332
	13	5/8 x 5/8		27°	93°	1.122	TR-D13JCR/L 10C-S	.625	.625	5.000	.625	.625	2.2	0.60	CoroTurn TR	TR-DC1308

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand



A5



J19



J9

A

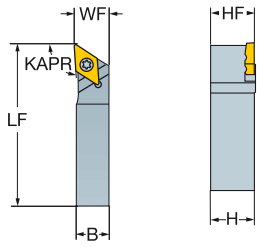
GENERAL TURNING

External tools



Shank tool for turning

Rectangular shank -inch: 5/8 x 5/8

B



C

		Dimensions, inch													
13	CZC _{MS}	LU	RMPX	KAPR	OHX	Ordering code	B	H	LF	WF	HF	FT/ LBS	LBS	PRODFAM	MIID
	5/8 x 5/8		50°	93°	1.260	TR-V13JBR/L 10C-S	.625	.625	5.000	.625	.625	1.5	0.57	CoroTurn TR	TR-VB1308
	5/8 x 5/8		70°	72°	1.260	TR-V13VBN 10C-S	.625	.625	5.000	.331	.625	1.5	0.58	CoroTurn TR	TR-VB1308

D

E

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand

F

G

H

I

J



A5



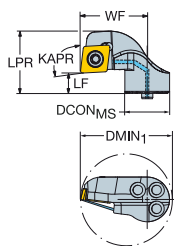
J19




J9


Head for turning

SL head (screw mounted) -size 16



		Dimensions, mm, inch															
	CZC _{MS}	DMIN ₁	KAPR	RMPX	CNCS	Ordering code	DCON _{MS}	LPR	LF	WF	LAMS	BAR NM KG			PRODFAM	MIID	
	09	16	33.0	93°	7°	1	SL-SCUCR-16-09-16X	16	22.0	7.0	24.0	-7	70	3.0	0.05	CoroTurn 107	CCMT 09 T3 08
			1.299	93°	7°			.630	.866	.276	.945	-7	1015			CoroTurn 107	CCMT 3(2.5)2

SL head (screw mounted) -size 20

		Dimensions, mm, inch															
	CZC _{MS}	DMIN ₁	KAPR	RMPX	CNCS	Ordering code	DCON _{MS}	LPR	LF	WF	LAMS	BAR NM KG			PRODFAM	MIID	
	09	20	41.0	93°	7°	1	SL-SCUCR-20-09-20X	20	22.0	7.0	30.0	-3	70	3.0	0.07	CoroTurn 107	CCMT 09 T3 08
			1.614	93°	7°			.787	.866	.276	1.181	-3	1015			CoroTurn 107	CCMT 3(2.5)2

For spare parts, visit www.sandvik.coromant.com

R = Right hand



A5



J19



J9



J16

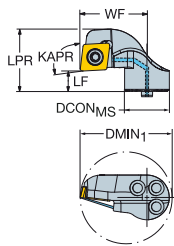
A

Head for turning

SL head (screw mounted) -size 25

ENG

B



C

		Dimensions, mm, inch														
	CZC _{MS}	DMIN ₁	KAPR	RMPX	CNCS	Ordering code	DCON _{MS}	LPR	LF	WF	LAMS	BAR	NM	KG	PRODFAM	MIID
												80	0.9	0.09		
	07	25	33.0	93°	27°	SL-SDUCR/L-25-07-DXHP	25	27.9	15.0	18.0	-2	80	0.9	0.09	CoroTurn 107	DCMT 07 02 04
			1.299	93°	27°		.984	1.098	.591	.709	-2	1160	CoroTurn 107	DCMT 2(1.5)1		
	07	25	33.0	62°	60°	SL-SDXCR/L-25-07-DHP	25	19.7	15.0	18.0	-1	80	0.9	0.07	CoroTurn 107	DCMT 07 02 04
			1.299	62°	60°		.984	.776	.591	.709	-1	1160	CoroTurn 107	DCMT 2(1.5)1		
	09	25	32.0	95°	0°	SL-SCLCR/L-25-09HP	25	20.0	17.0	-6	80	3.0	0.07	CoroTurn 107	CCMT 09 T3 08	
			1.260	95°	0°		.984	.787	.669	-6	1160	CoroTurn 107	CCMT 3(2.5)2			
	09	25	44.0	93°	7°	SL-SCUCR-25-09-18X	25	24.0	7.0	30.5	-4	70	3.0	0.09	CoroTurn 107	CCMT 09 T3 08
			1.732	93°	7°		.984	.945	.276	1.201	-4	1015	CoroTurn 107	CCMT 3(2.5)2		
	11	25	32.0	93°	27°	SL-SDUCR/L-25-11HP	25	23.0	17.0	-6	80	3.0	0.08	CoroTurn 107	DCMT 11 T3 08	
			1.260	93°	27°		.984	.906	.669	-6	1160	CoroTurn 107	DCMT 3(2.5)2			
	11	25	32.0	91°	0°	SL-STFCR/L-25-11-B1HP	25	20.0	17.0	-2	80	0.9	0.07	CoroTurn 107	TCMT 11 03 04	
			1.260	91°	0°		.984	.787	.669	-2	1160	CoroTurn 107	TCMT 221			
	16	25	35.0	95°	45°	SL-SVLBR/L-25-16-LFHP	25	25.0	20.0	-6	80	3.0	0.08	CoroTurn 107	VBMT 16 04 08	
			1.378	95°	45°		.984	.984	.787	-6	1160	CoroTurn 107	VBMT 332			
	13	25	36.0	93°	27°	TR-SL-D13UCR/L-25X	25	32.1	17.0	21.0	-5	10	3.0	0.09	CoroTurn TR	TR-DC1308
			1.417	93°	27°		.984	1.264	.669	.827	-5	145	CoroTurn TR	TR-DC1308		
	13	25	35.0	95°	45°	TR-SL-V13LBR/L-25	25	27.0	20.0	-5	10	2.0	0.08	CoroTurn TR	TR-VB1308	
			1.378	95°	45°		.984	1.063	.787	-5	145	CoroTurn TR	TR-VB1308			

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For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

J



A5



J19



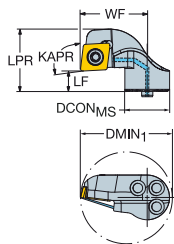
J9



J16

Head for turning

SL head (screw mounted) -size 25



								Dimensions, mm, inch									
		CZC _{MS}	DMIN ₁	KAPR	RMPX	CNSC	Ordering code	DCON _{MS}	LPR	LF	WF	LAMS	BAR	NM	KG	PRODFAM	MIID
	13	25	35.0	93°	27°	1	TR-SL-D13UCR/L-25	25	27.0	20.0	-5	10	3.0	0.08	CoroTurn TR	TR-DC1308	
			1.378	93°	27°			.984	1.063	.787	-5	145				CoroTurn TR	TR-DC1308
	13	25	35.0	62°	60°	1	TR-SL-D13XCR/L-25	25	23.3	20.0	20.0	-5	10	3.0	0.07	CoroTurn TR	TR-DC1308
			1.378	62°	60°			.984	.917	.787	.787	-5	145			CoroTurn TR	TR-DC1308
	13	25	33.0	117°	25°	1	TR-SL-V13PBR/L-25	25	28.0	17.0	-5	10	2.0	0.07	CoroTurn TR	TR-VB1308	
			1.299	117°	25°			.984	1.102	.669	-5	145				CoroTurn TR	TR-VB1308
	09	25	34.0	95°	0°	1	SL-PCLNR/L-25-09HP-G	25	28.0	19.0	-10	80	1.7	0.08	T-Max P	CNMG 09 03 08	
			1.339	95°	0°			.984	1.102	.748	-10	1160				T-Max P	CNMG 322
	11	25	38.0	93°	27°	1	SL-PDUNR/L-25-11HP-G	25	32.0	21.0	-10	80	2.0	0.10	T-Max P	DNMG 11 04 08	
			1.496	93°	27°			.984	1.260	.827	-10	1160				T-Max P	DNMG 332

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19

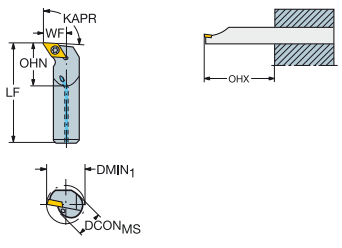


J9



J16

Boring bar for turning



Cylindrical shank without clamping features -metric: 5 With grooves for EasyFix sleeves

										Dimensions, mm								
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	BD	LF	WF	BAR	NM	KG	PRODFAM	MIID
	05	5	6.0	93°	0°	20.0	7.5	1	A05F-STUCR/L 05-GR	5	5.0	80.0	2.9	10	0.4	0.02	CoroTurn 107	TCEX 05 01 00R-F
	05	5	6.0	93°	0°	30.0	12.0	1	E05H-STUCR/L 05-GR	5	5.0	100.0	2.9	10	0.4	0.04	CoroTurn 107	TCEX 05 01 00R-F

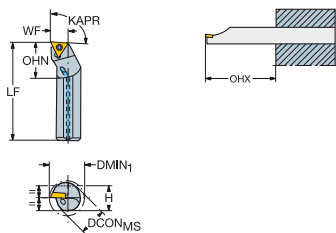
Cylindrical shank without clamping features -metric: 6 With grooves for EasyFix sleeves

										Dimensions, mm								
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	BD	LF	WF	BAR	NM	KG	PRODFAM	MIID
	05	6	7.0	93°	0°	24.0	9.0	1	A06F-STUCR/L 05-GR	6	6.0	80.0	3.2	10	0.4	0.03	CoroTurn 107	TCEX 05 01 00R-F
	05	6	7.0	93°	0°	36.0	13.0	1	E06H-STUCR/L 05-GR	6	6.0	100.0	3.2	10	0.4	0.05	CoroTurn 107	TCEX 05 01 00R-F
	06	6	8.5	91°	0°	24.0	9.0	1	A06F-STFCR/L 06-R	6	6.0	80.0	4.5	10	0.6	0.03	CoroTurn 107	TCMT 06 T1 02
	06	6	8.5	91°	0°	36.0	15.0	1	E06H-STFCR/L 06-R	6	6.0	100.0	4.5	10	0.6	0.05	CoroTurn 107	TCMT 06 T1 02

For spare parts, visit www.sandvik.coromant.com R = Right hand, L = Left hand



Boring bar for turning



Cylindrical shank with 3 flats -metric: 6

										Ordering code	Dimensions, mm							PRODFAM	MIID
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	DCON _{MS}		H	BD	LF	WF	BAR	NM	KG		
	06	6	8.5	91°	0°	24.0	9.0	1	A06F-STFCR/L 06	6	5.0	6.0	80.0	4.5	10	0.6	0.03	CoroTurn 107	TCMT 06 T1 02

Cylindrical shank without clamping features -metric: 8
With grooves for EasyFix sleeves

										Ordering code	Dimensions, mm							PRODFAM	MIID
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	DCON _{MS}		BD	LF	WF	BAR	NM	KG			
	06	8	10.0	95°	0°	32.0	12.0	1	A08H-SCLCR/L 06-R	8	8.0	100.0	5.0	10	0.9	0.05	CoroTurn 107	CCMT 06 02 04	
	06	8	10.0	95°	0°	48.0	17.0	1	E08H-SCLCR/L 06-R	8	8.0	125.0	5.0	10	0.9	0.09	CoroTurn 107	CCMT 06 02 04	
	06	8	9.0	93°	0°	32.0	12.0	1	A08H-STUCR/L 06-GR	8	8.0	100.0	4.2	10	0.6	0.05	CoroTurn 107	TCEX 06 T1 00R-F	
	06	8	9.0	93°	0°	48.0	17.0	1	E08K-STUCR/L 06-GR	8	8.0	125.0	4.2	10	0.6	0.08	CoroTurn 107	TCEX 06 T1 00R-F	
	06	8	11.0	91°	0°	32.0	12.0	1	A08H-STFCR/L 06-R	8	8.0	100.0	5.9	10	0.6	0.05	CoroTurn 107	TCMT 06 T1 02	
	06	8	11.0	91°	0°	48.0	20.0	1	E08K-STFCR/L 06-R	8	8.0	125.0	5.9	10	0.6	0.09	CoroTurn 107	TCMT 06 T1 02	

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



J16

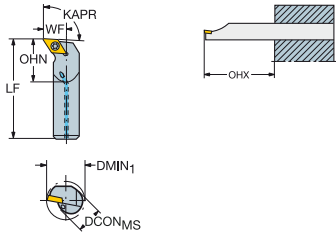
A

Boring bar for turning

Cylindrical shank with 3 flats -metric: 8

ENG

B



C

		Dimensions, mm																	
	CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNCS	Ordering code	DCON _{MS}	H	BD	LF	WF	BAR	NM	KG	PRODFAM	MIID	
														10	0.9	0.05			
	06	8	10.0	95°	0°	32.0	12.0	1	A08H-SCLCR/L 06	8	7.0	8.0	100.0	5.0	10	0.9	0.05	CoroTurn 107	CCMT 06 02 04
	06	8	11.0	91°	0°	32.0	12.0	1	A08H-STFCR/L 06	8	7.0	8.0	100.0	5.9	10	0.6	0.05	CoroTurn 107	TCMT 06 T1 02

E

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

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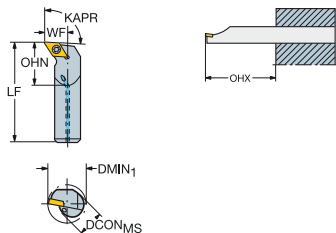
J



Boring bar for turning

Cylindrical shank without clamping features -metric: 10

With grooves for EasyFix sleeves



		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	Dimensions, mm						PRODFAM	MIID	
										DCON _{MS}	BD	LF	WF	BAR	NM			KG
	06	10	12.0	95°	0°	40.0	15.0	1	A10K-SCLCR/L 06-R	10	10.0	125.0	6.0	10	0.9	0.08	CoroTurn 107	CCMT 06 02 04
	06	10	12.0	95°	0°	60.0	21.0	1	E10M-SCLCR/L 06-R	10	10.0	150.0	6.0	10	0.9	0.15	CoroTurn 107	CCMT 06 02 04
	07	10	15.0	93°	27°	40.0	15.0	1	A10K-SDUCR/L 07-ER	10	10.0	125.0	9.0	10	0.9	0.08	CoroTurn 107	DCMT 07 02 04
	07	10	15.0	93°	27°	60.0	25.0	1	E10M-SDUCR/L 07-ER	10	10.0	150.0	9.0	10	0.9	0.15	CoroTurn 107	DCMT 07 02 04
	07	10	13.0	107°	17°	40.0	15.0	1	A10K-SDQCR/L 07-R	10	10.0	125.0	7.0	10	0.9	0.08	CoroTurn 107	DCMT 07 02 04
	06	10	11.0	93°	0°	40.0	15.0	1	A10K-STUCR/L 06-GR	10	10.0	125.0	5.2	10	0.6	0.08	CoroTurn 107	TCEX 06 T1 00R-F
	06	10	11.0	93°	0°	60.0	20.0	1	E10M-STUCR/L 06-GR	10	10.0	150.0	5.2	10	0.6	0.14	CoroTurn 107	TCEX 06 T1 00R-F
	09	10	13.0	91°	0°	40.0	15.0	1	A10K-STFCR/L 09-R	10	10.0	125.0	7.0	10	0.9	0.08	CoroTurn 107	TCMT 09 02 04
	09	10	13.0	91°	0°	60.0	25.0	1	E10M-STFCR/L 09-R	10	10.0	150.0	7.0	10	0.9	0.15	CoroTurn 107	TCMT 09 02 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



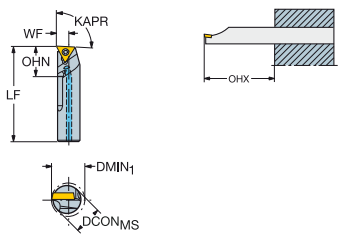
J9



J16

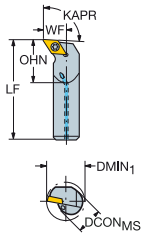


Boring bar for turning



Cylindrical shank without clamping features -metric: 10 With grooves for EasyFix sleeves

		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	Ordering code	Dimensions, mm					PRODFAM	MIID
									DCON _{MS}	LF	WF	NM	KG		
	07	10	15.0	93°	27°	100.0	60.0	F10M-SDUCR/L 07-ER	10	150.0	9.0	0.9	0.18	CoroTurn 107	DCMT 07 02 04
	09	10	13.0	91°	0°	100.0	60.0	F10M-STFCR/L 09-R	10	150.0	7.0	0.9	0.18	CoroTurn 107	TCMT 09 02 04



Cylindrical shank with 3 flats -metric: 10

		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	Dimensions, mm					PRODFAM	MIID			
										DCON _{MS}	H	BD	LF	WF			BAR	NM	KG
	06	10	12.0	95°	0°	40.0	15.0	1	A10K-SCLCR/L 06	10	9.0	10.0	125.0	6.0	10	0.9	0.08	CoroTurn 107	CCMT 06 02 04
	07	10	13.0	93°	27°	40.0	15.0	1	A10K-SDUCR/L 07	10	9.0	10.0	125.0	7.0	10	0.9	0.08	CoroTurn 107	DCMT 07 02 04
	07	10	13.0	107°	17°	40.0	15.0	1	A10K-SDQCR/L 07	10	9.0	10.0	125.0	7.0	10	0.9	0.08	CoroTurn 107	DCMT 07 02 04
	09	10	13.0	91°	0°	40.0	15.0	1	A10K-STFCR/L 09	10	9.0	10.0	125.0	7.0	10	0.9	0.08	CoroTurn 107	TCMT 09 02 04

For spare parts, visit www.sandvik.coromant.com

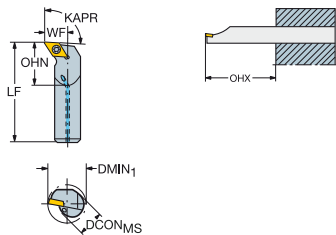
R = Right hand, L = Left hand



Boring bar for turning

Cylindrical shank without clamping features -metric: 12

With grooves for EasyFix sleeves



		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	Dimensions, mm						PRODFAM	MIID	
										DCON _{MS}	BD	LF	WF	BAR	NM			KG
	06	12	16.0	95°	0°	48.0	18.0	1	A12M-SCLCR/L 06-R	12	12.0	150.0	9.0	10	0.9	0.14	CoroTurn 107	CCMT 06 02 04
	06	12	16.0	95°	0°	72.0	25.0	1	E12Q-SCLCR/L 06-R	12	12.0	180.0	9.0	10	0.9	0.26	CoroTurn 107	CCMT 06 02 04
	07	12	18.0	93°	27°	48.0	18.0	1	A12M-SDUCR/L 07-ER	12	12.0	150.0	11.0	10	0.9	0.13	CoroTurn 107	DCMT 07 02 04
	07	12	18.0	93°	27°	72.0	30.0	1	E12Q-SDUCR/L 07-ER	12	12.0	180.0	11.0	10	0.9	0.25	CoroTurn 107	DCMT 07 02 04
	07	12	16.0	107°	17°	48.0	18.0	1	A12M-SDQCR/L 07-R	12	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	DCMT 07 02 04
	07	12	16.0	62°	60°	48.0	18.0	1	A12M-SDXCR/L 07-R	12	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	DCMT 07 02 04
	09	12	16.0	91°	0°	48.0	18.0	1	A12M-STFCR/L 09-R	12	12.0	150.0	9.0	10	0.9	0.12	CoroTurn 107	TCMT 09 02 04
	09	12	16.0	91°	0°	72.0	30.0	1	E12Q-STFCR/L 09-R	12	12.0	180.0	9.0	10	0.9	0.25	CoroTurn 107	TCMT 09 02 04
	11	12	16.0	91°	0°	48.0	18.0	1	A12M-STFCR/L 11-RB1	12	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	TCMT 11 03 04

For spare parts, visit www.sandvik.coromant.com

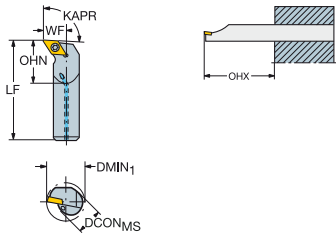
R = Right hand, L = Left hand



Boring bar for turning

Cylindrical shank without clamping features -metric: 12

With grooves for EasyFix sleeves



C

		Dimensions, mm														
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	Ordering code	DCON _{MS}	LF	WF	NM	KG	PRODFAM	MIID	
D		07	12	18.0	93°	27°	120.0	72.0	F12Q-SDUCR/L 07-ER	12	180.0	11.0	0.9	0.29	CoroTurn 107	DCMT 07 02 04
		09	12	16.0	91°	0°	120.0	72.0	F12Q-STFCR/L 09-R	12	180.0	9.0	0.9	0.29	CoroTurn 107	TCMT 09 02 04

E

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

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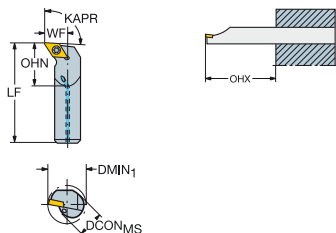
I

J



Boring bar for turning

Cylindrical shank with 3 flats -metric: 12



										Dimensions, mm							PRODFAM	MIID	
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	H	BD	LF	WF	BAR	NM			KG
	06	12	16.0	95°	0°	48.0	18.0	1	A12M-SCLCR/L 06	12	11.0	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	CCMT 06 02 04
	07	12	16.0	93°	27°	48.0	18.0	1	A12M-SDUCR/L 07	12	11.0	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	DCMT 07 02 04
	07	12	16.0	107°	17°	48.0	18.0	1	A12M-SDQCR/L 07	12	11.0	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	DCMT 07 02 04
	07	12	16.0	62°	60°	48.0	18.0	1	A12M-SDXCR/L 07	12	11.0	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	DCMT 07 02 04
	09	12	16.0	91°	0°	48.0	18.0	1	A12M-STFCR/L 09	12	11.0	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	TCMT 09 02 04
	11	12	16.0	91°	0°	48.0	18.0	1	A12M-STFCR/L 11	12	11.0	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	TCMT 11 02 04
	11	12	16.0	91°	0°	48.0	18.0	1	A12M-STFCR/L 11-B1	12	11.0	12.0	150.0	9.0	10	0.9	0.13	CoroTurn 107	TCMT 11 03 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



J16

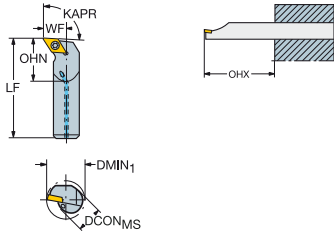


A

Boring bar for turning

Cylindrical shank without clamping features -metric: 16

With grooves for EasyFix sleeves



C

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										Ordering code	Dimensions, mm						PRODFAM	MIID
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	DCON _{MS}		BD	LF	WF	BAR	NM	KG		
	06	16	20.0	95°	0°	64.0	24.0	1	A16R-SCLCR/L 06-R	16	16.0	200.0	11.0	10	0.9	0.26	CoroTurn 107	CCMT 06 02 04
	06	16	20.0	95°	0°	96.0	33.0	1	E16R-SCLCR/L 06-R	16	16.0	200.0	11.0	10	0.9	0.50	CoroTurn 107	CCMT 06 02 04
	09	16	20.0	95°	0°	64.0	24.0	1	A16R-SCLCR/L 09-R	16	16.0	200.0	11.0	10	3.0	0.31	CoroTurn 107	CCMT 09 T3 08
	09	16	20.0	95°	0°	96.0	33.0	1	E16R-SCLCR/L 09-R	16	16.0	200.0	11.0	10	3.0	0.50	CoroTurn 107	CCMT 09 T3 08
	07	16	20.0	93°	27°	64.0	24.0	1	A16R-SDUCR/L 07-R	16	16.0	200.0	11.0	10	0.9	0.31	CoroTurn 107	DCMT 07 02 04
	07	16	22.0	93°	27°	96.0	33.3	1	E16R-SDUCR/L 07-ER	16	16.0	200.0	13.0	10	0.9	0.48	CoroTurn 107	DCMT 07 02 04
	07	16	20.0	117°	5°	64.0	24.0	1	A16K-SDXCR/L 07-R	16	16.0	125.0	9.0	10	0.9	0.17	CoroTurn 107	DCMT 07 02 04
	07	16	20.0	107°	17°	64.0	24.0	1	A16R-SDQCR/L 07-R	16	16.0	200.0	11.0	10	0.9	0.31	CoroTurn 107	DCMT 07 02 04
	07	16	22.0	93°	27°	64.0	24.0	1	A16R-SDUCR/L 07-ERX	16	16.0	200.0	13.0	10	0.9	0.31	CoroTurn 107	DCMT 07 02 04
	07	16	20.0	62°	60°	64.0	24.0	1	A16R-SDXCR/L 07-R	16	16.0	200.0	11.0	10	0.9	0.30	CoroTurn 107	DCMT 07 02 04
	08	16	20.0		90°	64.0	24.0	1	A16K-SRDDN 08-R	16	16.0	125.0	4.0	10	0.9	0.17	CoroTurn 107	R300-0828..

For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand



A5



J19



J9

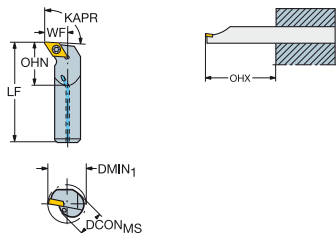


J16

Boring bar for turning

Cylindrical shank without clamping features -metric: 16

With grooves for EasyFix sleeves



		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNCS	Ordering code	Dimensions, mm						PRODFAM	MIID	
										DCON _{MS}	BD	LF	WF	BAR	NM			KG
	11	16	20.0	91°	0°	96.0	33.2	1	E16R-STFCR/L 11-R	16	16.0	200.0	11.0	10	0.9	0.49	CoroTurn 107	TCMT 11 02 04
	11	16	20.0	91°	0°	64.0	24.0	1	A16R-STFCR/L 11-RB1	16	16.0	200.0	11.0	10	0.9	0.30	CoroTurn 107	TCMT 11 03 04
	11	16	20.0	91°	0°	96.0	40.0	1	E16R-STFCR/L 11-RB1	16	16.0	200.0	11.0	10	0.9	0.50	CoroTurn 107	TCMT 11 03 04
	11	16	22.0	93°	50°	64.0	24.0	1	A16R-SVUBR/L 11-ERB1	16	16.0	200.0	13.0	10	0.9	0.30	CoroTurn 107	VBMT 11 03 04
	11	16	22.0	107°	35°	64.0	24.0	1	A16R-SVQCR/L 11-ER	16	16.0	200.0	13.0	10	0.9	0.30	CoroTurn 107	VCMT 11 03 04
	11	16	22.0	107°	35°	96.0	33.0	1	E16R-SVQCR/L 11-ER	16	16.0	200.0	13.0	10	0.9	0.49	CoroTurn 107	VCMT 11 03 04
	11	16	22.0	93°	50°	96.0	33.0	1	E16R-SVUCR/L 11-ER	16	16.0	200.0	13.0	10	0.9	0.50	CoroTurn 107	VCMT 11 03 04
	11	16	22.0	93°	50°	64.0	24.0	1	A16R-SVUCR/L 11-ER	16	16.0	200.0	13.0	10	0.9	0.30	CoroTurn 107	VCMT 11 03 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9

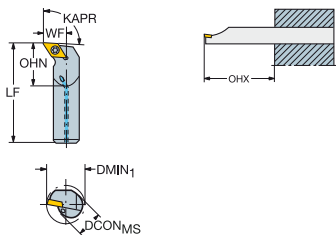


J16



Boring bar for turning

Cylindrical shank with 3 flats -metric: 16



C

										Dimensions, mm										PRODFAM	MIID
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	H	BD	LF	WF	BAR	NM	KG				
	06	16	20.0	95°	0°	64.0	24.0	1	A16R-SCLCR/L 06	16	15.0	16.0	200.0	11.0	10	0.9	0.26	CoroTurn 107	CCMT 06 02 04		
	09	16	20.0	95°	0°	64.0	24.0	1	A16R-SCLCR/L 09	16	15.0	16.0	200.0	11.0	10	3.0	0.32	CoroTurn 107	CCMT 09 T3 08		
	07	16	22.0	93°	27°	64.0	24.0	1	A16R-SDUCR/L 07-EX	16	15.0	16.0	200.0	13.0	10	0.9	0.31	CoroTurn 107	DCMT 07 02 04		
	07	16	20.0	93°	27°	64.0	24.0	1	A16R-SDUCR/L 07	16	15.0	16.0	200.0	11.0	10	0.9	0.31	CoroTurn 107	DCMT 07 02 04		
	07	16	20.0	107°	17°	64.0	24.0	1	A16R-SDQCR/L 07	16	15.0	16.0	200.0	11.0	10	0.9	0.28	CoroTurn 107	DCMT 07 02 04		
	07	16	20.0	62°	60°	64.0	24.0	1	A16R-SDXCR/L 07	16	15.0	16.0	200.0	11.0	10	0.9	0.29	CoroTurn 107	DCMT 07 02 04		
	11	16	20.0	91°	0°	64.0	24.0	1	A16R-STFCR/L 11	16	15.0	16.0	200.0	11.0	10	0.9	0.28	CoroTurn 107	TCMT 11 02 04		
	11	16	20.0	91°	0°	64.0	24.0	1	A16R-STFCR/L 11-B1	16	15.0	16.0	200.0	11.0	10	0.9	0.29	CoroTurn 107	TCMT 11 03 04		
	11	16	22.0	107°	35°	64.0	24.0	1	A16R-SVQBR/L 11-E	16	15.0	16.0	200.0	13.0	10	0.9	0.28	CoroTurn 107	VBMT 11 02 04		
	11	16	22.0	93°	50°	64.0	24.0	1	A16R-SVUBR/L 11-E	16	15.0	16.0	200.0	13.0	10	0.9	0.29	CoroTurn 107	VBMT 11 02 04		
	11	16	22.0	107°	35°	64.0	24.0	1	A16R-SVQBR/L 11-EB1	16	15.0	16.0	200.0	13.0	10	0.9	0.30	CoroTurn 107	VBMT 11 03 04		

For spare parts, visit www.sandvik.coromant.com

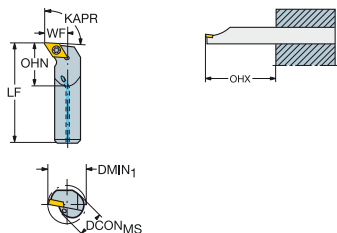
R = Right hand, L = Left hand

J



Boring bar for turning

Cylindrical shank with 3 flats -metric: 16



										Ordering code	Dimensions, mm							PRODFAM	MIID
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	DCON _{MS}		H	BD	LF	WF	BAR	NM	KG		
	11	16	22.0	93°	50°	64.0	24.0	1	A16R-SVUBR/L 11-EB1	16	15.0	16.0	200.0	13.0	10	0.9	0.28	CoroTurn 107	VBMT 11 03 04
	11	16	22.0	107°	35°	64.0	24.0	1	A16R-SVQCR/L 11-E	16	15.0	16.0	200.0	13.0	10	0.9	0.28	CoroTurn 107	VCMT 11 03 04
	11	16	22.0	93°	50°	64.0	24.0	1	A16R-SVUCR/L 11-E	16	15.0	16.0	200.0	13.0	10	0.9	0.29	CoroTurn 107	VCMT 11 03 04
	09	16	26.0	95°	0°	64.0	37.8	1	A16R-PCLNR/L09HP	16	15.0	16.0	200.0	11.0	275	2.0	0.28	T-Max P	CNMG 09 03 08
	09	16	20.0	95°	0°	64.0	26.0	1	A16R-PCLNR/L 09	16	15.0	16.0	200.0	11.0	10	2.0	0.28	T-Max P	CNMG 09 03 08
	11	16	28.0	91°	0°	64.0	30.9	1	A16R-PTFNR/L11HP	16	15.0	16.0	200.0	11.0	275	1.2	0.29	T-Max P	TNMG 11 03 04
	11	16	20.0	91°	0°	64.0	27.8	1	A16R-PTFNR/L 11	16	15.0	16.0	200.0	11.0	10	1.2	0.28	T-Max P	TNMG 11 03 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



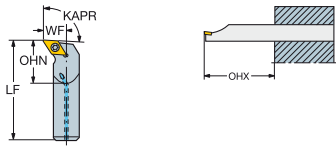
A

Boring bar for turning

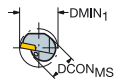
Cylindrical shank without clamping features -metric: 20

With grooves for EasyFix sleeves

B



C



D

E

F

G

H

I

										Dimensions, mm								
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	BD	LF	WF				PRODFAM	MIID
	09	20	25.0	95°	0°	80.0	33.8	1	A20S-SCLCR/L 09HP-R	20	20.0	250.0	13.0	275	3.0	0.58	CoroTurn 107	CCMT 09 T3 08
	09	20	25.0	95°	0°	80.0	30.0	1	A20S-SCLCR/L 09-R	20	20.0	250.0	13.0	10	3.0	0.58	CoroTurn 107	CCMT 09 T3 08
	09	20	25.0	95°	0°	120.0	36.3	1	E20S-SCLCR/L 09-R	20	20.0	220.0	13.0	10	3.0	0.86	CoroTurn 107	CCMT 09 T3 08
	07	20	25.0	93°	27°	80.0	23.1	1	A20S-SDUCR 07HP-R	20	20.0	250.0	13.0	275	0.9	0.57	CoroTurn 107	DCMT 07 02 04
	07	20	25.0	107°	17°	80.0	22.2	1	A20S-SDQCR/L 07HP-R	20	20.0	250.0	13.0	275	0.9	0.56	CoroTurn 107	DCMT 07 02 04
	07	20	27.0	93°	27°	80.0	30.0	1	A20S-SDUCR/L 07-ERX	20	20.0	250.0	15.0	10	0.9	0.60	CoroTurn 107	DCMT 07 02 04
	11	20	25.0	93°	27°	80.0	30.0	1	A20S-SDUCR/L 11-R	20	20.0	250.0	13.0	10	3.0	0.59	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	93°	27°	120.0	36.3	1	E20S-SDUCR/L 11-R	20	20.0	220.0	13.0	10	3.0	0.86	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	120°	3°	80.0	30.0	1	A20M-SDXCR/L 11-R	20	20.0	150.0	12.0	10	3.0	0.33	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	93°	27°	80.0	22.3	1	A20S-SDUCR/L 11HP-R	20	20.0	250.0	13.0	275	3.0	0.58	CoroTurn 107	DCMT 11 T3 08

For spare parts, visit www.sandvik.coromant.com R = Right hand, L = Left hand

J

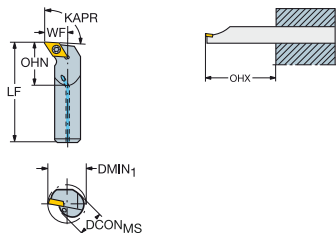


ENG

Boring bar for turning

Cylindrical shank without clamping features -metric: 20

With grooves for EasyFix sleeves



										Ordering code	Dimensions, mm						PRODFAM	MIID
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	DCON _{MS}		BD	LF	WF	BAR	NM	KG		
	11	20	25.0	107°	17°	80.0	30.0	1	A20S-SDQCR/L 11-R	20	20.0	250.0	13.0	10	3.0	0.58	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	62°	60°	80.0	30.0	1	A20S-SDXCR/L 11-R	20	20.0	250.0	13.0	10	3.0	0.59	CoroTurn 107	DCMT 11 T3 08
	08	20	25.0	0°	0°	80.0	30.0	1	A20M-SRXDR/L 08-R	20	20.0	150.0	9.0	10	1.2	0.34	CoroTurn 107	R300-0828..
	10	20	25.0	0°	0°	80.0	30.0	1	A20M-SRXDR/L 10-R	20	20.0	150.0	9.0	10	3.0	0.30	CoroTurn 107	R300-1032..
	11	20	25.0	91°	0°	80.0	27.1	1	A20S-STFCR/L 11HP-RB1	20	20.0	250.0	13.0	275	0.9	0.57	CoroTurn 107	TCMT 11 03 04
	11	20	25.0	91°	0°	80.0	30.0	1	A20S-STFCR/L 11-RB1	20	20.0	250.0	13.0	10	0.9	0.57	CoroTurn 107	TCMT 11 03 04
	11	20	25.0	91°	0°	120.0	36.3	1	E20S-STFCR/L 11-RB1	20	20.0	220.0	13.0	10	0.9	0.85	CoroTurn 107	TCMT 11 03 04
	11	20	27.0	107°	35°	80.0	30.0	1	A20S-SVQBR/L 11-ERB1	20	20.0	250.0	15.0	10	0.9	0.58	CoroTurn 107	VBMT 11 03 04
	11	20	27.0	93°	50°	80.0	30.0	1	A20S-SVUBR/L 11-ERB1	20	20.0	250.0	15.0	10	0.9	0.58	CoroTurn 107	VBMT 11 03 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



J16

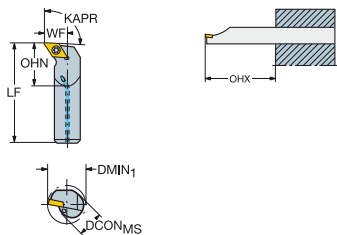
A

Boring bar for turning

Cylindrical shank with 3 flats -metric: 20

ENG

B



C

		Dimensions, mm																	
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	H	BD	LF	WF	BAR	NM	KG	PRODFAM	MIID
	09	20	25.0	95°	0°	80.0	33.0	1	A20S-SCLCR/L 09HP	20	18.0	20.0	250.0	13.0	275	3.0	0.55	CoroTurn 107	CCMT 09 T3 08
	09	20	25.0	95°	0°	80.0	30.0	1	A20S-SCLCR/L 09	20	18.0	20.0	250.0	13.0	10	3.0	0.40	CoroTurn 107	CCMT 09 T3 08
	07	20	27.0	93°	27°	80.0	30.0	1	A20S-SDUCR/L 07-EX	20	18.0	20.0	250.0	15.0	10	0.9	0.56	CoroTurn 107	DCMT 07 02 04
	07	20	25.0	107°	17°	80.0	21.2	1	A20S-SDQCR/L 07HP	20	18.0	20.0	250.0	13.0	275	0.9	0.55	CoroTurn 107	DCMT 07 02 04
	07	20	25.0	93°	27°	80.0	22.2	1	A20S-SDUCR 07HP	20	18.0	20.0	250.0	13.0	275	0.9	0.55	CoroTurn 107	DCMT 07 02 04
	11	20	25.0	93°	27°	80.0	30.0	1	A20S-SDUCR/L 11	20	18.0	20.0	250.0	13.0	10	3.0	0.46	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	107°	17°	80.0	30.0	1	A20S-SDQCR/L 11	20	18.0	20.0	250.0	13.0	10	3.0	0.56	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	93°	27°	80.0	22.0	1	A20S-SDUCR/L 11HP	20	18.0	20.0	250.0	13.0	275	3.0	0.55	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	62°	60°	80.0	30.0	1	A20S-SDXCR/L 11	20	18.0	20.0	250.0	13.0	10	3.0	0.56	CoroTurn 107	DCMT 11 T3 08
	11	20	25.0	91°	0°	80.0	30.0	1	A20S-STFCR/L 11	20	18.0	20.0	250.0	13.0	10	0.9	0.53	CoroTurn 107	TCMT 11 02 04

J

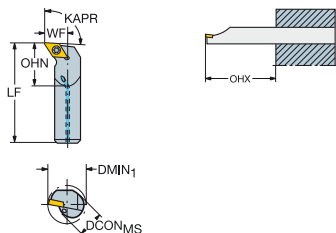
For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Boring bar for turning

Cylindrical shank with 3 flats -metric: 20



		Dimensions, mm										CNC	Ordering code	Dimensions, mm			PRODFAM	MIID	
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	BD	LF	WF	BAR			NM	KG	DCON _{MS}			H
	11	20	25.0	91°	0°	80.0	30.0	1	A20S-STFCR/L 11-B1	20	18.0	20.0	250.0	13.0	10	0.9	0.53	CoroTurn 107	TCMT 11 03 04
	11	20	27.0	107°	35°	80.0	30.0	1	A20S-SVQBR/L 11-E	20	18.0	20.0	250.0	15.0	10	0.9	0.54	CoroTurn 107	VBMT 11 02 04
	11	20	27.0	93°	50°	80.0	30.0	1	A20S-SVUBR/L 11-E	20	18.0	20.0	250.0	15.0	10	0.9	0.54	CoroTurn 107	VBMT 11 02 04
	11	20	27.0	107°	35°	80.0	30.0	1	A20S-SVQBR/L 11-EB1	20	18.0	20.0	250.0	15.0	10	0.9	0.54	CoroTurn 107	VBMT 11 03 04
	11	20	27.0	93°	50°	80.0	30.0	1	A20S-SVUBR/L 11-EB1	20	18.0	20.0	250.0	15.0	10	0.9	0.58	CoroTurn 107	VBMT 11 03 04
	09	20	25.0	95°	0°	80.0	34.6	1	A20S-PCLNR/L09HP	20	18.0	20.0	250.0	13.0	275	2.0	0.55	T-Max P	CNMG 09 03 08
	09	20	25.0	95°	0°	80.0	29.0	1	A20S-PCLNR/L 09	20	18.0	20.0	250.0	13.0	10	2.0	0.53	T-Max P	CNMG 09 03 08
	11	20	28.0	91°	0°	80.0	30.9	1	A20S-PTFNR/L11HP	20	18.0	20.0	250.0	13.0	275	1.2	0.54	T-Max P	TNMG 11 03 04
	11	20	25.0	91°	0°	80.0	30.4	1	A20S-PTFNR/L 11	20	18.0	20.0	250.0	13.0	10	1.2	0.53	T-Max P	TNMG 11 03 04

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



J16



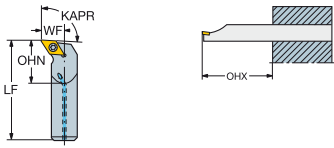
A

Boring bar for turning

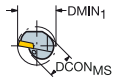
Cylindrical shank without clamping features -metric: 25

With grooves for EasyFix sleeves

B



C



D

E

F

G

												Dimensions, mm							
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	BD	LF	WF	BAR	NM	KG	PRODFAM	MIID	
	09	25	32.0	95°	0°	100.0	32.8	1	A25T-SCLCR/L 09HP-R	25	25.0	300.0	17.0	275	3.0	1.02	CoroTurn 107	CCMT 09 T3 08	
	11	25	32.0	93°	27°	100.0	28.7	1	A25T-SDUCR/L 11HP-R	25	25.0	300.0	17.0	275	3.0	1.03	CoroTurn 107	DCMT 11 T3 08	
	11	25	32.0	107°	17°	100.0	28.0	1	A25T-SDQCR/L 11HP-R	25	25.0	300.0	17.0	275	3.0	1.02	CoroTurn 107	DCMT 11 T3 08	
	16	25	32.0	91°	0°	100.0	31.5	1	A25T-STFCR/L 16HP-R	25	25.0	300.0	17.0	275	3.0	1.04	CoroTurn 107	TCMT 16 T3 08	
	16	25	32.0	117°	30°	100.0	31.4	1	A25T-SVPBR/L 16HP-R	25	25.0	300.0	17.0	275	3.0	1.02	CoroTurn 107	VBMT 16 04 08	
	16	25	33.0	93°	50°	100.0	32.5	1	A25T-SVUBR/L 16HP-DR	25	25.0	300.0	18.0	275	3.0	1.04	CoroTurn 107	VBMT 16 04 08	

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

H

I

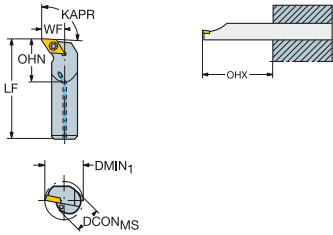
J



ENG

Boring bar for turning

Cylindrical shank with 3 flats -metric: 25



										Dimensions, mm								PRODFAM	MIID
		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	DCON _{MS}	H	BD	LF	WF	BAR	NM	KG		
	09	25	32.0	95°	0°	100.0	32.0	1	A25T-SCLCR/L 09HP	25	23.0	25.0	300.0	17.0	275	3.0	0.95	CoroTurn 107	CCMT 09 T3 08
	11	25	32.0	107°	17°	100.0	27.8	1	A25T-SDQCR/L 11HP	25	23.0	25.0	300.0	17.0	275	3.0	0.94	CoroTurn 107	DCMT 11 T3 08
	11	25	32.0	93°	27°	100.0	28.5	1	A25T-SDUCR/L 11HP	25	23.0	25.0	300.0	17.0	275	3.0	0.95	CoroTurn 107	DCMT 11 T3 08
	16	25	32.0	91°	0°	100.0	31.2	1	A25T-STFCR/L 16HP	25	23.0	25.0	300.0	17.0	275	3.0	0.96	CoroTurn 107	TCMT 16 T3 08
	11	25	33.0	93°	50°	100.0	26.7	1	A25T-SVUBR 11HP-DB1	25	23.0	25.0	300.0	18.0	275	0.9	0.96	CoroTurn 107	VBMT 11 03 04
	16	25	32.0	117°	30°	100.0	31.0	1	A25T-SVPBR/L 16HP	25	23.0	25.0	300.0	17.0	275	3.0	0.94	CoroTurn 107	VBMT 16 04 08
	16	25	33.0	107°	35°	100.0	32.8	1	A25T-SVQBR/L 16HP-D	25	23.0	25.0	300.0	18.0	275	3.0	0.95	CoroTurn 107	VBMT 16 04 08
	16	25	33.0	93°	50°	100.0	33.0	1	A25T-SVUBR/L 16HP-D	25	23.0	25.0	300.0	18.0	275	3.0	0.96	CoroTurn 107	VBMT 16 04 08
	09	25	32.0	95°	0°	100.0	37.5	1	A25T-DCLNR/L 09	25	23.0	25.0	300.0	17.0	10	1.7	0.96	T-Max P	CNMG 09 03 08

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



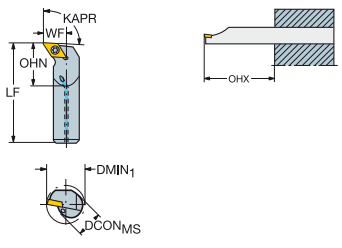
J9



J16

Boring bar for turning

Cylindrical shank with 3 flats -metric: 25



		CZC _{MS}	DMIN ₁	KAPR	RMPX	OHX	OHN	CNSC	Ordering code	Dimensions, mm						PRODFAM	MIID		
										DCON _{MS}	H	BD	LF	WF	BAR			NM	KG
	09	25	32.0	95°	0°	100.0	33.0	1	A25T-PCLNR/L 09	25	23.0	25.0	300.0	17.0	10	2.0	0.95	T-Max P	CNMG 09 03 08
	11	25	32.0	93°	27°	100.0	37.7	1	A25T-PDUNR/L11HP	25	23.0	25.0	300.0	17.0	275	2.0	0.95	T-Max P	DNMG 11 04 08
	11	25	32.0	93°	27°	100.0	37.5	1	A25T-DDUNR/L 11	25	23.0	25.0	300.0	17.0	10	1.7	0.97	T-Max P	DNMG 11 04 08
	11	25	32.0	93°	27°	100.0	39.4	1	A25T-PDUNR/L 11	25	23.0	25.0	300.0	17.0	10	2.0	0.94	T-Max P	DNMG 11 04 08
	11	25	32.0	91°	0°	100.0	30.9	1	A25T-PTFNR/L11HP	25	23.0	25.0	300.0	17.0	275	1.2	0.96	T-Max P	TNMG 11 03 04
	11	25	32.0	91°	0°	100.0	34.4	1	A25T-PTFNR/L 11	25	23.0	25.0	300.0	17.0	10	1.2	0.96	T-Max P	TNMG 11 03 04

For spare parts, visit www.sandvik.coromant.com

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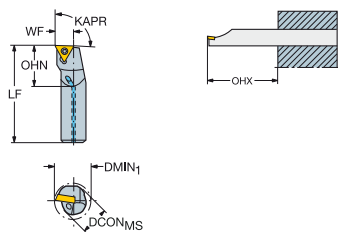
H

I

J



Boring bar for turning

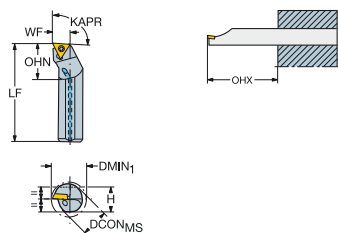


Cylindrical shank without clamping features -inch: 1/4 With grooves for EasyFix sleeves

Image	CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID
								DCON _{MS}	LF	WF	PSI	FT/LBS	LBS		
	06	1/4	.343	0°	91°	.375	A04F-STFCR/L 1.2-R	.250	3.250	.172	145	0.4	0.07	CoroTurn 107	TCMT 1.2(1.2)0
	06	1/4	.343	0°	91°	.625	E04H-STFCR/L 1.2-R	.250	4.000	.172	145	0.4	0.12	CoroTurn 107	TCMT 1.2(1.2)0

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Cylindrical shank with 3 flats -inch: 1/4

Image	CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID	
								DCON _{MS}	H	LF	WF	PSI	FT/LBS			LBS
	06	1/4	.343	0°	91°	.375	A04F-STFCR/L 1.2	.250	.210	3.250	.172	145	0.4	0.06	CoroTurn 107	TCMT 1.2(1.2)0

For spare parts, visit www.sandvik.coromant.com

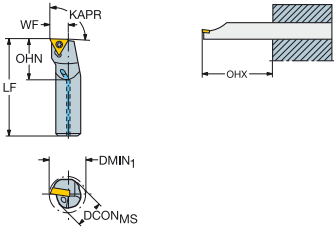
R = Right hand, L = Left hand



Boring bar for turning

Cylindrical shank without clamping features -inch: 5/16

With grooves for EasyFix sleeves



C

		Dimensions, inch														
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	PSI	FT/ LBS	LBS	PRODFAM	MIID
	06	5/16	.413	0°	95°	.781	1	E05K-SCLCR/L 2-R	.313	5.000	.219	145	0.7	0.20	CoroTurn 107	CCMT 2(1.5)1
	06	5/16	.413	0°	91°	.469	1	A05H-STFCR/L 1.2-R	.313	4.000	.219	145	0.4	0.11	CoroTurn 107	TCMT 1.2(1.2)0
	06	5/16	.413	0°	91°	.781	1	E05K-STFCR 1.2-R	.313	5.000	.219	145	0.4	0.20	CoroTurn 107	TCMT 1.2(1.2)0

D

E

Cylindrical shank with 3 flats -inch: 5/16

		Dimensions, inch															
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FT/ LBS	LBS	PRODFAM	MIID
	06	5/16	.413	0°	91°	.469	1	A05H-STFCR 1.2	.313	.272	4.000	.219	145	0.4	0.09	CoroTurn 107	TCMT 1.2(1.2)0

G

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

H

I

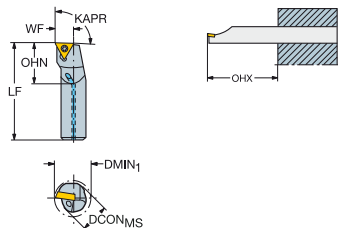
J



Boring bar for turning

Cylindrical shank without clamping features -inch: 3/8

With grooves for EasyFix sleeves



		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID
									DCON _{MS}	LF	WF	PSI	FT/LBS	LBS		
	06	3/8	.480	0°	95°	.563	1	A06M-SCLCR/L 2-R	.375	6.000	.250	145	0.5	0.20	CoroTurn 107	CCMT 2(1.5)1
	06	3/8	.480	0°	95°	.938	1	E06M-SCLCR/L 2-R	.375	6.000	.250	145	0.7	0.30	CoroTurn 107	CCMT 2(1.5)1
	07	3/8	.598	27°	93°	.563	1	A06M-SDUCR 2-R	.375	6.000	.375	145	0.7	0.20	CoroTurn 107	DCMT 2(1.5)1
	07	3/8	.598	17°	107°	.563	1	A06M-SDQCR 2-R	.375	6.000	.375	145	0.7	0.19	CoroTurn 107	DCMT 2(1.5)1
	09	3/8	.500	0°	91°	.563	1	A06M-STFCR 1.8-R	.375	6.000	.266	145	0.7	0.19	CoroTurn 107	TCMT 1.8(1.5)1
	11	3/8	.500	0°	91°	.563	1	A06M-STFCR/L 2-RB1	.375	6.000	.250	145	0.7	0.19	CoroTurn 107	TCMT 221

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A5



J19



J9

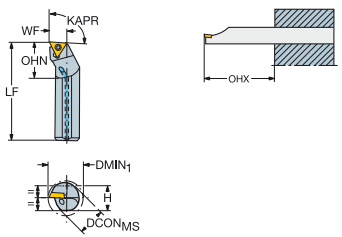


J16



Boring bar for turning

Cylindrical shank with 3 flats -inch: 3/8



C

									Dimensions, inch									
			CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FTZ LBS	LBS	PRODFAM	MIID
	06		3/8	.480	0°	95°	.563	1	A06M-SCLCR/L 2	.375	.336	6.000	.250	145	0.7	0.20	CoroTurn 107	CCMT 2(1.5)1
	07		3/8	.598	27°	93°	.563	1	A06M-SDUCR/L 2	.375	.336	6.000	.375	145	0.7	0.18	CoroTurn 107	DCMT 2(1.5)1
	07		3/8	.598	17°	107°	.563	1	A06M-SDQCR 2	.375	.336	6.000	.375	145	0.7	0.18	CoroTurn 107	DCMT 2(1.5)1
	11		3/8	.500	0°	91°	.563	1	A06M-STFCR/L 2	.375	.336	6.000	.250	145	0.7	0.18	CoroTurn 107	TCMT 2(1.5)1
	11		3/8	.500	0°	91°	.563	1	A06M-STFCR 2-B1	.375	.336	6.000	.250	145	0.7	0.18	CoroTurn 107	TCMT 221
	11		3/8	.500	0°	91°	.938	1	C06M-STFCR/L-2C	.375	.340	6.000	.250	145	0.7	0.28	CoroTurn 107	TCMT 2(1.5)1
	06		3/8	.480	0°	95°	.938	1	E06M-SCLCR/L 2	.375	.359	6.000	.250	145	0.7	0.30	CoroTurn 107	CCMT 2(1.5)1
	07		3/8	.598	27°	93°	.938	1	E06M-SDUCR/L 2	.375	.359	6.000	.375	145	0.7	0.30	CoroTurn 107	DCMT 2(1.5)1
	09		3/8	.500	0°	91°	.938	1	E06M-STFCR/L 1.8	.375	.359	6.000	.264	145	0.7	0.30	CoroTurn 107	TCMT 1.8(1.5)1
	11		3/8	.480	0°	91°	.938	1	E06M-STFCR/L 2-B1	.375	.359	6.000	.250	145	0.7	0.29	CoroTurn 107	TCMT 221

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I

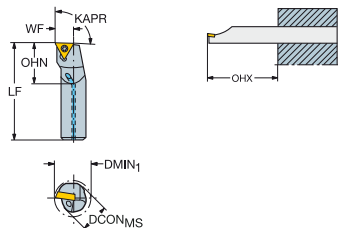
J








Boring bar for turning

Cylindrical shank without clamping features -inch: 1/2

With grooves for EasyFix sleeves



												Dimensions, inch						PRODFAM	MIID
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	PSI	FT/LBS	LBS					
	06	1/2	.598	0°	95°	.750	1	A08M-SCLCR/L 2-R	.500	6.000	.312	145	0.5	0.35	CoroTurn 107	CCMT 2(1.5)1			
	06	1/2	.598	0°	95°	1.250	1	E08R-SCLCR/L 2-R	.500	8.000	.312	145	0.7	0.76	CoroTurn 107	CCMT 2(1.5)1			
	07	1/2	.728	27°	93°	.750	1	A08M-SDUCR 2-R	.500	6.000	.438	145	0.7	0.33	CoroTurn 107	DCMT 2(1.5)1			
	09	1/2	.642	0°	91°	.750	1	A08M-STFCR 1.8-R	.500	6.000	.344	145	0.7	0.33	CoroTurn 107	TCMT 1.8(1.5)1			
	11	1/2	.598	0°	91°	.750	1	A08M-STFCR/L 2-RB1	.500	6.000	.312	145	0.7	0.27	CoroTurn 107	TCMT 221			

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R = Right hand, L = Left hand



A5



J19



J9

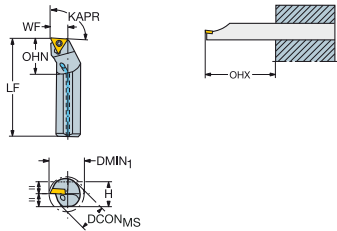


J16



Boring bar for turning

Cylindrical shank with 3 flats -inch: 1/2



C

		Dimensions, inch															
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FT/LBS	LBS	PRODFAM	MIID
	06	1/2	.598	0°	95°	.750	1	A08M-SCLCR/L 2	.500	.460	6.000	.312	145	0.5	0.32	CoroTurn 107	CCMT 2(1.5)1
	07	1/2	.728	27°	93°	.750	1	A08M-SDUCR/L 2	.500	.460	6.000	.438	145	0.7	0.32	CoroTurn 107	DCMT 2(1.5)1
	07	1/2	.728	17°	107°	.750	1	A08M-SDQCR/L 2	.500	.460	6.000	.437	145	0.7	0.32	CoroTurn 107	DCMT 2(1.5)1
	07	1/2	.681	60°	62°	.750	1	A08M-SDXCR/L 2	.500	.460	6.000	.392	145	0.7	0.44	CoroTurn 107	DCMT 2(1.5)1
	09	1/2	.642	0°	91°	.750	1	A08M-STFCR 1.8	.500	.460	6.000	.344	145	0.7	0.32	CoroTurn 107	TCMT 1.8(1.5)1
	11	1/2	.598	0°	91°	.750	1	A08M-STFCR/L 2	.500	.460	6.000	.312	145	0.7	0.32	CoroTurn 107	TCMT 2(1.5)1
	11	1/2	.598	0°	91°	.750	1	A08M-STFCR/L 2-B1	.500	.460	6.000	.312	145	0.7	0.31	CoroTurn 107	TCMT 221
	11	1/2	.624	0°	91°	1.250	1	C08R-STFCR/L-2C	.500	.484	8.000	.312	145	0.7	0.71	CoroTurn 107	TCMT 2(1.5)1
	06	1/2	.598	0°	95°	1.250	1	E08R-SCLCR/L 2	.500	.484	8.000	.312	145	0.7	0.75	CoroTurn 107	CCMT 2(1.5)1
	07	1/2	.717	27°	93°	1.250	1	E08R-SDUCR/L 2	.500	.484	8.000	.438	145	0.7	0.76	CoroTurn 107	DCMT 2(1.5)1
	09	1/2	.630	0°	91°	1.250	1	E08R-STFCR 1.8	.500	.484	8.000	.342	145	0.7	0.76	CoroTurn 107	TCMT 1.8(1.5)1
	11	1/2	.598	0°	91°	1.250	1	E08R-STFCR/L 2-B1	.500	.484	8.000	.312	145	0.7	0.66	CoroTurn 107	TCMT 221

G

H

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

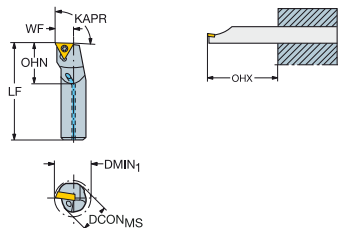
J



Boring bar for turning

Cylindrical shank without clamping features -inch: 5/8

With grooves for EasyFix sleeves



		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID
									DCON _{MS}	LF	WF	PSI	FT/LBS	LBS		
	06	5/8	.772	0°	95°	.938	1	A10R-SCLCR/L 2-R	.625	8.000	.406	145	0.5	0.65	CoroTurn 107	CCMT 2(1.5)1
	06	5/8	.772	0°	95°	1.563	1	E10R-SCLCR/L 2-R	.625	8.000	.406	145	0.7	1.08	CoroTurn 107	CCMT 2(1.5)1
	09	5/8	.772	0°	95°	.938	1	A10R-SCLCR/L 3-R	.625	8.000	.406	145	2.2	0.69	CoroTurn 107	CCMT 3(2.5)2
	09	5/8	.772	0°	95°	1.563	1	E10R-SCLCR/L 3-R	.625	8.000	.406	145	2.2	1.11	CoroTurn 107	CCMT 3(2.5)2
	07	5/8	.850	27°	93°	.938	1	A10R-SDUCR/L 2-R	.625	8.000	.500	145	0.7	0.66	CoroTurn 107	DCMT 2(1.5)1
	07	5/8	.787	5°	117°	.938	1	A10K-SDXCR/L 2-R	.625	4.921	.354	145	0.7	0.39	CoroTurn 107	DCMT 2(1.5)1
	08	5/8	.787	90°		.938	1	A10K-SRDDN 08-R	.625	4.921	.157	145	0.7	0.39	CoroTurn 107	R300-0828..
	11	5/8	.772	0°	91°	.938	1	A10R-STFCR/L 2-RB1	.625	8.000	.406	145	0.7	0.57	CoroTurn 107	TCMT 221

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



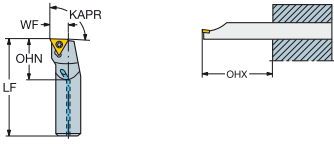
A

Boring bar for turning

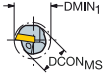
Cylindrical shank without clamping features -inch: 5/8

With grooves for EasyFix sleeves

B



C



		Dimensions, inch															
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	PSI	FT/LBS	LBS	PRODFAM	MIID	
D		11	5/8	.850	50°	93°	.938	1	A10R-SVUBR/L 2-ERB1	.625	8.000	.486	145	0.7	0.66	CoroTurn 107	VBMT 221
		11	5/8	.850	35°	107°	.938	1	A10R-SVQCL 2-ER	.625	8.000	.486	145	0.7	0.62	CoroTurn 107	VCMT 221
		11	5/8	.850	50°	93°	.938	1	A10R-SVUCR 2-ER	.625	8.000	.486	145	0.7	0.57	CoroTurn 107	VCMT 221

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

F

G

H

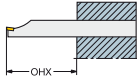
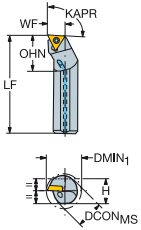
I











J



Boring bar for turning

Cylindrical shank with 3 flats -inch: 5/8



												Dimensions, inch						PRODFAM	MIID
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FT/LBS	LBS				
	11	5/8	.850	50°	93°	.938	1	A10R-SVUBR/L 2-E	.625	.560	8.000	.486	145	0.7	0.62	CoroTurn 107	VBMT 2(1.5)1		
	11	5/8	.850	50°	93°	.938	1	A10R-SVUBR/L 2-EB1	.625	.560	8.000	.486	145	0.7	0.62	CoroTurn 107	VBMT 221		
	11	5/8	.850	35°	107°	.938	1	A10R-SVQCR/L 2-E	.625	.562	8.000	.486	145	0.7	0.61	CoroTurn 107	VCMT 221		
	11	5/8	.850	50°	93°	.938	1	A10R-SVUCR 2-E	.625	.562	8.000	.486	145	0.7	0.62	CoroTurn 107	VCMT 221		
	06	5/8	.772	0°	95°	.938	1	A10R-SCLCR/L 2	.625	.562	8.000	.406	145	0.7	0.62	CoroTurn 107	CCMT 2(1.5)1		
	09	5/8	.772	0°	95°	.938	1	A10R-SCLCR/L 3	.625	.562	8.000	.406	145	2.2	0.65	CoroTurn 107	CCMT 3(2.5)2		
	07	5/8	.850	27°	93°	.938	1	A10R-SDUCR/L 2	.625	.562	8.000	.500	145	0.7	0.66	CoroTurn 107	DCMT 2(1.5)1		
	07	5/8	.850	17°	107°	.938	1	A10R-SDQCR 2	.625	.562	8.000	.500	145	0.7	0.61	CoroTurn 107	DCMT 2(1.5)1		
	07	5/8	.850	60°	62°	.938	1	A10R-SDXCR/L 2	.625	.562	8.000	.486	145	0.7	0.62	CoroTurn 107	DCMT 2(1.5)1		
	11	5/8	.772	0°	91°	.960	1	A10R-STFCR/L 2	.625	.562	8.000	.406	145	0.7	0.60	CoroTurn 107	TCMT 2(1.5)1		
	11	5/8	.772	0°	91°	.960	1	A10R-STFCR/L 2-B1	.625	.562	8.000	.406	145	0.7	0.62	CoroTurn 107	TCMT 221		
	09	5/8	1.063	0°	95°	1.488	1	A10R-PCLNR/L3HP	.625	.591	8.000	.406	3988	1.5	1.32	T-Max P	CNMG 322		

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



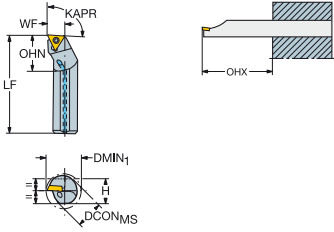
J9



J16

Boring bar for turning

Cylindrical shank with 3 flats -inch: 5/8



C

									Dimensions, inch									
			CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FTZ LBS	LBS	PRODFAM	MIID
	11	5/8	1.063	0°	91°	1.272	1	A10R-PTFNR/L2HP	.625	.591	8.000	.406	3988	0.9	0.62	T-Max P	TNMG 221	
	06	5/8	.772	0°	95°	1.563	1	E10R-SCLCR/L 2	.625	.609	8.000	.406	145	0.7	1.08	CoroTurn 107	CCMT 2(1.5)1	
	07	5/8	.850	27°	93°	1.563	1	E10R-SDUCR/L 2	.625	.609	8.000	.500	145	0.7	1.08	CoroTurn 107	DCMT 2(1.5)1	
	11	5/8	.772	0°	91°	1.112	1	E10R-STFCR/L 2-B1	.625	.609	8.000	.406	145	0.7	1.06	CoroTurn 107	TCMT 221	

D

E

F

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

G

H

I

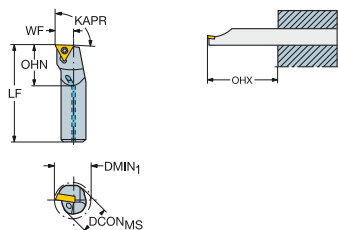
J



Boring bar for turning

Cylindrical shank without clamping features -inch: 3/4

With grooves for EasyFix sleeves



		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID
									DCON _{MS}	LF	WF	PSI	FT/LBS	LBS		
	09	3/4	.929	0°	95°	1.327	1	A12S-SCLCR/L 3HP-R	.750	10.000	.500	3988	2.2	1.18	CoroTurn 107	CCMT 3(2.5)2
	09	3/4	.929	0°	95°	1.125	1	A12S-SCLCR/L 3-R	.750	10.000	.500	145	2.2	1.24	CoroTurn 107	CCMT 3(2.5)2
	09	3/4	.929	0°	95°	1.437	1	E12R-SCLCR/L 3-R	.750	8.752	.500	145	2.2	1.74	CoroTurn 107	CCMT 3(2.5)2
	07	3/4	1.051	27°	93°	1.125	1	A12S-SDUCR/L 2-ERX	.750	10.000	.625	145	0.7	1.25	CoroTurn 107	DCMT 2(1.5)1
	11	3/4	1.039	27°	93°	1.437	1	E12R-SDUCR/L 3-R	.750	8.752	.625	145	2.2	1.81	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	1.051	27°	93°	1.125	1	A12S-SDUCR 3-R	.750	10.000	.625	145	2.2	1.20	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	.984	3°	120°	1.181	1	A12M-SDXCR/L 3-R	.750	5.906	.472	145	2.2	0.68	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	1.051	27°	93°	.929	1	A12S-SDUCR/L 3HP-R	.750	10.000	.625	3988	2.2	1.17	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	.980	17°	107°	.953	1	A12S-SDQCR/L 3HP-R	.750	10.000	.562	3988	2.2	1.21	CoroTurn 107	DCMT 3(2.5)2
	08	3/4	.984	0°		1.181	1	A12M-SRXDR/L 08-R	.750	5.906	.354	145	0.9	0.68	CoroTurn 107	R300-0828..

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



J16



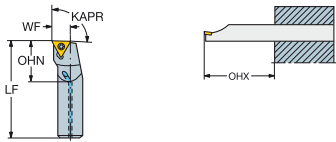
A

Boring bar for turning

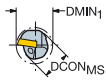
Cylindrical shank without clamping features -inch: 3/4

With grooves for EasyFix sleeves

B



C



D



E



F



		Dimensions, inch														
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	PSI	FT/LBS	LBS	PRODFAM	MIID
		10	3/4	.748	0°	1.181	1	A12M-SRXDR/L 10-R	.750	5.906	.354	145	2.2	0.80	CoroTurn 107	R300-1032..
		11	3/4	.929	0°	91°	1.067	A12S-STFCR/L 2HP-RB1	.750	10.000	.500	3988	0.7	1.21	CoroTurn 107	TCMT 221
		11	3/4	.929	0°	91°	1.437	E12R-STFCR 2-RB1	.750	8.752	.500	145	0.7	1.72	CoroTurn 107	TCMT 221
		11	3/4	1.012	50°	93°	1.125	A12S-SVUBR/L 2-ERB1	.750	10.000	.580	145	0.7	1.19	CoroTurn 107	VBMT 221

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

G

H

I

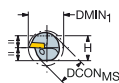
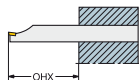
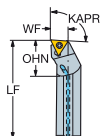
J



ENG

Boring bar for turning

Cylindrical shank with 3 flats -inch: 3/4



		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNCS	Ordering code	Dimensions, inch						PRODFAM	MIID	
									DCON _{MS}	H	LF	WF	PSI	FT/LBS			LBS
	09	3/4	.929	0°	95°	1.280	1	A12S-SCLCR/L 3HP	.750	.709	10.000	.500	3988	2.2	1.15	CoroTurn 107	CCMT 3(2.5)2
	09	3/4	.929	0°	95°	1.125	1	A12S-SCLCR/L 3	.750	.709	10.000	.500	145	2.2	1.26	CoroTurn 107	CCMT 3(2.5)2
	07	3/4	1.051	27°	93°	1.125	1	A12S-SDUCR/L 2-EX	.750	.709	10.000	.625	145	0.7	0.93	CoroTurn 107	DCMT 2(1.5)1
	07	3/4	.980	17°	107°	.783	1	A12S-SDQCR/L 2HP	.750	.709	10.000	.562	3988	0.7	1.21	CoroTurn 107	DCMT 2(1.5)1
	07	3/4	1.051	27°	93°	.799	1	A12S-SDUCR/L 2HP	.750	.709	10.000	.625	3988	0.7	1.21	CoroTurn 107	DCMT 2(1.5)1
	11	3/4	1.051	27°	93°	1.125	1	A12S-SDUCR/L 3	.750	.709	10.000	.625	145	2.2	1.18	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	.980	17°	107°	1.125	1	A12S-SDQCR/L 3	.750	.709	10.000	.562	145	2.2	1.01	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	1.051	27°	93°	.917	1	A12S-SDUCR/L 3HP	.750	.709	10.000	.625	3988	2.2	1.21	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	1.012	60°	62°	1.125	1	A12S-SDXCR/L 3	.750	.709	10.000	.580	145	2.2	1.18	CoroTurn 107	DCMT 3(2.5)2

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9

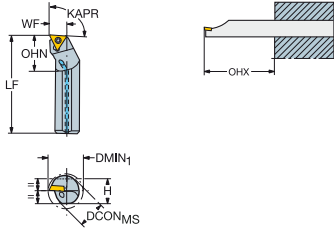


J16



Boring bar for turning

Cylindrical shank with 3 flats -inch: 3/4



C

									Dimensions, inch								
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FTZ LBS	LBS	PRODFAM	MIID
	11	3/4	.929	0°	91°	1.420	1	A12S-STFCR/L 2	.750	.709	10.000	.500	145	0.7	1.14	CoroTurn 107	TCMT 2(1.5)1
	11	3/4	.929	0°	91°	1.420	1	A12S-STFCR/L 2-B1	.750	.709	10.000	.500	145	0.7	1.13	CoroTurn 107	TCMT 221
	09	3/4	1.000	0°	95°	1.125	1	A12S-DCLNR/L 3	.750	.709	10.000	.500	145	1.3	1.16	T-Max P	CNMG 322
	09	3/4	1.000	0°	95°	1.362	1	A12S-PCLNR/L3HP	.750	.709	10.000	.500	3988	1.5	1.10	T-Max P	CNMG 322
	11	3/4	1.201	27°	93°	1.125	1	A12S-DDUNR/L 3	.750	.709	10.000	.625	145	1.3	1.19	T-Max P	DNMG 332
	11	3/4	1.063	0°	91°	1.217	1	A12S-PTFNR/L2HP	.750	.709	10.000	.500	3988	0.9	1.10	T-Max P	TNMG 221
	11	3/4	1.012	50°	93°	1.180	1	A12S-SVUBR/L 2-E	.750	.710	10.000	.580	145	0.7	1.16	CoroTurn 107	VBMT 2(1.5)1
	11	3/4	1.012	50°	93°	.906	1	A12S-SVUBR/L 2HP-EB1	.750	.710	10.000	.580	3988	0.7	1.06	CoroTurn 107	VBMT 221
	11	3/4	1.012	50°	93°	1.180	1	A12S-SVUBR/L 2-EB1	.750	.710	10.000	.580	145	0.7	0.88	CoroTurn 107	VBMT 221
	09	3/4	.929	0°	95°	1.875	1	E12S-SCLCR/L 3	.750	.734	10.000	.500	145	2.2	1.98	CoroTurn 107	CCMT 3(2.5)2

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For spare parts, visit www.sandvik.coromant.com

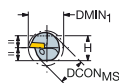
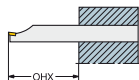
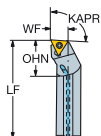
R = Right hand, L = Left hand





J



Boring bar for turning

Cylindrical shank with 3 flats -inch: 3/4



									Dimensions, inch							PRODFAM	MIID
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FT/LBS	LBS		
	11	3/4	1.039	27°	93°	1.875	1	E12S-SDUCR/L 3	.750	.734	10.000	.625	145	2.2	1.98	CoroTurn 107	DCMT 3(2.5)2
	11	3/4	1.000	0°	91°	1.875	1	C12S-STFCR-2C	.750	.734	10.000	.500	145	0.7	1.90	CoroTurn 107	TCMT 2(1.5)1
	11	3/4	.929	0°	91°	1.624	1	E12S-STFCR/L 2-B1	.750	.734	10.000	.500	145	0.7	1.81	CoroTurn 107	TCMT 221

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9



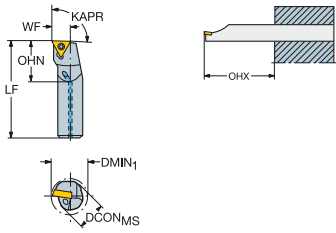
J16



Boring bar for turning

Cylindrical shank without clamping features -inch: 1

With grooves for EasyFix sleeves



C

									Dimensions, inch							
			DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	PSI	FT/LBS	LBS	PRODFAM	MIID
	09	1	1.201	0°	95°	1.291	1	A16T-SCLCR/L 3HP-R	1.000	12.000	.640	3988	2.2	2.37	CoroTurn 107	CCMT 3(2.5)2
	09	1	1.201	0°	95°	1.547	1	E16S-SCLCR 3-R	1.000	10.752	.640	145	2.2	3.66	CoroTurn 107	CCMT 3(2.5)2
	12	1	1.201	0°	95°	1.496	1	A16T-SCLCR 4HP-R	1.000	12.000	.640	3988	2.2	1.98	CoroTurn 107	CCMT 432
	11	1	1.299	27°	93°	.984	1	A16T-SDUCR/L 3HP-R	1.000	12.000	.750	3988	2.2	1.98	CoroTurn 107	DCMT 3(2.5)2
	16	1	1.201	0°	91°	1.228	1	A16T-STFCR/L 3HP-R	1.000	12.000	.640	3988	2.2	1.98	CoroTurn 107	TCMT 3(2.5)2
	11	1	1.240	50°	93°	.965	1	A16T-SVUBR/L 2HP-DRB1	1.000	12.000	.680	3988	0.7	4.19	CoroTurn 107	VBMT 221
	16	1	1.299	30°	117°	1.287	1	A16T-SVPBR/L 3HP-R	1.000	12.000	.750	3988	2.2	1.98	CoroTurn 107	VBMT 332

For spare parts, visit www.sandvik.coromant.com

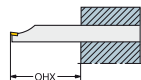
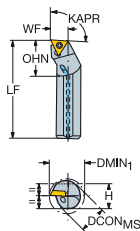
R = Right hand, L = Left hand

J



Boring bar for turning

Cylindrical shank with 3 flats -inch: 1



		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNCS	Ordering code	Dimensions, inch						PRODFAM	MIID	
									DCON _{MS}	H	LF	WF	PSI	FT/LBS			LBS
	09	1	1.201	0°	95°	1.500	1	A16T-DCLNR/L 3	1.000	.906	12.000	.640	145	1.3	2.29	T-Max P	CNMG 322
	11	1	1.252	27°	93°	1.488	1	A16T-PDUNR/L3HP	1.000	.906	12.000	.700	3988	1.5	2.25	T-Max P	DNMG 332
	11	1	1.299	27°	93°	1.500	1	A16T-DDUNR/L 3	1.000	.906	12.000	.750	145	1.3	2.31	T-Max P	DNMG 332
	11	1	1.201	0°	91°	1.217	1	A16T-PTFNR/L2HP	1.000	.906	12.000	.640	3988	0.9	2.43	T-Max P	TNMG 221
	09	1	1.201	0°	95°	1.272	1	A16T-SCLCR/L 3HP	1.000	.906	12.000	.640	3988	2.2	2.27	CoroTurn 107	CCMT 3(2.5)2
	09	1	1.201	0°	95°	1.500	1	A16T-SCLCR/L 3	1.000	.906	12.000	.640	145	2.2	2.25	CoroTurn 107	CCMT 3(2.5)2
	12	1	1.201	0°	95°	1.500	1	A16T-SCLCR/L 4	1.000	.906	12.000	.640	145	2.2	0.00	CoroTurn 107	CCMT 432
	07	1	1.299	27°	93°	1.500	1	A16T-SDUCR/L 2-DX	1.000	.906	12.000	.750	145	0.7	2.25	CoroTurn 107	DCMT 2(1.5)1
	11	1	1.299	27°	93°	1.500	1	A16T-SDUCR/L 3	1.000	.906	12.000	.750	145	2.2	2.27	CoroTurn 107	DCMT 3(2.5)2
	11	1	1.299	17°	107°	1.500	1	A16T-SDQCR/L 3	1.000	.906	12.000	.750	145	2.2	2.26	CoroTurn 107	DCMT 3(2.5)2

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



A5



J19



J9

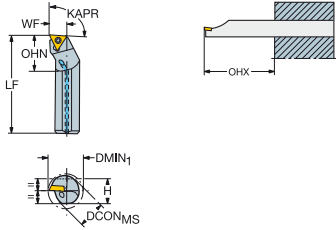


J16



Boring bar for turning

Cylindrical shank with 3 flats -inch: 1



C

									Dimensions, inch									
			CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FTZ LBS	LBS	PRODFAM	MIID
	11	1	1.299	27°	93°	1.000	1	A16T-SDUCR/L 3HP	1.000	.906	12.000	.750	3988	2.2	2.30	CoroTurn 107	DCMT 3(2.5)2	
	11	1	1.280	60°	62°	1.500	1	A16T-SDXCR/L 3	1.000	.906	12.000	.720	145	2.2	2.30	CoroTurn 107	DCMT 3(2.5)2	
	16	1	1.201	0°	91°	1.209	1	A16T-STFCR/L 3HP	1.000	.906	12.000	.640	3988	2.2	2.28	CoroTurn 107	TCMT 3(2.5)2	
	16	1	1.201	0°	91°	1.500	1	A16T-STFCR/L 3	1.000	.906	12.000	.640	145	2.2	2.26	CoroTurn 107	TCMT 3(2.5)2	
	16	1	1.299	35°	107°	1.500	1	A16T-SVQBR/L 3-D	1.000	.906	12.000	.750	145	2.2	2.27	CoroTurn 107	VBMT 332	
	16	1	1.299	25°	117°	1.500	1	A16T-SVPBR/L 3	1.000	.906	12.000	.750	145	2.2	2.27	CoroTurn 107	VBMT 332	
	16	1	1.299	30°	117°	1.276	1	A16T-SVPBR/L 3HP	1.000	.906	12.000	.750	3988	2.2	2.24	CoroTurn 107	VBMT 332	
	11	1	1.240	50°	93°	1.500	1	A16T-SVUBR/L 2-D	1.000	.910	12.000	.680	145	0.7	2.27	CoroTurn 107	VBMT 2(1.5)1	
	11	1	1.240	50°	93°	.980	1	A16T-SVUBR/L 2HP-DB1	1.000	.910	12.000	.680	3988	0.7	2.29	CoroTurn 107	VBMT 221	

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For spare parts, visit www.sandvik.coromant.com

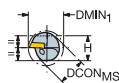
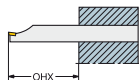
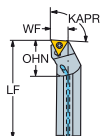
R = Right hand, L = Left hand

J



Boring bar for turning

Cylindrical shank with 3 flats -inch: 1



B

C

								Ordering code	Dimensions, inch						PRODFAM	MIID	
		CZC _{MS}	DMIN ₁	RMPX	KAPR	OHN	CNSC		DCON _{MS}	H	LF	WF	PSI	FT/ LBS			LBS
	11	1	1.240	50°	93°	1.500	1	A16T-SVUBR/L 2-DB1	1.000	.910	12.000	.680	145	0.7	2.12	CoroTurn 107	VBMT 221
	09	1	1.201	0°	95°	2.500	1	E16T-SCLCR/L 3	1.000	.984	12.000	.640	145	2.2	3.86	CoroTurn 107	CCMT 3(2.5)2
	11	1	1.299	27°	93°	2.500	1	E16T-SDUCR/L 3	1.000	.984	12.000	.750	145	2.2	3.66	CoroTurn 107	DCMT 3(2.5)2
	16	1	1.201	0°	91°	2.500	1	E16T-STFCR/L 3	1.000	.984	12.000	.640	145	2.2	3.62	CoroTurn 107	TCMT 3(2.5)2

D

E

F

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

G

H

I

J



A

CoroTurn® XS

B

Internal turning, face grooving and threading of small components

C

High quality holes

This precision ground tool is perfect when producing small holes with high quality. The large variety of adaptors fit most types of sliding head machines.

The tools are designed for exact insert location which enables high precision and repeatability.

ISO application area:



D

Application

- Internal turning
- Copying
- Backboring
- Profiling
- Grooving
- Face grooving
- Pre-parting
- Threading

E

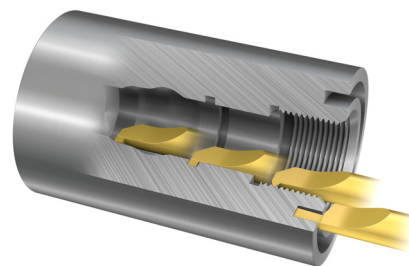
Benefits and features

- High precision
- Close tolerances
- Good accessibility when changing inserts
- Wide variety of insert widths
- Sharp cutting edges
- All inserts fit into the same tool holder
- High quality ground inserts and holders
- Full profile inserts for high quality threads in one operation
- Designed to maintain the tool holder intact in case of insert breakage.
- Available with precision coolant

F

G

www.sandvik.coromant.com/coroturnxs



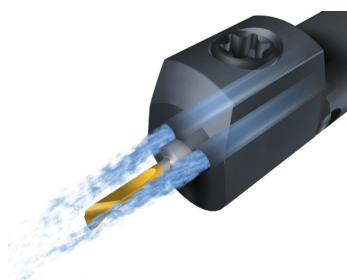
The inserts with A-geometry are optimized for preventing chip jamming in small holes



H

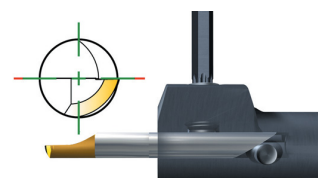
Internal coolant

- The adaptors are designed with internal precision coolant supply.
- Selectable coolant direction for better chip evacuation and safe machining



Locking precision

Precise location into the boring bar due to a locating pin.



I

J

CoroCut® MB

For internal machining and face grooving

Internal machining with high precision

The sharp cutting edges of CoroCut MB are perfect for internal machining with high quality demands at low feed and speed. The system is easy to index for fast set-up of both tools and inserts, keeping the machine down-time to a minimum. For long overhangs steel shanks and carbide shanks are available for up to 5.5 × bar diameter.

ISO application area:



Application

- For internal machining of small holes
- Pre-parting
- Grooving
- Face grooving
- Profiling
- Turning
- Copying
- Back boring
- Threading

Benefits and features

- Vibration free machining
- Fast set up for both tool and insert
- Stable high precision interface between interface and tool holder
- Front-mounted exchangeable cutting tool
- Sharp cutting edges
- Geometries and grades for all materials
- Carbide shanks for long overhangs
- Through coolant
- Easy fix clamping
- Grooving tools in a large variety of widths and corner radii – also for standardized grooves such as O-rings and circlip grooves.

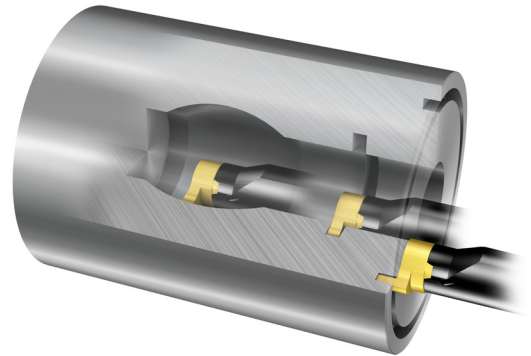
www.sandvik.coromant.com/corocutmb

EasyFix

Cylindrical steel and carbide boring bars to be used with EasyFix sleeves for exact centre height.

CoroCut® MB boring bars

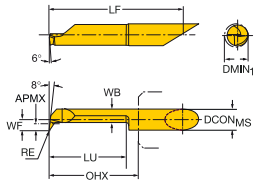
For stability and accessibility the bars are designed with an eccentric head with oval cross section.



Solid carbide tool for turning

CoroTurn XS -metric: 4

TSYC CXS-xxT098..R/L



C

CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHK	Ordering code	P M N S H O						Dimensions, mm, inch				PRODFAM						
									P		M		N		S		H			O		DCON _{MS}	WB	LF	WF
									1025	H10F	1025	H10F	1025	H10F	1025	7015	1025	H10F							
4	0.3	0.00	1.2	0.1	98°	17°	13.0	CXS-04T098-00-0301R/L	★	★	★	★	★	★	★	★	4	0.2	27.3	0.1	CoroTurn XS				
	.012	.000	.047	.002	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.007	1.073	.004	CoroTurn XS				
4	0.4	0.00	1.6	0.1	98°	17°	13.0	CXS-04T098-00-0401R/L	★	★	★	★	★	★	★	★	4	0.3	27.3	0.2	CoroTurn XS				
	.016	.000	.063	.003	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.011	1.073	.006	CoroTurn XS				
4	0.5	0.00	2.0	0.1	98°	17°	13.0	CXS-04T098-00-0502R/L	★	★	★	★	★	★	★	★	4	0.4	27.3	0.2	CoroTurn XS				
	.020	.000	.079	.003	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.015	1.073	.008	CoroTurn XS				
4	0.6	0.00	2.5	0.1	98°	17°	13.0	CXS-04T098-00-0602R/L	★	★	★	★	★	★	★	★	4	0.5	27.3	0.3	CoroTurn XS				
	.024	.000	.098	.004	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.018	1.073	.010	CoroTurn XS				
4	0.7	0.00	3.5	0.1	98°	17°	13.0	CXS-04T098-00-0703R/L	★	★	★	★	★	★	★	★	4	0.6	27.3	0.3	CoroTurn XS				
	.028	.000	.138	.004	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.022	1.073	.012	CoroTurn XS				
4	0.8	0.00	4.0	0.1	98°	17°	13.0	CXS-04T098-00-0804R/L	★	★	★	★	★	★	★	★	4	0.6	27.3	0.4	CoroTurn XS				
	.031	.000	.157	.004	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.025	1.073	.014	CoroTurn XS				
4	0.9	0.00	5.0	0.1	98°	17°	13.0	CXS-04T098-00-0905R/L	★	★	★	★	★	★	★	★	4	0.7	27.3	0.4	CoroTurn XS				
	.035	.000	.197	.004	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.029	1.073	.016	CoroTurn XS				
4	2.7	0.03	10.0	0.2	98°	17°	13.0	CXS-04T098-03-2710R/L	★	★	★	★	★	★	★	★	4	2.1	27.3	1.2	CoroTurn XS				
	.106	.001	.394	.008	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.081	1.073	.047	CoroTurn XS				
4	3.2	0.03	10.0	0.2	98°	17°	13.0	CXS-04T098-03-3210R/L	★	★	★	★	★	★	★	★	4	2.6	27.3	1.5	CoroTurn XS				
	.126	.001	.394	.008	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.100	1.073	.057	CoroTurn XS				
4	4.2	0.03	10.0	0.3	98°	17°	13.0	CXS-04T098-03-4210R/L	★	★	★	★	★	★	★	★	4	3.5	27.3	2.0	CoroTurn XS				
	.165	.001	.394	.012	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.136	1.073	.077	CoroTurn XS				
4	1.0	0.05	4.0	0.1	98°	17°	12.0	CXS-04T098-05-1004R/L	★	★	★	★	★	★	★	★	4	0.7	26.3	0.5	CoroTurn XS				
	.039	.002	.157	.004	98°	17°	.472		★	★	★	★	★	★	★	★	.157	.026	1.033	.018	CoroTurn XS				
4	1.0	0.05	6.0	0.1	98°	17°	12.0	CXS-04T098-05-1006R/L	★	★	★	★	★	★	★	★	4	0.7	26.3	0.5	CoroTurn XS				
	.039	.002	.236	.004	98°	17°	.472		★	★	★	★	★	★	★	★	.157	.026	1.033	.018	CoroTurn XS				
4	1.7	0.05	6.0	0.2	98°	17°	12.0	CXS-04T098-05-1706R/L	★	★	★	★	★	★	★	★	4	1.1	26.3	0.7	CoroTurn XS				
	.067	.002	.236	.008	98°	17°	.472		★	★	★	★	★	★	★	★	.157	.041	1.033	.028	CoroTurn XS				
4	1.7	0.05	9.0	0.2	98°	17°	12.0	CXS-04T098-05-1709R/L	★	★	★	★	★	★	★	★	4	1.1	26.3	0.7	CoroTurn XS				
	.067	.002	.354	.008	98°	17°	.472		★	★	★	★	★	★	★	★	.157	.041	1.033	.028	CoroTurn XS				
4	2.2	0.05	6.0	0.2	98°	17°	12.0	CXS-04T098-05-2206R/L	★	★	★	★	★	★	★	★	4	1.6	26.3	1.0	CoroTurn XS				
	.087	.002	.236	.008	98°	17°	.472		★	★	★	★	★	★	★	★	.157	.061	1.033	.037	CoroTurn XS				
4	2.2	0.05	9.0	0.2	98°	17°	12.0	CXS-04T098-05-2209R/L	★	★	★	★	★	★	★	★	4	1.6	26.3	1.0	CoroTurn XS				
	.087	.002	.354	.008	98°	17°	.472		★	★	★	★	★	★	★	★	.157	.061	1.033	.037	CoroTurn XS				
4	2.7	0.05	10.0	0.2	98°	17°	13.0	CXS-04T098-05-2710R/L	★	★	★	★	★	★	★	★	4	2.1	27.3	1.2	CoroTurn XS				
	.106	.002	.394	.008	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.081	1.073	.047	CoroTurn XS				
4	2.7	0.05	15.0	0.2	98°	17°	18.0	CXS-04T098-05-2715R/L	★	★	★	★	★	★	★	★	4	2.1	32.3	1.2	CoroTurn XS				
	.106	.002	.591	.008	98°	17°	.709		★	★	★	★	★	★	★	★	.157	.081	1.270	.047	CoroTurn XS				
4	3.2	0.05	15.0	0.2	98°	17°	18.0	CXS-04T098-05-3215R/L	★	★	★	★	★	★	★	★	4	2.6	32.3	1.5	CoroTurn XS				
	.126	.002	.591	.008	98°	17°	.709		★	★	★	★	★	★	★	★	.157	.100	1.270	.057	CoroTurn XS				
4	3.2	0.05	20.0	0.2	98°	17°	23.0	CXS-04T098-05-3220R/L	★	★	★	★	★	★	★	★	4	2.6	37.3	1.5	CoroTurn XS				
	.126	.002	.787	.008	98°	17°	.906		★	★	★	★	★	★	★	★	.157	.100	1.467	.057	CoroTurn XS				
4	4.2	0.05	15.0	0.3	98°	17°	18.0	CXS-04T098-05-4215R/L	★	★	★	★	★	★	★	★	4	3.5	32.3	2.0	CoroTurn XS				
	.165	.002	.591	.012	98°	17°	.709		★	★	★	★	★	★	★	★	.157	.136	1.270	.077	CoroTurn XS				
4	4.2	0.05	20.0	0.3	98°	17°	23.0	CXS-04T098-05-4220R/L	★	★	★	★	★	★	★	★	4	3.5	37.3	2.0	CoroTurn XS				
	.165	.002	.787	.012	98°	17°	.906		★	★	★	★	★	★	★	★	.157	.136	1.467	.077	CoroTurn XS				
4	4.2	0.05	25.0	0.3	98°	17°	28.0	CXS-04T098-05-4225R/L	★	★	★	★	★	★	★	★	4	3.5	42.3	2.0	CoroTurn XS				
	.165	.002	.984	.012	98°	17°	1.102		★	★	★	★	★	★	★	★	.157	.136	1.663	.077	CoroTurn XS				
4	1.0	0.10	4.0	0.1	98°	17°	13.0	CXS-04T098-10-1004R/L	★	★	★	★	★	★	★	★	4	0.7	27.3	0.5	CoroTurn XS				
	.039	.004	.157	.004	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.026	1.073	.018	CoroTurn XS				
4	1.0	0.10	6.0	0.1	98°	17°	13.0	CXS-04T098-10-1006R/L	★	★	★	★	★	★	★	★	4	0.7	27.3	0.5	CoroTurn XS				
	.039	.004	.236	.004	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.026	1.073	.018	CoroTurn XS				
4	1.7	0.10	6.0	0.2	98°	17°	13.0	CXS-04T098-10-1706R	★	★	★	★	★	★	★	★	4	1.1	27.3	0.7	CoroTurn XS				
	.067	.004	.236	.008	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.041	1.073	.028	CoroTurn XS				
4	1.7	0.10	6.0	0.2	98°	17°	13.0	CXS-04T098-10-1706R/L	★	★	★	★	★	★	★	★	4	1.1	27.3	0.7	CoroTurn XS				
	.067	.004	.236	.008	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.041	1.073	.028	CoroTurn XS				
4	1.7	0.10	9.0	0.2	98°	17°	13.0	CXS-04T098-10-1709R/L	★	★	★	★	★	★	★	★	4	1.1	27.3	0.7	CoroTurn XS				
	.067	.004	.354	.008	98°	17°	.512		★	★	★	★	★	★	★	★	.157	.041	1.073	.028	CoroTurn XS				

R = Right hand, L = Left hand

J



D2



A106



B109



J19



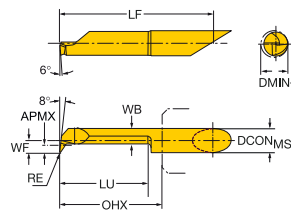
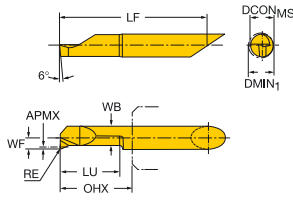
J9

Solid carbide tool for turning

CoroTurn XS -metric: 4

TSYC CXS-xxT090..R/L

CXS-xxT098..R/L



CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHX	Ordering code	Dimensions, mm, inch										PRODFAM								
									P		M		N		S		H			O							
									1025	1025	1025	1025	1025	1025	1025	1025	1025	1025		1025	1025						
4	2.2	0.10	6.0	0.2	98°	17°	13.0	CXS-04T098-10-2206R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	4	1.6	27.3	1.0	CoroTurn XS	
	.087	.004	.236	.008	98°	17°	.512	CXS-04T098-10-2209R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.061	1.073	.037	CoroTurn XS
4	2.2	0.10	9.0	0.2	98°	17°	13.0	CXS-04T098-10-2209R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	1.6	27.3	1.0	CoroTurn XS
	.087	.004	.354	.008	98°	17°	.512	CXS-04T098-10-2213R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.061	1.073	.037	CoroTurn XS
4	2.2	0.10	13.0	0.2	98°	17°	18.0	CXS-04T098-10-2213R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	1.6	32.3	1.0	CoroTurn XS
	.087	.004	.512	.008	98°	17°	.709	CXS-04T098-15-2710R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.061	1.270	.037	CoroTurn XS
4	2.7	0.15	10.0	0.2	98°	17°	13.0	CXS-04T098-15-2710R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.1	27.3	1.2	CoroTurn XS
	.106	.006	.394	.008	98°	17°	.512	CXS-04T098-15-2710R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.081	1.073	.047	CoroTurn XS
4	2.7	0.15	10.0	0.2	98°	17°	13.0	CXS-04T098-15-2710R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.1	27.3	1.2	CoroTurn XS
	.106	.006	.394	.008	98°	17°	.512	CXS-04T098-15-2715R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.081	1.073	.047	CoroTurn XS
4	2.7	0.15	15.0	0.2	98°	17°	18.0	CXS-04T098-15-2715R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.1	32.3	1.2	CoroTurn XS
	.106	.006	.591	.008	98°	17°	.709	CXS-04T098-15-3210R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.081	1.270	.057	CoroTurn XS
4	3.2	0.15	10.0	0.2	98°	17°	13.0	CXS-04T098-15-3210R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.6	27.3	1.4	CoroTurn XS
	.126	.006	.394	.008	98°	17°	.512	CXS-04T098-15-3210R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.100	1.073	.057	CoroTurn XS
4	3.2	0.15	10.0	0.2	98°	17°	13.0	CXS-04T098-15-3210R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.6	27.3	1.5	CoroTurn XS
	.126	.006	.394	.008	98°	17°	.512	CXS-04T098-15-3215R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.100	1.073	.057	CoroTurn XS
4	3.2	0.15	15.0	0.2	98°	17°	18.0	CXS-04T098-15-3215R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.6	32.3	1.5	CoroTurn XS
	.126	.006	.591	.008	98°	17°	.709	CXS-04T098-15-3215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.100	1.270	.057	CoroTurn XS
4	3.2	0.15	15.0	0.2	98°	17°	18.0	CXS-04T098-15-3215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.6	32.3	1.5	CoroTurn XS
	.126	.006	.591	.008	98°	17°	.709	CXS-04T098-15-3220R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.100	1.270	.057	CoroTurn XS
4	4.2	0.15	10.0	0.3	98°	17°	13.0	CXS-04T098-15-4210R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	27.3	2.0	CoroTurn XS
	.165	.006	.394	.012	98°	17°	.512	CXS-04T098-15-4210R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.073	.077	CoroTurn XS
4	4.2	0.15	10.0	0.3	98°	17°	13.0	CXS-04T098-15-4210R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	27.3	2.0	CoroTurn XS
	.165	.006	.394	.012	98°	17°	.512	CXS-04T098-15-4215R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.073	.077	CoroTurn XS
4	4.2	0.15	15.0	0.3	98°	17°	18.0	CXS-04T098-15-4215R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	32.3	2.0	CoroTurn XS
	.165	.006	.591	.012	98°	17°	.709	CXS-04T098-15-4215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.270	.077	CoroTurn XS
4	4.2	0.15	15.0	0.3	98°	17°	18.0	CXS-04T098-15-4215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	32.3	2.0	CoroTurn XS
	.165	.006	.591	.012	98°	17°	.709	CXS-04T098-15-4220R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.270	.077	CoroTurn XS
4	4.2	0.15	20.0	0.3	98°	17°	23.0	CXS-04T098-15-4220R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	37.3	2.0	CoroTurn XS
	.165	.006	.787	.012	98°	17°	.906	CXS-04T098-15-4220R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.467	.077	CoroTurn XS
4	4.2	0.15	20.0	0.3	98°	17°	23.0	CXS-04T098-15-4220R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	37.3	2.0	CoroTurn XS
	.165	.006	.787	.012	98°	17°	.906	CXS-04T098-15-4225R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.467	.077	CoroTurn XS
4	4.2	0.15	25.0	0.3	98°	17°	28.0	CXS-04T098-15-4225R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	42.3	2.0	CoroTurn XS
	.165	.006	.984	.012	98°	17°	1.102	CXS-04T098-15-4225R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.663	.077	CoroTurn XS
4	4.2	0.15	25.0	0.3	98°	17°	28.0	CXS-04T098-15-4225R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	42.3	2.0	CoroTurn XS
	.165	.006	.984	.012	98°	17°	1.102	CXS-04T098A08-4230R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.663	.077	CoroTurn XS
4	4.2	0.08	30.0	0.5	98°	2°	38.0	CXS-04T098A08-4230R	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.6	52.3	2.0	CoroTurn XS
	.165	.003	1.181	.020	98°	2°	1.496	CXS-04T098A15-4210R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.140	2.057	.077	CoroTurn XS
4	4.2	0.15	10.2	0.5	98°	0°	13.0	CXS-04T098A15-4210R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.8	27.3	2.0	CoroTurn XS
	.165	.006	.402	.020	98°	0°	.512	CXS-04T098A15-4220R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.150	1.073	.077	CoroTurn XS
4	4.2	0.15	20.3	0.5	98°	0°	23.0	CXS-04T098A15-4220R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.8	37.3	2.0	CoroTurn XS
	.165	.006	.799	.020	98°	0°	.906	CXS-04T098A15-4225R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.150	1.467	.077	CoroTurn XS
4	4.2	0.15	25.3	0.5	98°	0°	28.0	CXS-04T098A15-4225R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.8	42.3	2.0	CoroTurn XS
	.165	.006	.996	.020	98°	0°	1.102	CXS-04T098A20-4215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.150	1.663	.077	CoroTurn XS
4	4.2	0.15	15.3	0.3	98°	0°	18.0	CXS-04T098A20-4215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.1	32.3	2.0	CoroTurn XS
	.165	.006	.602	.012	98°	0°	.709	CXS-04T090-15-3212R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.120	1.270	.077	CoroTurn XS
4	3.2	0.15	12.0	0.2	90°	17°	15.0	CXS-04T090-15-3212R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	2.6	29.3	1.5	CoroTurn XS
	.126	.006	.472	.008	90°	17°	.591	CXS-04T090-15-4215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.100	1.152	.057	CoroTurn XS
4	4.2	0.15	15.0	0.3	90°	17°	18.0	CXS-04T090-15-4215R/L	*	*	*	*	*	*	*	*	*	*	*	*	*	*	4	3.5	32.3	2.0	CoroTurn XS
	.165	.006	.591	.012	90°	17°	.709		*	*	*	*	*	*	*	*	*	*	*	*	*	*	.157	.136	1.270	.077	CoroTurn XS

R = Right hand, L = Left hand



D2



A106



B109



J19



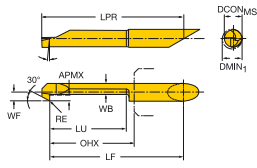
J9



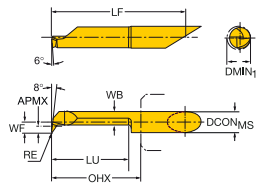
Solid carbide tool for turning

CoroTurn XS -metric: 4

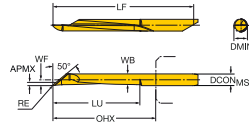
TSYC CXS-xxB090..R/L



CXS-xxT098..R/L (ISO)
CXS-xxTE98..R/L



CXS-xxT140..R/L



	CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHX	Ordering code	Material									Dimensions, mm, inch				PRODFAM		
										P	M	N	S	H	O	1025	1025	H10F	1025	H10F	1025	H10F		7015	1025
	4	3.7	0.15	15.0	0.2	98°	17°	18.0	CXS-04T098-15-3715R							*					4	3.1	32.3	1.7	CoroTurn XS
		.146	.006	.591	.008	98°	17°	.709								*					.157	.120	1.270	.067	CoroTurn XS
	4	4.2	0.15	20.0	0.8	98°	44°	23.0	CXS-04TE98-15-4220R		*		*	*			*			4	3.0	37.3	2.0	CoroTurn XS	
		.165	.006	.787	.031	98°	44°	.906			*	*	*	*	*		*			.157	.116	1.467	.077	CoroTurn XS	
	4	4.2	0.15	20.0	0.8	98°	44°	23.0	CXS-04TE98-15-4220R/L	*	*		*	*		*			4	3.0	37.3	2.0	CoroTurn XS		
		.165	.006	.787	.031	98°	44°	.906		*	*		*	*		*			.157	.116	1.467	.077	CoroTurn XS		
	4	4.2	0.15	23.4	0.8	92°	27°	26.0	CXS-04B090-15-4225R	*	*		*	*		*			4	2.6	40.3	2.0	CoroTurn XS		
		.165	.006	.921	.031	92°	27°	1.024		*	*		*	*		*			.157	.102	1.585	.077	CoroTurn XS		
	4	4.2	0.05	30.0	0.1	140°	2°	38.0	CXS-04T140A05-4230R	*	*		*	*		*			4	3.6	52.3	2.0	CoroTurn XS		
		.165	.002	1.181	.002	140°	2°	1.496		*	*		*	*		*			.157	.140	2.057	.077	CoroTurn XS		

R = Right hand, L = Left hand



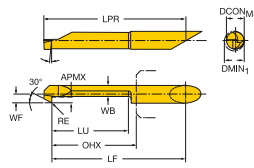
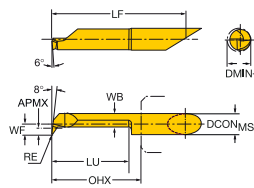
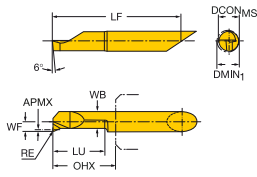
Solid carbide tool for turning

CoroTurn XS -metric: 5

TSYC CXS-xxT090..R/L

CXS-xxT098..R/L
CXS-xxTE98..R/L

CXS-xxB090..R/L



	CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHX	Ordering code	Dimensions, mm, inch									PRODFAM									
										P			M			N				S			H			O		
										1025	1025	H10F	1025	1025	H10F	1025	1025	H10F		7015	1025	1025	H10F	DCON _{MS}	WB	LF	WF	
	5	5.2	0.05	20.0	0.5	98°	17°	23.0	CXS-05T098-05-5220R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	42.3	2.5	CoroTurn XS			
		.205	.002	.787	.020	98°	17°	.906		*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.663	.096	CoroTurn XS			
	5	5.2	0.05	30.0	0.5	98°	17°	33.0	CXS-05T098-05-5230R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	52.3	2.5	CoroTurn XS			
		.205	.002	1.181	.020	98°	17°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	2.057	.096	CoroTurn XS		
	5	5.2	0.20	10.0	0.5	98°	17°	13.0	CXS-05T098-20-5210R	*	*	*	*	*	*	*	*	*	*	*	5	4.3	32.3	2.5	CoroTurn XS			
		.205	.008	.394	.020	98°	17°	.512		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.270	.096	CoroTurn XS		
	5	5.2	0.20	10.0	0.5	98°	17°	13.0	CXS-05T098-20-5210R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	32.3	2.5	CoroTurn XS			
		.205	.008	.394	.020	98°	17°	.512		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.270	.096	CoroTurn XS		
	5	5.2	0.20	20.0	0.5	98°	17°	23.0	CXS-05T098-20-5220R	*	*	*	*	*	*	*	*	*	*	*	5	4.3	42.3	2.5	CoroTurn XS			
		.205	.008	.787	.020	98°	17°	.906		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.663	.096	CoroTurn XS		
	5	5.2	0.20	20.0	0.5	98°	17°	23.0	CXS-05T098-20-5220R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	42.3	2.5	CoroTurn XS			
		.205	.008	.787	.020	98°	17°	.906		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.663	.096	CoroTurn XS		
5	5.2	0.20	25.0	0.5	98°	17°	28.0	CXS-05T098-20-5225R	*	*	*	*	*	*	*	*	*	*	*	5	4.3	47.3	2.5	CoroTurn XS				
	.205	.008	.984	.020	98°	17°	1.102		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.860	.096	CoroTurn XS			
5	5.2	0.20	25.0	0.5	98°	17°	28.0	CXS-05T098-20-5225R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	47.3	2.5	CoroTurn XS				
	.205	.008	.984	.020	98°	17°	1.102		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.860	.096	CoroTurn XS			
5	5.2	0.20	30.0	0.5	98°	17°	33.0	CXS-05T098-20-5230R	*	*	*	*	*	*	*	*	*	*	*	5	4.3	52.3	2.5	CoroTurn XS				
	.205	.008	1.181	.020	98°	17°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	2.057	.096	CoroTurn XS			
5	5.2	0.20	30.0	0.5	98°	17°	33.0	CXS-05T098-20-5230R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	52.3	2.5	CoroTurn XS				
	.205	.008	1.181	.020	98°	17°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	2.057	.096	CoroTurn XS			
5	5.2	0.20	35.0	0.5	98°	17°	38.0	CXS-05T098-20-5235R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	57.3	2.5	CoroTurn XS				
	.205	.008	1.378	.020	98°	17°	1.496		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	2.254	.096	CoroTurn XS			
5	5.2	0.20	40.0	0.5	98°	17°	43.0	CXS-05T098-20-5240R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	62.3	2.5	CoroTurn XS				
	.205	.008	1.575	.020	98°	17°	1.693		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	2.451	.096	CoroTurn XS			
5	5.2	0.08	40.0	0.5	98°	2°	48.0	CXS-05T098A08-5240R	*	*	*	*	*	*	*	*	*	*	*	5	4.6	67.3	2.5	CoroTurn XS				
	.205	.003	1.575	.020	98°	2°	1.890		*	*	*	*	*	*	*	*	*	*	*	*	.197	.179	2.648	.096	CoroTurn XS			
5	5.2	0.20	10.2	0.6	98°	0°	13.0	CXS-05T098A20-5210R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.8	32.3	2.5	CoroTurn XS				
	.205	.008	.402	.024	98°	0°	.512		*	*	*	*	*	*	*	*	*	*	*	*	.197	.187	1.270	.096	CoroTurn XS			
5	5.2	0.20	15.0	0.5	98°	0°	18.0	CXS-05T098A20-5215R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.3	37.3	2.5	CoroTurn XS				
	.205	.008	.591	.020	98°	0°	.709		*	*	*	*	*	*	*	*	*	*	*	*	.197	.167	1.467	.096	CoroTurn XS			
5	5.2	0.20	20.3	0.6	98°	0°	23.0	CXS-05T098A20-5220R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.8	42.3	2.5	CoroTurn XS				
	.205	.008	.799	.024	98°	0°	.906		*	*	*	*	*	*	*	*	*	*	*	*	.197	.187	1.663	.096	CoroTurn XS			
5	5.2	0.20	25.4	0.5	98°	0°	28.0	CXS-05T098A20-5225R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.8	47.3	2.5	CoroTurn XS				
	.205	.008	1.000	.020	98°	0°	1.102		*	*	*	*	*	*	*	*	*	*	*	*	.197	.187	1.860	.096	CoroTurn XS			
5	5.2	0.20	30.5	0.6	98°	0°	33.0	CXS-05T098A20-5230R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.8	52.3	2.5	CoroTurn XS				
	.205	.008	1.201	.024	98°	0°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	.197	.187	2.057	.096	CoroTurn XS			
	5	5.2	0.20	10.0	0.5	90°	17°	13.0	CXS-05T090-20-5210R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.2	32.3	2.5	CoroTurn XS			
		.205	.008	.394	.020	90°	17°	.512		*	*	*	*	*	*	*	*	*	*	*	.197	.165	1.270	.096	CoroTurn XS			
	5	5.2	0.20	15.0	0.5	90°	17°	18.0	CXS-05T090-20-5215R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.2	37.3	2.5	CoroTurn XS			
		.205	.008	.591	.020	90°	17°	.709		*	*	*	*	*	*	*	*	*	*	*	*	.197	.165	1.467	.096	CoroTurn XS		
	5	5.2	0.20	20.0	0.5	90°	17°	23.0	CXS-05T090-20-5220R/L	*	*	*	*	*	*	*	*	*	*	*	5	4.2	42.3	2.5	CoroTurn XS			
		.205	.008	.787	.020	90°	17°	.906		*	*	*	*	*	*	*	*	*	*	*	.197	.165	1.663	.096	CoroTurn XS			
	5	5.2	0.15	25.0	1.0	98°	44°	28.0	CXS-05TE98-15-5225R/L	*	*	*	*	*	*	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS			
		.205	.006	.984	.039	98°	44°	1.102		*	*	*	*	*	*	*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS			
	5	5.2	0.15	28.5	1.0	92°	27°	31.0	CXS-05B090-15-5230R	*	*	*	*	*	*	*	*	*	*	*	5	3.8	50.3	2.5	CoroTurn XS			
		.205	.006	1.122	.039	92°	27°	1.221		*	*	*	*	*	*	*	*	*	*	*	.197	.150	1.979	.096	CoroTurn XS			

R = Right hand, L = Left hand



D2



A106



B109



J19



J9

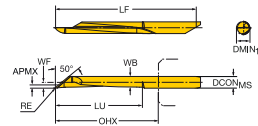
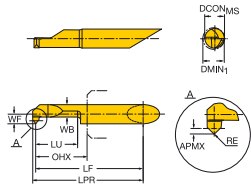


Solid carbide tool for turning

CoroTurn XS -metric: 5

TSYC CXS-xxT045..R/L

CXS-xxT140..R/L



C

	CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHX	Ordering code	P M N S H O						Dimensions, mm, inch				PRODFAM		
										1025	1025	H10F	1025	H10F	1025	H10F	7015	1025	H10F		DCON _{MS}	WB
	5	5.2	0.20	15.0	0.7	45°	42°	17.0	CXS-05T045-20-5215R/L	★	★	★	★	★	★	★	★	5	3.8	36.3	2.5	CoroTurn XS
		.205	.008	.591	.028	45°	42°	.669		★	★	★	★	★	★	★	★	.197	.148	1.427	.096	CoroTurn XS
	5	5.2	0.20	20.0	0.7	45°	42°	22.0	CXS-05T045-20-5220R/L	★	★	★	★	★	★	★	★	5	3.8	41.3	2.5	CoroTurn XS
		.205	.008	.787	.028	45°	42°	.866		★	★	★	★	★	★	★	★	.197	.148	1.624	.096	CoroTurn XS
	5	5.2	0.05	40.0	0.1	140°	2°	48.0	CXS-05T140A05-5240R	★	★	★	★	★	★	★	★	5	4.6	67.3	2.5	CoroTurn XS
		.205	.002	1.575	.002	140°	2°	1.890		★	★	★	★	★	★	★	★	.197	.179	2.648	.096	CoroTurn XS

R = Right hand, L = Left hand

E

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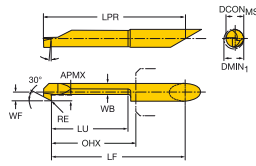
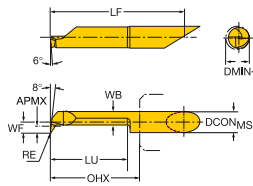


Solid carbide tool for turning

CoroTurn XS -metric: 6

TSYC CXS-xxT098..R/L
CXS-xxTE98..R/L

CXS-xxB090..R/L

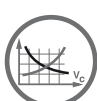


	CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHX	Ordering code	P M N S H O									Dimensions, mm, inch				PRODFAM				
										1025	1025	H10F	1025	1025	H10F	1025	H10F	7015	1025	H10F	DCON _{MS}	WB		LF	WF		
										*	*	*	*	*	*	*	*	*	*	*	*	*		*	*	*	
	6	6.2	0.05	20.0	0.5	98°	17°	23.0	CXS-06T098-05-6220R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	42.3	3.0	CoroTurn XS	
		.244	.002	.787	.020	98°	17°	.906		*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	1.663	.116	CoroTurn XS	
	6	6.2	0.20	15.0	0.5	98°	17°	18.0	CXS-06T098-20-6215R	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	37.3	3.0	CoroTurn XS	
		.244	.008	.591	.020	98°	17°	.709		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	1.467	.116	CoroTurn XS
	6	6.2	0.20	15.0	0.5	98°	17°	18.0	CXS-06T098-20-6215R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	37.3	3.0	CoroTurn XS	
		.244	.008	.591	.020	98°	17°	.709		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	1.467	.116	CoroTurn XS
	6	6.2	0.20	20.0	0.5	98°	17°	23.0	CXS-06T098-20-6220R	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	42.3	3.0	CoroTurn XS	
		.244	.008	.787	.020	98°	17°	.906		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	1.663	.116	CoroTurn XS
	6	6.2	0.20	20.0	0.5	98°	17°	23.0	CXS-06T098-20-6220R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	42.3	3.0	CoroTurn XS	
		.244	.008	.787	.020	98°	17°	.906		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	1.663	.116	CoroTurn XS
	6	6.2	0.20	25.0	0.5	98°	17°	28.0	CXS-06T098-20-6225R	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	47.3	3.0	CoroTurn XS	
		.244	.008	.984	.020	98°	17°	1.102		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	1.860	.116	CoroTurn XS
6	6.2	0.20	25.0	0.5	98°	17°	28.0	CXS-06T098-20-6225R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	47.3	3.0	CoroTurn XS		
	.244	.008	.984	.020	98°	17°	1.102		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	1.860	.116	CoroTurn XS	
6	6.2	0.20	30.0	0.5	98°	17°	33.0	CXS-06T098-20-6230R	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	52.3	3.0	CoroTurn XS		
	.244	.008	1.181	.020	98°	17°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	2.057	.116	CoroTurn XS	
6	6.2	0.20	30.0	0.5	98°	17°	33.0	CXS-06T098-20-6230R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	52.3	3.0	CoroTurn XS		
	.244	.008	1.181	.020	98°	17°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	2.057	.116	CoroTurn XS	
6	6.2	0.20	35.0	0.5	98°	17°	38.0	CXS-06T098-20-6235R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	57.3	3.0	CoroTurn XS		
	.244	.008	1.378	.020	98°	17°	1.496		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	2.254	.116	CoroTurn XS	
6	6.2	0.20	40.0	0.5	98°	17°	43.0	CXS-06T098-20-6240R	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	62.3	3.0	CoroTurn XS		
	.244	.008	1.575	.020	98°	17°	1.693		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	2.451	.116	CoroTurn XS	
6	6.2	0.20	40.0	0.5	98°	17°	43.0	CXS-06T098-20-6240R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	62.3	3.0	CoroTurn XS		
	.244	.008	1.575	.020	98°	17°	1.693		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	2.451	.116	CoroTurn XS	
6	6.2	0.08	45.0	0.5	98°	2°	53.0	CXS-06T098A08-6245R	*	*	*	*	*	*	*	*	*	*	*	*	6	5.5	72.3	3.0	CoroTurn XS		
	.244	.003	1.772	.020	98°	2°	2.087		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.217	2.844	.116	CoroTurn XS	
6	6.2	0.20	15.2	0.8	98°	0°	18.0	CXS-06T098A20-6215R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.7	37.3	3.0	CoroTurn XS		
	.244	.008	.598	.030	98°	0°	.709		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.224	1.467	.116	CoroTurn XS	
6	6.2	0.20	20.3	0.8	98°	0°	23.0	CXS-06T098A20-6220R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.7	42.3	3.0	CoroTurn XS		
	.244	.008	.799	.030	98°	0°	.906		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.224	1.663	.116	CoroTurn XS	
6	6.2	0.20	25.4	0.8	98°	0°	28.0	CXS-06T098A20-6225R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.7	47.3	3.0	CoroTurn XS		
	.244	.008	1.000	.030	98°	0°	1.102		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.224	1.860	.116	CoroTurn XS	
6	6.2	0.20	30.5	0.5	98°	0°	33.0	CXS-06T098A20-6230R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.7	52.3	3.0	CoroTurn XS		
	.244	.008	1.201	.020	98°	0°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.224	2.057	.116	CoroTurn XS	
6	6.2	0.20	40.0	0.5	98°	0°	43.0	CXS-06T098A20-6240R/L	*	*	*	*	*	*	*	*	*	*	*	*	6	5.3	62.3	3.0	CoroTurn XS		
	.244	.008	1.575	.020	98°	0°	1.693		*	*	*	*	*	*	*	*	*	*	*	*	*	.236	.207	2.451	.116	CoroTurn XS	
	6	6.2	0.15	30.0	1.8	98°	44°	33.0	CXS-06TE98-15-6230R	*	*	*	*	*	*	*	*	*	*	*	6	4.0	52.3	3.0	CoroTurn XS		
		.244	.006	1.181	.071	98°	44°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	.236	.156	2.057	.116	CoroTurn XS	
	6	6.2	0.15	30.0	1.8	98°	44°	33.0	CXS-06TE98-15-6230R/L	*	*	*	*	*	*	*	*	*	*	*	6	4.0	52.3	3.0	CoroTurn XS		
		.244	.006	1.181	.071	98°	44°	1.299		*	*	*	*	*	*	*	*	*	*	*	*	.236	.156	2.057	.116	CoroTurn XS	
	6	6.2	0.15	28.5	1.8	92°	27°	31.0	CXS-06B090-15-6230R	*	*	*	*	*	*	*	*	*	*	*	6	4.0	50.3	3.0	CoroTurn XS		
		.244	.006	1.122	.071	92°	27°	1.221		*	*	*	*	*	*	*	*	*	*	*	*	.236	.157	1.979	.116	CoroTurn XS	

R = Right hand, L = Left hand



D2



A106



B109



J19



J9

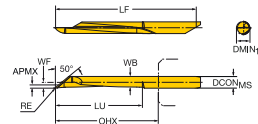
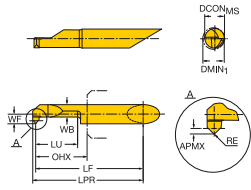


Solid carbide tool for turning

CoroTurn XS -metric: 6

TSYC CXS-xxT045..R/L

CXS-xxT140..R/L



C

	CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHX	Ordering code	P M N S H O								Dimensions, mm, inch				PRODFAM		
										1025	1025	H10F	1025	H10F	1025	H10F	7015	1025	H10F	DCON _{MS}	WB		LF	WF
	6	6.2	0.20	20.0	0.7	45°	42°	22.0	CXS-06T045-20-6220R/L	★	★	★	★	★	★	★	★	★	★	6	4.0	41.3	3.0	CoroTurn XS
		.244	.008	.787	.028	45°	42°	.866		★	★	★	★	★	★	★	★	★	.236	.156	1.624	.116	CoroTurn XS	
	6	6.2	0.20	25.0	0.7	45°	42°	27.0	CXS-06T045-20-6225R/L	★	★	★	★	★	★	★	★	★	6	4.0	46.3	3.0	CoroTurn XS	
		.244	.008	.984	.028	45°	42°	1.063		★	★	★	★	★	★	★	★	★	.236	.156	1.821	.116	CoroTurn XS	
	6	6.2	0.05	45.0	0.1	140°	2°	53.0	CXS-06T140A05-6245R	★	★	★	★	★	★	★	★	★	6	5.5	72.3	3.0	CoroTurn XS	
		.244	.002	1.772	.002	140°	2°	2.087		★	★	★	★	★	★	★	★	★	.236	.217	2.844	.116	CoroTurn XS	

R = Right hand, L = Left hand

E

F

G

H

I

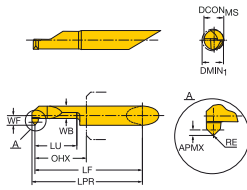
J



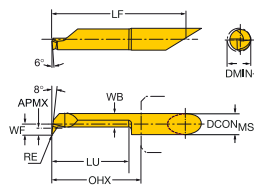
Solid carbide tool for turning

CoroTurn XS -metric: 7

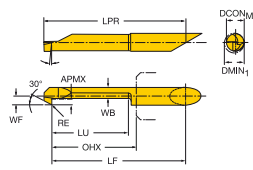
TSYC CXS-xxT045..R/L



CXS-xxT098..R/L
CXS-xxTE98..R/L



CXS-xxB090..R/L



CXS-xxT140..R/L

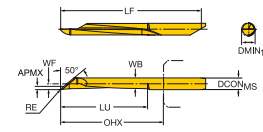


Image										P M N S H O									Dimensions, mm, inch						
	CZC _{MS}	DMIN ₁	RE	LU	APMX	KAPR	RMPX	OHX	Ordering code	1025	1025	H10F	1025	H10F	1025	H10F	7015	1025	H10F	DCON _{MS}	WB	LF	WF	PRODFAM	
										*	*	*	*	*	*	*	*	*	*						*
	7	7.2	0.20	25.0	0.5	98°	17°	28.0	CXS-07T098-20-7225R	*	*	*	*	*	*	*	*	*	*	7	6.3	47.3	3.5	CoroTurn XS	
		.283	.008	.984	.020	98°	17°	1.102		*	*	*	*	*	*	*	*	*	*	.276	.246	1.860	.136	CoroTurn XS	
	7	7.2	0.20	25.0	0.5	98°	17°	28.0	CXS-07T098-20-7225R/L	*	*	*	*	*	*	*	*	*	*	7	6.3	47.3	3.5	CoroTurn XS	
		.283	.008	.984	.020	98°	17°	1.102		*	*	*	*	*	*	*	*	*	*	*	.276	.246	1.860	.136	CoroTurn XS
	7	7.2	0.20	30.0	0.5	98°	17°	33.0	CXS-07T098-20-7230R								*			7	6.3	52.3	3.5	CoroTurn XS	
		.283	.008	1.181	.020	98°	17°	1.299									*			.276	.246	2.057	.136	CoroTurn XS	
	7	7.2	0.20	30.0	0.5	98°	17°	33.0	CXS-07T098-20-7230R/L	*	*	*	*	*	*	*	*	*	*	7	6.3	52.3	3.5	CoroTurn XS	
		.283	.008	1.181	.020	98°	17°	1.299		*	*	*	*	*	*	*	*	*	*	*	.276	.246	2.057	.136	CoroTurn XS
	7	7.2	0.20	40.0	0.5	98°	17°	43.0	CXS-07T098-20-7240R								*			7	6.3	62.3	3.5	CoroTurn XS	
		.283	.008	1.575	.020	98°	17°	1.693									*			.276	.246	2.451	.136	CoroTurn XS	
	7	7.2	0.20	40.0	0.5	98°	17°	43.0	CXS-07T098-20-7240R/L	*	*	*	*	*	*	*	*	*	*	7	6.3	62.3	3.5	CoroTurn XS	
		.283	.008	1.575	.020	98°	17°	1.693		*	*	*	*	*	*	*	*	*	*	*	.276	.246	2.451	.136	CoroTurn XS
	7	7.2	0.20	45.0	0.5	98°	17°	48.0	CXS-07T098-20-7245R/L	*	*	*	*	*	*	*	*	*	*	7	6.3	67.3	3.5	CoroTurn XS	
		.283	.008	1.772	.020	98°	17°	1.890		*	*	*	*	*	*	*	*	*	*	*	.276	.246	2.648	.136	CoroTurn XS
	7	7.2	0.20	50.0	0.5	98°	17°	53.0	CXS-07T098-20-7250R								*			7	6.3	72.3	3.5	CoroTurn XS	
		.283	.008	1.969	.020	98°	17°	2.087									*			.276	.246	2.844	.136	CoroTurn XS	
7	7.2	0.20	50.0	0.5	98°	17°	53.0	CXS-07T098-20-7250R/L	*	*	*	*	*	*	*	*	*	*	7	6.3	72.3	3.5	CoroTurn XS		
	.283	.008	1.969	.020	98°	17°	2.087		*	*	*	*	*	*	*	*	*	*	*	.276	.246	2.844	.136	CoroTurn XS	
7	7.2	0.08	55.0	0.5	98°	2°	63.0	CXS-07T098A08-7255R	*	*	*	*	*	*	*	*	*	*	7	6.5	82.3	3.5	CoroTurn XS		
	.283	.003	2.165	.020	98°	2°	2.480		*	*	*	*	*	*	*	*	*	*	*	.276	.256	3.238	.136	CoroTurn XS	
7	7.2	0.20	25.4	0.9	98°	0°	28.0	CXS-07T098A20-7225R/L	*	*	*	*	*	*	*	*	*	*	7	6.7	47.3	3.5	CoroTurn XS		
	.283	.008	1.000	.035	98°	0°	1.102		*	*	*	*	*	*	*	*	*	*	*	.276	.262	1.860	.136	CoroTurn XS	
7	7.2	0.20	30.5	0.9	98°	0°	33.0	CXS-07T098A20-7230R/L	*	*	*	*	*	*	*	*	*	*	7	6.7	52.3	3.5	CoroTurn XS		
	.283	.008	1.201	.035	98°	0°	1.299		*	*	*	*	*	*	*	*	*	*	*	.276	.262	2.057	.136	CoroTurn XS	
7	7.2	0.20	40.6	0.5	98°	0°	43.0	CXS-07T098A20-7240R/L	*	*	*	*	*	*	*	*	*	*	7	6.7	62.3	3.5	CoroTurn XS		
	.283	.008	1.598	.020	98°	0°	1.693		*	*	*	*	*	*	*	*	*	*	*	.276	.262	2.451	.136	CoroTurn XS	
	7	7.2	0.20	40.0	2.5	98°	44°	43.0	CXS-07TE98-20-7240R/L	*	*	*	*	*	*	*	*	*	7	6.3	62.3	4.2	CoroTurn XS		
		.283	.008	1.575	.098	98°	44°	1.693		*	*	*	*	*	*	*	*	*	*	.276	.246	2.451	.163	CoroTurn XS	
	7	7.2	0.15	27.5	2.5	92°	27°	30.0	CXS-07B090-15-7230R	*	*	*	*	*	*	*	*	*	7	4.3	49.3	3.5	CoroTurn XS		
		.283	.006	1.083	.098	92°	27°	1.182		*	*	*	*	*	*	*	*	*	*	.276	.169	1.940	.136	CoroTurn XS	
	7	7.2	0.20	20.0	0.7	45°	42°	22.0	CXS-07T045-20-7220R/L	*	*	*	*	*	*	*	*	*	7	4.3	41.3	3.5	CoroTurn XS		
		.283	.008	.787	.028	45°	42°	.866		*	*	*	*	*	*	*	*	*	*	.276	.167	1.624	.136	CoroTurn XS	
	7	7.2	0.20	40.0	0.7	45°	42°	42.0	CXS-07T045-20-7240R/L	*	*	*	*	*	*	*	*	*	7	4.3	61.3	3.5	CoroTurn XS		
		.283	.008	1.575	.028	45°	42°	1.654		*	*	*	*	*	*	*	*	*	*	.276	.167	2.411	.136	CoroTurn XS	
	7	7.2	0.05	55.0	0.1	140°	2°	63.0	CXS-07T140A05-7255R	*	*	*	*	*	*	*	*	*	7	6.5	82.3	3.5	CoroTurn XS		
		.283	.002	2.165	.002	140°	2°	2.480		*	*	*	*	*	*	*	*	*	*	.276	.256	3.238	.136	CoroTurn XS	

R = Right hand, L = Left hand



D2



A106



B109



J19

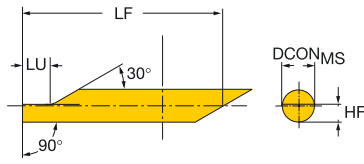
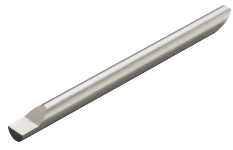


J9

CoroTurn® XS carbide blank

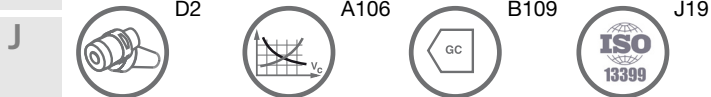
Blanks

ENG



CZC _{MS}	Ordering code	P M K N				Dimensions, mm, inch			
		HF	HF	HF	HF	DCON _{MS}	LF	LU	HF
4	CXS-04B-50	*	*	*	*	04	50	3.5	2.25
						1.968	.138	.0886	
5	CXS-05B-65	*	*	*	*	05	65	4	2.750
						2.559	.157	.108	
6	CXS-06B-70	*	*	*	*	06	70	5	3.250
						2.756	.197	.128	
7	CXS-07B-70	*	*	*	*	07	70	6	3.750
						2.756	.236	.148	

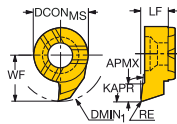
CZC_{MS} to correspond with CZC_{WS} on adaptor.



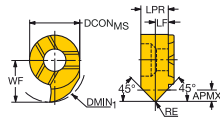
Solid carbide head for turning

CoroCut MB -size 07

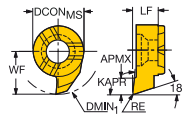
TSYC MB..T020



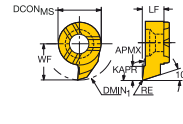
MB..T045



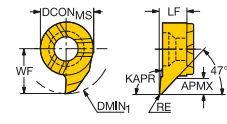
MB..T093



MB..T093A



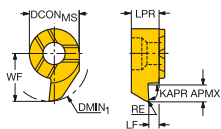
MB..TE



	CZC _{MS}	DMIN ₁	RE	APMX	KAPR	RMPX	Ordering code	P	M	N	S	H	O	Dimensions, mm, inch			PRODFAM
								1025	1025	1025	1025	7015	1025	DCON _{MS}	LF	WF	
	07	10.0	0.20	1.5	110°	17°	MB-07T020-02-10R/L	*	*	*	*	*	*	7	3.9	5.6	CoroCut MB
		.394	.008	.059	110°	17°		*	*	*	*	*	*	.276	.154	.220	CoroCut MB
	07	10.0	0.20	1.5	45°	42°	MB-07T045-02-10R/L	*	*	*	*	*	*	7	2.0	5.8	CoroCut MB
		.394	.008	.059	45°	42°		*	*	*	*	*	*	.276	.079	.228	CoroCut MB
	07	10.0	0.20	1.8	93°	45°	MB-07TE93-02-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
		.394	.008	.071	93°	45°		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
	07	10.0	0.20	1.8	93°	15°	MB-07T093-02-10R					*	*	7	3.9	5.6	CoroCut MB
		.394	.008	.071	93°	15°						*	*	.276	.154	.220	CoroCut MB
	07	10.0	0.20	1.8	93°	15°	MB-07T093-02-10R/L	*	*	*	*	*	*	7	3.9	5.6	CoroCut MB
		.394	.008	.071	93°	15°		*	*	*	*	*	*	.276	.154	.220	CoroCut MB
	07	10.0	0.20	1.8	93°	15°	MB-07T093A02-10R/L	*	*	*	*	*	*	7	3.9	5.6	CoroCut MB
		.394	.008	.071	93°	15°		*	*	*	*	*	*	.276	.154	.220	CoroCut MB

Solid carbide head for back boring

CoroCut MB -size 07



	CZC _{MS}	RE	DMIN ₁	APMX	KAPR	RMPX	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM
									1025	1025	1025	1025	1025	DCON _{MS}	LPR	LF	WF	
	07	0.2	10.0	2.0	92°	27°	1.3	MB-07B030-02-10R/L	*	*	*	*	*	7	4.0	1.3	5.8	CoroCut MB
		.008	.394	.079	92°	27°	.051		*	*	*	*	*	.276	.156	.051	.228	CoroCut MB
	07	0.2	11.0	2.6	92°	27°	1.3	MB-07B030-02-11R/L	*	*	*	*	*	7	4.0	1.3	6.8	CoroCut MB
		.008	.433	.102	92°	27°	.051		*	*	*	*	*	.276	.157	.051	.268	CoroCut MB

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



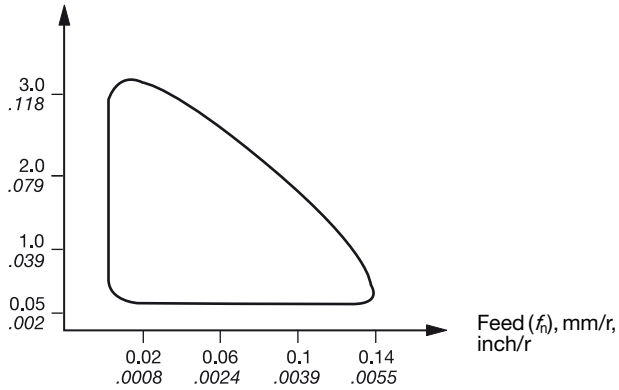
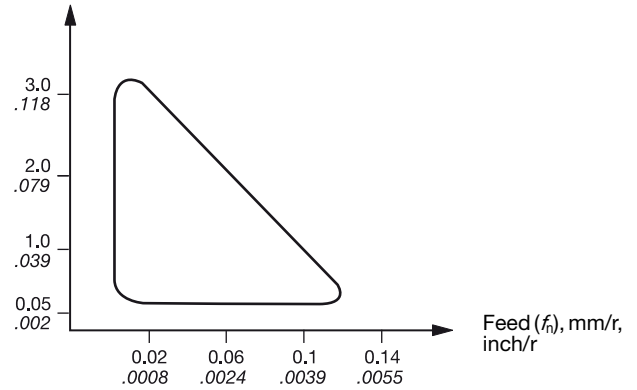
CoroTurn® XS

Insert size	Dimensions, mm, inch				Application area							
	WB mm	WB inch	RE mm	RE inch	General turning/Back boring				Rec. cutting feed			
					Rec. depth of cut		Rec. cutting feed		Rec. depth of cut		Rec. cutting feed	
CZC					a_p mm	Min - Max	a_p inch	Min - Max	f_r mm/r	Min - Max	f_r inch/r	Min - Max
4	0.18	.007	-	-	0.05	(0.01 - 0.08)	.0020	(.0004 - .0031)	0.007	(0.050 - 0.015)	.00028	(.00020 - .00059)
4	0.28	.011	-	-	0.06	(0.01 - 0.10)	.0024	(.0004 - .0041)	0.010	(0.050 - 0.014)	.00039	(.00020 - .00059)
4	0.38	.015	-	-	0.08	(0.01 - 0.15)	.0031	(.0004 - .0059)	0.012	(0.008 - 0.017)	.00047	(.00032 - .00067)
4	0.46	.018	-	-	0.09	(0.01 - 0.20)	.0035	(.0004 - .0071)	0.015	(0.010 - 0.020)	.00059	(.00039 - .00079)
4	0.56	.022	-	-	0.12	(0.01 - 0.22)	.0047	(.0004 - .0087)	0.018	(0.010 - 0.025)	.00071	(.00039 - .00098)
4	0.63	.025	-	-	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
4	0.66	.026	0.05	.002	0.15	(0.05 - 0.30)	.0059	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
4	0.66	.026	0.10	.004	0.15	(0.09 - 0.30)	.0059	(.0039 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
4	0.74	.029	-	-	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
4	1.04	.041	0.05	.002	0.18	(0.05 - 0.30)	.0071	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
4	1.04	.041	0.10	.004	0.18	(0.01 - 0.30)	.0071	(.0004 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
4	1.55	.061	0.05	.002	0.20	(0.05 - 0.40)	.0079	(.0020 - .0158)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
4	1.55	.061	0.10	.004	0.20	(0.09 - 0.40)	.0079	(.0039 - .0158)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
4	2.06	.081	0.05	.002	0.25	(0.05 - 0.51)	.0098	(.0020 - .0200)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
4	2.06	.081	0.15	.006	0.25	(0.15 - 0.51)	.0098	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
4	2.54	.100	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
4	2.06/2.59	.100/.102	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
4	2.95	.116	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
4	3.45	.136	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
4	3.45	.136	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
5	3.76	.148	0.15	.006	0.35	(0.15 - 0.60)	.0138	(.0059 - .0236)	0.040	(0.020 - 0.060)	.00157	(.00079 - .00236)
5	3.75/3.81	.148/.150	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.060)	.00157	(.00079 - .00236)
5	4.19	.165	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
5	4.24	.167	0.05	.002	0.25	(0.05 - 0.60)	.0098	(.0020 - .0236)	0.030	(0.020 - 0.040)	.00118	(.00079 - .00157)
5	4.24	.167	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
6	3.96/3.99	.156/.157	0.15	.006	0.35	(0.15 - 0.60)	.0138	(.0059 - .0236)	0.045	(0.020 - 0.070)	.00177	(.00079 - .00276)
6	3.96	.156	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.045	(0.020 - 0.070)	.00177	(.00079 - .00276)
6	5.26	.207	0.20	.008	0.40	(0.20 - 0.70)	.0157	(.0079 - .0276)	0.045	(0.020 - 0.080)	.00177	(.00079 - .00315)
7	4.29	.169	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
7	6.25	.246	0.20	.008	0.50	(0.20 - 0.80)	.0197	(.0079 - .0315)	0.050	(0.030 - 0.080)	.00197	(.00118 - .00315)

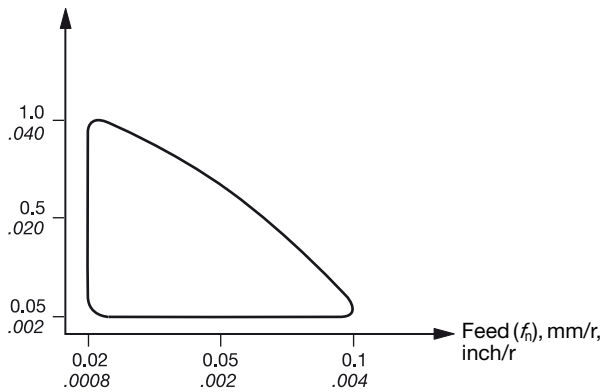
Cutting speed recommendations

Cutting speed (v_c), m/min (ft/min)

Grade 1025/1105	P	M	N	S
	60-200	60-180	90-400	20-50
	(195-655)	(195-590)	(295-1310)	(65-165)

CoroCut® XS**Turning**Cutting depth (a_p), mm, inch**Back turning**Cutting depth (a_p), mm, inch**CoroCut® MB****Turning**

Insert size 07

Cutting depth (a_p), mm, inch**Cutting speed recommendations**Cutting speed (v_c), m/min (ft/min)

Grade 1025/1105

P**M****N****S**60-200
(195-655)60-180
(195-590)90-400
(295-1310)20-50
(65-165)

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO P	CMC No.	Steel Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					CT5015	GC1525	GC4305	GC4315
					h_{ex} , mm = feed f_n , mm/r			
					0.05-0.1-0.2	0.05-0.1-0.2	0.1-0.4-0.8	0.1-0.4-0.8
MC No.	CMC No.	Material	N/mm ²	HB	Cutting speed (v_c), m/min			
P1.1.Z.AN	01.1	Unalloyed steel C = 0.1-0.25%	1500	125	650-540-440	560-465-380	620-450-330	570-405-300
P1.2.Z.AN	01.2	C = 0.25-0.55%	1600	150	380-245-180	495-415-335	560-405-295	510-365-265
P1.3.Z.AN	01.3	C = 0.55-0.80%	1700	170	510-425-340	430-365-295	530-385-275	460-330-240
P2.1.Z.AN	02.1	Low-alloy steel (alloying elements ≤5%) Non-hardened	1700	180	480-400-320	375-320-255	610-410-285	560-370-260
P2.1.Z.AN	02.12	Ball bearing steel	1800	210	-	-	530-350-250	460-305-215
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	285-235-190	200-165-135	330-230-175	300-210-155
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	230-190-150	160-135-110	265-185-140	240-170-125
P3.0.Z.AN	03.11	High-alloy steel (alloying elements >5%) Annealed	1950	200	395-330-250	260-215-175	445-295-215	405-270-200
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	195-165-130	140-115-90	220-140-105	200-130-95
P1.5.C.UT	06.1	Steel castings Unalloyed	1550	180	260-215-175	225-185-145	335-235-185	300-215-170
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	270-225-170	175-145-105	290-205-155	260-185-140
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	200-165-125	140-115-85	225-150-115	205-135-105
ISO M	CMC No.	Stainless steel Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					GC1115	GC1125	GC2015	GC2220
					h_{ex} , mm = feed f_n , mm/r			
					0.1-0.2-0.3	0.1-0.2-0.3	0.2-0.4-0.6	0.2-0.4-0.6
MC No.	CMC No.	Material	N/mm ²	HB	Cutting speed (v_c), m/min			
P5.0.Z.AN	05.11	Ferritic/martensitic Bars/forged Non-hardened	1800	200	335-255-200	280-215-170	260-220-200	-
P5.0.Z.PH	05.12	PH-hardened	2850	330	185-150-120	155-125-100	125-100-80	-
P5.0.Z.HT	05.13	Hardened	2350	330	200-160-140	165-135-120	145-120-85	-
M1.0.Z.AQ	05.21	Austenitic Bars/forged Austenitic	1800	180	265-215-165	220-180-135	290-240-190	225-165-125
M1.0.Z.PH	05.22	PH-hardened	2850	330	185-150-120	155-125-100	130-100-80	100-70-55
M2.0.Z.AQ	05.23	Super austenitic	2250	200	220-190-155	185-160-130	160-135-100	130-100-75
M3.1.Z.AQ	05.51	Austenitic-ferritic (Duplex) Bars/forged Non-weldable ≥ 0.05%C	2000	230	250-205-155	210-170-130	220-185-145	190-150-110
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	230-170-130	190-140-110	190-150-120	150-120-90
P5.0.C.UT	15.11	Ferritic/martensitic Cast Non-hardened	1700	200	320-265-205	265-220-170	250-210-170	-
	15.12	PH-hardened	2450	330	160-130-95	135-110-80	100-70-55	-
P5.0.C.HT	15.13	Hardened	2150	330	175-145-110	145-120-90	110-90-60	-
M1.0.C.UT	15.21	Austenitic Cast Austenitic	1700	180	280-225-170	230-185-145	220-180-140	200-155-115
	15.22	PH-hardened	2450	330	160-130-95	135-110-80	105-80-60	85-55-40
M2.0.C.AQ	15.23	Super austenitic	2150	200	210-180-150	175-150-125	145-115-95	130-90-65
M3.1.C.AQ	15.51	Austenitic-ferritic (Duplex) Cast Non-weldable ≥ 0.05%C	1800	230	230-170-120	190-140-100	185-150-135	150-120-90
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	205-155-110	170-130-90	160-140-105	125-105-80
ISO K	CMC No.	Cast iron Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					CB7525	CB7925	CC6190	CC650
					h_{ex} , mm = feed f_n , mm/r			
					0.1-0.25-0.4	0.1-0.25-0.4	0.2-0.4-0.6	0.1-0.25-0.4
MC No.	CMC No.	Material	N/mm ²	HB	Cutting speed (v_c), m/min			
K1.1.C.NS	07.1	Malleable cast iron Ferritic (short chipping)	790	130	-	-	810-660-550	800-700-600
	07.2	Pearlitic	900	230	-	-	700-660-550	700-600-500
K2.1.C.UT	08.1	Grey cast iron Low tensile strength	890	180	1700-1450-1200	1450-1200-1050	890-720-600	800-700-600
K2.2.C.UT	08.2	High tensile strength	970	220	1450-1250-1050	1250-1050-890	790-620-500	760-650-540
K3.1.C.UT	09.1	Nodular SG iron Ferritic	900	160	-	-	-	610-550-450
K3.3.C.UT	09.2	Pearlitic	1350	250	-	-	-	510-450-350
K3.4.C.UT	09.3	Martensitic	2100	380	-	-	-	350-305-260

Cutting speed recommendations, metric values

TOUGHNESS >>>>										
GC4325	GC4335									
0.1-0.4-0.8	0.1-0.4-0.8									
510-345-245 455-305-215 425-290-205	425-275-200 380-245-180 365-235-170									
460-305-215 395-265-190 255-180-140 205-145-110	300-185-135 250-155-110 185-120-85 150-95-70									
300-205-150 135-95-75	240-155-105 110-70-50									
240-180-130 210-140-100 185-125-90	185-140-100 165-100-70 145-95-65									
TOUGHNESS >>>>										
GC2025	GC2035									
0.2-0.4-0.6	0.2-0.4-0.6									
225-175-130 100-70-45 115-80-55	180-160-130 85-65-45 95-70-50									
190-145-110 100-70-55 130-100-75	170-145-115 85-65-45 100-90-70									
135-100-70 100-70-50	160-135-105 130-110-85									
160-125-90 100-70-45 115-80-55	170-145-115 70-50-40 75-60-50									
170-135-100 85-55-40 130-90-65	150-120-95 70-50-40 100-80-60									
115-85-60 100-70-50	130-110-85 105-95-75									
TOUGHNESS >>>>										
GC3210	GC3225	H13A								
0.2-0.4-0.6	0.2-0.4-0.6	0.1-0.3-0.5								
385-315-265 315-255-215	260-215-185 210-175-150	140-125-110 125-110-90								
445-360-305 355-290-245	300-250-210 240-200-170	180-145-110 140-115-95								
360-305-250 325-275-225 245-210-170	240-195-165 215-175-150 165-135-115	135-125-95 125-115-90 100-85-65								

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO N	CMC No.	Non-ferrous metals Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE		
					CD05	CD10	H10
					h_{ex} mm \approx feed f_{rn} mm/r		
					Cutting speed (v_c), m/min		
N1.2.Z.UT N1.2.Z.AG	30.11 30.12	Aluminium alloys Wrought or wrought and coldworked, non-aging Wrought or wrought and aged	400 650	60 100	- -	2 000 (2500-250) ¹⁾ 2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾ 2 000 (2500-250) ¹⁾
N1.3.C.UT N1.3.C.AG		Aluminium alloys Cast, non-aging Cast or cast and aged	600 700	75 90	2 000 (2500-250) ¹⁾ 2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾ 2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾ 2 000 (2500-250) ¹⁾
N1.4.C.NS	30.41 30.42	Aluminium alloys Cast, 13–15% Si Cast, 16–22% Si	700 700	130 130	1 550 (1950-195) ¹⁾ 770 (960-95) ¹⁾	1 550 (1950-195) ¹⁾ 770 (960-95) ¹⁾	450 (560-55) ¹⁾ 300 (375-38) ¹⁾
N3.3.U.UT N3.2.C.UT N3.1.U.UT	33.1 33.2 33.3	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb Brass, leaded bronzes, $\leq 1\%$ Pb Bronze and non-leaded copper incl. electrolytic copper	550 550 1350	110 90 100	- - -	500 (630-65) ¹⁾ 500 (630-65) ¹⁾ 300 (375-38) ¹⁾	500 (630-65) ¹⁾ 500 (630-65) ¹⁾ 300 (375-38) ¹⁾
ISO S	CMC No.	Heat resistant material Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	<<<< WEAR RESISTANCE		
					S05F	GC1105	GC1115
					h_{ex} mm \approx feed f_{rn} mm/r		
					Cutting speed (v_c), m/min		
S1.0.U.AN S1.0.U.AG	20.11 20.12	Heat resistant super alloys Iron base Annealed or solution treated Aged or solution treated and aged	2400 2500	200 280	160-135-110 125-105-85	150-100-70 120-80-60	120-80-55 95-65-50
S2.0.Z.AN S2.0.Z.AG S2.0.C.NS	20.21 20.22 20.24	Nickel base Annealed or solution treated Aged or solution treated and aged Cast or cast and aged	2650 2900 3000	250 350 320	100-85-70 90-75-60 80-65-55	90-55-30 80-50-27 70-45-24	70-45-24 65-40-22 60-37-19
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31 20.32 20.33	Cobalt alloys Annealed or solution treated Solution treated and aged Cast or cast and aged	2700 3000 3100	200 300 320	100-85-70 90-75-60 80-65-55	90-60-30 80-50-27 70-45-24	70-45-24 65-40-21 60-37-19
S4.1.Z.UT S4.2.Z.AN S4.3.Z.AG	23.1 23.21 23.22	Titanium alloys²⁾ Commercial pure (99,5% Ti) α , near α and $\alpha + \beta$ alloys, annealed $\alpha + \beta$ alloys in aged conditions. β alloys. Annealed or aged	1300 1400 1400	Rm³⁾ 400 950 1050	- - -	- - -	185-155-130 80-65-50 75-55-45
ISO H	CMC No.	Hardened material Material	Specific cutting force k_{c1} N/mm ²	Hardness	<<<< WEAR RESISTANCE		
					CB7105	CB7115	CB7015
					h_{ex} mm \approx feed f_{rn} mm/r		
					Cutting speed (v_c), m/min		
H1.1.Z.HA H1.1.Z.HA H1.2.Z.HA	04.1 04.1 04.1	Hard steel Hardened and tempered	2500 3050 3650	<i>45HRC</i> <i>50HRC</i> <i>55HRC</i>	- 395-300-250 330-250-210	- 350-265-225 295-225-185	- 350-265-225 295-225-185
H1.3.Z.HA H1.4.Z.HA	04.1 04.1	Extra hard steel Hardened and tempered	4300 5000	<i>60HRC</i> <i>65HRC</i>	280-215-180 240-185-155	250-190-160 215-165-135	250-190-160 215-165-135
H2.0.C.UT	10.1	Chilled cast iron Cast or cast and aged	2250	400 HB	-	-	-

1) The cutting speeds, shown in the table, are valid for all feeds within the feed range.

2) 45–60° entering angle, positive cutting geometry and coolant should be used.

3) Rm = ultimate tensile strength measured in MPa.

Cutting speed recommendations, metric values

H13A							
0.15-0.8							
1 900 (2400-240) ¹⁾							
1 900 (2400-240) ¹⁾							
1 900 (2400-240) ¹⁾							
1 900 (2400-240) ¹⁾							
400 (500-50) ¹⁾							
250 (315-31) ¹⁾							
450 (560-55) ¹⁾							
450 (560-55) ¹⁾							
270 (340-34) ¹⁾							
GC1125 H13A							
0.1-0.2-0.5 0.1-0.3-0.5							
75-60-45	80-65-50						
55-45-35	60-50-40						
45-35-25	50-40-30						
35-25-15	40-30-20						
23-17-12	25-20-15						
45-35-25	50-40-30						
35-25-15	40-30-20						
23-17-12	25-20-15						
-	50-40-30						
-	40-30-20						
-	25-20-15						
CB7025 CB7525							
0.05-0.15-0.25 0.1-0.25-0.4							
-	-						
250-210-185	205-165-135						
210-175-155	175-140-110						
180-150-135	145-120-95						
155-130-115	125-100-80						
-	180-150-120						

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Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO P	CMC No.	Steel Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					CT5015	GC1525	GC4305	GC4315
					h_{ex} , inch = feed, f_n inch/rev. at 0° to -5° lead			
					Cutting speed v_c , ft/min			
P1.1.Z.AN	01.1	Unalloyed steel C = 0.1-0.25%	216,500	125	2150-1800-1450	1850-1500-1250	2050-1450-1100	1850-1350-990
P1.2.Z.AN	01.2	C = 0.25-0.55%	233,000	150	1900-1550-1250	1600-1350-1100	1850-1300-970	1650-1200-880
P1.3.Z.AN	01.3	C = 0.55-0.80%	247,000	170	1650-1400-1100	1400-1200-960	1750-1250-920	1500-1100-790
P2.1.Z.AN	02.1	Low-alloy steel (alloying elements ≤5%)	249,500	180	1550-1300-1050	1250-1050-830	2000-1350-940	1800-1200-860
		Non-hardened						
		Ball bearing steel						
		Hardened and tempered						
P2.5.Z.HT	02.2	Hardened and tempered	268,000	275	920-770-610	650-540-435	1050-750-570	980-680-510
P2.5.Z.HT	02.2	Hardened and tempered	298,000	350	740-620-495	520-435-350	870-610-460	790-550-415
P3.0.Z.AN	03.11	High-alloy steel (alloying elements >5%)	282,000	200	1300-1050-820	840-710-570	1450-970-720	1350-880-650
		Annealed						
P3.0.Z.HT	03.21	Hardened tool steel	435,500	325	640-530-420	465-370-290	710-460-345	650-415-315
P1.5.C.UT	06.1	Steel castings Unalloyed	225,000	180	850-700-570	740-600-470	1100-770-610	990-700-550
		Low-alloy (alloying elements ≤5%)						
		High-alloy (alloying elements >5%)						
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230,500	200	880-730-550	580-470-345	950-670-510	860-610-470
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	300,500	225	660-550-410	460-365-280	730-490-380	660-450-345
ISO M	CMC No.	Stainless steel Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					GC1115	GC1125	GC2015	GC2220
					h_{ex} , inch = feed, f_n inch/rev. at 0° to -5° lead			
					Cutting speed (v_c), ft/min			
P5.0.Z.AN	05.11	Ferritic/martensitic Bars/forged Non-hardened	262,000	200	1100-840-650	910-700-550	850-720-650	-
		PH-hardened						
		Hardened						
P5.0.Z.PH	05.12	PH-hardened	411,500	330	610-490-390	510-405-325	410-325-260	-
P5.0.Z.HT	05.13	Hardened	340,000	330	650-530-460	540-440-385	475-390-275	-
M1.0.Z.AQ	05.21	Austenitic Bars/forged Austenitic	259,000	180	870-700-530	730-580-445	950-780-620	740-540-400
		PH-hardened						
		Super austenitic						
M1.0.Z.PH	05.22	PH-hardened	414,000	330	610-490-390	510-405-325	425-325-260	330-235-175
M2.0.Z.AQ	05.23	Super austenitic	328,000	200	730-630-510	610-520-420	520-440-325	425-325-245
M3.1.Z.AQ	05.51	Austenitic-ferritic (Duplex) Bars/forged Non-weldable ≥ 0.05%C	286,500	230	830-660-510	690-550-420	720-600-470	620-485-355
		Weldable < 0.05%C						
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	740-550-430	620-455-355	620-490-390	490-390-290
P5.0.C.UT	15.11	Ferritic/martensitic Cast Non-hardened	246,500	200	1050-860-660	870-720-550	820-680-550	-
		PH-hardened						
		Hardened						
P5.0.C.HT	15.13	Hardened	311,000	330	570-470-350	475-390-290	360-290-195	-
M1.0.C.UT	15.21	Austenitic Cast Austenitic	248,000	180	910-730-560	760-610-465	720-590-455	660-500-370
		PH-hardened						
		Super austenitic						
M2.0.C.AQ	15.23	Super austenitic	310,500	200	690-590-490	570-490-405	475-375-310	425-290-210
M3.1.C.AQ	15.51	Austenitic-ferritic (Duplex) Cast Non-weldable ≥ 0.05%C	258,000	230	750-550-390	620-455-325	600-490-440	490-390-290
		Weldable < 0.05%C						
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,000	260	670-510-350	560-420-290	530-455-340	410-340-260
ISO K	CMC No.	Cast iron Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	<<<< WEAR RESISTANCE			
					CB7525	CB7925	CC6190	CC650
					h_{ex} , inch = feed, f_n inch/rev. at 0° to -5° lead			
					Cutting speed (v_c), ft/min			
K1.1.C.NS	07.1	Malleable cast iron Ferritic (short chipping)	115,000	130	-	-	2650-2150-1800	2600-2300-1950
		Pearlitic						
K1.1.C.NS	07.2	Pearlitic	131,000	230	-	-	2300-1800-1450	2300-1950-1600
K2.1.C.UT	08.1	Grey cast iron Low tensile strength	130,000	180	5600-4650-3950	4750-3950-3400	2900-2350-1950	2650-2300-1950
		High tensile strength						
K2.2.C.UT	08.2	High tensile strength	140,500	220	4800-4000-3450	4100-3400-2900	2600-2000-1650	2500-2100-1750
K3.1.C.UT	09.1	Nodular SG iron Ferritic	130,000	160	-	-	-	2000-1800-1450
		Pearlitic						
		Martensitic						
K3.3.C.UT	09.2	Pearlitic	194,500	250	-	-	-	1650-1450-1150
K3.4.C.UT	09.3	Martensitic	307,000	380	-	-	-	1150-1000-860

Cutting speed recommendations, inch values

TOUGHNESS >>>>									
GC4325	GC4335								
.004-.016-.031	.004-.016-.031								
1400-890-660 1250-800-590 1200-760-560	1400-890-660 1250-800-590 1200-760-560								
980-600-445 820-500-365 600-385-280 485-310-225	980-600-445 820-500-365 600-385-280 485-310-225								
780-500-345 360-225-165	780-500-345 360-225-165								
600-450-335 540-320-235 470-305-220	600-450-335 540-320-235 470-305-220								
TOUGHNESS >>>>									
GC2025	GC2035								
.008-.016-.024	.008-.016-.024								
739-575-427 328-230-148 378-263-181	590-520-420 280-210-145 310-225-160								
624-476-361 328-230-181 427-328-246	560-470-375 280-210-145 330-295-225								
443-328-230 328-230-164	520-440-340 425-360-275								
525-410-296 328-230-148 378-263-181	560-470-375 230-165-130 240-190-160								
558-443-328 279-181-131 427-296-213	490-390-310 230-165-130 330-260-195								
378-279-197 328-230-164	425-360-275 345-310-245								
TOUGHNESS >>>>									
GC3210	GC3225	H13A							
.008-.016-.024	.008-.016-.024	.004-.010-.016							
1250-1050-860 1050-830-700	850-700-600 690-570-490	460-410-360 410-360-295							
1450-1150-990 1150-950-800	980-820-680 790-650-550	590-470-355 460-375-310							
1200-990-810 1050-900-730 800-680-550	780-640-540 700-570-490 540-440-375	445-470-310 410-375-290 330-275-210							

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO N	CMC No.	Non-ferrous metals Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	<<<< WEAR RESISTANCE		
					CD05	CD10	H10
					h_{ex} inch = feed, f_n inch/rev. at 0° to -5° lead		
					Cutting speed (v_c), ft/min		
N1.2.Z.UT N1.2.Z.AG	30.11 30.12	Aluminium alloys Wrought or wrought and coldworked, non-aging Wrought or wrought and aged	58,000 94,500	60 100	- -	6550 (8200-820) ¹⁾ 6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾ 6550 (8200-820) ¹⁾
N1.3.C.UT N1.3.C.AG		Aluminium alloys Cast, non-aging Cast or cast and aged	87,000 101,500	75 90	6550 (8200-820) ¹⁾ 6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾ 6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾ 6550 (8200-820) ¹⁾
N1.4.C.NS	30.41 30.42	Aluminium alloys Cast, 13–15% Si Cast, 16–22% Si	101,500 101,500	130 130	5000 (6250-630) ¹⁾ 2500 (3150-315) ¹⁾	5000 (6250-630) ¹⁾ 2500 (3150-315) ¹⁾	1500 (1900-190) ¹⁾ 980 (1250-125) ¹⁾
N3.3.U.UT N3.2.C.UT N3.1.U.UT	33.1 33.2 33.3	Copper and copper alloys Free cutting alloys, ≥1% Pb Brass, leaded bronzes, ≤1% Pb Bronze and non-leaded copper incl. electrolytic copper	79,500 80,000 196,000	110 90 100	- - -	1650 (2050-205) ¹⁾ 1650 (2050-205) ¹⁾ 980 (1250-125) ¹⁾	1650 (2050-205) ¹⁾ 1650 (2050-205) ¹⁾ 980 (1250-125) ¹⁾
ISO S	CMC No.	Heat resistant material Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	<<<< WEAR RESISTANCE		
					S05F	GC1105	GC1115
					h_{ex} inch = feed, f_n inch/rev. at 0° to -5° lead		
					Cutting speed (v_c), ft/min		
S1.0.U.AN S1.0.U.AG	20.11 20.12	Heat resistant super alloys Iron base Annealed or solution treated Aged or solution treated and aged	348,000 359,000	200 280	520-435-355 410-345-280	490-325-225 390-260-195	395-260-180 315-210-155
S2.0.Z.AN S2.0.Z.AG S2.0.C.NS	20.21 20.22 20.24	Nickel base Annealed or solution treated Aged or solution treated and aged Cast or cast and aged	383,000 420,500 436,500	250 350 320	325-275-225 295-245-200 260-220-180	295-185-95 265-165-85 235-150-75	235-150-75 215-135-70 190-120-60
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31 20.32 20.33	Cobalt alloys Annealed or solution treated Solution treated and aged Cast or cast and aged	391,500 432,000 450,500	200 300 320	325-275-225 290-245-200 260-220-180	295-185-95 265-165-85 235-150-75	240-150-75 210-135-70 190-120-60
S4.1.Z.UT S4.2.Z.AN S4.3.Z.AG	23.1 23.21 23.22	Titanium alloys²⁾ Commercial pure (99,5% Ti) α , near α and $\alpha + \beta$ alloys, annealed $\alpha + \beta$ alloys in aged conditions. β alloys. Annealed or aged	188,500 203,000 203,000	400 950 1050	- - -	- - -	610-500-425 255-205-170 245-180-155
ISO H	CMC No.	Hardened material Material	Specific cutting force k_{c1} lbs/in ²	Hardness	<<<< WEAR RESISTANCE		
					CB7105	CB7115	CB7015
					h_{ex} inch = feed, f_n inch/rev. at 0° to -5° lead		
					Cutting speed (v_c), ft/min		
H1.1.Z.HA H1.1.Z.HA H1.2.Z.HA	04.1 04.1 04.1	Hard steel Hardened and tempered	336,000 445,500 532,000	45HRC 50HRC 55HRC	- 1300-980-820 1100-820-690	- 1150-870-730 960-730-610	- 1150-870-730 960-730-610
H1.3.Z.HA H1.4.Z.HA	04.1 04.1	Extra hard steel Hardened and tempered	625,500 726,500	60HRC 65HRC	920-700-580 790-600-500	820-620-520 710-530-450	820-620-520 710-530-450
H2.0.C.UT	10.1	Chilled cast iron Cast or cast and aged	326,500	400 HB	-	-	-

1) The cutting speeds, shown in the table, are valid for all feeds within the feed range.

2) 45–60° entering angle, positive cutting geometry and coolant should be used.

3) Rm = ultimate tensile strength measured in MPa.

Cutting speed recommendations, inch values

H13A							
.006-.031							
6250 (7800-780) ¹⁾ 6250 (7800-780) ¹⁾							
6250 (7800-780) ¹⁾ 6250 (7800-780) ¹⁾							
1300 (1650-165) ¹⁾ 820 (1050-105) ¹⁾							
1500 (1900-190) ¹⁾ 1500 (1900-190) ¹⁾ 890 (1100-110) ¹⁾							
GC1125 H13A							
.004-.012-.020 .004-.012-.020							
245-195-145 180-145-115	260-210-160 195-165-130						
150-115-80 115-80-50 75-55-39	165-130-95 130-95-65 80-65-50						
150-115-80 115-80-50 75-55-39	165-130-95 130-95-65 80-65-50						
- - -	590-485-410 245-200-165 235-175-150						
CB7025 CB7525							
.002-.006-.010 .004-.010-.016							
- 820-690-610 690-580-510	- 680-540-435 570-455-365						
590-490-435 510-425-375	480-385-310 415-330-270						
-	590-480-390						

B

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H

I

J

Recommended depth of cut and cutting feed, metric

CoroTurn® 107 insert for turning

Insert	Depth of cut			Cutting feed		
	Rec	$a_p = \text{mm}$		Rec	$f_n = \text{mm/r}$	
		Min	Max.		Min	Max.
CCET060201-UM	0.30	0.10	0.70	0.02	0.01	0.04
CCET060202-UM	0.40	0.20	0.70	0.02	0.01	0.06
CCET060204-UM	0.70	0.50	1.00	0.02	0.01	0.06
CCGT060201-UM	0.30	0.10	0.70	0.02	0.01	0.06
CCGT060202-UM	0.50	0.10	1.05	0.05	0.02	0.08
CCGT060204-UM	1.00	0.50	1.40	0.14	0.08	0.21
CCGT09T301-UM	0.30	0.10	0.70	0.02	0.01	0.06
CCGT09T302-UM	0.50	0.10	1.05	0.05	0.02	0.08
CCGT09T304-UM	1.25	0.50	2.10	0.11	0.08	0.18
CCGT09T308-UM	1.25	0.50	2.10	0.14	0.12	0.25
CCGX060202-AL	1.00	0.30	3.00	0.12	0.05	0.15
CCGX060204-AL	1.00	0.30	3.00	0.12	0.05	0.15
CCGX09T304-AL	1.50	0.50	5.00	0.20	0.10	0.30
CCGX09T308-AL	1.50	0.50	5.00	0.30	0.15	0.60
CCGX120404-AL	1.50	0.50	7.00	0.20	0.10	0.30
CCGX120408-AL	1.50	0.50	7.00	0.30	0.15	0.60
CCMT060202-MF	0.30	0.06	1.70	0.06	0.03	0.11
CCMT060202-PF	0.30	0.06	1.70	0.06	0.05	0.11
CCMT060202-UF	0.40	0.10	1.50	0.07	0.05	0.15
CCMT060202-WF	0.30	0.10	1.50	0.10	0.03	0.15
CCMT060204-MF	0.30	0.10	1.70	0.08	0.05	0.17
CCMT060204-MM	0.64	0.20	2.40	0.11	0.06	0.17
CCMT060204-PF	0.30	0.10	1.70	0.08	0.05	0.17
CCMT060204-PM	0.64	0.20	2.40	0.11	0.06	0.17
CCMT060204-UF	0.40	0.20	1.50	0.10	0.05	0.20
CCMT060204-UM	1.00	0.50	2.50	0.20	0.08	0.30
CCMT060204-UR	1.50	1.00	2.50	0.25	0.15	0.30
CCMT060204-WF	0.80	0.30	2.00	0.12	0.05	0.30
CCMT060208-MM	0.64	0.40	2.40	0.15	0.08	0.23
CCMT060208-PM	0.64	0.40	2.40	0.15	0.08	0.23
CCMT060208-UF	0.40	0.20	1.50	0.10	0.05	0.25
CCMT060208-UM	1.00	0.50	2.50	0.25	0.12	0.40
CCMT060208-WF	0.80	0.30	2.00	0.15	0.09	0.35
CCMT09T302-MF	0.35	0.08	2.00	0.08	0.04	0.15
CCMT09T302-PF	0.35	0.08	2.00	0.08	0.05	0.15
CCMT09T302-UF	0.40	0.10	2.00	0.07	0.05	0.15
CCMT09T302-WF	0.30	0.10	1.50	0.10	0.03	0.15
CCMT09T304-MF	0.35	0.11	2.00	0.11	0.06	0.23
CCMT09T304-MM	0.64	0.25	3.00	0.15	0.08	0.23
CCMT09T304-PF	0.35	0.11	2.00	0.11	0.06	0.23
CCMT09T304-PM	0.64	0.25	3.00	0.15	0.08	0.23
CCMT09T304-UF	0.40	0.20	2.00	0.10	0.05	0.20
CCMT09T304-UM	1.25	0.50	4.00	0.20	0.08	0.30
CCMT09T304-UR	2.00	1.00	4.00	0.25	0.15	0.30
CCMT09T304-WF	1.00	0.30	3.00	0.20	0.07	0.30
CCMT09T308-MF	0.35	0.15	2	0.15	0.08	0.3
CCMT09T308-MM	0.8	0.5	3	0.2	0.1	0.3
CCMT09T308-PF	0.35	0.15	2	0.15	0.08	0.3
CCMT09T308-PM	0.8	0.5	3	0.2	0.1	0.3
CCMT09T308-UM	1.25	0.5	4	0.25	0.12	0.4
CCMT09T308-WF	1	0.3	3	0.25	0.12	0.5
CCMT120404-MF	0.42	0.14	2.4	0.14	0.07	0.27
CCMT120404-MM	0.96	0.3	3.6	0.18	0.09	0.27
CCMT120404-PF	0.42	0.14	2.4	0.14	0.07	0.27
CCMT120404-PM	0.96	0.3	3.6	0.18	0.09	0.27
CCMT120408-MM	0.96	0.6	3.6	0.24	0.12	0.36
CCMT120408-PM	0.96	0.6	3.6	0.24	0.12	0.36
CCMT120408-UM	1.5	0.5	4	0.25	0.12	0.4
CCMT120412-MM	0.96	0.72	3.6	0.29	0.14	0.3
CCMT120412-PM	0.96	0.72	3.6	0.29	0.14	0.43
CCMW060204FP	0.5	0.1	2.3	0.1	0.05	0.2
CCMW09T304FP	0.5	0.1	3.4	0.1	0.05	0.2
CCMW09T308FP	1	0.1	3.4	0.15	0.05	0.4
DCET070200-UM	0.3	0.1	4	0.03	0.01	0.06
DCET070201-UM	0.5	0.1	4	0.03	0.01	0.06
DCET11T301-UM	0.3	0.1	4	0.03	0.01	0.06
DCET11T302-UM	0.3	0.2	4	0.03	0.01	0.06
DCET11T304-UM	1.25	0.5	4	0.05	0.02	0.1
DCGT070201-UM	0.3	0.1	1	0.03	0.01	0.08
DCGT070202-UM	0.5	0.1	1.5	0.07	0.02	0.16
DCGT070204-UM	1	0.3	2.5	0.15	0.08	0.25
DCGT070208-UM	1	0.3	2.5	0.2	0.12	0.3
DCGT11T301-UM	0.3	0.1	1	0.03	0.01	0.06

Insert	Depth of cut			Cutting feed		
	Rec	$a_p = \text{mm}$		Rec	$f_n = \text{mm/r}$	
		Min	Max.		Min	Max.
DCGT11T302-UM	0.3	0.1	1.5	0.03	0.01	0.06
DCGT11T304-UM	1.25	0.3	3	0.15	0.08	0.25
DCGT11T308-UM	1.25	0.3	3	0.2	0.12	0.3
DCGX070202-AL	1	0.3	4	0.12	0.05	0.15
DCGX070204-AL	1.5	0.5	4	0.2	0.1	0.3
DCGX11T302-AL	1	0.3	5.5	0.12	0.05	0.15
DCGX11T304-AL	1.5	0.5	5.5	0.2	0.1	0.3
DCGX11T308-AL	1.5	0.5	5.5	0.3	0.15	0.6
DCMT070202-MF	0.26	0.06	1.5	0.06	0.03	0.11
DCMT070202-PF	0.26	0.06	1.5	0.06	0.05	0.11
DCMT070202-UF	0.4	0.1	1.5	0.07	0.05	0.15
DCMT070204-MF	0.26	0.08	1.5	0.08	0.05	0.17
DCMT070204-MM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070204-PF	0.26	0.08	1.5	0.08	0.05	0.17
DCMT070204-PM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070204-UF	0.4	0.2	1.5	0.1	0.05	0.2
DCMT070204-UM	1	0.3	2.5	0.2	0.06	0.3
DCMT070208-MM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT070208-PM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT070208-UM	1	0.5	2.5	0.25	0.12	0.35
DCMT11T302-MF	0.35	0.08	2	0.08	0.04	0.15
DCMT11T302-PF	0.35	0.08	2	0.08	0.05	0.15
DCMT11T304-MF	0.35	0.11	2	0.11	0.06	0.23
DCMT11T304-MM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T304-PF	0.35	0.11	2	0.11	0.06	0.23
DCMT11T304-PM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T304-UF	0.4	0.2	2	0.1	0.05	0.2
DCMT11T304-UM	1.25	0.5	4	0.2	0.08	0.3
DCMT11T304-UR	2	1	4	0.25	0.15	0.3
DCMT11T308-MF	0.35	0.15	2	0.15	0.08	0.3
DCMT11T308-MM	0.8	0.5	3	0.2	0.1	0.3
DCMT11T308-PF	0.35	0.15	2	0.15	0.08	0.3
DCMT11T308-PM	0.8	0.5	3	0.2	0.1	0.3
DCMT11T308-UF	0.4	0.2	2	0.1	0.05	0.25
DCMT11T308-UM	1.25	0.5	4	0.25	0.12	0.4
DCMT11T312-MM	0.8	0.6	3	0.24	0.12	0.36
DCMT11T312-PM	0.8	0.6	3	0.24	0.12	0.36
DCMW11T304FP	0.5	0.1	3.3	0.1	0.05	0.2
DCMW11T308FP	1	0.1	3	0.15	0.05	0.4
DCMX070202-WF	0.3	0.1	1.5	0.1	0.03	0.15
DCMX070204-WF	0.7	0.3	2	0.12	0.05	0.25
DCMX070208-WF	0.7	0.3	2	0.15	0.09	0.35
DCMX11T302-WF	0.3	0.1	1.5	0.1	0.03	0.15
DCMX11T304-WF	1	0.3	3	0.2	0.07	0.3
DCMX11T308-WF	1	0.3	3	0.25	0.12	0.4
RCGX0602M0-AL	1	0.6	2.4	0.24	0.13	0.38
RCGX0803M0-AL	1.5	0.8	3.2	0.35	0.16	0.54
RCGX10T3M0-AL	2	1	4	0.36	0.16	0.63
RCMT0502M0	1	0.5	2	0.11	0.05	0.16
RCMT0602M0	1.5	0.5	2.4	0.15	0.05	0.17
RCMT060300	1.5	0.5	2.4	0.15	0.05	0.17
RCMT060300-SM	0.8	0.26	1.6	0.08	0.08	0.05
RCMT0803M0	2	0.8	3.2	0.2	0.05	0.25
RCMT0803M0-SM	1	0.33	2	0.08	0.08	0.06
RCMT10T3M0	2.5	1	4	0.25	0.06	0.32
RCMT10T3M0-SM	1.5	0.4	2.5	0.1	0.09	0.08
SCGX09T308-AL	1.5	0.5	5	0.31	0.16	0.62
SCMT09T304-MF	0.35	0.11	2	0.11	0.06	0.24
SCMT09T304-MM	0.8	0.25	3	0.16	0.08	0.24
SCMT09T304-PF	0.35	0.11	2	0.11	0.06	0.24
SCMT09T304-PM	0.8	0.25	3	0.16	0.08	0.24
SCMT09T308-MF	0.35	0.15	2	0.16	0.08	0.31
SCMT09T308-MM	0.8	0.5	3	0.21	0.1	0.31
SCMT09T308-PF	0.35	0.15	2	0.16	0.08	0.31
SCMT09T308-PM	0.8	0.5	3	0.21	0.1	0.31
SCMT09T308-UF	0.4	0.2	2	0.1	0.05	0.26
SCMT09T308-UM	1.25	0.5	4	0.26	0.12	0.41
TCEX050100L-F	0.15	0.05	0.8	0.04	0.01	0.06
TCEX050100R-F	0.15	0.05	0.8	0.04	0.02	0.06
TCEX050101L-F	0.15	0.05	0.8	0.05	0.01	0.07
TCEX050101R-F	0.15	0.05	0.8	0.06	0.02	0.1
TCEX06T100L-F	0.2	0.05	1	0.05	0.01	0.07
TCEX06T100R-F	0.5	0.05	1.5	0.05	0.01	0.07

Recommended depth of cut and cutting feed, metric

CoroTurn® 107 insert for turning

Insert	Depth of cut			Cutting feed			Insert	Depth of cut			Cutting feed		
	Rec	$a_p = \text{mm}$ Min Max.		Rec	$f_n = \text{mm/r}$ Min Max.			Rec	$a_p = \text{mm}$ Min Max.		Rec	$f_n = \text{mm/r}$ Min Max.	
TCEX06T101L-F	0.2	0.05	1	0.08	0.01	0.12	TCMT090204-UM	1	0.5	2.5	0.2	0.08	0.3
TCEX06T101R-F	0.08	0.05	1.5	0.08	0.01	0.12	TCMT090208-MM	0.6	0.38	2.25	0.15	0.08	0.23
TCEX06T102L-F	0.2	0.05	1	0.08	0.02	0.15	TCMT090208-PM	0.6	0.38	2.25	0.15	0.08	0.23
TCEX090200L-F	0.3	0.05	1.2	0.04	0.01	0.07	TCMT090208-UF	0.4	0.2	1.5	0.1	0.05	0.25
TCEX090200R-F	0.4	0.05	1.4	0.06	0.01	0.08	TCMT090208-UM	1	0.5	2.5	0.25	0.12	0.4
TCEX090201L-F	0.4	0.05	1.2	0.05	0.02	0.08	TCMT110202-UF	0.4	0.2	2	0.07	0.05	0.15
TCEX090201R-F	0.6	0.05	2	0.07	0.02	0.1	TCMT110204-UF	0.4	0.2	2	0.1	0.05	0.2
TCEX090202L-F	0.4	0.05	1.2	0.08	0.02	0.12	TCMT110204-UM	1.25	0.5	3	0.2	0.08	0.3
TCEX110300L-F	0.5	0.05	1.5	0.05	0.01	0.08	TCMT110204-UR	2	1	3	0.25	0.15	0.3
TCEX110300R-F	0.8	0.05	4	0.07	0.01	0.1	TCMT110208-UF	0.4	0.2	2	0.1	0.05	0.25
TCEX110301L-F	0.6	0.05	1.7	0.06	0.02	0.1	TCMT110208-UM	1.25	0.5	3	0.25	0.12	0.4
TCEX110301R-F	0.8	0.05	4	0.08	0.02	0.15	TCMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13
TCEX110302L-F	0.7	0.05	2	0.08	0.02	0.12	TCMT110302-PF	0.3	0.06	1.7	0.06	0.05	0.13
TCGT06T102L-K	0.3	0.1	0.7	0.04	0.03	0.11	TCMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19
TCGT06T102R-K	0.3	0.1	1	0.05	0.03	0.15	TCMT110304-MM	0.67	0.21	2.5	0.13	0.06	0.19
TCGT06T104L-K	0.5	0.15	0.7	0.05	0.03	0.14	TCMT110304-PF	0.3	0.1	1.7	0.1	0.05	0.19
TCGT06T104R-K	0.5	0.15	1	0.07	0.03	0.2	TCMT110304-PM	0.67	0.21	2.5	0.13	0.06	0.19
TCGT090202L-K	0.3	0.1	0.84	0.04	0.03	0.11	TCMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26
TCGT090202R-K	0.3	0.1	1.2	0.05	0.03	0.15	TCMT110308-MM	0.67	0.42	2.5	0.17	0.09	0.26
TCGT090204L-K	0.5	0.15	0.84	0.07	0.03	0.14	TCMT110308-PF	0.3	0.13	1.7	0.13	0.07	0.26
TCGT090204R-K	0.5	0.15	1.2	0.1	0.03	0.2	TCMT110308-PM	0.67	0.42	2.5	0.17	0.09	0.26
TCGT090204-UM	1	0.5	2.25	0.2	0.08	0.25	TCMT110312-PM	0.67	0.5	2.5	0.2	0.1	0.31
TCGT110201-UM	0.3	0.1	1	0.03	0.01	0.06	TCMT16T304-MF	0.35	0.11	2	0.11	0.06	0.23
TCGT110202L-K	0.3	0.1	1.05	0.04	0.03	0.11	TCMT16T304-MM	0.8	0.25	3	0.15	0.08	0.23
TCGT110204L-K	0.5	0.15	1.05	0.07	0.03	0.18	TCMT16T304-PF	0.35	0.11	2	0.11	0.06	0.23
TCGT110204R-K	0.5	0.15	1.5	0.1	0.03	0.25	TCMT16T304-PM	0.8	0.25	3	0.15	0.08	0.23
TCGT110204-UM	1.25	0.3	2.5	0.15	0.08	0.25	TCMT16T304-UM	1.5	0.5	4	0.2	0.08	0.3
TCGT110208-UM	1.25	0.3	2.5	0.2	0.12	0.3	TCMT16T304-UR	2.5	1	4	0.25	0.15	0.3
TCGT110301-UM	0.3	0.1	1	0.03	0.01	0.06	TCMT16T308-MM	0.8	0.5	3	0.2	0.1	0.3
TCGT110302L-K	0.3	0.1	1.05	0.04	0.03	0.11	TCMT16T308-PM	0.8	0.5	3	0.2	0.1	0.3
TCGT110302R-K	0.3	0.1	1.5	0.05	0.03	0.15	TCMT16T308-UF	0.4	0.2	2	0.1	0.05	0.25
TCGT110302-UM	0.3	0.1	1.5	0.07	0.02	0.12	TCMT16T308-UM	1.5	0.5	4	0.25	0.12	0.4
TCGT110304L-K	0.5	0.15	1.05	0.07	0.03	0.18	TCMT16T312-MM	0.8	0.6	3	0.24	0.12	0.36
TCGT110304R-K	0.5	0.15	1.5	0.1	0.03	0.25	TCMT16T312-PM	0.8	0.6	3	0.24	0.12	0.36
TCGT110304-UM	1.25	0.3	2.5	0.15	0.08	0.25	TCMW090204FP	0.5	0.1	2.2	0.1	0.05	0.2
TCGT110308-UM	1.25	0.3	2.5	0.2	0.12	0.3	TCMW110204FP	0.5	0.1	2.2	0.1	0.05	0.2
TCGT16T304-UM	1.5	0.5	2.8	0.11	0.08	0.18	TCMW110208FP	1	0.1	1.9	0.15	0.05	0.4
TCGT16T308-UM	1.5	0.5	2.8	0.14	0.12	0.25	TCMW110304FP	0.5	0.1	2.2	0.1	0.05	0.2
TCGX06T104-AL	1	0.5	2	0.2	0.1	0.3	TCMW110308FP	1	0.1	1.9	0.15	0.05	0.4
TCGX06T104L-WK	0.5	0.15	1	0.15	0.03	0.25	TCMW16T304FLP	0.5	0.1	7	0.1	0.05	0.2
TCGX06T104R-WK	0.5	0.15	1	0.15	0.03	0.25	TCMW16T304FP	0.5	0.1	3.4	0.1	0.05	0.2
TCGX090202-AL	1	0.3	4	0.12	0.05	0.15	TCMW16T304FRP	0.5	0.1	7	0.1	0.05	0.2
TCGX090204-AL	1.5	0.5	4	0.2	0.1	0.3	TCMW16T308FP	1	0.1	3.1	0.15	0.05	0.4
TCGX090204L-WK	0.5	0.15	1.2	0.2	0.04	0.28	TCMX090202-WF	0.3	0.1	1.5	0.1	0.03	0.15
TCGX090204R-WK	0.5	0.15	1.2	0.2	0.04	0.28	TCMX090204-WF	0.7	0.3	2	0.12	0.05	0.3
TCGX110202-AL	1	0.3	5	0.12	0.05	0.15	TCMX090208-WF	0.7	0.3	2	0.25	0.1	0.35
TCGX110204-AL	1.5	0.5	5	0.2	0.1	0.3	TCMX110302-WF	0.3	0.1	1.5	0.1	0.03	0.15
TCGX110204L-WK	0.5	0.15	1.5	0.2	0.05	0.3	TCMX110304-WF	1	0.3	2.5	0.2	0.07	0.3
TCGX110204R-WK	0.5	0.15	1.5	0.2	0.05	0.3	TCMX110308-WF	1	0.3	2.5	0.25	0.12	0.4
TCGX110208-AL	1.5	0.5	5	0.3	0.15	0.6	TCMX16T304-WF	1.2	0.3	3.5	0.2	0.07	0.35
TCGX110302-AL	1	0.3	5	0.12	0.05	0.15	TCMX16T308-WF	1.2	0.3	3.5	0.25	0.12	0.5
TCGX110304-AL	1.5	0.5	5	0.2	0.1	0.3	VBGT160401-UM	0.3	0.1	1	0.03	0.01	0.08
TCGX110304L-WK	0.5	0.15	1.5	0.2	0.05	0.3	VBGT160402-UM	0.5	0.1	1.5	0.07	0.02	0.16
TCGX110304R-WK	0.5	0.15	1.5	0.2	0.05	0.3	VBGT160404-UM	1.25	0.3	4	0.2	0.08	0.3
TCGX110308-AL	1.5	0.5	5	0.3	0.15	0.6	VBGT160408-UM	1.25	0.3	4	0.25	0.12	0.3
TCGX16T304-AL	1.5	0.5	7	0.2	0.1	0.3	VBMT110202-UF	0.4	0.2	1.5	0.07	0.05	0.15
TCGX16T308-AL	1.5	0.5	7	0.3	0.15	0.6	VBMT110204-UF	0.4	0.2	1.5	0.1	0.05	0.2
TCMT06T102-MF	0.26	0.06	1.5	0.06	0.03	0.11	VBMT110208-UF	0.4	0.2	1.5	0.1	0.05	0.25
TCMT06T102-PF	0.26	0.06	1.5	0.06	0.05	0.11	VBMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13
TCMT06T102-UF	0.4	0.2	1.5	0.07	0.05	0.15	VBMT110302-PF	0.3	0.06	1.7	0.06	0.05	0.13
TCMT06T104-MF	0.26	0.08	1.5	0.08	0.05	0.17	VBMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT06T104-PF	0.26	0.08	1.5	0.08	0.05	0.17	VBMT110304-PF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT06T104-UF	0.4	0.2	1.5	0.1	0.05	0.2	VBMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26
TCMT06T108-MF	0.26	0.11	1.5	0.11	0.06	0.23	VBMT110308-PF	0.3	0.13	1.7	0.13	0.07	0.26
TCMT06T108-PF	0.26	0.11	1.5	0.11	0.06	0.23	VBMT110312-PF	0.3	0.13	1.7	0.15	0.08	0.31
TCMT090202-MF	0.3	0.06	1.7	0.06	0.03	0.13	VBMT160402-MF	0.32	0.07	1.8	0.07	0.04	0.14
TCMT090202-PF	0.3	0.06	1.7	0.06	0.05	0.13	VBMT160402-PF	0.32	0.07	1.8	0.07	0.05	0.14
TCMT090204-MF	0.3	0.1	1.7	0.1	0.05	0.19	VBMT160404-MF	0.32	0.1	1.8	0.1	0.05	0.2
TCMT090204-MM	0.6	0.19	2.25	0.11	0.06	0.17	VBMT160404-MM	0.72	0.23	2.7	0.14	0.07	0.2
TCMT090204-PF	0.3	0.1	1.7	0.1	0.05	0.19	VBMT160404-PF	0.32	0.1	1.8	0.1	0.05	0.2
TCMT090204-PM	0.6	0.19	2.25	0.11	0.06	0.17	VBMT160404-PM	0.72	0.23	2.7	0.14	0.07	0.2
TCMT090204-UF	0.4	0.2	1.5	0.1	0.05	0.2	VBMT160404-UM	1.25	0.5	4	0.2	0.08	0.3
TCMT090204-UM	1	0.3	2.5	0.2	0.06	0.3	VBMT160404-UR	2	1	4	0.25	0.15	0.3

Recommended depth of cut and cutting feed, metric

CoroTurn® 107 insert for turning

T-Max® P insert for turning

Insert	Depth of cut			Cutting feed		
	Rec	$a_p = \text{mm}$		Rec	$f_n = \text{mm/r}$	
		Min	Max.		Min	Max.
VBMT160408-MF	0.32	0.14	1.8	0.14	0.07	0.27
VBMT160408-MM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160408-PF	0.32	0.14	1.8	0.14	0.07	0.27
VBMT160408-PM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160408-UM	1.25	0.5	4	0.25	0.12	0.4
VBMT160412-MM	0.72	0.54	2.7	0.22	0.11	0.32
VBMT160412-PF	0.32	0.14	1.8	0.16	0.09	0.32
VBMT160412-PM	0.72	0.54	2.7	0.22	0.11	0.32
VBMT160412-UM	1.25	0.5	4	0.25	0.1	0.4
VCET110301-UM	0.3	0.1	4	0.03	0.01	0.06
VCET110302-UM	0.5	0.2	4	0.03	0.02	0.08
VCEX110300L-F	1	0.03	3	0.05	0.01	0.14
VCEX110300R-F	1	0.03	4	0.05	0.01	0.2
VCEX110301L-F	1	0.05	3	0.07	0.01	0.21
VCEX110301R-F	1	0.05	4	0.1	0.01	0.3
VCGT110301-UM	0.3	0.1	1	0.03	0.01	0.08
VCGT110302-UM	0.5	0.1	1.5	0.07	0.02	0.16
VCGT110304-UM	1.25	0.3	3	0.15	0.08	0.25
VCGX110202-AL	1	0.3	3	0.12	0.05	0.15
VCGX110204-AL	1.5	0.5	3	0.2	0.1	0.3
VCGX110302-AL	1	0.3	3	0.12	0.05	0.15
VCGX110304-AL	1.5	0.5	3	0.2	0.1	0.3
VCGX160404-AL	1.5	0.5	5	0.2	0.1	0.3
VCGX160408-AL	1.5	0.5	5	0.3	0.15	0.6
VCGX160412-AL	1.5	0.5	5	0.4	0.15	0.8
VCGX220520-AL	1.5	0.5	7	0.6	0.25	1
VCGX220530-AL	1.5	0.5	7	0.6	0.25	1
VCMT110302-PF	0.3	0.07	1.5	0.07	0.05	0.13
VCMT110304-MF	0.3	0.1	1.5	0.1	0.05	0.2
VCMT110304-MM	0.77	0.31	2.55	0.15	0.1	0.25
VCMT110304-PF	0.3	0.1	1.5	0.1	0.05	0.2
VCMT110304-PM	0.77	0.31	2.55	0.15	0.1	0.25
VCMT110308-MM	0.77	0.61	2.55	0.2	0.13	0.33
VCMT110308-PM	0.77	0.61	2.55	0.2	0.13	0.33
VCMW110204FP	0.5	0.1	3.5	0.1	0.05	0.2
VCMW110304FP	0.5	0.1	3.5	0.1	0.05	0.2
VCMW160408FP	1	0.1	2.8	0.15	0.05	0.4
VCMW160412FP	1	0.1	2.1	0.15	0.05	0.4

Insert	Depth of cut			Cutting feed		
	Rec	$a_p = \text{mm}$		Rec	$f_n = \text{mm/r}$	
		Min	Max.		Min	Max.
CNMG090304-MF	0.40	0.10	1.50	0.15	0.05	0.25
CNMG090304-MM	1.50	0.15	4.00	0.25	0.10	0.40
CNMG090304-PF	0.40	0.25	1.50	0.15	0.07	0.30
CNMG090304-PM	2.00	0.40	4.00	0.20	0.10	0.30
CNMG090304-QM	3.00	1.00	4.50	0.25	0.18	0.30
CNMG090304-WF	0.50	0.30	1.50	0.15	0.05	0.25
CNMG090308-MF	0.40	0.10	1.50	0.20	0.10	0.35
CNMG090308-MM	2.00	0.50	4.00	0.25	0.10	0.40
CNMG090308-PF	0.40	0.30	1.50	0.15	0.10	0.30
CNMG090308-PM	2.00	0.50	4.00	0.30	0.15	0.50
CNMG090308-QM	3.00	1.00	4.50	0.35	0.20	0.50
CNMG090308-WF	1.00	0.30	2.00	0.30	0.10	0.30
DNMG110404-MF	0.40	0.10	1.50	0.15	0.05	0.30
DNMG110404-PF	0.40	0.25	1.50	0.15	0.07	0.30
DNMG110404-PM	2.00	0.40	5.00	0.20	0.10	0.30
DNMG110404-QM	3.00	1.00	5.50	0.25	0.18	0.30
DNMG110404-SF	0.40	0.15	1.50	0.12	0.08	0.22
DNMG110404-SM	1.00	0.40	4.00	0.15	0.10	0.30
DNMG110408-MF	0.40	0.10	1.50	0.20	0.10	0.40
DNMG110408-MM	2.00	0.50	4.40	0.25	0.10	0.45
DNMG110408-PF	0.40	0.30	1.50	0.20	0.10	0.40
DNMG110408-PM	2.00	0.50	5.00	0.30	0.15	0.50
DNMG110408-QM	3.00	1.00	5.50	0.35	0.20	0.50
DNMG110408-SF	0.50	0.20	1.50	0.15	0.10	0.25
DNMG110412-MM	2.00	0.50	4.40	0.30	0.10	0.60
DNMG110412-PF	0.80	0.35	1.50	0.25	0.15	0.50
DNMG110412-PM	2.00	0.80	5.00	0.35	0.18	0.50
DNMG110412-QM	3.00	1.00	5.50	0.35	0.25	0.60
DNMX110404-WF	1.00	0.20	1.50	0.20	0.08	0.30
DNMX110408-WF	1.00	0.20	3.00	0.30	0.10	0.40

CoroTurn® TR insert for turning

TR-DC1304-F	1.00	0.15	3.00	0.20	0.08	0.30
TR-DC1304S01020F	0.20	0.07	0.60	0.20	0.05	0.30
TR-DC1308-F	1.00	0.15	3.00	0.24	0.10	0.40
TR-DC1308-M	2.00	0.50	5.00	0.25	0.10	0.40
TR-DC1308S01020F	0.20	0.07	0.60	0.20	0.05	0.30
TR-DC1312-M	2.00	0.50	5.00	0.30	0.15	0.50
TR-VB1302-F	0.30	0.05	1.00	0.07	0.03	0.13
TR-VB1304-F	0.80	0.10	2.00	0.15	0.06	0.35
TR-VB1304S01020F	0.10	0.07	0.20	0.10	0.05	0.20
TR-VB1308-F	0.80	0.10	2.00	0.20	0.09	0.40
TR-VB1308S01020F	0.10	0.07	0.20	0.10	0.05	0.20
TR-VB1312-F	0.80	0.10	2.00	0.20	0.09	0.40

Recommended depth of cut and cutting feed, inch

CoroTurn® 107 insert for turning

Insert	Depth of cut			Cutting feed			Insert	Depth of cut			Cutting feed		
	Rec	$a_p = \text{inch}$ Min Max.		Rec	$f_n = \text{inch/r}$ Min Max.			Rec	$a_p = \text{inch}$ Min Max.		Rec	$f_n = \text{inch/r}$ Min Max.	
CCET060201-UM	.012	.004	.028	.001	0	.002	DCGT11T302-UM	.012	.004	.059	.001	0	.002
CCET060202-UM	.016	.008	.028	.001	0	.002	DCGT11T304-UM	.049	.012	.118	.006	.003	.01
CCET060204-UM	.028	.020	.039	.001	0	.002	DCGT11T308-UM	.049	.012	.118	.008	.005	.012
CCGT060201-UM	.012	.004	.028	.001	0	.002	DCGX070202-AL	.039	.012	.157	.005	.002	.006
CCGT060202-UM	.020	.004	.041	.002	.001	.003	DCGX070204-AL	.059	.02	.157	.008	.004	.012
CCGT060204-UM	.039	.020	.055	.006	.003	.008	DCGX11T302-AL	.039	.012	.217	.005	.002	.006
CCGT09T301-UM	.012	.004	.028	.001	0	.002	DCGX11T304-AL	.059	.02	.217	.008	.004	.012
CCGT09T302-UM	.020	.004	.041	.002	.001	.003	DCGX11T308-AL	.059	.02	.217	.012	.006	.024
CCGT09T304-UM	.049	.020	.083	.004	.003	.007	DCMT070202-MF	.01	.002	.059	.002	.001	.004
CCGT09T308-UM	.049	.020	.083	.006	.005	.010	DCMT070202-PF	.01	.002	.059	.002	.002	.004
CCGX060202-AL	.039	.012	.118	.005	.002	.006	DCMT070202-UF	.016	.004	.059	.003	.002	.006
CCGX060204-AL	.039	.012	.118	.005	.002	.006	DCMT070204-MF	.01	.003	.059	.003	.002	.007
CCGX09T304-AL	.059	.020	.197	.008	.004	.012	DCMT070204-MM	.024	.007	.089	.004	.002	.007
CCGX09T308-AL	.059	.020	.197	.012	.006	.024	DCMT070204-MM	.024	.007	.089	.004	.002	.007
CCGX120404-AL	.059	.020	.276	.008	.004	.012	DCMT070204-MM	.024	.007	.089	.004	.002	.007
CCGX120408-AL	.059	.020	.276	.012	.006	.024	DCMT070204-MM	.024	.007	.089	.004	.002	.007
CCMT060202-MF	.012	.002	.067	.002	.001	.004	DCMT070204-MM	.024	.007	.089	.004	.002	.007
CCMT060202-PF	.012	.002	.067	.002	.002	.004	DCMT070204-MM	.024	.007	.089	.004	.002	.007
CCMT060202-UF	.016	.004	.059	.003	.002	.006	DCMT070204-MM	.024	.007	.089	.004	.002	.007
CCMT060202-WF	.012	.004	.059	.004	.001	.006	DCMT070208-UM	.039	.02	.098	.01	.005	.014
CCMT060204-MF	.012	.004	.067	.003	.002	.007	DCMT11T302-MF	.014	.003	.079	.003	.002	.006
CCMT060204-MM	.025	.008	.094	.004	.002	.007	DCMT11T302-PF	.014	.003	.079	.003	.002	.006
CCMT060204-PF	.012	.004	.067	.003	.002	.007	DCMT11T304-MF	.014	.004	.079	.004	.002	.009
CCMT060204-PM	.025	.008	.094	.004	.002	.007	DCMT11T304-MM	.031	.01	.118	.006	.003	.009
CCMT060204-UF	.016	.008	.059	.004	.002	.008	DCMT11T304-MM	.031	.01	.118	.006	.003	.009
CCMT060204-UM	.039	.020	.098	.008	.003	.012	DCMT11T304-MM	.031	.01	.118	.006	.003	.009
CCMT060204-UR	.059	.039	.098	.010	.006	.012	DCMT11T304-MM	.031	.01	.118	.006	.003	.009
CCMT060204-WF	.031	.012	.079	.005	.002	.012	DCMT11T304-MM	.031	.01	.118	.006	.003	.009
CCMT060208-MM	.025	.016	.094	.006	.003	.009	DCMT11T304-MM	.031	.01	.118	.006	.003	.009
CCMT060208-PM	.025	.016	.094	.006	.003	.009	DCMT11T304-MM	.031	.01	.118	.006	.003	.009
CCMT060208-UF	.016	.008	.059	.004	.002	.010	DCMT11T308-MF	.014	.006	.079	.006	.003	.012
CCMT060208-UM	.039	.020	.098	.010	.005	.016	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT060208-WF	.031	.012	.079	.006	.004	.014	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT09T302-MF	.014	.003	.079	.003	.002	.006	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT09T302-PF	.014	.003	.079	.003	.002	.006	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT09T302-UF	.016	.004	.079	.003	.002	.006	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT09T302-WF	.012	.004	.059	.004	.001	.006	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT09T304-MF	.014	.004	.079	.004	.002	.009	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT09T304-MM	.025	.010	.118	.006	.003	.009	DCMT11T308-MM	.031	.02	.118	.008	.004	.012
CCMT09T304-PF	.014	.004	.079	.004	.002	.009	DCMW11T304FP	.02	.004	.13	.004	.002	.008
CCMT09T304-PM	.025	.010	.118	.006	.003	.009	DCMW11T308FP	.039	.004	.118	.006	.002	.016
CCMT09T304-UF	.016	.008	.079	.004	.002	.008	DCMX070202-WF	.012	.004	.059	.004	.001	.006
CCMT09T304-UM	.049	.020	.157	.008	.003	.012	DCMX070204-WF	.028	.012	.079	.005	.002	.01
CCMT09T304-UR	.079	.039	.157	.010	.006	.012	DCMX070208-WF	.028	.012	.079	.006	.004	.014
CCMT09T304-WF	.039	.012	.118	.008	.003	.012	DCMX11T302-WF	.012	.004	.059	.004	.001	.006
CCMT09T308-MF	.014	.006	.079	.006	.003	.012	DCMX11T304-WF	.039	.012	.118	.008	.003	.012
CCMT09T308-MM	.031	.02	.118	.008	.004	.012	DCMX11T308-WF	.039	.012	.118	.01	.005	.016
CCMT09T308-PF	.014	.006	.079	.006	.003	.012	RCGX0602M0-AL	.039	.024	.094	.009	.005	.015
CCMT09T308-PM	.031	.02	.118	.008	.004	.012	RCGX0803M0-AL	.059	.031	.126	.014	.006	.021
CCMT09T308-UM	.049	.02	.157	.01	.005	.016	RCGX10T3M0-AL	.079	.039	.157	.014	.006	.025
CCMT09T308-WF	.039	.012	.118	.01	.005	.02	RCMT0502M0	.039	.02	.079	.004	.002	.006
CCMT120404-MF	.017	.006	.094	.006	.003	.011	RCMT0602M0	.059	.02	.094	.006	.002	.007
CCMT120404-MM	.038	.012	.142	.007	.004	.011	RCMT060300	.059	.02	.094	.006	.002	.007
CCMT120404-PF	.017	.006	.094	.006	.003	.011	RCMT060300-SM	.031	.01	.063	.003	.003	.002
CCMT120404-PM	.038	.012	.142	.007	.004	.011	RCMT0803M0	.079	.031	.126	.008	.002	.01
CCMT120408-MM	.038	.024	.142	.009	.005	.014	RCMT0803M0-SM	.039	.013	.079	.003	.003	.002
CCMT120408-PM	.038	.024	.142	.009	.005	.014	RCMT10T3M0	.098	.039	.157	.01	.002	.013
CCMT120408-UM	.059	.02	.157	.01	.005	.016	RCMT10T3M0-SM	.059	.016	.098	.004	.004	.003
CCMT120412-MM	.038	.028	.142	.011	.006	.012	SCGX09T308-AL	.059	.02	.197	.012	.006	.024
CCMT120412-PM	.038	.028	.142	.011	.006	.017	SCMT09T304-MF	.014	.004	.079	.004	.002	.009
CCMW060204FP	.02	.004	.091	.004	.002	.008	SCMT09T304-MM	.031	.01	.118	.006	.003	.009
CCMW09T304FP	.02	.004	.134	.004	.002	.008	SCMT09T304-PF	.014	.004	.079	.004	.002	.009
CCMW09T308FP	.039	.004	.134	.006	.002	.016	SCMT09T304-PM	.031	.01	.118	.006	.003	.009
DCET070200-UM	.012	.004	.157	.001	0	.002	SCMT09T308-MF	.014	.006	.079	.006	.003	.012
DCET070201-UM	.02	.004	.157	.001	0	.002	SCMT09T308-MM	.031	.02	.118	.008	.004	.012
DCET11T301-UM	.012	.004	.157	.001	0	.002	SCMT09T308-PF	.014	.006	.079	.006	.003	.012
DCET11T302-UM	.012	.008	.157	.001	0	.002	SCMT09T308-PM	.031	.02	.118	.008	.004	.012
DCET11T304-UM	.049	.02	.157	.002	.001	.004	SCMT09T308-UF	.016	.008	.079	.004	.002	.01
DCGT070201-UM	.012	.004	.039	.001	0	.003	SCMT09T308-UM	.049	.02	.157	.01	.005	.016
DCGT070202-UM	.02	.004	.059	.003	.001	.006	TCEX050100L-F	.006	.002	.031	.002	0	.002
DCGT070204-UM	.039	.012	.098	.006	.003	.01	TCEX050100R-F	.006	.002	.031	.002	.001	.002
DCGT070208-UM	.039	.012	.098	.008	.005	.012	TCEX050101L-F	.006	.002	.031	.002	0	.003
DCGT11T301-UM	.012	.004	.039	.001	0	.002	TCEX050101R-F	.006	.002	.031	.002	.001	.004
							TCEX06T100L-F	.008	.002	.039	.002	0	.003
							TCEX06T100R-F	.02	.002	.059	.002	0	.003

Recommended depth of cut and cutting feed, inch

CoroTurn® 107 insert for turning

Insert	Depth of cut			Cutting feed		
	Rec	a _p = inch		Rec	f _n = inch/r	
		Min	Max.		Min	Max.
TCEX06T101L-F	.008	.002	.039	.003	0	.005
TCEX06T101R-F	.003	.002	.059	.003	0	.005
TCEX06T102L-F	.008	.002	.039	.003	.001	.006
TCEX090200L-F	.012	.002	.047	.002	0	.003
TCEX090200R-F	.016	.002	.055	.002	0	.003
TCEX090201L-F	.016	.002	.047	.002	.001	.003
TCEX090201R-F	.024	.002	.079	.003	.001	.004
TCEX090202L-F	.016	.002	.047	.003	.001	.005
TCEX110300L-F	.02	.002	.059	.002	0	.003
TCEX110300R-F	.031	.002	.157	.003	0	.004
TCEX110301L-F	.024	.002	.067	.002	.001	.004
TCEX110301R-F	.031	.002	.157	.003	.001	.006
TCEX110302L-F	.028	.002	.079	.003	.001	.005
TCGT06T102L-K	.012	.004	.028	.002	.001	.004
TCGT06T102R-K	.012	.004	.039	.002	.001	.006
TCGT06T104L-K	.02	.006	.028	.002	.001	.006
TCGT06T104R-K	.02	.006	.039	.003	.001	.008
TCGT090202L-K	.012	.004	.033	.002	.001	.004
TCGT090202R-K	.012	.004	.047	.002	.001	.006
TCGT090204L-K	.02	.006	.033	.003	.001	.006
TCGT090204R-K	.02	.006	.047	.004	.001	.008
TCGT090204-UM	.039	.02	.089	.008	.003	.01
TCGT110201-UM	.012	.004	.039	.001	0	.002
TCGT110202L-K	.012	.004	.041	.002	.001	.004
TCGT110204L-K	.02	.006	.041	.003	.001	.007
TCGT110204R-K	.02	.006	.059	.004	.001	.01
TCGT110204-UM	.049	.012	.098	.006	.003	.01
TCGT110208-UM	.049	.012	.098	.008	.005	.012
TCGT110301-UM	.012	.004	.039	.001	0	.002
TCGT110302L-K	.012	.004	.041	.002	.001	.004
TCGT110302R-K	.012	.004	.059	.002	.001	.006
TCGT110302-UM	.012	.004	.059	.003	.001	.005
TCGT110304L-K	.02	.006	.041	.003	.001	.007
TCGT110304R-K	.02	.006	.059	.004	.001	.01
TCGT110304-UM	.049	.012	.098	.006	.003	.01
TCGT110308-UM	.049	.012	.098	.008	.005	.012
TCGT16T304-UM	.059	.02	.11	.004	.003	.007
TCGT16T308-UM	.059	.02	.11	.006	.005	.01
TCGX06T104-AL	.039	.02	.079	.008	.004	.012
TCGX06T104L-WK	.02	.006	.039	.006	.001	.01
TCGX06T104R-WK	.02	.006	.039	.006	.001	.01
TCGX090202-AL	.039	.012	.157	.005	.002	.006
TCGX090204-AL	.059	.02	.157	.008	.004	.012
TCGX090204L-WK	.02	.006	.047	.008	.002	.011
TCGX090204R-WK	.02	.006	.047	.008	.002	.011
TCGX110202-AL	.039	.012	.197	.005	.002	.006
TCGX110204-AL	.059	.02	.197	.008	.004	.012
TCGX110204L-WK	.02	.006	.059	.008	.002	.012
TCGX110204R-WK	.02	.006	.059	.008	.002	.012
TCGX110208-AL	.059	.02	.197	.012	.006	.024
TCGX110302-AL	.039	.012	.197	.005	.002	.006
TCGX110304-AL	.059	.02	.197	.008	.004	.012
TCGX110304L-WK	.02	.006	.059	.008	.002	.012
TCGX110304R-WK	.02	.006	.059	.008	.002	.012
TCGX110308-AL	.059	.02	.197	.012	.006	.024
TCGX16T304-AL	.059	.02	.276	.008	.004	.012
TCGX16T308-AL	.059	.02	.276	.012	.006	.024
TCMT06T102-MF	.01	.002	.059	.002	.001	.004
TCMT06T102-PF	.01	.002	.059	.002	.002	.004
TCMT06T102-UF	.016	.008	.059	.003	.002	.006
TCMT06T104-MF	.01	.003	.059	.003	.002	.007
TCMT06T104-PF	.01	.003	.059	.003	.002	.007
TCMT06T104-UF	.016	.008	.059	.004	.002	.008
TCMT06T108-MF	.01	.004	.059	.004	.002	.009
TCMT06T108-PF	.01	.004	.059	.004	.002	.009
TCMT090202-MF	.012	.002	.067	.002	.001	.005
TCMT090202-PF	.012	.002	.067	.002	.002	.005
TCMT090204-MF	.012	.004	.067	.004	.002	.007
TCMT090204-MM	.024	.007	.089	.004	.002	.007
TCMT090204-PF	.012	.004	.067	.004	.002	.007
TCMT090204-PM	.024	.007	.089	.004	.002	.007
TCMT090204-UF	.016	.008	.059	.004	.002	.008
TCMT090204-UM	.039	.012	.098	.008	.002	.012

Insert	Depth of cut			Cutting feed		
	Rec	a _p = inch		Rec	f _n = inch/r	
		Min	Max.		Min	Max.
TCMT090204-UM	.039	.02	.098	.008	.003	.012
TCMT090208-MM	.024	.015	.089	.006	.003	.009
TCMT090208-PM	.024	.015	.089	.006	.003	.009
TCMT090208-UF	.016	.008	.059	.004	.002	.01
TCMT090208-UM	.039	.02	.098	.01	.005	.016
TCMT110202-UF	.016	.008	.079	.003	.002	.006
TCMT110204-UF	.016	.008	.079	.004	.002	.008
TCMT110204-UM	.049	.02	.118	.008	.003	.012
TCMT110204-UR	.079	.039	.118	.01	.006	.012
TCMT110208-UF	.016	.008	.079	.004	.002	.01
TCMT110208-UM	.049	.02	.118	.01	.005	.016
TCMT110302-MF	.012	.002	.067	.002	.001	.005
TCMT110302-PF	.012	.002	.067	.002	.002	.005
TCMT110304-MF	.012	.004	.067	.004	.002	.007
TCMT110304-MM	.026	.008	.098	.005	.002	.007
TCMT110304-PF	.012	.004	.067	.004	.002	.007
TCMT110304-PM	.026	.008	.098	.005	.002	.007
TCMT110308-MF	.012	.005	.067	.005	.003	.01
TCMT110308-MM	.026	.017	.098	.007	.004	.01
TCMT110308-PF	.012	.005	.067	.005	.003	.01
TCMT110308-PM	.026	.017	.098	.007	.004	.01
TCMT110312-PM	.026	.02	.098	.008	.004	.012
TCMT16T304-MF	.014	.004	.079	.004	.002	.009
TCMT16T304-MM	.031	.01	.118	.006	.003	.009
TCMT16T304-PF	.014	.004	.079	.004	.002	.009
TCMT16T304-PM	.031	.01	.118	.006	.003	.009
TCMT16T304-UM	.059	.02	.157	.008	.003	.012
TCMT16T304-UR	.098	.039	.157	.01	.006	.012
TCMT16T308-MM	.031	.02	.118	.008	.004	.012
TCMT16T308-PM	.031	.02	.118	.008	.004	.012
TCMT16T308-UF	.016	.008	.079	.004	.002	.01
TCMT16T308-UM	.059	.02	.157	.01	.005	.016
TCMT16T312-MM	.031	.024	.118	.009	.005	.014
TCMT16T312-PM	.031	.024	.118	.009	.005	.014
TCMW090204FP	.02	.004	.087	.004	.002	.008
TCMW110204FP	.02	.004	.087	.004	.002	.008
TCMW110208FP	.039	.004	.075	.006	.002	.016
TCMW110304FP	.02	.004	.087	.004	.002	.008
TCMW110308FP	.039	.004	.075	.006	.002	.016
TCMW16T304FLP	.02	.004	.276	.004	.002	.008
TCMW16T304FP	.02	.004	.134	.004	.002	.008
TCMW16T304FRP	.02	.004	.276	.004	.002	.008
TCMW16T308FP	.039	.004	.122	.006	.002	.016
TCMX090202-WF	.012	.004	.059	.004	.001	.006
TCMX090204-WF	.028	.012	.079	.005	.002	.012
TCMX090208-WF	.028	.012	.079	.01	.004	.014
TCMX110302-WF	.012	.004	.059	.004	.001	.006
TCMX110304-WF	.039	.012	.098	.008	.003	.012
TCMX110308-WF	.039	.012	.098	.01	.005	.016
TCMX16T304-WF	.047	.012	.138	.008	.003	.014
TCMX16T308-WF	.047	.012	.138	.01	.005	.02
VBGT160401-UM	.012	.004	.039	.001	0	.003
VBGT160402-UM	.02	.004	.059	.003	.001	.006
VBGT160404-UM	.049	.012	.157	.008	.003	.012
VBGT160408-UM	.049	.012	.157	.01	.005	.012
VBMT110202-UF	.016	.008	.059	.003	.002	.006
VBMT110204-UF	.016	.008	.059	.004	.002	.008
VBMT110208-UF	.016	.008	.059	.004	.002	.01
VBMT110302-MF	.012	.002	.067	.002	.001	.005
VBMT110302-PF	.012	.002	.067	.002	.002	.005
VBMT110304-MF	.012	.004	.067	.004	.002	.007
VBMT110304-PF	.012	.004	.067	.004	.002	.007
VBMT110308-MF	.012	.005	.067	.005	.003	.01
VBMT110308-PF	.012	.005	.067	.005	.003	.01
VBMT110312-PF	.012	.005	.067	.006	.003	.012
VBMT160402-MF	.013	.003	.071	.003	.002	.006
VBMT160402-PF	.013	.003	.071	.003	.002	.006
VBMT160404-MF	.013	.004	.071	.004	.002	.008
VBMT160404-MM	.028	.009	.106	.006	.003	.008
VBMT160404-PF	.013	.004	.071	.004	.002	.008
VBMT160404-PM	.028	.009	.106	.006	.003	.008
VBMT160404-UM	.049	.02	.157	.008	.003	.012
VBMT160404-UR	.079	.039	.157	.01	.006	.012

Recommended depth of cut and cutting feed, inch

CoroTurn® 107 insert for turning

Insert	Depth of cut			Cutting feed		
	Rec	a _p = inch		Rec	f _n = inch/r	
		Min	Max.		Min	Max.
VBMT160408-MF	.013	.006	.071	.006	.003	.011
VBMT160408-MM	.028	.018	.106	.007	.004	.011
VBMT160408-PF	.013	.006	.071	.006	.003	.011
VBMT160408-PM	.028	.018	.106	.007	.004	.011
VBMT160408-UM	.049	.02	.157	.01	.005	.016
VBMT160412-MM	.028	.021	.106	.009	.004	.013
VBMT160412-PF	.013	.006	.071	.006	.004	.013
VBMT160412-PM	.028	.021	.106	.009	.004	.013
VBMT160412-UM	.049	.02	.157	.01	.004	.016
VCET110301-UM	.012	.004	.157	.001	0	.002
VCET110302-UM	.02	.008	.157	.001	.001	.003
VCEX110300L-F	.039	.001	.118	.002	0	.006
VCEX110300R-F	.039	.001	.157	.002	0	.008
VCEX110301L-F	.039	.002	.118	.003	0	.008
VCEX110301R-F	.039	.002	.157	.004	0	.012
VCGT110301-UM	.012	.004	.039	.001	0	.003
VCGT110302-UM	.02	.004	.059	.003	.001	.006
VCGT110304-UM	.049	.012	.118	.006	.003	.01
VCGX110202-AL	.039	.012	.118	.005	.002	.006
VCGX110204-AL	.059	.02	.118	.008	.004	.012
VCGX110302-AL	.039	.012	.118	.005	.002	.006
VCGX110304-AL	.059	.02	.118	.008	.004	.012
VCGX160404-AL	.059	.02	.197	.008	.004	.012
VCGX160408-AL	.059	.02	.197	.012	.006	.024
VCGX160412-AL	.059	.02	.197	.016	.006	.031
VCGX220520-AL	.059	.02	.276	.024	.01	.039
VCGX220530-AL	.059	.02	.276	.024	.01	.039
VCMT110302-PF	.012	.003	.059	.003	.002	.005
VCMT110304-MF	.012	.004	.059	.004	.002	.008
VCMT110304-MM	.03	.012	.1	.006	.004	.01
VCMT110304-PF	.012	.004	.059	.004	.002	.008
VCMT110304-PM	.03	.012	.1	.006	.004	.01
VCMT110308-MM	.03	.024	.1	.008	.005	.013
VCMT110308-PM	.03	.024	.1	.008	.005	.013
VCMW110204FP	.02	.004	.138	.004	.002	.008
VCMW110304FP	.02	.004	.138	.004	.002	.008
VCMW160408FP	.039	.004	.11	.006	.002	.016
VCMW160412FP	.039	.004	.083	.006	.002	.016

CoroTurn® TR insert for turning

TR-DC1304-F	.039	.006	.118	.008	.003	.012
TR-DC1304S01020F	.008	.003	.024	.008	.002	.012
TR-DC1308-F	.039	.006	.118	.009	.004	.016
TR-DC1308-M	.079	.020	.197	.010	.004	.016
TR-DC1308S01020F	.008	.003	.024	.008	.002	.012
TR-DC1312-M	.079	.020	.197	.012	.006	.020
TR-VB1302-F	.012	.002	.039	.003	.001	.005
TR-VB1304-F	.031	.004	.079	.006	.002	.014
TR-VB1304S01020F	.004	.003	.008	.004	.002	.008
TR-VB1308-F	.031	.004	.079	.008	.004	.016
TR-VB1308S01020F	.004	.003	.008	.004	.002	.008
TR-VB1312-F	.031	.004	.079	.008	.004	.016

T-Max® P insert for turning

Insert	Depth of cut			Cutting feed		
	Rec	a _p = inch		Rec	f _n = inch/r	
		Min	Max.		Min	Max.
CNMG090304-MF	.016	.004	.059	.006	.002	.010
CNMG090304-MM	.059	.006	.157	.010	.004	.016
CNMG090304-PF	.016	.010	.059	.006	.003	.012
CNMG090304-PM	.079	.016	.157	.008	.004	.012
CNMG090304-QM	.118	.039	.177	.010	.007	.012
CNMG090304-WF	.020	.012	.059	.006	.002	.010
CNMG090308-MF	.016	.004	.059	.008	.004	.014
CNMG090308-MM	.079	.020	.157	.010	.004	.016
CNMG090308-PF	.016	.012	.059	.006	.004	.012
CNMG090308-PM	.079	.020	.157	.012	.006	.020
CNMG090308-QM	.118	.039	.177	.014	.008	.020
CNMG090308-WF	.039	.012	.079	.012	.004	.012
DNMG110404-MF	.016	.004	.059	.006	.002	.012
DNMG110404-PF	.016	.010	.059	.006	.003	.012
DNMG110404-PM	.079	.016	.197	.008	.004	.012
DNMG110404-QM	.118	.039	.217	.010	.007	.012
DNMG110404-SF	.016	.006	.059	.005	.003	.009
DNMG110404-SM	.039	.016	.157	.006	.004	.012
DNMG110408-MF	.016	.004	.059	.008	.004	.016
DNMG110408-MM	.079	.020	.173	.010	.004	.018
DNMG110408-PF	.016	.012	.059	.008	.004	.016
DNMG110408-PM	.079	.020	.197	.012	.006	.020
DNMG110408-QM	.118	.039	.217	.014	.008	.020
DNMG110408-SF	.020	.008	.059	.006	.004	.010
DNMG110412-MM	.079	.020	.173	.012	.004	.024
DNMG110412-PF	.031	.014	.059	.010	.006	.020
DNMG110412-PM	.079	.031	.197	.014	.007	.020
DNMG110412-QM	.118	.039	.217	.014	.010	.024
DNMX110404-WF	.039	.008	.059	.008	.003	.012
DNMX110408-WF	.039	.008	.118	.012	.004	.016

Grades for general turning

P Steel, cast steel, martensitic stainless steel, long chipping malleable iron

Basic grades



GC4305 (HC) - P05 (P01-P15)

A CVD-coated grade recommended for stable conditions when higher metal removal rate is needed in medium to rough steel applications. Is able to withstand high temperatures.



GC4315 (HC) - P15 (P01-P30)

A CVD-coated carbide grade for finishing to roughing in applications with continuous cut to light intermittence of steel and steel castings.



GC4325 (HC) - P25 (P10-P40)

A CVD-coated carbide grade for finishing to roughing of steel and steel castings. This grade can handle continuous cuts as well as interrupted cuts at high metal removal rates. A grade for a broad application area.



GC4335 (HC) - P35 (P25-P45)

A CVD-coated grade for steel turning with secure and reliable performance in tough and demanding operations. Ideal for difficult surfaces, vibration issues, heavy interruptions and unstable conditions.

Complementary grades



GC1525 (HC) - P15 (P05-P25)

A PVD coated cermet for finishing and semi-finishing of low carbon and low alloyed steels. To be used when good surface quality is demanded at medium to high cutting speeds. $f_n \times a_p < 0.35 \text{ mm}^2$.



CT5015 (HT) - P10 (P01-P20)

An uncoated cermet for finishing when high surface quality is required. $f_n \times a_p < 0.35 \text{ mm}^2$

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al_2O_3).

CM Mixed ceramics containing primarily aluminium oxide (Al_2O_3) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si_3N_4)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for general turning

M

Austenitic stainless steel, cast steel, manganese steel, alloy cast iron, malleable iron, free cutting steel.

Basic grades



GC2015 (HC) – M15 (M05-M25)

A CVD-coated carbide grade for finishing and light roughing. A choice for continuous cuts at moderate to high cutting speeds.



GC2025 (HC) – M25 (M15-M35)

A CVD-coated carbide optimized for semi-finishing to roughing. The grade performs well in interrupted cuts.



GC2220 (HC) - M20 (M15-M30)

A grade optimized for stainless steel. For external and internal turning in rough to medium operations, wet and dry machining. For stable cutting conditions with continuous and light interruptions in high to average cutting speeds.



GC2035 (HC) – M35 (M25-M40)

A PVD-coated carbide. To be used for semi-finishing to roughing at low to moderate cutting speeds.

Complementary grades



GC1115 (HC) – M15 (M05-M25)

A PVD-coated carbide grade. Recommended to be used at low feedrate or medium cutting speed.



GC1125 (HC) - M25 (M10-M30)

A PVD-coated grade for toughness demanding operations.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW	Uncoated hardmetal containing primarily tungsten carbide (WC)
HT	Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
HC	Hardmetals as above, but coated

Ceramics:

CA	Oxide ceramics containing primarily aluminium oxide (Al ₂ O ₃).
CM	Mixed ceramics containing primarily aluminium oxide (Al ₂ O ₃) but containing components other than oxides.
CN	Nitride ceramics containing primarily silicon nitride (Si ₃ N ₄)
CC	Ceramics as above, but coated.

Diamond:

DP	Polycrystalline diamond ¹⁾
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Boron nitride:

BN	Polycrystalline boron nitride ¹⁾
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¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for general turning



Cast iron, chilled cast iron, short chipping malleable iron.

Basic grades



GC3210 (HC) – K10 (K01-K20)

A CVD coated cemented carbide grade. To be used in good to average machining conditions in all cast iron materials. A grade suitable for continuous to interrupted cut.



GC3225 (HC) – K25 (K15-K35)

A CVD coated cemented carbide grade. To be used in average to difficult machining conditions in all cast iron materials. A grade suitable for light to heavy interrupted cuts.



CC6190 (CN) – K10 (K05 – K15)

Pure silicon nitride based ceramic. To be used in high speed roughing to finishing of cast irons under good conditions. Is able to handle some interruptions.

Complementary grades



H13A (HW) – K20 (K10-K30)

Uncoated carbide grade. For moderate to low speeds and high feeds in cast iron.



CB7525 (BN) - K05 (K01-K10)

A Cubic boron nitride grade. For high speed finishing of grey cast iron under continuous as well as interrupted conditions.



CC650 (CM) – K01 (K01-K05)

Mixed Al₂O₃-based ceramic. Recommended for high speed finishing of grey cast irons and hardened cast irons under stable conditions.



CB7925 (BN) - K05 (K01-K10)

A cubic boron nitride grade. Suited for both machining in grey cast iron and chilled iron under continuous as well as interrupted conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).

CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for general turning

N

Non ferrous metals

Basic grades



H10 (HW) – N15 (N01-N25)

Uncoated carbide grade. For rough to finish turning of aluminum alloys.



CD05 – N01 (N01-N10)

A polycrystalline diamond grade for finishing and semi-finishing of highly abrasive non-ferrous and non-metallic materials, Matrix Composites (MMC), fiberglass, fiberboard and wood laminates.



CD10 (DP) – N05 (N01-N10)

A polycrystalline diamond grade for finishing and semi-finishing of non-ferrous and non-metallic materials.

Complementary grades



H13A (HW) - N15 (N05-N25)

Uncoated carbide grade for medium to rough turning of aluminum alloys.



GC1125 (HC) – N25 (N15-N30)

A PVD-coated carbide grade to be used in toughness demanding operations, or when a sharp edge is needed.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al_2O_3).

CM Mixed ceramics containing primarily aluminium oxide (Al_2O_3) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si_3N_4)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for general turning

S Heat resistant and super alloys

B

Basic grades



GC1105 (HC) – S15 (S05-S20)
A PVD-coated carbide grade. Suitable for finishing to medium machining.

Complementary grades



GC1125 (HC) – S25 (S20-S30)
A PVD-coated carbide grade to be used at low speeds, or light intermittent cuts.

C



S05F (HC) - S05 (S05-S15)
A CVD-coated carbide grade. For high speed finishing, or long cuts at lower speeds. For applications where notch is not a significant problem, i.e. round inserts, large entry angle and softer materials. This grade can also be used in roughing applications.



H13A (HW) – S15 (S10-S30)
Uncoated carbide grade for moderate to low speeds.

D



GC1115 (HC) - S20 (S15-S25)
A PVD-coated carbide grade. The grade has an excellent performance in combination with sharp edge geometries. Suitable for medium to rough turning in smearing materials.

S Titanium alloys

Basic grades



H13A (HW) – S15 (S10-S30)
Uncoated carbide grade for moderate to low speeds.

E

Complementary grades



GC1115 (HC) - S20 (S15-S25)
A PVD-coated carbide grade. The grade has an excellent performance in combination with sharp edge geometries. Suitable for medium to rough turning in smearing materials.

F

G

H

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

- HW Uncoated hardmetal containing primarily tungsten carbide (WC)
- HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
- HC Hardmetals as above, but coated

Ceramics:

- CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).
- CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.
- CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)
- CC Ceramics as above, but coated.

Diamond:

- DP Polycrystalline diamond¹⁾

Boron nitride:

- BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for general turning



Hardened materials

Basic grades



CB7105 (BN) - H05 (H01-H10)

For continuous cut, smaller depth of cut and smaller chip loads at high speed.



CB7015 (BN) - H10 (H05 - H15)

A cubic boron nitride grade. To be used in continuous and light interrupted cuts at high speed in case hardened steels.



CB7115 (BN) - H15 (H10-H20)

For continuous cut to light interrupted cut or larger chip loads at medium to high speed.



CB7025 (BN) - H15 (H10-H20)

A cubic boron nitride composite for hardened ferrous material. Suitable for cuts with substantial interruptions at medium speeds in case hardened steels, bearing steels.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW	Uncoated hardmetal containing primarily tungsten carbide (WC)
HT	Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
HC	Hardmetals as above, but coated

Ceramics:

CA	Oxide ceramics containing primarily aluminium oxide (Al_2O_3).
CM	Mixed ceramics containing primarily aluminium oxide (Al_2O_3) but containing components other than oxides.
CN	Nitride ceramics containing primarily silicon nitride (Si_3N_4)
CC	Ceramics as above, but coated.

Diamond:

DP	Polycrystalline diamond ¹⁾
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Boron nitride:

BN	Polycrystalline boron nitride ¹⁾
----	---

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for general turning

ENG

	ISO	ANSI		
P Steel	01	C8	GC 4305	▲ ▼
	10	C7	GC 4315	
	20	C6	GC 4325	
	30	C6	GC 4335	
	40	C5	GC 4335	
	50	C5	GC 4335	
M Stainless steel	10	-	GC 2015	▲ ▼
	20	-	GC 2220	
	30	-	GC 2025	
	40	-	GC 2035	
K Cast iron	01	C4	GC 3210	▲ ▼
	10	C3	GC 3210	
	20	C2	GC 3225	
	30	C1	GC 3225	
N Non-ferrous metals	01	C4	H10	▲ ▼
	10	C3	CD 10	
	20	C2	CD 05	
	30	C1	H13A	
S Heat resistant and super alloys	01	-	Ni-based: CC 670, CC 6060, CC 6160, S05F, GC 1105, GC 1115, CC 6065, H13A, CC 650, Ti-based: H13A, GC 1115	▲ ▼
	10	-		
	20	-		
	30	-		
H Hardened materials	01	C4	CB 7105	▲ ▼
	10	C3	CB 7015	
	20	C2	CB 7115, CB 7025	
	30	C1	CB 7525	

The position and form of the grade symbols indicate the suitable field of application.

Centre of the field of application.

Recommended field of application.

▲ Wear resistance

▼ Toughness



= Basic grades



= Complementary grades

Parting and grooving

External grooving

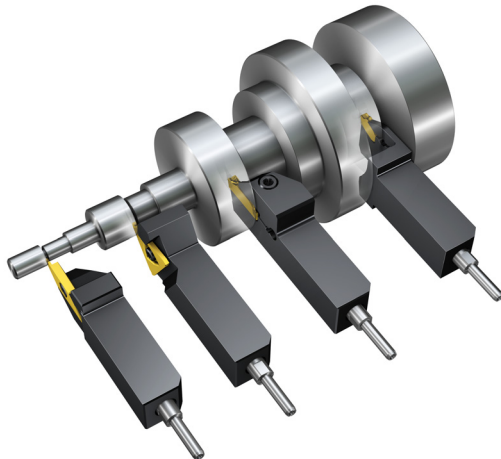
CoroCut® 1-2

Max. cutting depth: 6–16 mm (.240–.630 inch)
Cutting width: 1.5–3 mm (.060–0.120 inch)



CoroCut® QD

Max. cutting depth: >16 mm (.630 inch)
Cutting width: 1.5–3 mm (.060–.120 inch)



CoroCut® XS

Max. cutting depth: 1.3–3.7 mm (.050–.150 inch)
Cutting width: 0.5–2.5 mm (.020–.098 inch)



CoroCut® 3

Max. cutting depth: 3–6 mm (.120–.240 inch)
Cutting width: 0.5–3.18 mm (.020–.125 inch)



Internal grooving

CoroTurn® XS

Max. cutting depth: 2.5 mm (.100 inch)
Cutting width: ≥ 0.78 mm (.031 inch)
Min. hole diameter: 4.2 mm (.165 inch)



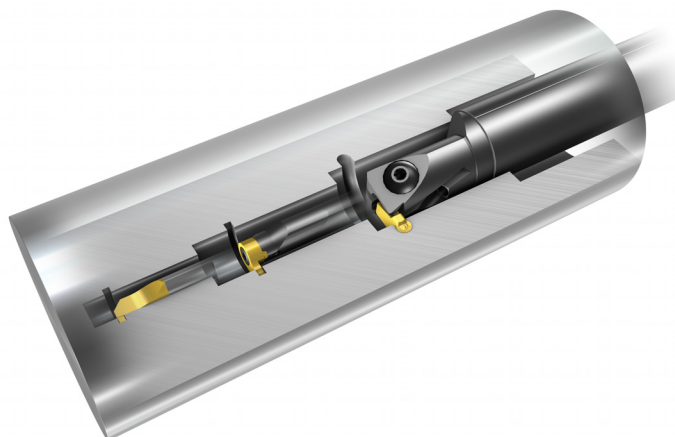
CoroCut® MB

Max. cutting depth: 8 mm (.315 inch)
Cutting width: ≥ 0.73 mm (.029 inch)
Min. hole diameter: 10 mm (.394 inch)



T-Max® Q-Out

Max. cutting depth: 5 mm (.197 inch)
Cutting width: ≥ 1.85 mm (.073 inch)
Min. hole diameter: 12 mm (.472 inch)



Parting off

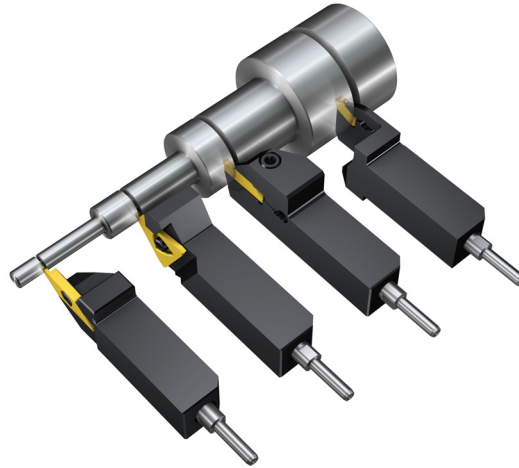
CoroCut® XS

Diameter: <8 mm (.315 inch)
Cutting width ≥ 0.7 mm (.030 inch)



CoroCut® 1-2

Diameter: 6–32 mm (.240–1.25 inch)
Cutting width: ≥ 1.5 mm (.060 inch)



CoroCut® 3

Diameter: 6–12 mm (.240–0.500 inch)
Cutting width ≥ 1 mm (.040 inch)

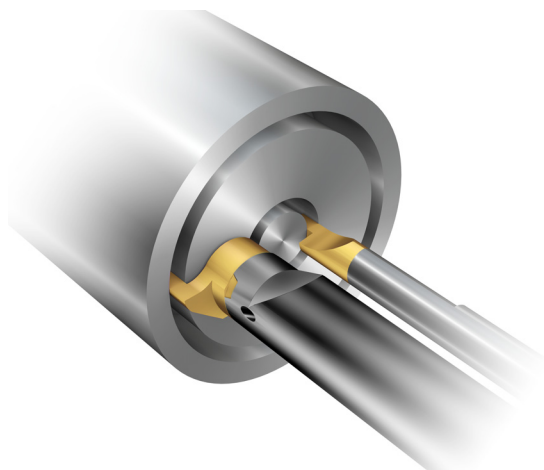


CoroCut® QD

Diameter: ≥ 20 mm (.790 inch)
Cutting width 1–3 mm (.039–.120 inch)



Face grooving



CoroTurn® XS

Min. groove diameter: 6 mm (.240 inch)
Max. cutting depth: 2–30 mm (.080–1.180 inch)
Cutting width: 1–5 mm (.040–.200 inch)



CoroCut® MB

Min. groove diameter: 12 mm (.470 inch)
Max. cutting depth: 1.5–10 mm (.060–.394 inch)
Cutting width: 1–4 mm (.040–1.570 inch)



B

CoroCut® 1-2 B7

Inserts B8-B19
 External tools B47-B64
 Internal tools B65-B68

CoroCut® QD B20

Inserts B21-B26
 External tools B47-B62

C

CoroCut® 3 B27

Inserts B28-B34
 External tools B47-B64

T-Max® Q-Cut B35

Inserts B36-B37
 External tools B63-B64
 Internal tools B65-B68

D

T-Max® U-Lock B38

Inserts B39
 Internal tools B65

E

CoroCut® XS B40

Inserts B41-B44
 External tools B47-B64

CoroThread® 266 B45

Inserts B46
 External tools C4

F

CoroTurn® XS B70

Cutting tools B72-B82
 Adaptors D2

CoroCut® MB B71

Cutting tools B84-B90
 Adaptors D2

G

H

I

J

Tool overview

External tools

		CoroCut® 1-2			CoroCut® QD		CoroCut® 3			CoroCut® XS		
		QS™-HP shank tools	QS™ shank tools	Rectangular shank tools	QS™-HP shank tools	Rectangular shank tools	QS™-HP shank tools	QS™ shank tools	Rectangular shank tools	QS™-HP shank tools	QS™ shank tools	Rectangular shank tools
		CZC _{MS}										
Metric	7 x 7					B47						
	10 x 10	B47	B48	B49	B47	B49	B47	B48	B49	B47	B48	B49
	12 x 12	B50	B51	B52	B50	B52	B50	B51	B52	B50	B51	B52
	16 x 16	B53	B54	B55	B53	B55	B53	B54	B55	B53	B54	B55
Inch	3/8 x 3/8		B56	B57	B56	B57	B56	B56	B57	B56		
	1/2 x 1/2	B58	B59	B60	B58	B60	B58	B59	B60	B58	B59	B60
	5/8 x 5/8	B61	B62	B62	B61	B62	B61	B62	B62	B61	B62	B62

		CoroCut® 1-2	CoroCut® 3	CoroCut® XS	T-Max® Q-Cut
		CoroTurn® SL head for grooving			
		CZC _{MS}			
Metric	16				B63
	20				B63
	25	B64	B64	B64	B64

Internal tools










		CoroCut® 1-2	T-Max® Q-Cut		T-Max® U-Lock
		Cylindrical shank without clamping features	Cylindrical shank without clamping features	Cylindrical shank with 3 flats	Cylindrical shank with 3 flats
		Boring bar			
		CZC _{MS}			
Metric	16	B65	B65		B65
	20	B66	B66		
	25	B66	B66	B69	
Inch	5/8	B67	B67	B67	
	3/4	B68	B68	B67	
	1	B68		B68	










Cutting tools

		CoroTurn® XS				CoroCut® MB				
		Pre-parting	Grooving	Face grooving	Profiling	Pre-parting	Grooving	Face grooving	Profiling	Back boring
		Solid carbide tool				Solid carbide head				
		CZC _{MS}								
Metric	4		B73		B82					
	5	B72	B74		B82					
	6		B76	B80	B82					
	7		B78		B83	B84	B85		B90	A105
	8			B80						
	9						B86	B88	B90	
	10			B81						
	11					B87	B89	B90		








Inserts overview

CoroCut® 1-2






Parting				Grooving			For circlip grooves	Hardened materials
								
123-CF B8	123-CM B9	123-CR B10	123-CS B11	123-GF B12	123-GM B13	123-GE B13	123-GF B14	123-S B14

Profiling		Hardened materials and HRSA		Non-ferrous and hardened materials		Turning		Carbide blank
								
123-RO B15	123-RM B15	123-RE B16	123-RE B16	123-S B17	123-RS B17	123-TF B18	123-TM B18	123-BG B19







CoroCut® QD

Parting					Turning	Carbide blank
						
QD-CF B21	QD-CL B21	QD-CM B22	QD-CO B23	QD-CR B24	QD-TF/TM B25	QD-BG B26

CoroCut® 3

Parting		Grooving	Profiling	Carbide blank
				
123-CM B28	123-CS B28	123-GS B31	123-RS B33	123-BG B34

CoroCut® XS

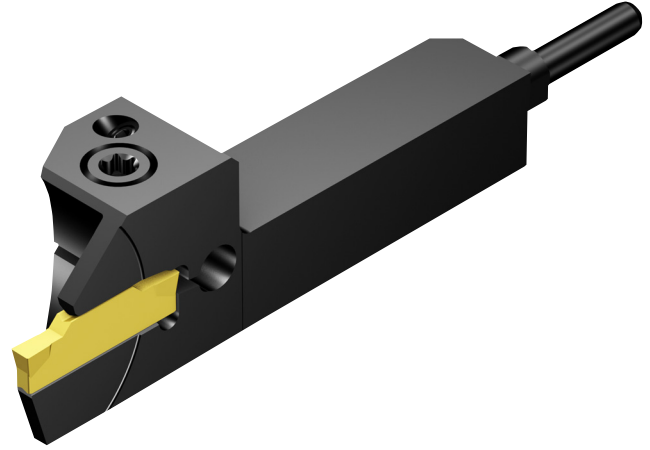
Turning	Back turning	Parting off	Grooving	Profiling	Threading
					
A30 A30	A30 A30	B41 B41	B43 B43	B43 B43	C37 C37

CoroCut® 1-2

Parting, profiling and grooving operations

Stable and efficient machining

With a wide range of dedicated geometries and grades for all material groups CoroCut 1-2 is the first choice system for parting and grooving. The tool holders have high precision coolant for good chip control, less tool wear and a more stable performance. The rigid rail interface between tool holder and insert provides high accuracy and efficient machining.



ISO application area:

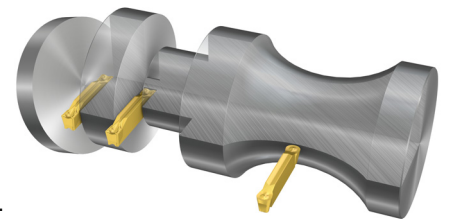


Application

- Parting off
- External grooving
- Internal grooving
- Face grooving
- Profiling

Benefits and features

- Strong tool material alloy for high fatigue resistance
- Plug and play adaptors make it easy to connect the coolant
- Easy to change inserts: no torque wrench needed – always correct clamping with quick-release key



Note: In parting off and grooving CoroCut® 1-2 is the best choice to depths where the 2-edged inserts can be used.

www.sandvik.coromant.com/corocut1-2

Inserts

- Geometries and grades for all applications and feeds
- Insert grades in advanced cutting materials PCD and CBN
- Wiper inserts for excellent surface finish

Tools

- QS™ shanks
- Shank tools
- Boring bars
- CoroTurn® SL heads

Rigid spring clamping

The system combines rigid spring clamping mechanism with railed insert seat and long inserts for exceptional stability.

Over- and under coolant

Tools with internal over- and under coolant available for best chip control and tool life.



B6



B5



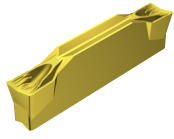
B5



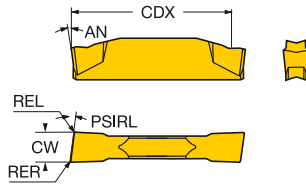
J9

CoroCut® 1-2 insert for parting

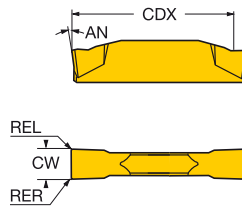
Parting



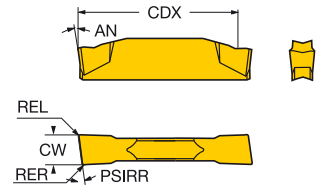
L123x2-CF



N123x2-CF



R123x2-CF



CoroCut® 2-edge

Finishing	SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	P				M				K		N		S			H	Dimensions, mm, inch						
									1105	1125	1145	2135	525	1105	1125	1145	2135	525	1125	2135	4925	1105	1125	2135		1105	1125	1145	2135	2135	AN
									★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		☆	☆	☆	☆	☆	☆
	F	2.50	0.15	0.15	18.4	5°		L123F2-0250-0501-CF																			7°				
		.098	.006	.006	.724																										
	G	3.00	0.15	0.15	18.3	5°		L123G2-0300-0501-CF																				7°			
		.118	.006	.006	.720																										
	F	2.50	0.10	0.10	18.4			N123F2-0250-0001-CF																				7°			
		.098	.004	.004	.724																										
	G	3.00	0.10	0.10	18.4			N123G2-0300-0001-CF																				7°			
		.118	.004	.004	.724																										
	F	2.50	0.15	0.15	18.4	5°		R123F2-0250-0501-CF																				7°			
		.098	.006	.006	.724																										
	G	3.00	0.15	0.15	18.3	5°		R123G2-0300-0501-CF																					7°		
		.118	.006	.006	.720																										

SSC = To correspond with SSC on holder.

N = Neutral, R = Right hand, L = Left hand

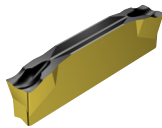
Tolerances:

	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
L123x2-CF	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
N123x2-CF	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
R123x2-CF	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039

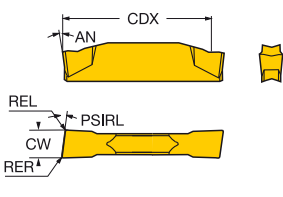


CoroCut® 1-2 insert for parting

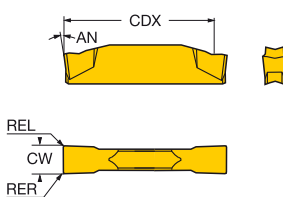
Parting



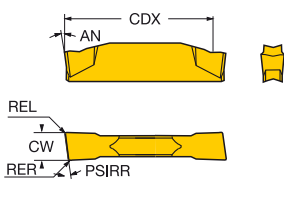
L123x2-CM



N123x2-CM



R123x2-CM



CoroCut® 2-edge

	SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	P					M				K			N		S			H	Dimension s. mm, inch						
									1105	1125	1145	2135	3115	525	1105	1125	1145	2135	525	1125	2135	3115	4925	1105	1125	2135		1105	1125	1145	2135	2135	
Medium	E	2.00	0.20	0.20	19.0	5°		L123E2-0200-0502-CM	☆	☆	☆	★			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	AN	7°		
		.079	.008	.008	.748																												
	F	2.50	0.20	0.20	18.9	5°		L123F2-0250-0502-CM		☆	☆	★			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
		.098	.008	.008	.744																												
	G	3.00	0.20	0.20	18.8	5°		L123G2-0300-0502-CM		☆	☆	★	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
		.118	.008	.008	.740																												
	D	1.50	0.20	0.20	12.9			N123D2-0150-0002-CM	☆	☆	☆	★			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
		.059	.008	.008	.508																												
	E	2.00	0.20	0.20	19.0			N123E2-0200-0002-CM	☆	☆	☆	★	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
	.079	.008	.008	.748																													
F	2.50	0.20	0.20	18.9			N123F2-0250-0002-CM	☆	☆	☆	★	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.098	.008	.008	.744																													
G	3.00	0.20	0.20	18.9			N123G2-0300-0002-CM	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.118	.008	.008	.744																													
E	2.00	0.20	0.20	19.0		5°	R123E2-0200-0502-CM	☆	☆	☆	★			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.079	.008	.008	.748																													
F	2.50	0.20	0.20	18.9		5°	R123F2-0250-0502-CM	☆	☆	☆	★			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.098	.008	.008	.744																													
G	3.00	0.20	0.20	18.8		5°	R123G2-0300-0502-CM	☆	☆	☆	★	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.118	.008	.008	.740																													

SSC = To correspond with SSC on holder.

N = Neutral, R = Right hand, L = Left hand

Tolerances:

	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
L123x2-CM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
N123x2-CM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
R123x2-CM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039



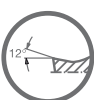
B5



B91



B109



B100



J19

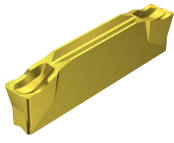


J9

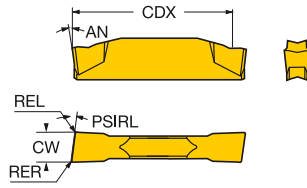


CoroCut® 1-2 insert for parting

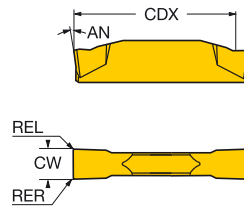
Parting



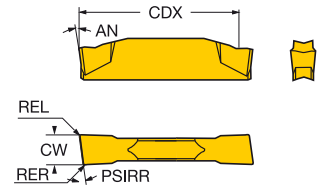
L123x2-CR



N123x2-CR



R123x2-CR



CoroCut® 2-edge

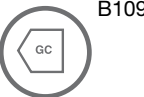
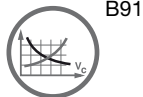
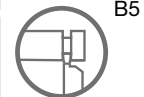
D	E	Roughing	Ordering code							P					M				K			N			S			H	Dimension s, mm, inch						
			SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	1105	1125	1145	2135	3115	525	1105	1125	1145	2135	525	1125	2135	3115	4325	1105	1125	2135		1105	1125	1145	2135	2135	AN
			F	2.50	0.30	0.30	18.9	5°	L123F2-0250-0503-CR	★						☆					☆	☆											7°		
				.098	.012	.012	.744																												
			G	3.00	0.30	0.30	18.8	5°	L123G2-0300-0503-CR	★		☆					☆					☆	☆						☆		☆		7°		
				.118	.012	.012	.740																												
			F	2.50	0.30	0.30	18.9		N123F2-0250-0003-CR	★	☆	☆	☆				☆				☆	☆	☆						☆		☆		7°		
				.098	.012	.012	.744																												
			G	3.00	0.30	0.30	18.8		N123G2-0300-0003-CR	☆	★	☆	☆	☆			☆				☆	☆	☆	☆					☆	★	☆		7°		
				.118	.012	.012	.740																												
			F	2.50	0.30	0.30	18.9	5°	R123F2-0250-0503-CR	★		☆					☆				☆	☆						☆		☆			7°		
				.098	.012	.012	.744																												
			G	3.00	0.30	0.30	18.8	5°	R123G2-0300-0503-CR	★	☆	☆					☆				☆	☆						☆	★	☆			7°		
				.118	.012	.012	.740																												

SSC = To correspond with SSC on holder.

N = Neutral, R = Right hand, L = Left hand

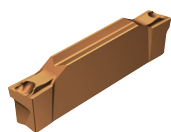
Tolerances:

	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
L123x2-CR	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
N123x2-CR	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
R123x2-CR	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039

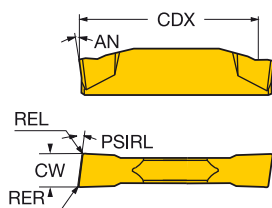


CoroCut® 1-2 insert for parting

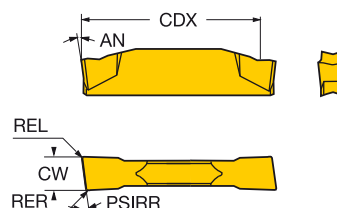
Parting



L123x2-CS



R123x2-CS



CoroCut® 2-edge

SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	Dimensions, mm, inch				AN	CWTOLL	CWTOLU	RETOLL	RETOU	
								P	M	K	N						
								1125	1125	1125	1125						
D	1.50	0.10	0.10	13.4	10.0		L123D2-0150-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.059	.004	.004	.528	10.000		L123D2-0150-1501-CS	★	☆	☆	☆	★	5°	-0.008	.008	-0.020	.020
E	2.00	0.10	0.10	19.4	10.0		L123E2-0200-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.079	.004	.004	.764	10.000		L123E2-0200-1501-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
F	2.50	0.10	0.10	19.4	10.0		L123F2-0250-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.098	.004	.004	.764	10.000		L123F2-0250-1501-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
G	3.00	0.10	0.10	19.4	10.0		L123G2-0300-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.118	.004	.004	.764	10.000		L123G2-0300-1501-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
D	1.50	0.10	0.10	13.4	10.0		R123D2-0150-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.059	.004	.004	.528	10.000		R123D2-0150-1501-CS	★	☆	☆	☆	★	5°	-0.008	.008	-0.020	.020
E	2.00	0.10	0.10	19.4	10.0		R123E2-0200-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.079	.004	.004	.764	10.000		R123E2-0200-1501-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
F	2.50	0.10	0.10	19.4	10.0		R123F2-0250-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.098	.004	.004	.764	10.000		R123F2-0250-1501-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
G	3.00	0.10	0.10	19.4	10.0		R123G2-0300-1001-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050
	.118	.004	.004	.764	10.000		R123G2-0300-1501-CS	★	☆	☆	☆	★	5°	-0.020	0.020	-0.050	0.050

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand



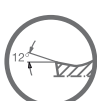
B5



B91



B109



B100



J19

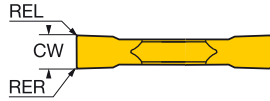
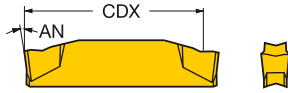
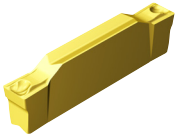


J9



CoroCut® 1-2 insert for grooving

Grooving



CoroCut® 2-edge

D	SSC	CW	REL	RER	CDX	Ordering code	P				M				K			N			S			H	Dimensions, mm, inch										
							1105	1125	2135	525	1005	1105	1125	2135	525	H13A	1125	2135	H13A	1005	1105	1125	2135			H13A	1005	1105	1125	2135	H13A	2135			
							☆	★			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	
E	D	1.50	0.10	0.10	13.3	N123D2-0150-0001-GF	☆	★				☆	☆														☆						AN	5°	
		.059	.004	.004	.524																							☆							
	E	1.98	0.20	0.20	19.2	N123E2-0198-0002-GF			☆																				☆						7°
		.078	.008	.008	.756																								☆						
	F	2.00	0.20	0.20	19.2	N123E2-0200-0002-GF	☆	☆	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
		.079	.008	.008	.756																								☆	☆	☆	☆	☆	☆	☆
	F	2.00	0.40	0.40	19.2	N123E2-0200-0004-GF	☆	☆			☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
		.079	.016	.016	.756																								☆	☆	☆	☆	☆	☆	☆
	F	2.24	0.20	0.20	19.2	N123E2-0224-0002-GF	☆	☆				☆	☆																☆	☆					7°
		.088	.008	.008	.756																								☆	☆					
	F	2.39	0.20	0.20	19.2	N123F2-0239-0002-GF	☆	☆			☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
		.094	.008	.008	.756																								☆	☆	☆	☆	☆	☆	☆
	F	2.39	0.40	0.40	19.2	N123F2-0239-0004-GF	☆	☆			☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
		.094	.016	.016	.756																								☆	☆	☆	☆	☆	☆	☆
	F	2.46	0.30	0.30	19.1	N123F2-0246-0003-GF	☆	☆	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
		.097	.012	.012	.752																								☆	☆	☆	☆	☆	☆	☆
	F	2.67	0.20	0.20	19.2	N123F2-0267-0002-GF		☆																					☆	☆					7°
		.105	.008	.008	.756																								☆	☆					
	F	2.79	0.30	0.30	19.1	N123F2-0279-0003-GF	☆	☆			☆	☆				☆	☆												☆	☆					7°
		.110	.012	.012	.752																								☆	☆					
G	3.00	0.20	0.20	19.2	N123G2-0300-0002-GF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.118	.008	.008	.756																								☆	☆	☆	☆	☆	☆	☆	
G	3.00	0.40	0.40	19.2	N123G2-0300-0004-GF	☆	☆			☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.118	.016	.016	.756																								☆	☆	☆	☆	☆	☆	☆	
G	3.10	0.20	0.20	19.2	N123G2-0310-0002-GF		☆																						☆	☆					7°
	.122	.008	.008	.756																									☆	☆					
G	3.18	0.20	0.20	19.2	N123G2-0318-0002-GF	☆	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.125	.008	.008	.756																								☆	☆	☆	☆	☆	☆	☆	
G	3.18	0.40	0.40	19.2	N123G2-0318-0004-GF		☆			☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.125	.016	.016	.756																								☆	☆	☆	☆	☆	☆	☆	
G	3.18	0.80	0.80	19.2	N123G2-0318-0008-GF	☆	☆			☆	☆	☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.125	.031	.031	.756																								☆	☆	☆	☆	☆	☆	☆	
G	3.61	0.30	0.30	19.1	N123G2-0361-0003-GF	☆	☆			☆	☆				☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°		
	.142	.012	.012	.752																								☆	☆	☆	☆	☆	☆	☆	

SSC = To correspond with SSC on holder.

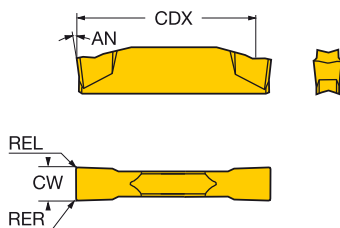
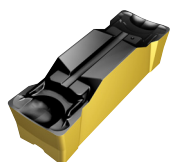
Tolerances:

	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
N123x2-GF	-0.020	0.020	-0.008	.0008	-0.05	0.05	-0.0020	.0020



CoroCut® 1-2 insert for grooving

Grooving



CoroCut® 2-edge

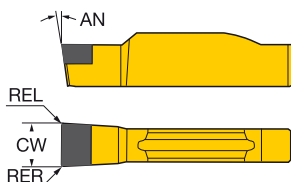
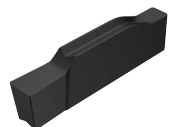
	SSC	CW	REL	RER	CDX	Ordering code	Dimensions, mm, inch																				
							P			M			K			N			S			AN					
							1125	1145	2135	1125	1145	H13A	1125	2135	3115	4325	H13A	1125	2135	H13A	1125		1145	2135	H13A		
Medium	E	2.00	0.20	0.20	18.8	N123E2-0200-0002-GM	☆	☆	★	☆	☆	★	☆	☆	☆	☆	★	☆	☆	★	☆	☆	☆	☆	☆	☆	7°
		.079	.008	.008	.740																						
		2.39	0.20	0.20	18.4	N123E2-0239-0002-GM	☆		★	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	7°	
		.094	.008	.008	.724																						
	G	3.00	0.30	0.30	18.2	N123G2-0300-0003-GM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
	.118	.012	.012	.717																							
	3.18	0.30	0.30	18.0	N123G2-0318-0003-GM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
	.125	.012	.012	.709																							

SSC = To correspond with SSC on holder.

Tolerances:

Ordering code	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
N123E2-0200-0002-GM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
N123E2-0239-0002-GM	-0.050	0.050	-.0020	.0020	-0.10	0.10	-.0039	.0039
N123G2-0300-0003-GM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
N123G2-0318-0003-GM	-0.050	0.050	-.0020	.0020	-0.10	0.10	-.0039	.0039

Grooving



	SSC	CW	REL	RER	Ordering code	Dimensions, mm, inch	
						H	AN
						CP20	
Finishing	G	3.00	0.20	0.20	N123G1-0300-0002-GE	☆	7°
		.118	.008	.008			
		3.18	0.20	0.20	N123G1-0318-0002-GE	☆	7°
	.125	.008	.008				

SSC = To correspond with SSC on holder.

Tolerances:

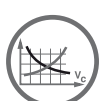
Ordering code	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
N123G1-0300-0002-GE	-0.020	0.020	-.0008	.0008	-0.05	0.05	-.0020	.0020
N123G1-0318-0002-GE	-0.020	0.020	-.0008	.0008	-0.05	0.05	-.0020	.0020



B5



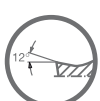
B5



B91



B109



B100



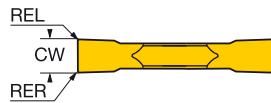
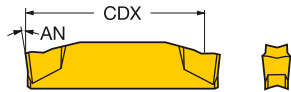
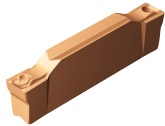
J19



J9

CoroCut® 1-2 insert for grooving

For circlip grooves

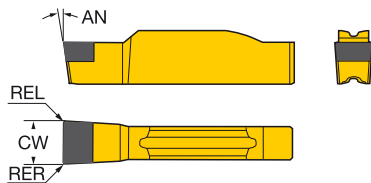
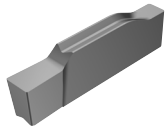


CoroCut® 2-edge

	SSC	CW	REL	RER	CDX	Ordering code	P						M			K			N			S			Dimensions, mm, inch						
							1105		1125		1105		H13A		1125		H13A		1105		H13A		1105		H13A		AN	CWTOLL	CWTOLU	RETOLL	RETOLU
							☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★					
Finishing	E	1.85	0.10	0.10	19.3	N123E2-0185-0001-GF	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	7°	0.090	0.130	-0.050	0.050				
		.073	.004	.004	.760																			.0035	.0051	-.0020	.0020				
		2.15	0.10	0.10	19.3	N123E2-0215-0001-GF		★		★		★		★		★		★		★		★	7°	0.090	0.130	-0.050	0.050				
		.085	.004	.004	.760																			.0035	.0051	-.0020	.0020				
	F	2.65	0.20	0.20	19.2	N123F2-0265-0002-GF		★		★		★		★		★		★		★		★	7°	0.090	0.130	-0.050	0.050				
		.104	.008	.008	.756																			.0035	.0051	-.0020	.0020				
	G	3.15	0.20	0.20	19.2	N123G2-0315-0002-GF		★		★		★		★		★		★		★		★	7°	0.090	0.130	-0.050	0.050				
		.124	.008	.008	.756																		.0035	.0051	-.0020	.0020					

SSC = To correspond with SSC on holder.

For grooving of hardened materials



CoroCut® 1-edge

	SSC	CW	REL	RER	Ordering code	S		H								Dimensions, mm, inch					
						7015	7015	GB	BN	AN	CWTOLL	CWTOLU	RETOLL	RETOLU	GB	BN	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
						☆	★	25°	0.1	7°	-0.020	0.020	-0.050	0.050							
Finishing	G	3.00	0.40	0.40	N123G1-030004S01025	☆	★	25°	0.1	7°	-0.020	0.020	-0.050	0.050	25°	.004	-.0008	.0008	-.0020	.0020	
		.118	.016	.016																	

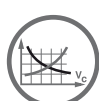
SSC = To correspond with SSC on holder.



B5



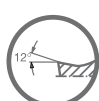
B5



B91



B109



B100



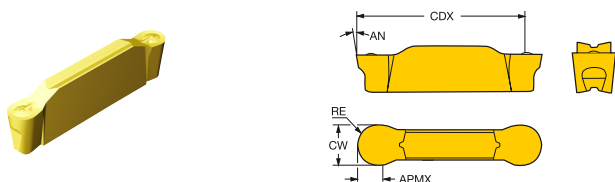
J19



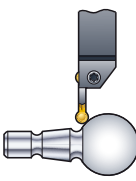
J9

CoroCut® 1-2 insert for profiling

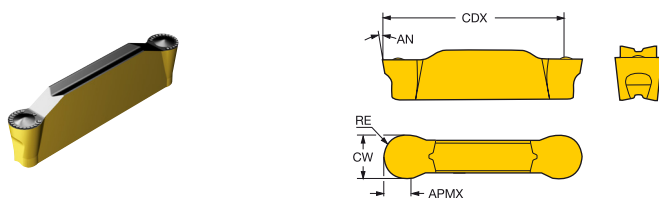
Profiling



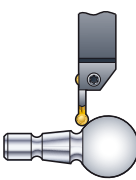
CoroCut® 2-edge

	SSC	CW	RE	CDX	APMX	Ordering code	P		M				K		N			S				H	Dimensions, mm, inch		
							1105	1125	2135	1005	1105	1125	2135	H13A	S05F	1125	2135	H13A	1005	1105	1125	2135		H13A	S05F
Finishing 	E	2.00	1.00	19.2	0.8	N123E2-0200-RO	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	AN	7°
			.079	.039	.756	.031																			
	N123E2-0239-RO	2.39	1.20	19.0	1.0			★		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
			.094	.047	.748	.039																			
	F	3.00	1.50	18.7	1.3	N123F2-0300-RO	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
			.118	.059	.736	.051																			
N123F2-0318-RO	3.18	1.59	18.6	1.4		☆	★		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	
		.125	.063	.732	.055																				

SSC = To correspond with SSC on holder.



CoroCut® 2-edge

	SSC	CW	RE	CDX	APMX	Ordering code	P		M				K		N			S		H	Dimensions, mm, inch			
							1125	2135	3115	525	1125	2135	525	H13A	1125	2135	3115	4325	H13A	1125		2135	H13A	1125
Medium 	F	3.00	1.50	18.6	1.3	N123F2-0300-RM	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	AN	7°
			.118	.059	.732	.051																		
	N123F2-0318-RM	3.18	1.59	18.6	1.4		☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
			.125	.063	.732	.055																		
	G	4.00	2.00	18.1	1.8	N123G2-0400-RM	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°
			.157	.079	.713	.071																		

SSC = To correspond with SSC on holder.

Tolerances:

Ordering code	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
N123E2-0200-RO	-0.020	0.020	-.0008	.0008	-0.01	0.01	-.0004	.0004
N123E2-0239-RO	-0.020	0.020	-.0008	.0008	-0.01	0.01	-.0004	.0004
N123F2-0300-RM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039
N123F2-0300-RO	-0.020	0.020	-.0008	.0008	-0.01	0.01	-.0004	.0004
N123F2-0318-RM	-0.050	0.050	-.0020	.0020	-0.10	0.10	-.0039	.0039
N123F2-0318-RO	-0.020	0.020	-.0008	.0008	-0.01	0.01	-.0004	.0004
N123G2-0400-RM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039



B5



B5



B91



B109



B100



J19



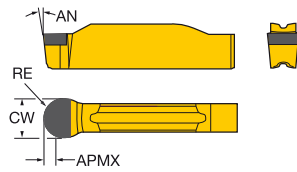
J9

CoroCut® 1-2 insert for profiling

Profiling hardened materials and heat resistant super alloys

ENG

B



C

CoroCut® 1-edge

D

						S	H			Dimensions, mm, inch					
		SSC	CW	RE	APMX	Ordering code	7015	7015	7025	CB20	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		F	3.00	1.50	0.6	N123F1-0300-RE	★	★	☆	☆	7°	-0.020	0.020	-0.020	0.020
			.118	.059	.024							-.0008	.0008	-.0008	.0008
			3.18	1.59	0.6	N123F1-0318-RE	★	★			7°	-0.020	0.020	-0.020	0.020
			.125	.063	.024							-.0008	.0008	-.0008	.0008

E

SSC = To correspond with SSC on holder.

F

G

H

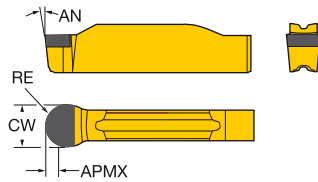
I

J



CoroCut® 1-2 insert for profiling

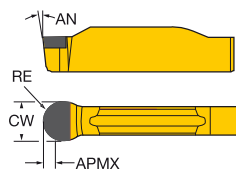
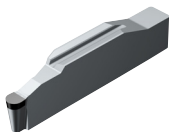
Profiling non-ferrous and hardened materials



CoroCut® 1-edge

						S	H	Dimensions, mm, inch						
		SSC	CW	RE	APMX	7015	7015	GB	BN	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		F	3.00	1.50	2.5	*	*	25°	0.1	7°	-0.020	0.020	-0.020	0.020
			.118	.059	.098			25°	.004		-.0008	.0008	-.0008	.0008
		Ordering code												
		N123F1-0300S01025												

N123x1-RS



CoroCut® 1-edge

						N	Dimensions, mm, inch				
		SSC	CW	RE	APMX	CD10	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		F	3.00	1.50	1.3	*	7°	-0.020	0.020	-0.020	0.020
			.118	.059	.051			-.0008	.0008	-.0008	.0008
		Ordering code									
		N123F1-0300-RS									

SSC = To correspond with SSC on holder.



B5



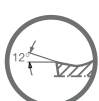
B5



B91



B109



B100



J19

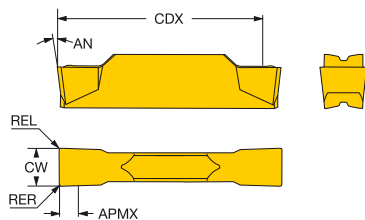
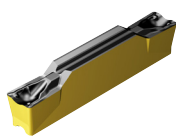


J9

CoroCut® 1-2 insert for turning

Turning

B



C

CoroCut® 2-edge

	SSC	CW	REL	RER	CDX	APMX	Ordering code	Material Groups												H	Dimensions, mm, inch															
								P	M	K	N	S	P		M		K		N			S														
Finishing	G	3.00	0.30	0.30	18.5	1.8	N123G2-0300-0003-TF	1105	1125	1145	2135	3115	4325	525	1005	1105	1125	1145	2135	3115	4325	H13A	1125	2135	3115	4325	H13A	1005	1105	1125	1145	2135	H13A	2135	AN	7°
		.118	.012	.012	.728	.071		★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★

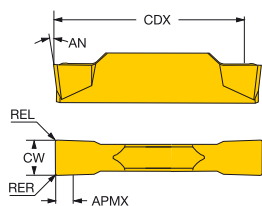
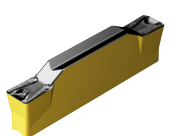
SSC = To correspond with SSC on holder.

E

Tolerances:	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
N123x2-TF	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039

Turning

F



G

CoroCut® 2-edge

	SSC	CW	REL	RER	CDX	APMX	Ordering code	Material Groups												H	Dimensions, mm, inch															
								P	M	K	N	S	P		M		K		N			S														
Medium	G	3.00	0.40	0.40	18.4	1.8	N123G2-0300-0004-TM	1105	1125	1145	2135	3115	4325	525	1005	1105	1125	1145	2135	3115	4325	H13A	1125	2135	3115	4325	H13A	1005	1105	1125	1145	2135	H13A	2135	AN	7°
		.118	.016	.016	.724	.071		★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★	★

SSC = To correspond with SSC on holder.

I

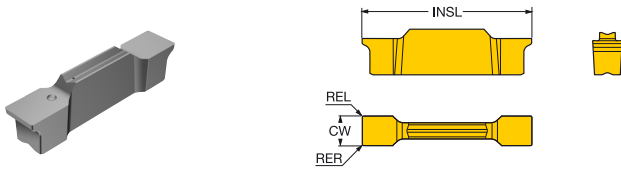
Tolerances:	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
N123x2-TM	0.000	0.100	.0000	.0039	-0.10	0.10	-.0039	.0039

J



CoroCut® 1-2 carbide blank

Blanks



CoroCut® 2-edge

SSC	CW	REL	RER	Ordering code	P	M	K	N		S	Dimensions, mm, inch	
					H10F	H10F	H13A	H10F	H13A	H10		H10F
D	2.3 .091	0.2 .008	0.2 .008	N123D2-0230-0002-BG	☆	☆	☆	☆	☆	☆	☆	INSL 15.00 .591
E	2.7 .106	0.2 .008	0.2 .008	N123E2-0270-0002-BG	☆	☆	☆	☆	☆	☆	☆	21.60 .850
F	3.8 .150	0.2 .008	0.2 .008	N123F2-0380-0002-BG	☆	☆	☆	☆	☆	☆	☆	21.60 .850
G	4.2 .165	0.2 .008	0.2 .008	N123G2-0420-0002-BG	☆	☆	☆	☆	☆	☆	☆	21.60 .850

SSC = To correspond with SSC on holder.

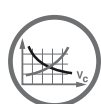
N = Neutral



B5



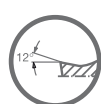
B5



B91



B109



B100



J19



J9

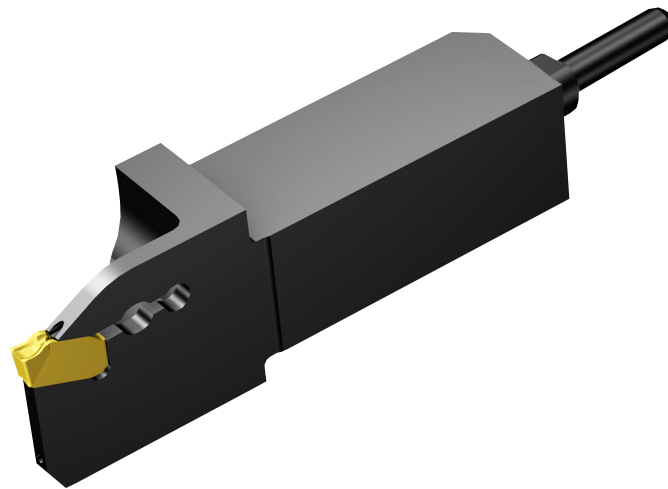
CoroCut® QD

For secure parting off and deep grooving

Reliability and easy handling

When machining components with diameter larger than 32 mm (1.26 inch), CoroCut QD is the first choice. The tools have over- and under coolant and a stable clamping mechanism for chip control and secure performance.

With support from plug and play coolant adaptors and easy insert changes, CoroCut QD is both reliable and easy to use.



ISO application area:



Application

- Parting off
- Deep grooving
- When machining with long overhang

Benefits and features

- Insert geometries optimize coolant access
- Insert grades with high edge-line security
- Chip breaking geometries
- Material alloy with high fatigue resistance
- No torque wrench needed, correct clamping force ensured with quick-release key
- Rail insert seat ensures stable, precise insert position

www.sandvik.coromant.com/corocutqd

Tools

- QS™ shank tools
- Shank tools

Inserts

- Insert grades and geometries dedicated for parting off
- Wiper inserts for excellent surface finish

Key for insert indexing

Quick-release key for insert indexing with one hand.



Precision coolant

All tools have internal over- and under coolant supply for chip control and tool life. The adaptors have plug and play function for easy connection in the machine.



B6

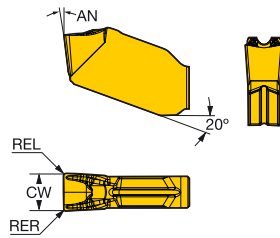


B5

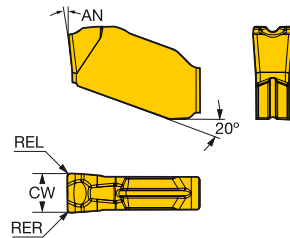


J9

CoroCut® QD insert for parting



Finishing	SSC	CW	REL	RER	Ordering code	Dimensions, mm, inch																			
						P			M			K		N		S		H							
						1106	1125	1135	1145	1105	1125	1135	1145	1125	4825	1105	1125	1135	1105	1125	1135	1145	1135		
	B	1.00	0.07	0.07	QD-NB-0100-0001-CF	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050	
		.039	.003	.003																	-.0020	.0020	-.0020	.0020	
	C	1.20	0.10	0.10	QD-NC-0120-0001-CF	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050	
		.047	.004	.004																		-.0020	.0020	-.0020	.0020
	D	1.50	0.10	0.10	QD-ND-0150-0001-CF	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050	
		.059	.004	.004																		-.0020	.0020	-.0020	.0020
	E	2.00	0.15	0.15	QD-NE-0200-0001-CF	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050	
	.079	.006	.006																		-.0020	.0020	-.0020	.0020	
F	2.50	0.15	0.15	QD-NF-0250-0001-CF	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050		
	.098	.006	.006																		-.0020	.0020	-.0020	.0020	
G	3.00	0.15	0.15	QD-NG-0300-0001-CF	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050		
	.118	.006	.006																		-.0020	.0020	-.0020	.0020	



Medium	SSC	CW	REL	RER	Ordering code	Dimensions, mm, inch																		
						P			M			K		N		S		H						
						1125	1135	1145	1125	1135	1145	1125	1135	4825	1125	1135	1135	1145	1135					
	E	2.00	0.30	0.30	QD-NE-0200-0003-CL	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050	
		.079	.012	.012																	-.0020	.0020	-.0020	.0020
	F	2.50	0.30	0.30	QD-NF-0250-0003-CL	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050
	.098	.012	.012																		-.0020	.0020	-.0020	.0020
G	3.00	0.30	0.30	QD-NG-0300-0003-CL	★	★	★	★	★	★	★	★	★	★	★	★	★	★	7°	-0.050	0.050	-0.050	0.050	
	.118	.012	.012																		-.0020	.0020	-.0020	.0020

SSC = To correspond with SSC on holder.



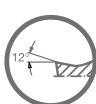
B5



B91



B109



B105



J19

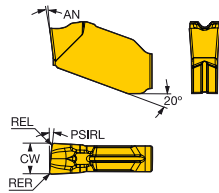


J9

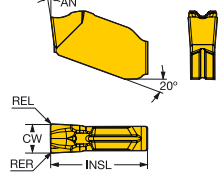
CoroCut® QD insert for parting



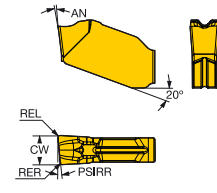
QD-L.-CM



QD-N.-CM



QD-R.-CM



	SSC	CW	REL	RER	PSIRL	PSIRR	Ordering code	P			M				K			N			S			H	Dimensions, mm, inch		
								1105	1125	1135	1145	1105	1125	1135	1145	H13A	1125	1135	4325	H13A	1105	1125	1135	H13A		1105	1125
Medium	E	2.00	0.20	0.20	5°		QD-LE-0200-0502-CM	☆	☆	☆														AN			
		.079	.008	.008																					7°		
	F	2.50	0.20	0.20	5°		QD-LF-0250-0502-CM		☆	☆	☆														7°		
		.098	.008	.008																						7°	
	G	3.00	0.20	0.20	5°		QD-LG-0300-0502-CM		☆	☆	☆															7°	
		.118	.008	.008																							7°
	B	1.00	0.07	0.07			QD-NB-0100-0001-CM	☆	☆		☆	☆		☆												7°	
		.039	.003	.003																							7°
	C	1.20	0.10	0.10			QD-NC-0120-0001-CM	☆	☆		☆	☆		☆													7°
		.047	.004	.004																							7°
	D	1.50	0.10	0.10			QD-ND-0150-0001-CM	☆	☆		☆	☆		☆													7°
		.059	.004	.004																							7°
	E	2.00	0.20	0.20			QD-NE-0200-0002-CM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		7°
		.079	.008	.008																							7°
		2.39	0.20	0.20			QD-NE-0239-0002-CM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		7°
	.094	.008	.008																							7°	
F	2.50	0.20	0.20			QD-NF-0250-0002-CM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		7°	
	.098	.008	.008																							7°	
G	3.00	0.20	0.20			QD-NG-0300-0002-CM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		7°	
	.118	.008	.008																							7°	
	3.00	0.40	0.40			QD-NG-0300-0004-CM		☆	☆		☆	☆		☆	☆		☆	☆		☆	☆	☆	☆			7°	
	.118	.016	.016																							7°	
	3.18	0.20	0.20			QD-NG-0318-0002-CM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		7°	
	.125	.008	.008																							7°	
E	2.00	0.20	0.20	5°		QD-RE-0200-0502-CM		☆	☆		☆	☆		☆	☆		☆	☆		☆	☆	☆	☆			7°	
	.079	.008	.008																							7°	
F	2.50	0.20	0.20	5°		QD-RF-0250-0502-CM		☆	☆		☆	☆		☆	☆		☆	☆		☆	☆	☆	☆			7°	
	.098	.008	.008																							7°	
G	3.00	0.20	0.20	5°		QD-RG-0300-0502-CM		☆	☆		☆	☆		☆	☆		☆	☆		☆	☆	☆	☆			7°	
	.118	.008	.008																							7°	

SSC = To correspond with SSC on holder.

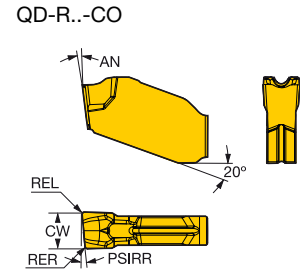
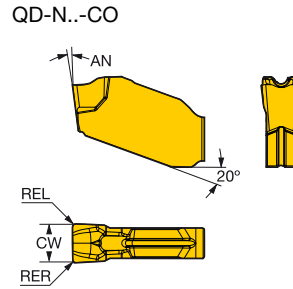
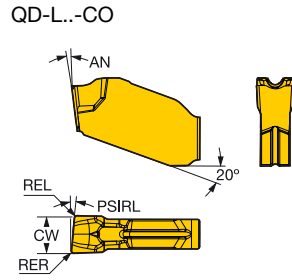
N = Neutral, R = Right hand, L = Left hand

Tolerances:

	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
QD-L.-CM	-0.050	0.050	-0.0020	.0020	-0.05	0.05	-0.0020	.0020
QD-N.-CM	-0.050	0.050	-0.0020	.0020	-0.05	0.05	-0.0020	.0020
QD-R.-CM	-0.050	0.050	-0.0020	.0020	-0.05	0.05	-0.0020	.0020



CoroCut® QD insert for parting



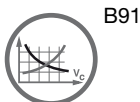
SSC	CW	REL	RER	PSIRL	PSIRR	Ordering code	Material Groups												H	Dimensions, mm, inch				
							P			M				K		N					S			
							1105	1125	1135	1105	1125	1135	1145	H13A	1125	1135	H13A	1105			1125	1135	H13A	1105
E	2.00	0.10	0.10	8°		QD-LE-0200-0801-CO	★	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	7°
	.079	.004	.004																					
F	2.50	0.10	0.10	8°		QD-LF-0250-0801-CO	★	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	7°
	.098	.004	.004																					
G	3.00	0.10	0.10	5°		QD-LG-0300-0501-CO	★	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	7°
	.118	.004	.004																					
E	2.00	0.10	0.10			QD-NE-0200-0001-CO	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	7°
	.079	.004	.004																					
F	2.50	0.10	0.10			QD-NF-0250-0001-CO	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	7°
	.098	.004	.004																					
G	3.00	0.10	0.10			QD-NG-0300-0001-CO	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	7°
	.118	.004	.004																					
E	2.00	0.10	0.10		8°	QD-RE-0200-0801-CO	★	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	7°
	.079	.004	.004																					
F	2.50	0.10	0.10		8°	QD-RF-0250-0801-CO	★	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	7°
	.098	.004	.004																					
G	3.00	0.10	0.10		5°	QD-RG-0300-0501-CO	★	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	7°
	.118	.004	.004																					

SSC = To correspond with SSC on holder.

N = Neutral, R = Right hand, L = Left hand

Tolerances:

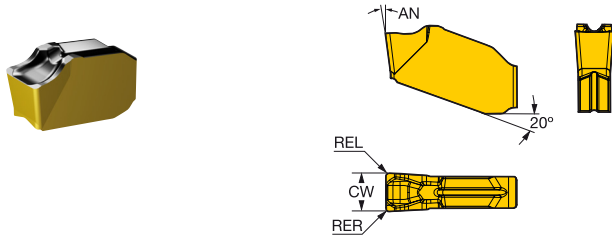
	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
QD-L..-CO	-0.020	0.020	-0.008	.0008	-0.05	0.05	-0.0020	.0020
QD-N..-CO	-0.020	0.020	-0.008	.0008	-0.05	0.05	-0.0020	.0020
QD-R..-CO	-0.020	0.020	-0.008	.0008	-0.05	0.05	-0.0020	.0020



CoroCut® QD insert for parting

ENG

B



C

	SSC	CW	REL	RER	Ordering code	Dimensions, mm, inch																				
						P			M			K			N			S			H					
						1125	1135	1145	1125	1135	1145	1125	1135	4825	1125	1135	1145	1135	1145	1135						
 Roughing	E	2.00	0.30	0.30	QD-NE-0200-0003-CR	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
		.079	.012	.012																		7°	-0.050	0.050	-0.050	0.050
	F	2.50	0.30	0.30	QD-NF-0250-0003-CR	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	-0.050	0.050	-0.050	0.050
		.098	.012	.012																		7°	-0.050	0.050	-0.050	0.050
G	3.00	0.30	0.30	QD-NG-0300-0003-CR	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7°	-0.050	0.050	-0.050	0.050	
	.118	.012	.012																		7°	-0.050	0.050	-0.050	0.050	

SSC = To correspond with SSC on holder.

E

F

G

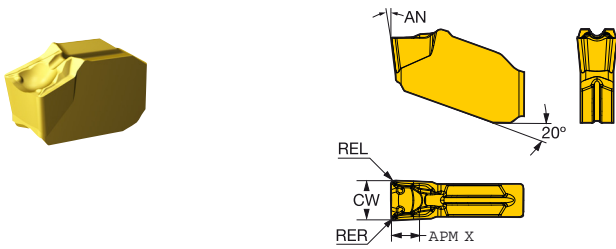
H

I

J



CoroCut® QD insert for turning



	SSC	CW	REL	RER	APMX	Ordering code	Material Groups												H	Dimensions, mm, inch		
							P	M	K	N	S											
Finishing	G	3.00	0.30	0.30	2.1	QD-NG-0300-0003-TF	1105	1125	1135	1145	1105	1125	1135	1145	1135	1105	1125	1135	1145	1135	AN	7°
		.118	.012	.012	.083		☆	☆	★	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	
Medium	G	3.00	0.40	0.40	2.1	QD-NG-0300-0004-TM																7°
		.118	.016	.016	.083		☆	★			☆	★			☆	☆			★	☆		

SSC = To correspond with SSC on holder.

Tolerances:

	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
QD-N..-TF	-0.050	0.050	-.0020	.0020	-0.05	0.05	-.0020	.0020
QD-N..-TM	-0.050	0.050	-.0020	.0020	-0.05	0.05	-.0020	.0020



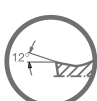
B5



B91



B109



B105

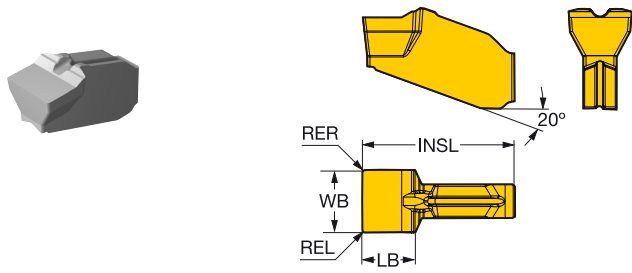


J19



J9

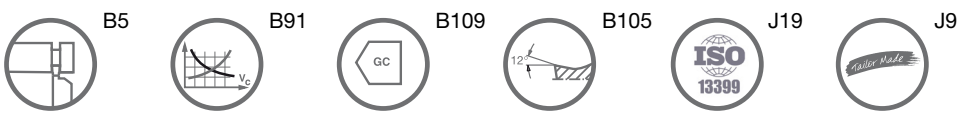
CoroCut® QD carbide blank



SSC	WB	REL	REL	Ordering code	Dimensions, mm, inch													
					P		M		K		N		S		O		INSL	LB
					H10F	H13A	H10F	H13A	H10F	H13A	H10F	H13A	H10F	H13A	H10F	H13A		
E	2.91	0.20	0.20	QD-NE-0290-0002-BG	*	*	*	*	*	*	*	*	*	*	*	*	10.5	3.1
	.115	.008	.008													.413	.122	
F	3.40	0.20	0.20	QD-NF-0340-0002-BG	*	*	*	*	*	*	*	*	*	*	*	*	10.5	3.1
	.134	.008	.008													.413	.122	
G	4.40	0.20	0.20	QD-NG-0440-0002-BG	*	*	*	*	*	*	*	*	*	*	*	*	10.7	3.5
	.173	.008	.008													.421	.138	

SSC = To correspond with SSC on holder.

SSC	Min. width	Max. width
E	2.0	2.5
F	2.5	3.0
G	3.0	4.0
H	4.0	5.0
J	5.0	6.0



CoroCut® 3

Shallow parting off and precision grooving

Material savings in mass production

This system offers precision grooving down to the smallest widths. The inserts have three edges and they all fit the same holder, making CoroCut 3 a flexible and cost-efficient solution. The effects can be seen in terms of material savings, especially when working with mass production.

ISO application area:



Application

- Parting off
- Circlip grooving
- External grooving
- Profiling
- Optimized for parting off bearing rings



Benefits and features

- Precision grooving down to the smallest widths
- Maximum versatility – one holder for all insert widths
- Cost efficient due to three cutting edges
- Stable interface
- Three-edge inserts with very close insert indexing tolerance
- Tailor Made inserts available

www.sandvik.coromant.com/corocut3

Inserts

GC1125: One versatile grade in four different geometries:

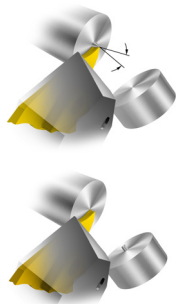
- CM for parting off in the medium feed area
- CS for parting off in extremely low feed machining
- GS for precision grooving at low feed
- RS for profiling and grooving at low feed

Tools

- QS Shank tools
- Rectangular shank holders
- CoroTurn® SL cutting heads

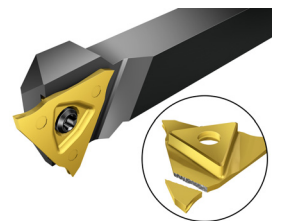
Front angled inserts

Inserts available with front angle for pip and burr free parting off.



Independent insert location if breakages occur

Inserts can be indexed directly in the machine by unscrewing two turns. If insert breakage occurs, the clamping mechanism will not be affected - just index the insert and re-start the machine.



B6



B5

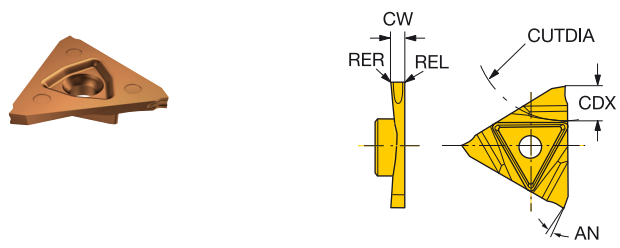


J9

CoroCut® 3 insert for parting

Shallow parting

B



C

							P	M	K	N	S	Dimensions, mm, inch							
		SSC	CW	REL	RER	CDX	Ordering code	1125	1125	1125	1125	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU		
D	Finishing	T	1.00	0.00	0.00	4.3	N123T3-0100-0000-CS	★	☆	☆	☆	★	7°	50.00	-0.050	0.030	0.000	0.050	
			.039	.000	.000	.169													
			1.50	0.00	0.00	6.4	N123T3-0150-0000-CS	★	☆	☆	☆	★	7°	100.00	-0.050	0.030	0.000	0.050	
			.059	.000	.000	.252													
			2.00	0.00	0.00	6.4	N123T3-0200-0000-CS	★	☆	☆	☆	★	7°	100.00	-0.050	0.030	0.000	0.050	
		.079	.000	.000	.252														
		U	1.00	0.00	0.00	4.3	N123U3-0100-0000-CS	★	☆	☆	☆	★	7°	50.00	-0.050	0.030	0.000	0.050	
			.039	.000	.000	.169													
			1.50	0.00	0.00	6.4	N123U3-0150-0000-CS	★	☆	☆	☆	★	7°	100.00	-0.050	0.030	0.000	0.050	
			.059	.000	.000	.252													
2.00	0.00		0.00	6.4	N123U3-0200-0000-CS	★	☆	☆	☆	★	7°	100.00	-0.050	0.030	0.000	0.050			
.079	.000	.000	.252																
E	Medium	T	1.00	0.10	0.10	4.3	N123T3-0100-0001-CM	★	☆	☆	☆	★	7°	50.00	-0.030	0.030	-0.050	0.050	
			.039	.004	.004	.169													
			1.50	0.10	0.10	6.4	N123T3-0150-0001-CM	★	☆	☆	☆	★	7°	100.00	-0.030	0.030	-0.050	0.050	
			.059	.004	.004	.252													
			2.00	0.10	0.10	6.4	N123T3-0200-0001-CM	★	☆	☆	☆	★	7°	100.00	-0.030	0.030	-0.050	0.050	
		.079	.004	.004	.252														
		U	1.00	0.10	0.10	4.3	N123U3-0100-0001-CM	★	☆	☆	☆	★	7°	50.00	-0.030	0.030	-0.050	0.050	
			.039	.004	.004	.169													
			1.50	0.10	0.10	6.4	N123U3-0150-0001-CM	★	☆	☆	☆	★	7°	100.00	-0.030	0.030	-0.050	0.050	
			.059	.004	.004	.252													
2.00	0.10		0.10	6.4	N123U3-0200-0001-CM	★	☆	☆	☆	★	7°	100.00	-0.030	0.030	-0.050	0.050			
.079	.004	.004	.252																

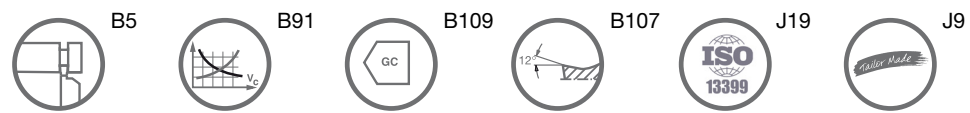
SSC = To correspond with SSC on holder.

G

H

I

J

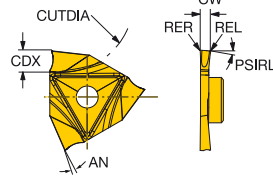


CoroCut® 3 insert for parting

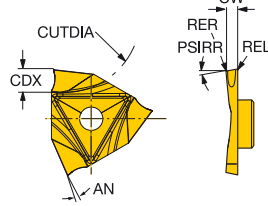
Shallow parting



L123T3-CS



R123T3-CS



								P M K N S					Dimensions, mm, inch						
		SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	1125	1125	1125	1125	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing	T	1.00	0.00	0.00	4.2	5.0			L123T3-0100-0500-CS	★	☆	☆	☆	7°	50.00	-0.100	0.000	0.000	0.050
		.039	.000	.000	.165	5.000									1.969	-.0039	.0000	.0000	.0020
		1.00	0.00	0.00	4.2	10.0			L123T3-0100-1000-CS	★	☆	☆	☆	7°	50.00	-0.100	0.000	0.000	0.050
		.039	.000	.000	.165	10.000									1.969	-.0039	.0000	.0000	.0020
		2.00	0.00	0.00	6.3	10.0			L123T3-0200-1000-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050
		.079	.000	.000	.248	10.000									3.937	-.0039	.0000	.0000	.0020
		2.00	0.00	0.00	6.3	15.0			L123T3-0200-1500-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050
		.079	.000	.000	.248	15.000									3.937	-.0039	.0000	.0000	.0020
		1.00	0.00	0.00	4.2		5.0		R123T3-0100-0500-CS	★	☆	☆	☆	7°	50.00	-0.100	0.000	0.000	0.050
		.039	.000	.000	.165		5.000								1.969	-.0039	.0000	.0000	.0020
		1.00	0.00	0.00	4.2		10.0		R123T3-0100-1000-CS	★	☆	☆	☆	7°	50.00	-0.100	0.000	0.000	0.050
		.039	.000	.000	.165		10.000								1.969	-.0039	.0000	.0000	.0020
		1.00	0.00	0.00	4.2		15.0		R123T3-0100-1500-CS	★	☆	☆	☆	7°	50.00	-0.100	0.000	0.000	0.050
		.039	.000	.000	.165		15.000								1.969	-.0039	.0000	.0000	.0020
		1.50	0.00	0.00	6.3		5.0		R123T3-0150-0500-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050
		.059	.000	.000	.248		5.000								3.937	-.0039	.0000	.0000	.0020
		1.50	0.00	0.00	6.3		10.0		R123T3-0150-1000-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050
		.059	.000	.000	.248		10.000								3.937	-.0039	.0000	.0000	.0020
		1.50	0.00	0.00	6.3		15.0		R123T3-0150-1500-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050
		.059	.000	.000	.248		15.000								3.937	-.0039	.0000	.0000	.0020
	2.00	0.00	0.00	6.3		5.0		R123T3-0200-0500-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050	
	.079	.000	.000	.248		5.000								3.937	-.0039	.0000	.0000	.0020	
	2.00	0.00	0.00	6.3		10.0		R123T3-0200-1000-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050	
	.079	.000	.000	.248		10.000								3.937	-.0039	.0000	.0000	.0020	
	2.00	0.00	0.00	6.3		15.0		R123T3-0200-1500-CS	★	☆	☆	☆	7°	100.00	-0.100	0.000	0.000	0.050	
	.079	.000	.000	.248		15.000								3.937	-.0039	.0000	.0000	.0020	

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand



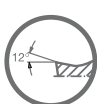
B5



B91



B109



B107



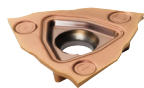
J19



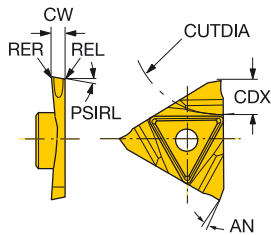
J9

CoroCut® 3 insert for parting

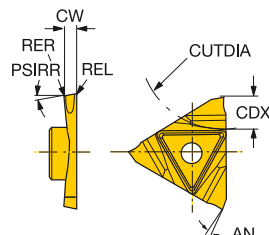
Shallow parting



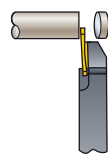
L123U3-CS



R123U3-CS



Finishing



SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	Dimensions, mm, inch				AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU	
								P	M	K	N							
U	1.00	0.00	0.00	4.2	5.0		L123U3-0100-0500-CS	★	☆	☆	☆	★	7°	50.00	-0.100	0.000	0.000	0.050
	.039	.000	.000	.165	5.000									1.969	-.0039	.0000	.0000	.0020
	1.00	0.00	0.00	4.2	10.0		L123U3-0100-1000-CS	★	☆	☆	☆	★	7°	50.00	-0.100	0.000	0.000	0.050
	.039	.000	.000	.165	10.000									1.969	-.0039	.0000	.0000	.0020
	1.00	0.00	0.00	4.2	15.0		L123U3-0100-1500-CS	★	☆	☆	☆	★	7°	50.00	-0.100	0.000	0.000	0.050
	.039	.000	.000	.165	15.000									1.969	-.0039	.0000	.0000	.0020
	1.50	0.00	0.00	6.3	5.0		L123U3-0150-0500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.059	.000	.000	.248	5.000									3.937	-.0039	.0000	.0000	.0020
	1.50	0.00	0.00	6.3	10.0		L123U3-0150-1000-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.059	.000	.000	.248	10.000									3.937	-.0039	.0000	.0000	.0020
	1.50	0.00	0.00	6.3	15.0		L123U3-0150-1500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.059	.000	.000	.248	15.000									3.937	-.0039	.0000	.0000	.0020
	2.00	0.00	0.00	6.3	5.0		L123U3-0200-0500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.079	.000	.000	.248	5.000									3.937	-.0039	.0000	.0000	.0020
	2.00	0.00	0.00	6.3	10.0		L123U3-0200-1000-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.079	.000	.000	.248	10.000									3.937	-.0039	.0000	.0000	.0020
	2.00	0.00	0.00	6.3	15.0		L123U3-0200-1500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.079	.000	.000	.248	15.000									3.937	-.0039	.0000	.0000	.0020
	1.00	0.00	0.00	4.2	5.0		R123U3-0100-0500-CS	★	☆	☆	☆	★	7°	50.00	-0.100	0.000	0.000	0.050
	.039	.000	.000	.165	5.000									1.969	-.0039	.0000	.0000	.0020
	1.00	0.00	0.00	4.2	10.0		R123U3-0100-1000-CS	★	☆	☆	☆	★	7°	50.00	-0.100	0.000	0.000	0.050
	.039	.000	.000	.165	10.000									1.969	-.0039	.0000	.0000	.0020
	1.50	0.00	0.00	6.3	5.0		R123U3-0150-0500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.059	.000	.000	.248	5.000									3.937	-.0039	.0000	.0000	.0020
	1.50	0.00	0.00	6.3	10.0		R123U3-0150-1000-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.059	.000	.000	.248	10.000									3.937	-.0039	.0000	.0000	.0020
	1.50	0.00	0.00	6.3	15.0		R123U3-0150-1500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.059	.000	.000	.248	15.000									3.937	-.0039	.0000	.0000	.0020
	2.00	0.00	0.00	6.3	5.0		R123U3-0200-0500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.079	.000	.000	.248	5.000									3.937	-.0039	.0000	.0000	.0020
	2.00	0.00	0.00	6.3	10.0		R123U3-0200-1000-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.079	.000	.000	.248	10.000									3.937	-.0039	.0000	.0000	.0020
	2.00	0.00	0.00	6.3	15.0		R123U3-0200-1500-CS	★	☆	☆	☆	★	7°	100.00	-0.100	0.000	0.000	0.050
	.079	.000	.000	.248	15.000									3.937	-.0039	.0000	.0000	.0020

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand



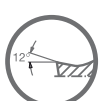
B5



B91



B109



B107



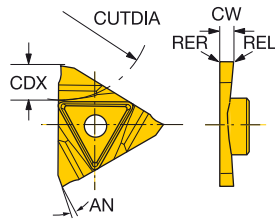
J19



J9

CoroCut® 3 insert for grooving

Grooving



							P	M	K	N	S	Dimensions, mm, inch					
		SSC	CW	REL	RER	CDX	Ordering code	1125	1125	1125	1125	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing	T	0.50	0.00	0.00	1.5	N123T3-0050-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.020	.000	.000	.059								3.937	-.0008	.0008	.0000	.0020
		0.60	0.00	0.00	1.6	N123T3-0060-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.024	.000	.000	.063								3.937	-.0008	.0008	.0000	.0020
		0.70	0.00	0.00	1.7	N123T3-0070-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.028	.000	.000	.067								3.937	-.0008	.0008	.0000	.0020
		0.80	0.00	0.00	1.8	N123T3-0080-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.031	.000	.000	.071								3.937	-.0008	.0008	.0000	.0020
		0.90	0.00	0.00	2.0	N123T3-0090-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.035	.000	.000	.079								3.937	-.0008	.0008	.0000	.0020
		1.00	0.00	0.00	2.2	N123T3-0100-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.039	.000	.000	.087								3.937	-.0008	.0008	.0000	.0020
		1.20	0.00	0.00	2.3	N123T3-0120-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.047	.000	.000	.091								3.937	-.0008	.0008	.0000	.0020
		1.40	0.00	0.00	2.7	N123T3-0140-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.055	.000	.000	.106								3.937	-.0008	.0008	.0000	.0020
		1.50	0.00	0.00	3.0	N123T3-0150-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.059	.000	.000	.118								3.937	-.0008	.0008	.0000	.0020
		1.60	0.00	0.00	3.2	N123T3-0160-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.063	.000	.000	.126								3.937	-.0008	.0008	.0000	.0020
		1.70	0.00	0.00	3.3	N123T3-0170-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.067	.000	.000	.130								3.937	-.0008	.0008	.0000	.0020
		1.95	0.00	0.00	3.9	N123T3-0195-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050
		.077	.000	.000	.154								3.937	-.0008	.0008	.0000	.0020
	2.00	0.00	0.00	4.0	N123T3-0200-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.079	.000	.000	.157								3.937	-.0008	.0008	.0000	.0020	
	2.25	0.00	0.00	4.5	N123T3-0225-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.089	.000	.000	.177								3.937	-.0008	.0008	.0000	.0020	
	2.50	0.00	0.00	5.0	N123T3-0250-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.098	.000	.000	.197								3.937	-.0008	.0008	.0000	.0020	
	2.75	0.00	0.00	5.5	N123T3-0275-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.108	.000	.000	.217								3.937	-.0008	.0008	.0000	.0020	
	3.00	0.00	0.00	6.0	N123T3-0300-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.118	.000	.000	.236								3.937	-.0008	.0008	.0000	.0020	
	3.18	0.00	0.00	6.0	N123T3-0318-0000-GS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.125	.000	.000	.236								3.937	-.0008	.0008	.0000	.0020	

SSC = To correspond with SSC on holder.

T = Right hand cutting insert, U = Left hand cutting insert.



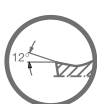
B5



B91



B109



B107



J19

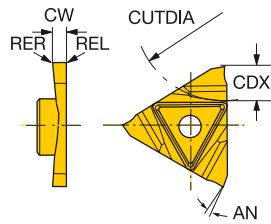


J9



CoroCut® 3 insert for grooving

Grooving



						P	M	K	N	S	Dimensions, mm, inch					
						1125	1125	1125	1125	1125	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
SSC	CW	REL	RER	CDX	Ordering code	★	★	★	★	★						
Finishing	U	0.50	0.00	0.00	1.5	N123U3-0050-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.020	.000	.000	.059							3.937	-0.0008	.0008	.0000	.0020
		0.70	0.00	0.00	1.7	N123U3-0070-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.028	.000	.000	.067							3.937	-0.0008	.0008	.0000	.0020
		0.80	0.00	0.00	1.8	N123U3-0080-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.031	.000	.000	.071							3.937	-0.0008	.0008	.0000	.0020
		0.90	0.00	0.00	2.0	N123U3-0090-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.035	.000	.000	.079							3.937	-0.0008	.0008	.0000	.0020
		1.00	0.00	0.00	2.2	N123U3-0100-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.039	.000	.000	.087							3.937	-0.0008	.0008	.0000	.0020
		1.20	0.00	0.00	2.3	N123U3-0120-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.047	.000	.000	.091							3.937	-0.0008	.0008	.0000	.0020
		1.40	0.00	0.00	2.7	N123U3-0140-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.055	.000	.000	.106							3.937	-0.0008	.0008	.0000	.0020
		1.50	0.00	0.00	3.0	N123U3-0150-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.059	.000	.000	.118							3.937	-0.0008	.0008	.0000	.0020
		1.60	0.00	0.00	3.2	N123U3-0160-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.063	.000	.000	.126							3.937	-0.0008	.0008	.0000	.0020
		1.70	0.00	0.00	3.3	N123U3-0170-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050
		.067	.000	.000	.130							3.937	-0.0008	.0008	.0000	.0020
	2.00	0.00	0.00	4.0	N123U3-0200-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.079	.000	.000	.157							3.937	-0.0008	.0008	.0000	.0020	
	2.25	0.00	0.00	4.5	N123U3-0225-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.089	.000	.000	.177							3.937	-0.0008	.0008	.0000	.0020	
	2.50	0.00	0.00	5.0	N123U3-0250-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.098	.000	.000	.197							3.937	-0.0008	.0008	.0000	.0020	
	3.00	0.00	0.00	6.0	N123U3-0300-0000-GS	★	★	★	★	7°	100.00	-0.020	0.020	0.000	0.050	
	.118	.000	.000	.236							3.937	-0.0008	.0008	.0000	.0020	

SSC = To correspond with SSC on holder.

T = Right hand cutting insert, U = Left hand cutting insert.



B5



B91



B109



B107



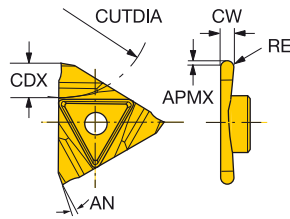
J19



J9

CoroCut® 3 insert for profiling

Grooving/Profiling



	SSC	CW	RE	CDX	APMX	Ordering code	P	M	K	N	S	Dimensions, mm, inch					
							1125	1125	1125	1125	1125	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
							★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
Finishing	T	0.50	0.25	1.5	0.3	N123T3-0050-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.020	.010	.059	.012								3.937	-0.008	.008	-0.020	.020
		0.80	0.40	1.8	0.5	N123T3-0080-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.031	.016	.071	.020								3.937	-0.008	.008	-0.020	.020
		1.00	0.50	2.2	0.5	N123T3-0100-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.039	.020	.087	.020								3.937	-0.008	.008	-0.020	.020
		1.50	0.75	3.3	0.5	N123T3-0150-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.059	.030	.130	.020								3.937	-0.008	.008	-0.020	.020
		2.00	1.00	4.0	1.0	N123T3-0200-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.079	.039	.157	.039								3.937	-0.008	.008	-0.020	.020
	2.50	1.25	5.0	1.0	N123T3-0250-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050	
	.098	.049	.197	.039								3.937	-0.008	.008	-0.020	.020	
	3.00	1.50	6.0	1.0	N123T3-0300-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050	
	.118	.059	.236	.039								3.937	-0.008	.008	-0.020	.020	
	U	0.50	0.25	1.5	0.3	N123U3-0050-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.020	.010	.059	.012								3.937	-0.008	.008	-0.020	.020
		0.80	0.40	1.8	0.5	N123U3-0080-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.031	.016	.071	.020								3.937	-0.008	.008	-0.020	.020
		1.00	0.50	2.2	0.5	N123U3-0100-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050
		.039	.020	.087	.020								3.937	-0.008	.008	-0.020	.020
1.50		0.75	3.3	0.5	N123U3-0150-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050	
.059		.030	.130	.020								3.937	-0.008	.008	-0.020	.020	
2.00		1.00	4.0	1.0	N123U3-0200-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050	
.079		.039	.157	.039								3.937	-0.008	.008	-0.020	.020	
3.00	1.50	6.0	1.0	N123U3-0300-RS	★	★	☆	☆	★	7°	100.00	-0.020	0.020	-0.050	0.050		
.118	.059	.236	.039								3.937	-0.008	.008	-0.020	.020		

SSC = To correspond with SSC on holder.

T = Right hand cutting insert, U = Left hand cutting insert.



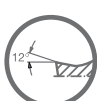
B5



B91



B109



B107



J19



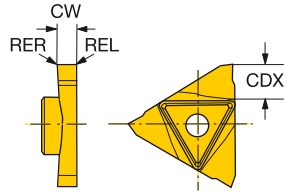
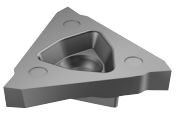
J9

CoroCut® 3 carbide blank

Blanks

ENG

B



C

D

							Dimensions, mm, inch					
	SSC	CW	REL	RER	CDX	Ordering code	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
Medium	T	3.40	0.00	0.00	6.4	N123T3-0340-BG	7°	100.00	-0.050	0.050	0.000	0.000
		.134	.000	.000	.252			3.937	-.0020	.0020	.0000	.0000
	U	3.40	0.00	0.00	6.4	N123U3-0340-BG	7°	100.00	-0.050	0.050	0.000	0.000
		.134	.000	.000	.252			3.937	-.0020	.0020	.0000	.0000

T = Right hand cutting insert, U = Left hand cutting insert.

E

F

G

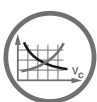
H

I

J



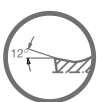
B5



B91



B109



B107



J19



J9

T-Max Q-Cut®

Internal grooving, face grooving and undercutting

Application

- Internal grooving
- Face grooving
- Undercutting

ISO application area:



Benefits and features

- Excellent surface finish due to wiper technology
- Proven, versatile system
- V-clamped 1-edged insert for good stability
- Tailor Made

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B6



B5

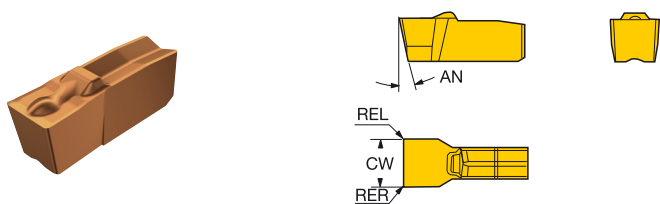


J9



T-Max® Q-Cut insert for grooving

Internal grooving



C

D

E

Finishing	SSC	CW	REL	RER	Ordering code	Dimensions, mm, inch																		
						P			M			K		N		S			H					
						1125	1145	2135	1125	1145	2135	H13A	1125	2135	H13A	1125	2135	H13A	1125	2135	H13A			
	20	2.00	0.20	0.20	N151.3-200-20-4G	☆	☆	★	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	CWTOLL	CWTOLU	RETOLL	RETOLU
		.079	.008	.008																	-0.020	0.020	-0.050	0.050
	25	2.39	0.18	0.18	N151.3-A094-25-4G	★	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	-0.008	.0008	-0.020	.0020
		.094	.007	.007																	-0.020	0.020	-0.051	0.051
		2.46	0.33	0.33	N151.3-A097-25-4G	★			★		☆	☆	☆	☆	☆	☆	☆	★	★	☆	-0.008	.0008	-0.020	.0020
		.097	.013	.013																	-0.020	0.020	-0.051	0.051
		2.67	0.18	0.18	N151.3-A105-25-4G		☆			☆	☆			☆			★	☆	☆	☆	-0.008	.0008	-0.020	.0020
		.105	.007	.007																	-0.020	0.020	-0.051	0.051
		2.79	0.33	0.33	N151.3-A110-25-4G	★			★		☆			☆			★			☆	-0.008	.0008	-0.020	.0020
		.110	.013	.013																	-0.020	0.020	-0.051	0.051
	30	3.00	0.20	0.20	N151.3-300-30-4G	☆	☆	★	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	-0.020	0.020	-0.050	0.050
		.118	.008	.008																	-0.008	.0008	-0.020	.0020
		3.18	0.18	0.18	N151.3-A125-30-4G	★			★		☆	☆	☆	☆	☆	☆	☆	★	★	☆	-0.008	.0008	-0.020	.0020
		.125	.007	.007																	-0.020	0.020	-0.051	0.051
		3.61	0.33	0.33	N151.3-A142-30-4G	★			★		☆			☆			★			☆	-0.008	.0008	-0.020	.0020
		.142	.013	.013																	-0.020	0.020	-0.051	0.051

F

For circlip grooves

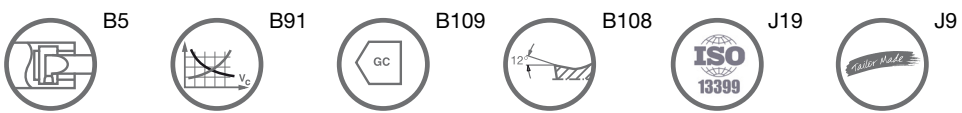
Finishing	SSC	CW	REL	RER	Ordering code	Dimensions, mm, inch														
						P			M			K		N		S				
						1125	1125	H13A	1125	H13A	H13A	1125	H13A	AN	CWTOLL	CWTOLU	RETOLL	RETOLU		
	20	1.85	0.10	0.10	N151.3-185-20-4G	★	★	☆	☆	☆	☆	★	☆	☆	11°	0.090	0.130	-0.050	0.050	
		.073	.004	.004												.0035	.0051	-0.020	.0020	
		2.15	0.15	0.15	N151.3-215-20-4G	★	★	☆	☆	☆	☆	★	☆	☆	11°	0.090	0.130	-0.050	0.050	
		.085	.006	.006												.0035	.0051	-0.020	.0020	
		25	2.65	0.15	0.15	N151.3-265-25-4G	★	★	☆	☆	☆	☆	★	☆	☆	11°	0.090	0.130	-0.050	0.050
			.104	.006	.006												.0035	.0051	-0.020	.0020

SSC = To correspond with SSC on holder.

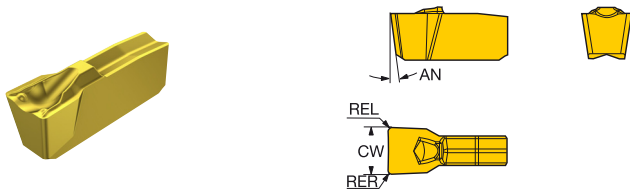
H

I

J



T-Max® Q-Cut insert for grooving

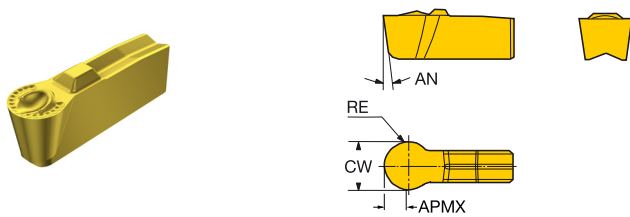


Face grooving, internal grooving and turning

Medium	SSC	CW	REL	RER	Ordering code	Dimensions, mm, inch																
						P		M		K		N		S		H						
						1125	1145	2135	3020	1125	1145	2135	3020	1125	1145	2135	2135					
	25	3.00	0.30	0.30	N151.3-300-25-7G	☆	☆	★	☆	☆	☆	★	☆	☆	☆	☆	☆	8°	0.000	0.100	-0.100	0.100
		.118	.012	.012														.0000	.0039	-.0039	.0039	
	30	4.00	0.40	0.40	N151.3-400-30-7G	☆	☆	★	☆	☆	☆	★	☆	☆	☆	☆	☆	8°	0.000	0.100	-0.100	0.100
		.157	.016	.016														.0000	.0039	-.0039	.0039	

SSC = To correspond with SSC on holder.

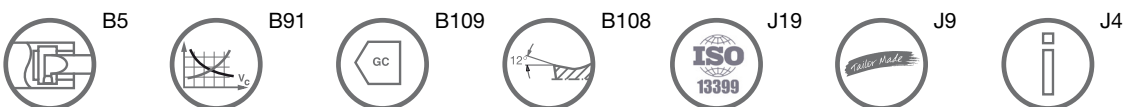
T-Max® Q-Cut insert for profiling



Internal profiling and face grooving

Medium	SSC	CW	RE	APMX	Ordering code	Dimensions, mm, inch															
						P		M		K		N		S		H					
						1125	2135	1125	2135	1125	2135	1125	2135	1125	2135	2135					
	25	3.00	1.50	1.3	N151.3-300-25-7P	☆	★	☆	☆	☆	☆	★	☆	☆	☆	☆	9°	-0.050	0.050	-0.020	0.020
		.118	.059	.051														-.0020	.0020	-.0008	.0008
	30	4.00	2.00	1.7	N151.3-400-30-7P	☆	★	☆	☆	☆	☆	★	☆	☆	☆	☆	8°	-0.050	0.050	-0.020	0.020
		.157	.079	.067														-.0020	.0020	-.0008	.0008

SSC = To correspond with SSC on holder.



T-Max® U-Lock

B Internal threading

C T-Max® U-Lock is a complement to the CoroThread® 266 rigid indexable insert threading system. It provides a specialized solution for 11 mm (.433 inch) internal threading applications in two different geometries: all-round and sharp.

ISO application area:



D Application

- Internal threading
- Circlip grooving

E Benefits and features

- Indexable inserts
- Three sharp cutting edges for high quality threads

F www.sandvik.coromant.com/tmaxulock

G Inserts

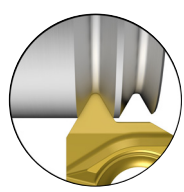
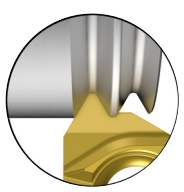
- Full profile

Inserts

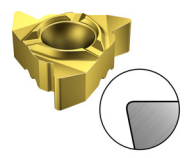
- V-profile

Tools

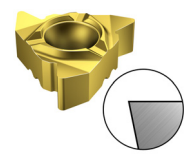
- Boring bars



- Insert geometries and grades for all materials
- Tailor Made inserts for almost any thread form or pitch

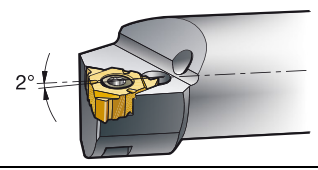


Standard geometry



Sharp F-geometry

The tool holders for inserts with size 11 are made for a 2° inclination angle and no shim



B39

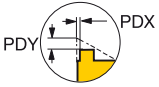
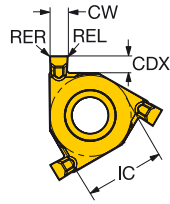
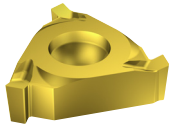


B5



J9

T-Max® U-Lock insert for grooving



		Dimensions, mm, inch										
Medium		CW	REL	RER	CDX	Ordering code	AN	CWTOLL	CWTOLU	RETOLL	RETOLU	
		11	1.10	0.08	0.08	0.7	L154.0G-11CC01-110	0°	0.050	0.130	-0.020	0.020
			.043	.003	.003	.028			.0020	.0051	-.0008	.0008

SSC = To correspond with SSC on holder.

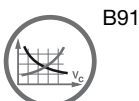
Note!

The right hand insert can be used in right hand external and left hand internal holders, and the left hand insert in left hand external and right hand internal holders.

When using CoroThread® 266 boring bars for these inserts, a shim giving an angle of inclination of 0° must be used, see page C72



B5



B91



B109



J19

CoroCut® XS

For external machining of small and slender components

High precision components

CoroCut XS inserts offer low cutting forces thanks to the extremely sharp cutting edges. This means, at low feeds CoroCut XS is excellent for producing high precision components with close tolerances. As a bonus, all inserts fit the same tool holder keeping the tool inventory small.

ISO application area:

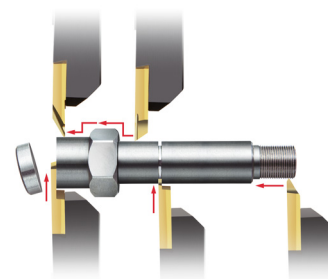
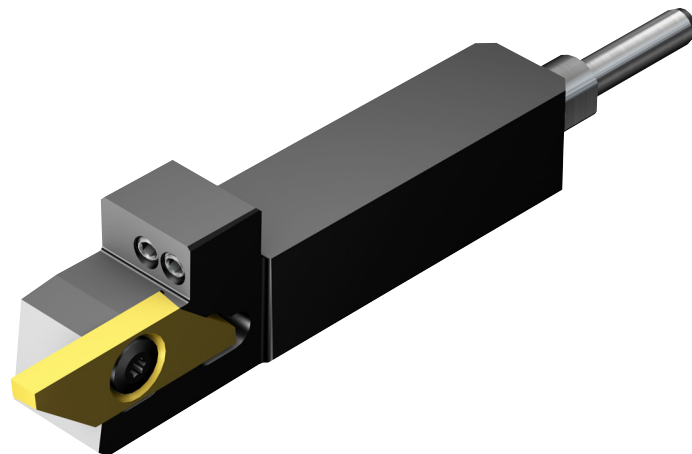


Application

- Parting off
- External threading
- External grooving
- Turning

Benefits and features

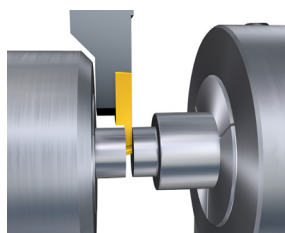
- High precision
- Close tolerances
- Good accessibility when changing inserts
- Wide variety of insert widths
- Sharp cutting edges
- All inserts fit into the same tool holder
- High quality ground inserts and holders
- Full profile inserts for high quality threads in one operation
- Designed to maintain the tool holder intact in case of insert breakage.
- Available with precision coolant



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Holders

Dedicated holders for parting off close to sub spindle are available in high precision square shank style.



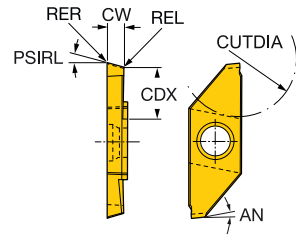
A30

CoroCut® XS insert for parting

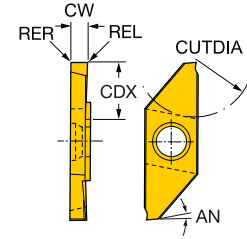
Parting off



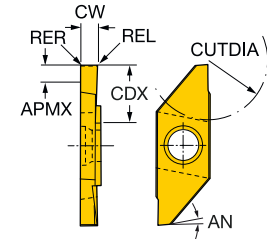
MACR/L-L



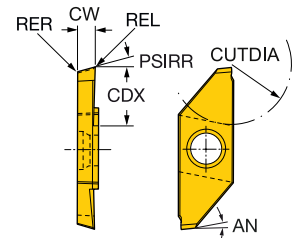
MACR/L-N



MACR/L-T



										Dimensions, mm, inch										
		SSC	CW	REL	RER	CDX	PSIRL	APMX	Ordering code	P 1025	M 1105	K 1025	N 1105	S 1025	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
	3	0.70	0.05	0.05	4.3				MACR/L 3 070-N	☆	☆	☆	☆	☆	6°	8.00	-0.020	0.020	-0.030	0.030
		.028	.002	.002	.169					☆	☆	☆	☆	☆		.315	-.0008	.0008	-.0012	.0012
		1.00	0.05	0.05	6.3				MACR/L 3 100-N	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030
		.039	.002	.002	.248					☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012
		1.50	0.05	0.05	6.3				MACR/L 3 150-N	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030
		.059	.002	.002	.248					☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012
	3	0.70	0.05	0.05	4.3	15.0			MACR/L 3 070-L	☆	☆	☆	☆	☆	6°	8.00	-0.020	0.020	-0.030	0.030
		.028	.002	.002	.169	15.000				☆	☆	☆	☆	☆		.315	-.0008	.0008	-.0012	.0012
		1.00	0.05	0.05	6.3	15.0			MACR/L 3 100-L	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030
		.039	.002	.002	.248	15.000				☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012
		1.50	0.05	0.05	6.3	15.0			MACR/L 3 150-L	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030
		.059	.002	.002	.248	15.000				☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012
	3	1.00	0.05	0.05	6.3		1.5		MACR/L 3 100-T	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030
		.039	.002	.002	.248		.059			☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012
		1.50	0.05	0.05	6.3		1.5		MACR/L 3 150-T	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030
		.059	.002	.002	.248		.059			☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012
		2.00	0.05	0.05	8.2		3.0		MACR/L 3 200-T	☆	☆	☆	☆	☆	6°	16.00	-0.020	0.020	-0.030	0.030
		.079	.002	.002	.323		.118			☆	☆	☆	☆	☆		.630	-.0008	.0008	-.0012	.0012
	2.50	0.05	0.05	8.2		3.0		MACR/L 3 250-T	☆	☆	☆	☆	☆	6°	16.00	-0.020	0.020	-0.030	0.030	
	.098	.002	.002	.323		.118			☆	☆	☆	☆	☆		.630	-.0008	.0008	-.0012	.0012	



										Dimensions, mm, inch										
		SSC	CW	REL	RER	CDX	PSIRR	Ordering code	P 1025	M 1025	K H13A	N 1025	S H13A	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU	
	3	0.70	0.05	0.05	4.3	15.0		MACR/L 3 070-R	☆	☆	☆	☆	☆	6°	8.00	-0.020	0.020	-0.030	0.030	
		.028	.002	.002	.169	15.000			☆	☆	☆	☆	☆		.315	-.0008	.0008	-.0012	.0012	
		1.00	0.05	0.05	6.3	15.0		MACR/L 3 100-R	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030	
		.039	.002	.002	.248	15.000			☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012	
		1.50	0.05	0.05	6.3	15.0		MACR/L 3 150-R	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030	
		.059	.002	.002	.248	15.000			☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012	
	3	1.50	0.05	0.05	6.3	20.0		MACR/L 3 150-R20	☆	☆	☆	☆	☆	6°	12.00	-0.020	0.020	-0.030	0.030	
		.059	.002	.002	.248	20.000			☆	☆	☆	☆	☆		.472	-.0008	.0008	-.0012	.0012	
		2.00	0.05	0.05	8.5	20.0		MACR/L 3 200-R20	☆	☆	☆	☆	☆	6°	16.00	-0.020	0.020	-0.030	0.030	
		.079	.002	.002	.335	20.000			☆	☆	☆	☆	☆		.630	-.0008	.0008	-.0012	.0012	

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand



B5



B99



B109



J19

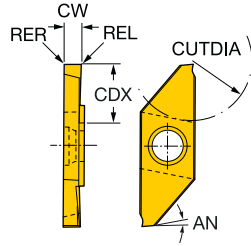


CoroCut® XS insert for parting

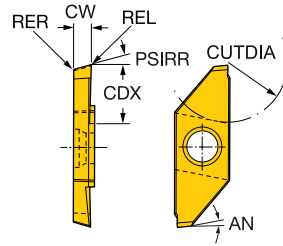
Parting off



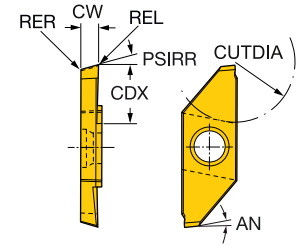
MACR/L-N



MACR/L-R



MACR/L-R20



		Dimensions, mm, inch													
		P		M		K		N		S			AN		
		1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	1105	1105		
	SSC	CW	REL	RER	CDX	PSIRR	Ordering code						AN		
	3	0.70	0.05	0.05	4.3	15°	MACR/L 3 070-R	☆	☆	☆	☆	☆	☆	6°	
		.028	.002	.002	.169										
		1.00	0.05	0.05	6.3	15°	MACR/L 3 100-R	☆	☆	☆	☆	☆	☆	6°	
		.039	.002	.002	.248										
		1.50	0.05	0.05	6.3	15°	MACR/L 3 150-R	☆	☆	☆	☆	☆	☆	6°	
		.059	.002	.002	.248										
		2.00	0.05	0.05	8.5	15°	MACR/L 3 200-R	☆	☆	☆	☆	☆	☆	6°	
		.079	.002	.002	.335										
			3	0.70	0.05	0.05	4.3	MACR/L 3 070-N	☆	☆	☆	☆	☆	☆	6°
		.028	.002	.002	.169										
		1.00	0.05	0.05	6.3	15°	MACR/L 3 100-N	☆	☆	☆	☆	☆	☆	6°	
		.039	.002	.002	.248										
		1.50	0.05	0.05	6.3	15°	MACR/L 3 150-N	☆	☆	☆	☆	☆	☆	6°	
		.059	.002	.002	.248										
		2.00	0.05	0.05	8.5	15°	MACR/L 3 200-N	☆	☆	☆	☆	☆	☆	6°	
		.079	.002	.002	.335										
			3	1.50	0.05	0.05	6.3	20°	MACR/L 3 150-R20	☆	☆	☆	☆	☆	6°
			.059	.002	.002	.248									
		2.00	0.05	0.05	8.5	20°	MACR/L 3 200-R20	☆	☆	☆	☆	☆	☆	6°	
	.079	.002	.002	.335											

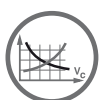
R = Right hand, L = Left hand

Tolerances:

	CWTOLL	CWTOLU	CWTOLL"	CWTOLU"	RETOLL	RETOLU	RETOLL"	RETOLU"
MACR/L-N	-0.020	0.020	-.0008	.0008	-0.03	0.03	-.0012	.0012
MACR/L-R	-0.020	0.020	-.0008	.0008	-0.03	0.03	-.0012	.0012
MACR/L-R20	-0.020	0.020	-.0008	.0008	-0.03	0.03	-.0012	.0012



B5



B99



B109



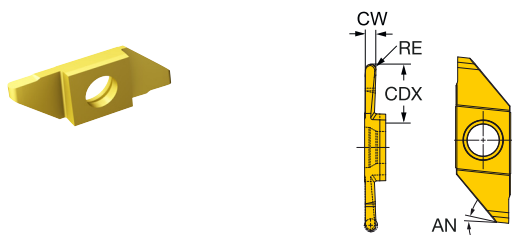
J19

CoroCut® XS insert for grooving



SSC	CW	REL	RER	CDX	Ordering code	Dimensions, mm, inch										
						P	M	K	N	S	AN	CWTOLL	CWTOLU	RETOLL	RETOLU	
3	0.50	0.05	0.05	1.3	MAGR/L 3 050	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020
	.020	.002	.002	.051												
	0.75	0.05	0.05	2.5	MAGR/L 3 075	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020
	.030	.002	.002	.098												
	1.00	0.05	0.05	2.7	MAGR/L 3 100	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020
	.039	.002	.002	.106												
	1.25	0.05	0.05	2.7	MAGR/L 3 125	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020
	.049	.002	.002	.106												
	1.50	0.05	0.05	3.7	MAGR/L 3 150	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020
	.059	.002	.002	.146												
	1.75	0.05	0.05	3.7	MAGR/L 3 175	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020
	.069	.002	.002	.146												
2.00	0.05	0.05	3.7	MAGR/L 3 200	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020	
.079	.002	.002	.146													
2.50	0.05	0.05	3.7	MAGR/L 3 250	☆	☆	☆	☆	☆	☆	6°	-0.025	0.025	-0.020	0.020	
.098	.002	.002	.146													

CoroCut® XS insert for profiling



SSC	CW	RE	CDX	APMX	Ordering code	Dimensions, mm, inch								
						P	M	N	S					
3	0.80	0.40	3.8	3.8	MAPL 3 080	☆	☆	☆	☆	6°	-0.025	0.025	-0.025	0.025
	.031	.016	.148	.148										
	1.25	0.63	5.0	4.0	MAPL 3 125	☆	☆	☆	☆	6°	-0.025	0.025	-0.025	0.025
	.049	.025	.197	.157										
	1.60	0.80	7.5	4.0	MAPL 3 160	☆	☆	☆	☆	6°	-0.025	0.025	-0.025	0.025
	.063	.031	.295	.157										
2.50	1.25	7.5	4.0	MAPL 3 250	☆	☆	☆	☆	6°	-0.025	0.025	-0.025	0.025	
.098	.049	.295	.157											

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand



B5



B99



B109



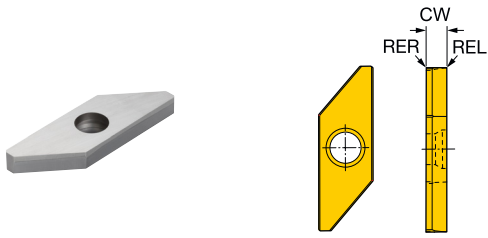
J19



A

CoroCut® XS carbide blank

B



C

SSC	CW	Ordering code	P	M	N	S
			H10	H10	H10	H10
3	3.18	MAXL 3 300	☆	☆	☆	
	.125					
	3.18	MAXR 3 300	☆	☆	☆	☆
	.125					

D

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand

E

F

G

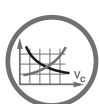
H

I

J



B5



B99



B109



J19

A
B
C
D
E
F
G
H
I
J

CoroThread® 266

Ultra-rigid thread turning for all types of threads

Highly productive threading

When talking about thread turning CoroThread 266 has a solution for any component. The three-edged system includes almost every thread profile, and the excellent insert stability secures high thread quality while at the same time allowing for increased cutting data.

Application

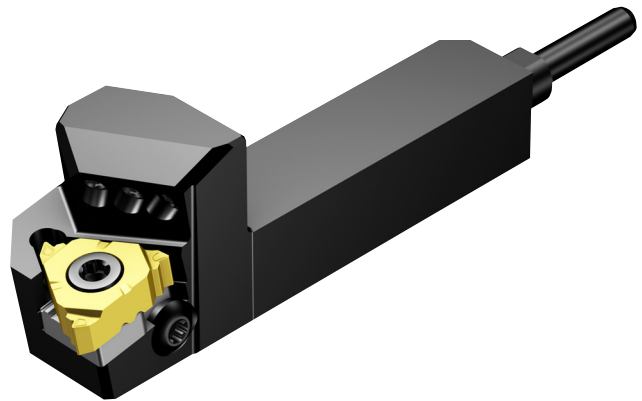
- External threading

ISO application area:



Benefits and features

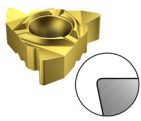
- Reduced machine- and downtime
- Excellent surface finish due to the exceptional stability
- Three sharp cutting edges for high-quality threads
- Multi-point inserts available, require fewer passes resulting in increased productivity
- Large standard product range of tools and thread profile inserts
- Unique guide rail interface between the insert and tip seat
- Good edge indexing
- Easy to mount the insert correctly



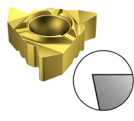
www.sandvik.coromant.com/corothread266

Inserts

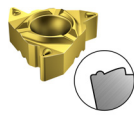
- Insert geometries and grades for all materials
- Tailor Made inserts for almost any thread form or pitch



Standard
A-geometry



Sharp
F-geometry



Chip-breaking
C-geometry

Tools

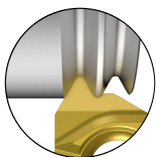
- QS Shank tools
- Shank tools
- CoroTurn® SL heads



Three different threading insert types

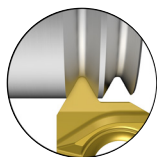
Full profile

High productivity



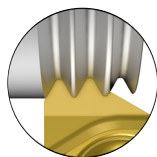
V-profile

Minimum tool inventory



Multi-point

Economical mass production



Secure iLock™ clamping

The slotted insert sits rigidly on the T-rails in the pocket eliminating any insert movement caused by cutting force variations.



C7



C4



J9

CoroThread® 266 insert for grooving

For circlip grooving and machining in shallow grooves

ENG

B



C

					P	M	K	N	S	Dimensions, mm, inch				
					1135	1135	1135	1135	1135	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
	CW	REL	RER	CDX	Ordering code	*	*	*	*	0°	0.050	0.130	-0.080	0.020
	.043	.003	.003	.051	254R/LG-16CC01-110	*	*	*	*		.0020	.0051	-.0032	.0008
	CW	REL	RER	CDX	Ordering code	*	*	*	*	0°	0.050	0.130	-0.080	0.020
	.051	.003	.003	.063	254R/LG-16CC01-130	*	*	*	*		.0020	.0051	-.0032	.0008
	CW	REL	RER	CDX	Ordering code	*	*	*	*	0°	0.050	0.130	-0.080	0.020
	.063	.003	.003	.073	254R/LG-16CC01-160	*	*	*	*		.0020	.0051	-.0032	.0008
	CW	REL	RER	CDX	Ordering code	*	*	*	*	0°	0.050	0.130	-0.080	0.020
	.073	.003	.003	.073	254R/LG-16CC01-185	*	*	*	*		.0020	.0051	-.0032	.0008
	CW	REL	RER	CDX	Ordering code	*	*	*	*	0°	0.050	0.130	-0.080	0.020
	.085	.003	.003	.073	254R/LG-16CC01-215	*	*	*	*		.0020	.0051	-.0032	.0008

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand

E

Note!
The right hand insert can be used in right hand external and left hand internal holders, and the left hand insert in left hand external and right hand internal holders.

F

When using CoroThread® 266 boring bars for these inserts, a shim giving an angle of inclination of 0° must be used, see page C72

G

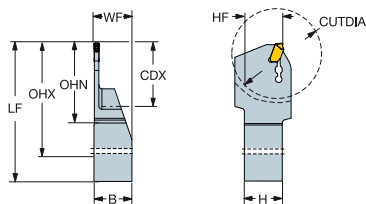
H

I


J



Shank tool for parting and grooving

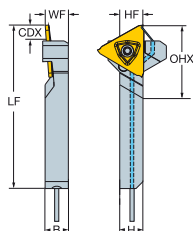


Rectangular shank -metric: 7 x 7


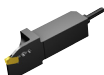
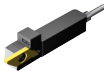
		Dimensions, mm											
SSC	CZC _{MS}	CDX	OHX	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MIID
	E	7 x 7	12.0	22.0	QD-R/LFE12-0707S	7.0	7.0	125.0	7.3	7.0	0.08	CoroCut QD	QD-NE-0200-0002-CM

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



QS-HP shank coupling -metric: 10 x 10

		Dimensions, mm														
SSC	CZC _{MS}	CDX	OHX	CNSC	Ordering code	B	H	LF	WF	HF	BAR	NM	KG	PRODFAM	MIID	
	T	10 x 10	6.4	23.0	1	QS-RF123T06-1010BHP	10.0	10.0	70.0	10.0	10.0	80	3.0	0.09	CoroCut 3	N123T3-0150- CM
	U	10 x 10	6.4	23.0	1	QS-LF123U06-1010BHP	10.0	10.0	70.0	10.0	10.0	80	3.0	0.09	CoroCut 3	N123U3-0150- CM
	B	10 x 10	10.0	25.0	1	QS-QD-R/LFB10C1010S	10.0	10.0	70.0	10.0	10.0	80		0.06	CoroCut QD	QD-NB-0100-0001-CM
	E	10 x 10	12.0	25.0	1	QS-QD-R/LFE12C1010S	10.0	10.0	70.0	10.0	10.0	80		0.04	CoroCut QD	QD-NE-0200-0002-CM
	F	10 x 10	12.0	25.0	1	QS-QD-R/LFF12C1010S	10.0	10.0	70.0	10.0	10.0	80		0.04	CoroCut QD	QD-NF-0250-0002-CM
	3	10 x 10	8.5	29.0	1	QS-SMALR/L1010E3HP	10.0	10.0	70.0	10.0	10.0	80	1.2	0.94	CoroCut XS	MACL 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



B6



J19



J16



J9

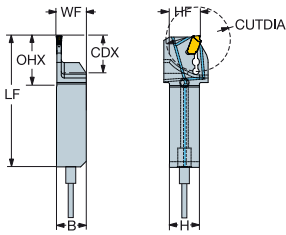


A

Shank tool for parting and grooving

QS shank coupling -metric: 10 x 10

B



C

	SSC	CZC _{MS}	CDX	OHX	Ordering code	Dimensions, mm						PRODFAM	MIID	
						B	H	LF	WF	HF	NM			KG
	D	10 x 10	10.0	18.0	QS-R/LF123D10-1010B	10.0	10.0	70.0	10.2	10.0	2.5	0.02	CoroCut 1-2	N123D2-0150-0002-CM
	E	10 x 10	10.0	21.0	QS-R/LF123E10-1010B	10.0	10.0	70.0	10.2	10.0	2.5	0.06	CoroCut 1-2	N123E2-0200-0002-CM
	F	10 x 10	10.0	21.6	QS-R/LF123F10-1010B	10.0	10.0	70.0	10.0	10.0	2.5	0.06	CoroCut 1-2	N123F2-0250-0002-CM
	T	10 x 10	6.4	31.7	QS-RF123T06-1010B	10.0	10.0	70.0	10.0	10.0	3.0	0.08	CoroCut 3	N123T3-0150- CM
	U	10 x 10	6.4	31.7	QS-LF123U06-1010B	10.0	10.0	70.0	10.0	10.0	3.0	0.08	CoroCut 3	N123U3-0150- CM
	3	10 x 10	8.5	27.0	QS-SMALR 1010E-X	10.0	10.0	70.0	10.0	10.0	1.2	0.09	CoroCut XS	MACR 3 200-N
	E	10 x 10	8.5	27.0	QS-SMALR 1010E3	10.0	10.0	70.0	10.0	10.0	1.2	0.09	CoroCut XS	MACR 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

F

G

H

I

J



B6



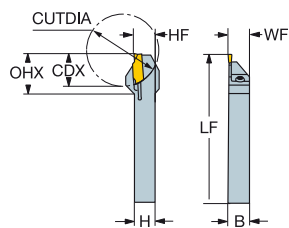
J19



J9

Shank tool for parting and grooving

Rectangular shank -metric: 10 x 10



	SSC	CZC _{MS}	CDX	OHX	Ordering code	Dimensions, mm						PRODFAM	MIID	
						B	H	LF	WF	HF	NM			KG
	D	10 x 10	10.0	21.6	R/LF123D10-1010B-S	10.0	10.0	125.0	10.0	10.0	2.5	0.11	CoroCut 1-2	N123D2-0150-0002-CM
	E	10 x 10	10.0	21.6	R/LF123E10-1010B-S	10.0	10.0	125.0	10.0	10.0	2.5	0.11	CoroCut 1-2	N123E2-0200-0002-CM
	F	10 x 10	10.0	21.6	R/LF123F10-1010B-S	10.0	10.0	125.0	10.0	10.0	2.5	0.11	CoroCut 1-2	N123F2-0250-0002-CM
	T	10 x 10	6.4	23.0	RF123T06-1010BM	10.0	10.0	125.0	10.0	10.0	3.0	0.13	CoroCut 3	N123T3-0150- CM
	U	10 x 10	6.4	23.0	LF123U06-1010BM	10.0	10.0	125.0	10.0	10.0	3.0	0.13	CoroCut 3	N123U3-0150- CM
	E	10 x 10	13.0	22.0	QD-R/LFE13-1010S	10.0	10.0	127.0	10.0	10.0		0.09	CoroCut QD	QD-NE-0200-0002-CM
	3	10 x 10	8.5	27.0	SMALR/L 1010K 3	10.0	10.0	125.0	10.0	10.0	1.2	0.08	CoroCut XS	MACL 3 200-N
	3	10 x 10	8.5	27.0	SMALR 1010K 3-X	10.0	10.0	125.0	10.0	10.0	1.2	0.13	CoroCut XS	MACR 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



B6



J19



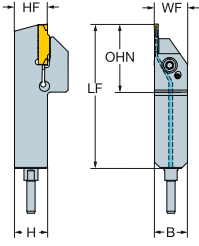
J9

A





Shank tool for parting and grooving

QS-HP shank coupling -metric: 12 x 12

B



C

		Dimensions, mm														
SSC	CZ _{MS}	CDX	OHX	CNSC	Ordering code	B	H	LF	WF	HF	BAR	NM	KG	PRODFAM	MIID	
	E	12 x 12	11.0	21.0	1	QS-R/LF123E11-1212BHP	12.0	12.0	70.0	12.2	12.0	80	2.5	0.11	CoroCut 1-2	N123E2-0200-0002-CM
	F	12 x 12	15.0	20.0	1	QS-R/LF123F15-1212BHP	12.0	12.0	70.0	12.0	12.0	80	2.5	0.10	CoroCut 1-2	N123F2-0250-0002-CM
	T	12 x 12	6.4	23.0	1	QS-RF123T06-1212BHP	12.0	12.0	70.0	12.0	12.0	80	3.0	0.11	CoroCut 3	N123T3-0150-CM
	U	12 x 12	6.4	23.0	1	QS-LF123U06-1212BHP	12.0	12.0	70.0	12.0	12.0	80	3.0	0.11	CoroCut 3	N123U3-0150-CM
	B	12 x 12	10.0	25.0	1	QS-QD-R/LFB10C1212S	12.0	12.0	70.0	12.0	12.0	80		0.08	CoroCut QD	QD-NB-0100-0001-CM
	C	12 x 12	10.0	25.0	1	QS-QD-R/LFC10C1212S	12.0	12.0	70.0	12.0	12.0	80		0.08	CoroCut QD	QD-NC-0125-0001-CM
	E	12 x 12	16.0	25.0	1	QS-QD-R/LFE16C1212S	12.0	12.0	70.0	12.0	12.0	80		0.09	CoroCut QD	QD-NE-0200-0002-CM
	E	12 x 12	13.0	25.0	1	QS-QD-R/LFE13C1212S	12.0	12.0	70.0	12.0	12.0	80		0.09	CoroCut QD	QD-NE-0200-0002-CM
	F	12 x 12	13.0	25.0	1	QS-QD-R/LFF13C1212S	12.0	12.0	70.0	12.0	12.0	80		0.10	CoroCut QD	QD-NF-0250-0002-CM
	3	12 x 12	8.5	28.0	1	QS-SMALR/L1212E3HP-M	12.0	12.0	70.0	12.0	12.0	80	1.2	0.11	CoroCut XS	MACL 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

F

G

H

I

J



B6



J19



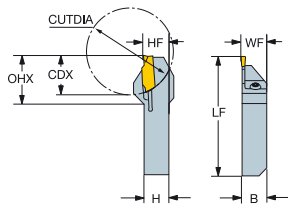
J16



J9

Shank tool for parting and grooving

QS shank coupling -metric: 12 x 12



	SSC	CZC _{MS}	CDX	OHX	Ordering code	Dimensions, mm						PRODFAM	MIID	
						B	H	LF	WF	HF	NM			KG
	D	12 x 12	11.0	20.0	QS-R/LF123D11-1212B	12.0	12.0	70.0	12.2	12.0	2.5	0.08	CoroCut 1-2	N123D2-0150-0002-CM
	E	12 x 12	11.0	21.0	QS-R/LF123E11-1212B	12.0	12.0	70.0	12.2	12.0	2.5	0.08	CoroCut 1-2	N123E2-0200-0002-CM
	F	12 x 12	15.0	20.0	QS-R/LF123F15-1212B	12.0	12.0	70.0	12.0	12.0	2.5	0.08	CoroCut 1-2	N123F2-0250-0002-CM
	T	12 x 12	6.4	31.7	QS-RF123T06-1212B	12.0	12.0	70.0	12.0	12.0	3.0	0.10	CoroCut 3	N123T3-0150- CM
	U	12 x 12	6.4	31.7	QS-LF123U06-1212B	12.0	12.0	70.0	12.0	12.0	3.0	0.10	CoroCut 3	N123U3-0150- CM
	3	12 x 12	8.5	27.0	QS-SMALR/L 1212E3	12.0	12.0	70.0	12.0	12.0	1.2	0.10	CoroCut XS	MACL 3 200-N
	3	12 x 12	8.5	27.0	QS-SMALR 1212E-X	12.0	12.0	70.0	12.0	12.0	1.2	0.10	CoroCut XS	MACR 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

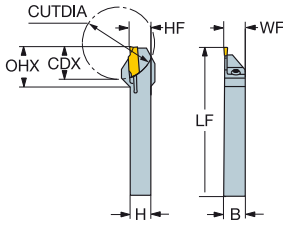


A

Shank tool for parting and grooving

Rectangular shank -metric: 12 x 12

B



C

	SSC	CZC _{MS}	CDX	OHX	Ordering code	Dimensions, mm						PRODFAM	MIID	
						B	H	LF	WF	HF	NM			KG
	D	12 x 12	11.0	22.6	R/LF123D11-1212B-S	12.0	12.0	125.0	12.0	12.0	2.5	0.15	CoroCut 1-2	N123D2-0150-0002-CM
	E	12 x 12	11.0	22.6	R/LF123E11-1212B-S	12.0	12.0	125.0	12.0	12.0	2.5	0.15	CoroCut 1-2	N123E2-0200-0002-CM
	F	12 x 12	15.0	20.0	R/LF123F15-1212B-S	12.0	12.0	125.0	12.0	12.0	2.5	0.15	CoroCut 1-2	N123F2-0250-0002-CM
	T	12 x 12	6.4	23.0	RF123T06-1212BM	12.0	12.0	125.0	12.0	12.0	3.0	0.17	CoroCut 3	N123T3-0150- CM
	U	12 x 12	6.4	23.0	LF123U06-1212BM	12.0	12.0	125.0	12.0	12.0	3.0	0.16	CoroCut 3	N123U3-0150- CM
	E	12 x 12	16.0	22.0	QD-R/LFE16-1212S	12.0	12.0	127.0	12.0	12.0		0.16	CoroCut QD	QD-NE-0200-0002-CM
	3	12 x 12	8.5	27.0	SMALR/L 1212K 3	12.0	12.0	125.0	12.0	12.0	1.2	0.17	CoroCut XS	MACL 3 200-N
	3	12 x 12	8.5	27.0	SMALR 1212K 3-X	12.0	12.0	125.0	12.0	12.0	1.2	0.17	CoroCut XS	MACR 3 200-N

D

E

F

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

G

H

I

J



B6



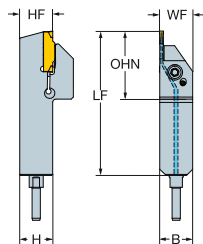
J19



J9

Shank tool for parting and grooving

QS-HP shank coupling -metric: 16 x 16



							Dimensions, mm									
SSC	CZC _{MS}	CDX	OHX	CNSC	Ordering code	B	H	LF	WF	HF	BAR	NM	KG	PRODFAM	MIID	
	E	16 x 16	11.0	22.6	1	QS-R/LF123E11-1616BHP	16.0	16.0	70.0	16.0	16.0	80	2.5	0.16	CoroCut 1-2	N123E2-0200-0002-CM
	E	16 x 16	17.0	26.0	1	QS-R/LF123E17-1616BHP	16.0	16.0	70.0	16.2	16.0	80	2.5	0.15	CoroCut 1-2	N123E2-0200-0002-CM
	F	16 x 16	17.0	26.0	1	QS-R/LF123F17-1616BHP	16.0	16.0	70.0	16.2	16.0	80	2.5	0.15	CoroCut 1-2	N123F2-0250-0002-CM
	G	16 x 16	17.0	28.6	1	QS-R/LF123G17-1616BHP	16.0	16.0	70.0	16.0	16.0	80	2.5	0.15	CoroCut 1-2	N123G2-0300-0003-TF
	T	16 x 16	6.4	23.0	1	QS-RF123T06-1616BHP	16.0	16.0	70.0	16.0	16.0	80	3.0	0.17	CoroCut 3	N123T3-0150- CM
	U	16 x 16	6.4	23.0	1	QS-LF123U06-1616BHP	16.0	16.0	70.0	16.0	16.0	80	3.0	0.17	CoroCut 3	N123U3-0150- CM
	C	16 x 16	13.0	25.0	1	QS-QD-R/LFC13C1616S	16.0	16.0	70.0	16.0	16.0	80		0.13	CoroCut QD	QD-NC-0125-0001-CM
	D	16 x 16	16.0	25.0	1	QS-QD-R/LFD16C1616S	16.0	16.0	70.0	16.0	16.0	80		0.13	CoroCut QD	QD-ND-0150-0001-CM
	E	16 x 16	20.0	25.0	1	QS-QD-R/LFE20C1616S	16.0	16.0	70.0	16.0	16.0	80		0.13	CoroCut QD	QD-NE-0200-0002-CM
	E	16 x 16	16.0	25.0	1	QS-QD-R/LFE16C1616S	16.0	16.0	70.0	16.0	16.0	80		0.14	CoroCut QD	QD-NE-0200-0002-CM
	F	16 x 16	20.0	25.0	1	QS-QD-R/LFF20C1616S	16.0	16.0	70.0	16.0	16.0	80		0.14	CoroCut QD	QD-NF-0250-0002-CM
	F	16 x 16	16.0	25.0	1	QS-QD-R/LFF16C1616S	16.0	16.0	70.0	16.0	16.0	80		0.14	CoroCut QD	QD-NF-0250-0002-CM
	G	16 x 16	20.0	25.0	1	QS-QD-R/LFG20C1616S	16.0	16.0	70.0	16.0	16.0	80		0.14	CoroCut QD	QD-NG-0300-0002-CM
G	16 x 16	16.0	25.0	1	QS-QD-R/LFG16C1616S	16.0	16.0	70.0	16.0	16.0	80		0.14	CoroCut QD	QD-NG-0300-0002-CM	
	3	16 x 16	8.5	28.0	1	QS-SMALR/L1616E3HP	16.0	16.0	70.0	16.0	16.0	80	1.2	0.16	CoroCut XS	MACL 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

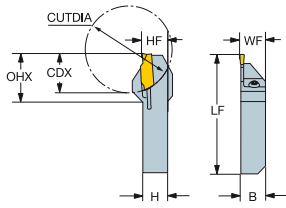


A

Shank tool for parting and grooving

QS shank coupling -metric: 16 x 16

B



C

		Dimensions, mm												
SSC	CZC _{MS}	CDX	OHX	Ordering code	B	H	LF	WF	HF	NM	KG	PRODFAM	MIID	
	D	16 x 16	8.0	19.6	QS-R/LF123D08-1616B	16.0	16.0	70.0	16.0	16.0	2.5	0.14	CoroCut 1-2	N123D2-0150-0002-CM
	D	16 x 16	17.0	28.6	QS-R/LF123D17-1616B	16.0	16.0	70.0	16.0	16.0	2.5	0.13	CoroCut 1-2	N123D2-0150-0002-CM
	E	16 x 16	17.0	26.0	QS-R/LF123E17-1616B	16.0	16.0	70.0	16.2	16.0	2.5	0.14	CoroCut 1-2	N123E2-0200-0002-CM
	E	16 x 16	11.0	22.6	QS-R/LF123E11-1616B	16.0	16.0	70.0	16.0	16.0	2.5	0.14	CoroCut 1-2	N123E2-0200-0002-CM
	F	16 x 16	17.0	26.0	QS-R/LF123F17-1616B	16.0	16.0	70.0	16.2	16.0	2.5	0.14	CoroCut 1-2	N123F2-0250-0002-CM
	G	16 x 16	17.0	28.6	QS-R/LF123G17-1616B	16.0	16.0	70.0	16.0	16.0	2.5	0.13	CoroCut 1-2	N123G2-0300-0003-TF
	T	16 x 16	6.4	31.7	QS-RF123T06-1616B	16.0	16.0	70.0	16.0	16.0	3.0	0.15	CoroCut 3	N123T3-0150- CM
	U	16 x 16	6.4	31.7	QS-LF123U06-1616B	16.0	16.0	70.0	16.0	16.0	3.0	0.15	CoroCut 3	N123U3-0150- CM
	3	16 x 16	8.5	27.0	QS-SMALR 1616E3	16.0	16.0	70.0	16.0	16.0	1.2	0.16	CoroCut XS	MACR 3 200-N

D

E

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

F

G

H

I

J



B6



J19



J9

Shank tool for parting and grooving

Rectangular shank -metric: 16 x 16

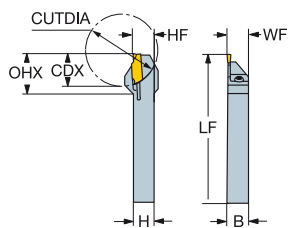


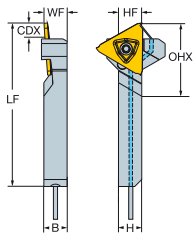
Image	SSC	CZC _{MS}	CDX	OHX	Ordering code	Dimensions, mm						PRODFAM	MIID	
						B	H	LF	WF	HF	NM			KG
	D	16 x 16	8.0	19.6	R/LF123D08-1616B-S	16.0	16.0	125.0	16.0	16.0	2.5	0.26	CoroCut 1-2	N123D2-0150-0002-CM
	D	16 x 16	17.0	28.6	R/LF123D17-1616B-S	16.0	16.0	125.0	16.0	16.0	2.5	0.24	CoroCut 1-2	N123D2-0150-0002-CM
	E	16 x 16	17.0	28.6	R/LF123E17-1616B-S	16.0	16.0	125.0	16.0	16.0	2.5	0.24	CoroCut 1-2	N123E2-0200-0002-CM
	E	16 x 16	11.0	22.6	R/LF123E11-1616B-S	16.0	16.0	125.0	16.0	16.0	2.5	0.25	CoroCut 1-2	N123E2-0200-0002-CM
	F	16 x 16	17.0	28.6	R/LF123F17-1616B-S	16.0	16.0	125.0	16.0	16.0	2.5	0.24	CoroCut 1-2	N123F2-0250-0002-CM
	G	16 x 16	17.0	28.6	R/LF123G17-1616B-S	16.0	16.0	125.0	16.0	16.0	3.0	0.24	CoroCut 1-2	N123G2-0300-0003-TF
	T	16 x 16	6.4	23.0	RF123T06-1616BM	16.0	16.0	125.0	16.0	16.0	3.0	0.26	CoroCut 3	N123T3-0150- CM
	U	16 x 16	6.4	23.0	LF123U06-1616BM	16.0	16.0	125.0	16.0	16.0	3.0	0.26	CoroCut 3	N123U3-0150- CM
	B	16 x 16	10.0	25.0	QD-R/LFB10-1616S	16.0	16.0	125.0	16.0	16.0		0.24	CoroCut QD	QD-NB-0100-0001-CM
	C	16 x 16	13.0	26.1	QD-R/LFC13-1616S	16.0	16.0	125.0	16.0	16.0		0.24	CoroCut QD	QD-NC-0125-0001-CM
	D	16 x 16	16.0	25.0	QD-R/LFD16-1616S	16.0	16.0	125.0	16.0	16.0		0.24	CoroCut QD	QD-ND-0150-0001-CM
	E	16 x 16	20.0	29.0	QD-R/LFE20-1616S	16.0	16.0	125.0	16.0	16.0		0.25	CoroCut QD	QD-NE-0200-0002-CM
	F	16 x 16	20.0	29.0	QD-R/LFF20-1616S	16.0	16.0	125.0	16.0	16.0		0.25	CoroCut QD	QD-NF-0250-0002-CM
	G	16 x 16	20.0	29.0	QD-R/LFG20-1616S	16.0	16.0	125.0	16.0	16.0		0.25	CoroCut QD	QD-NG-0300-0002-CM
	3	16 x 16	8.5	27.0	SMALR/L 1616K 3	16.0	16.0	125.0	16.0	16.0	1.2	0.27	CoroCut XS	MACL 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Shank tool for parting and grooving

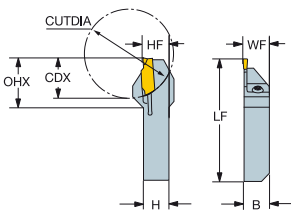


QS-HP shank coupling -inch: 3/8 x 3/8

SSC	CZC _{MS}	CDX	KAPR	OHX	CNCS	Ordering code	Dimensions, inch							PRODFAM	MIID	
							B	H	LF	WF	HF	PSI	FT/LBS			LBS
T	3/8 x 3/8	.250	90°	.787	1	QS-RF123T023-06BHP	.375	.375	2.750	.375	.375	1160	2.2	0.18	CoroCut 3	N123T3-0150-CM
U	3/8 x 3/8	.252	90°	.787	1	QS-LF123U023-06BHP	.375	.375	2.750	.375	.500	1160	2.2	0.18	CoroCut 3	N123U3-0150-CM
B	3/8 x 3/8	.375	90°	1.000	1	QS-QD-R/LFB0375C06S	.375	.375	2.756	.375	.375	1160		0.22	CoroCut QD	QD-NB-0100-0001-CM
E	3/8 x 3/8	.500	90°	.984	1	QS-QD-R/LFE0500C06S	.375	.375	2.756	.375	.375	1160		0.08	CoroCut QD	QD-NE-0200-0002-CM
F	3/8 x 3/8	.500	90°	.984	1	QS-QD-R/LFF0500C06S	.375	.375	2.756	.375	.375	1160		0.08	CoroCut QD	QD-NF-0250-0002-CM
3	3/8 x 3/8	.335	90°	1.142	1	QS-SMALR/L063XHP	.375	.375	2.756	.375	.375	1160	0.9	0.20	CoroCut XS	MACL 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



QS shank coupling -inch: 3/8 x 3/8

SSC	CZC _{MS}	CDX	KAPR	OHX	Ordering code	Dimensions, inch							PRODFAM	MIID
						B	H	LF	WF	HF	FT/LBS	LBS		
D	3/8 x 3/8	.375	90°	.709	QS-R/LF123D039-06B	.375	.375	2.756	.381	.375	1.8	0.13	CoroCut 1-2	N123D2-0150-0002-CM
E	3/8 x 3/8	.394	90°	.827	QS-R/LF123E039-06B	.375	.375	2.756	.381	.375	1.8	0.13	CoroCut 1-2	N123E2-0200-0002-CM
F	3/8 x 3/8	.390	90°	.847	QS-RF123F039-06B	.375	.375	2.756	.375	.375	1.8	0.13	CoroCut 1-2	N123F2-0250-0002-CM
T	3/8 x 3/8	.250	90°	1.248	QS-RF123T023-06B	.375	.375	2.750	.375	.375	2.2	0.16	CoroCut 3	N123T3-0150-CM
U	3/8 x 3/8	.252	90°	1.248	QS-LF123U023-06B	.375	.375	2.750	.375	.500	2.2	0.12	CoroCut 3	N123U3-0150-CM

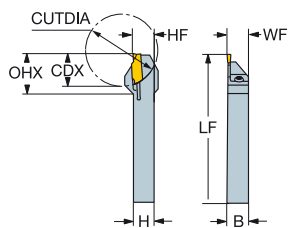
For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Shank tool for parting and grooving

Rectangular shank -inch: 3/8 x 3/8



	SSC	CZC _{MS}	CDX	KAPR	OHX	Ordering code	Dimensions, inch						PRODFAM	MIID	
							B	H	LF	WF	HF	FT/LBS			LBS
	D	3/8 x 3/8	.390	90°	.847	R/LF123D039-06B-S	.375	.375	5.000	.375	.375	1.8	0.22	CoroCut 1-2	N123D2-0150-0002-CM
	E	3/8 x 3/8	.390	90°	.847	R/LF123E039-06B-S	.375	.375	5.000	.375	.375	1.8	2.25	CoroCut 1-2	N123E2-0200-0002-CM
	F	3/8 x 3/8	.390	90°	.847	R/LF123F039-06B-S	.375	.375	5.000	.375	.375	1.8	0.25	CoroCut 1-2	N123F2-0250-0002-CM
	T	3/8 x 3/8	.252	90°	.906	RF123T023-06BM	.375	.375	4.500	.375	.375	2.2	0.24	CoroCut 3	N123T3-0150- CM
	U	3/8 x 3/8	.252	90°	.906	LF123U023-06BM	.375	.375	4.500	.375	.375	2.2	0.23	CoroCut 3	N123U3-0150- CM
	E	3/8 x 3/8	.500	90°	.866	QD-R/LFE0500-06S	.375	.375	5.000	.375	.375		0.18	CoroCut QD	QD-NE-0200-0002-CM

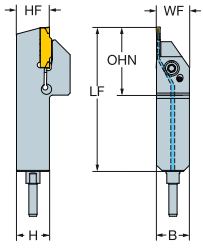
For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand








Shank tool for parting and grooving

QS-HP shank coupling -inch: 1/2 x 1/2



C

								Dimensions, inch									
SSC	CZC _{MS}	CDX	KAPR	OHX	CNSC	Ordering code	B	H	LF	WF	HF	PSI	FT/LBS	LBS	PRODFAM	MIID	
	C	1/2 x 1/2	.500	90°	1.000	2	QS-QD-R/LFC0500C08S	.500	.500	2.756	.500	.500	1160	0.09	CoroCut QD	QD-NC-0125-0001-CM	
	E	1/2 x 1/2	.430	90°	.827	1	QS-R/LF123E043-08BHP	.500	.500	2.756	.506	.500	1160	1.8	0.24	CoroCut 1-2	N123E2-0200-0002-CM
	F	1/2 x 1/2	.590	90°	1.047	1	QS-R/LF123F059-08BHP	.500	.500	2.756	.500	.500	1160	1.8	0.23	CoroCut 1-2	N123F2-0250-0002-CM
	T	1/2 x 1/2	.250	90°	.787	1	QS-RF123T023-08BHP	.500	.500	2.750	.500	.500	1160	2.2	0.26	CoroCut 3	N123T3-0150-CM
	U	1/2 x 1/2	.250	90°	.787	1	QS-LF123U023-08BHP	.500	.500	2.750	.500	.500	1160	2.2	0.26	CoroCut 3	N123U3-0150-CM
	B	1/2 x 1/2	.375	90°	1.000	1	QS-QD-R/LFB0375C08S	.500	.500	2.756	.500	.500	1160	0.19	CoroCut QD	QD-NB-0100-0001-CM	
	E	1/2 x 1/2	.500	90°	.984	1	QS-QD-R/LFE0500C08S	.500	.500	2.756	.500	.500	1160	0.09	CoroCut QD	QD-NE-0200-0002-CM	
	F	1/2 x 1/2	.500	90°	.984	1	QS-QD-R/LFF0500C08S	.500	.500	2.756	.500	.500	1160	0.22	CoroCut QD	QD-NF-0250-0002-CM	
	3	1/2 x 1/2	.335	90°	1.102	1	QS-SMALR/L083XHP-M	.500	.500	2.756	.500	.500	1160	0.9	0.27	CoroCut XS	MACL 3 200-N

D

E

F

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

G

H

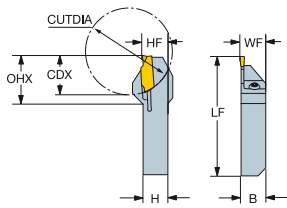
I

J



Shank tool for parting and grooving

QS shank coupling -inch: 1/2 x 1/2



	SSC	CZC _{MS}	CDX	LU	KAPR	OHX	Ordering code	Dimensions, inch						PRODFAM	MIID	
								B	H	LF	WF	HF	FT/LBS			LBS
	D	1/2 x 1/2	.430		90°	.787	QS-R/LF123D043-08B	.500	.500	2.756	.506	.500	1.8	0.20	CoroCut 1-2	N123D2-0150-0002-CM
	E	1/2 x 1/2	.430		90°	.827	QS-R/LF123E043-08B	.500	.500	2.756	.506	.500	1.8	0.21	CoroCut 1-2	N123E2-0200-0002-CM
	F	1/2 x 1/2	.590		90°	1.047	QS-R/LF123F059-08B	.500	.500	2.756	.500	.500	1.8	0.19	CoroCut 1-2	N123F2-0250-0002-CM
	T	1/2 x 1/2	.250		90°	1.248	QS-RF123T023-08B	.500	.500	2.750	.500	.500	2.2	0.23	CoroCut 3	N123T3-0150- CM
	U	1/2 x 1/2	.250		90°	1.248	QS-LF123U023-08B	.500	.500	2.750	.500	.500	2.2	0.18	CoroCut 3	N123U3-0150- CM
	3	1/2 x 1/2	.335		90°	1.063	QS-SMALR 083X	.500	.500	2.756	.500	.500	0.9	0.25	CoroCut XS	MACR 3 200-N
	3	1/2 x 1/2	.335	.787	90°	1.063	QS-SMALR 083X-X	.500	.500	2.756	.500	.500	0.9	0.25	CoroCut XS	MACR 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



B6



J19



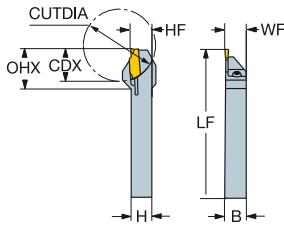
J9

A

Shank tool for parting and grooving

Rectangular shank -inch: 1/2 x 1/2

B



C

	SSC	CZC _{MS}	CDX	KAPR	OHX	Ordering code	Dimensions, inch						PRODFAM	MIID	
							B	H	LF	WF	HF	FT/ LBS			LBS
	D	1/2 x 1/2	.430	90°	.887	R/LF123D043-08B-S	.500	.500	5.000	.500	.500	1.8	0.35	CoroCut 1-2	N123D2-0150-0002-CM
	E	1/2 x 1/2	.430	90°	.887	R/LF123E043-08B-S	.500	.500	5.000	.500	.500	1.8	0.31	CoroCut 1-2	N123E2-0200-0002-CM
	F	1/2 x 1/2	.590	90°	1.047	R/LF123F059-08B-S	.500	.500	5.000	.500	.500	1.8	0.37	CoroCut 1-2	N123F2-0250-0002-CM
	T	1/2 x 1/2	.252	90°	.906	RF123T023-08BM	.500	.500	4.500	.500	.500	2.2	0.36	CoroCut 3	N123T3-0150- CM
	U	1/2 x 1/2	.252	90°	.906	LF123U023-08BM	.500	.500	4.500	.500	.500	2.2	0.37	CoroCut 3	N123U3-0150- CM
	E	1/2 x 1/2	.625	90°	.866	QD-R/LFE0625-08S	.500	.500	5.000	.500	.500		0.31	CoroCut QD	QD-NE-0200-0002-CM
	3	1/2 x 1/2	.335	90°	1.063	SMALR/L 08C3	.500	.500	5.000	.500	.500	0.9	0.42	CoroCut XS	MACL 3 200-N
	3	1/2 x 1/2	.335	90°	1.063	SMALR 08C 3-X	.500	.500	5.000	.500	.500	0.9	0.41	CoroCut XS	MACR 3 200-N

D

E

F

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

G

H

I

J



B6



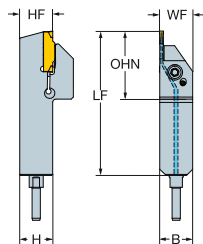
J19



J9

Shank tool for parting and grooving

QS-HP shank coupling -inch: 5/8 x 5/8



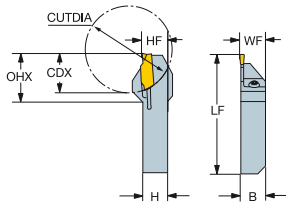
								Dimensions, inch									
SSC	CZC _{MS}	CDX	KAPR	OHX	CNSC	Ordering code	B	H	LF	WF	HF	PSI	FT/LBS	LBS	PRODFAM	MIID	
	E	5/8 x 5/8	.430	90°	.887	1	QS-R/LF123E043-10BHP	.625	.625	2.756	.625	.625	1160	1.8	0.35	CoroCut 1-2	N123E2-0200-0002-CM
	E	5/8 x 5/8	.669	90°	1.024	1	QS-R/LF123E067-10BHP	.625	.625	2.756	.631	.625	1160	1.8	0.33	CoroCut 1-2	N123E2-0200-0002-CM
	F	5/8 x 5/8	.670	90°	1.126	1	QS-R/LF123F067-10BHP	.625	.625	2.756	.625	.625	1160	1.8	0.32	CoroCut 1-2	N123F2-0250-0002-CM
	G	5/8 x 5/8	.670	90°	1.126	1	QS-R/LF123G067-10BHP	.625	.625	2.756	.625	.625	1160	1.8	0.33	CoroCut 1-2	N123G2-0300-0003-TF
	T	5/8 x 5/8	.250	90°	.787	1	QS-RF123T023-10BHP	.625	.625	2.750	.625	.625	1160	2.2	0.34	CoroCut 3	N123T3-0150-CM
	U	5/8 x 5/8	.250	90°	.787	1	QS-LF123U023-10BHP	.625	.625	2.750	.625	.625	1160	2.2	0.36	CoroCut 3	N123U3-0150-CM
	C	5/8 x 5/8	.500	90°	1.000	1	QS-QD-R/LFC0500C10S	.625	.625	2.756	.625	.625	1160		0.24	CoroCut QD	QD-NC-0125-0001-CM
	D	5/8 x 5/8	.625	90°	1.000	1	QS-QD-R/LFD0625C10S	.625	.625	2.756	.625	.625	1160		0.22	CoroCut QD	QD-ND-0150-0001-CM
	E	5/8 x 5/8	.625	90°	.984	1	QS-QD-R/LFE0625C10S	.625	.625	2.756	.625	.625	1160		0.26	CoroCut QD	QD-NE-0200-0002-CM
	E	5/8 x 5/8	.800	90°	.984	1	QS-QD-R/LFE0800C10S	.625	.625	2.756	.625	.625	1160		0.30	CoroCut QD	QD-NE-0200-0002-CM
	F	5/8 x 5/8	.625	90°	.984	1	QS-QD-R/LFF0625C10S	.625	.625	2.756	.625	.625	1160		0.26	CoroCut QD	QD-NF-0250-0002-CM
	F	5/8 x 5/8	.800	90°	.984	1	QS-QD-R/LFF0800C10S	.625	.625	2.756	.625	.625	1160		0.22	CoroCut QD	QD-NF-0250-0002-CM
	G	5/8 x 5/8	.625	90°	.984	1	QS-QD-R/LFG0625C10S	.625	.625	2.756	.625	.625	1160		0.26	CoroCut QD	QD-NG-0300-0002-CM
	G	5/8 x 5/8	.800	90°	.984	1	QS-QD-R/LFG0800C10S	.625	.625	2.756	.625	.625	1160		0.22	CoroCut QD	QD-NG-0300-0002-CM
	3	5/8 x 5/8	.335	90°	1.102	1	QS-SMALR/L103XHP	.625	.625	2.756	.625	.625	1160	0.9	0.34	CoroCut XS	MACL 3 200-N

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Shank tool for parting and grooving

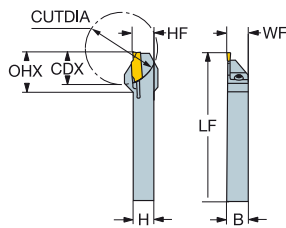


QS shank coupling -inch: 5/8 x 5/8

		Dimensions, inch													
SSC	CZC _{MS}	CDX	LU	KAPR	OHX	Ordering code	B	H	LF	WF	HF	FT/LBS	LBS	PRODFAM	MIID
	D	5/8 x 5/8	.320	90°	.777	QS-R/LF123D032-10B	.625	.625	2.756	.625	.625	1.8	0.31	CoroCut 1-2	N123D2-0150-0002-CM
	D	5/8 x 5/8	.670	90°	1.127	QS-R/LF123D067-10B	.625	.625	2.756	.625	.625	1.8	0.27	CoroCut 1-2	N123D2-0150-0002-CM
	E	5/8 x 5/8	.430	90°	.887	QS-R/LF123E043-10B	.625	.625	2.756	.625	.625	1.8	0.13	CoroCut 1-2	N123E2-0200-0002-CM
	E	5/8 x 5/8	.669	90°	1.024	QS-R/LF123E067-10B	.625	.625	2.756	.631	.625	1.8	0.27	CoroCut 1-2	N123E2-0200-0002-CM
	G	5/8 x 5/8	.670	90°	1.126	QS-R/LF123G067-10B	.625	.625	2.756	.625	.625	1.8	0.04	CoroCut 1-2	N123G2-0300-0003-TF
	T	5/8 x 5/8	.250	90°	1.248	QS-RF123T023-10B	.625	.625	2.750	.625	.625	2.2	0.31	CoroCut 3	N123T3-0150- CM
	U	5/8 x 5/8	.250	90°	1.248	QS-LF123U023-10B	.625	.625	2.750	.625	.625	2.2	0.24	CoroCut 3	N123U3-0150- CM

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Rectangular shank -inch: 5/8 x 5/8

		Dimensions, inch													
SSC	CZC _{MS}	CDX	KAPR	OHX	Ordering code	B	H	LF	WF	HF	FT/LBS	LBS	PRODFAM	MIID	
	D	5/8 x 5/8	.320	90°	.777	R/LF123D032-10B-S	.625	.625	5.000	.625	.625	1.8	0.56	CoroCut 1-2	N123D2-0150-0002-CM
	D	5/8 x 5/8	.670	90°	1.127	R/LF123D067-10B-S	.625	.625	5.000	.625	.625	1.8	0.53	CoroCut 1-2	N123D2-0150-0002-CM
	E	5/8 x 5/8	.430	90°	.887	R/LF123E043-10B-S	.625	.625	5.000	.625	.625	1.8	0.88	CoroCut 1-2	N123E2-0200-0002-CM
	E	5/8 x 5/8	.670	90°	1.127	R/LF123E067-10B-S	.625	.625	5.000	.625	.625	1.8	0.49	CoroCut 1-2	N123E2-0200-0002-CM
	F	5/8 x 5/8	.670	90°	1.127	R/LF123F067-10B-S	.625	.625	5.000	.625	.625	1.8	0.66	CoroCut 1-2	N123F2-0250-0002-CM
	G	5/8 x 5/8	.670	90°	1.127	R/LF123G067-10B-S	.625	.625	5.000	.625	.625	2.2	0.54	CoroCut 1-2	N123G2-0300-0003-TF
	T	5/8 x 5/8	.252	90°	.906	RF123T023-10BM	.625	.625	4.500	.625	.625	2.2	0.52	CoroCut 3	N123T3-0150- CM
	U	5/8 x 5/8	.252	90°	.906	LF123U023-10BM	.625	.625	4.500	.625	.625	2.2	0.50	CoroCut 3	N123U3-0150- CM
	B	5/8 x 5/8	.375	90°	1.000	QD-R/LFB0375-10S	.625	.625	5.000	.629	.625		0.49	CoroCut QD	QD-NB-0100-0001-CM
	C	5/8 x 5/8	.500	90°	1.000	QD-R/LFC0500-10S	.625	.625	5.000	.629	.625		0.48	CoroCut QD	QD-NC-0125-0001-CM
	D	5/8 x 5/8	.625	90°	1.000	QD-R/LFD0625-10S	.625	.625	5.000	.631	.625		0.48	CoroCut QD	QD-ND-0150-0001-CM
	E	5/8 x 5/8	.800	90°	1.181	QD-R/LFE0800-10S	.625	.625	5.000	.625	.625		0.46	CoroCut QD	QD-NE-0200-0002-CM
	F	5/8 x 5/8	.800	90°	1.181	QD-R/LFF0800-10S	.625	.625	5.000	.625	.625		0.47	CoroCut QD	QD-NF-0250-0002-CM
	G	5/8 x 5/8	.800	90°	1.181	QD-R/LFG0800-10S	.625	.625	5.000	.625	.625		0.47	CoroCut QD	QD-NG-0300-0002-CM
	3	5/8 x 5/8	.335	90°	1.063	SMALR/L 10C3	.625	.625	5.000	.625	.625	0.9	0.59	CoroCut XS	MACL 3 200-N

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B6

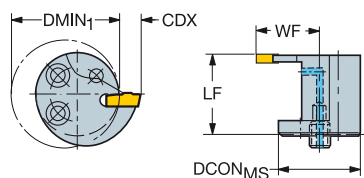


J19




J9


Head for grooving



SL head (screw mounted) -size 16

SSC	CZC _{MS}	DMIN ₁	CDX	CNCS	Ordering code	Dimensions, mm, inch						PRODFAM	MIID
						DCON _{MS}	LF	LF ₁	WF	WF ₁	BAR		
	20	16	25.0	8.5	1	R/LAG551.31-160808-20	16	8.0	16.5	10	0.03	T-Max Q-Cut	N151.3-200-20- 4G
			.984	.335			.630	.315	.650	145		T-Max Q-Cut	N151.3-200-20- 4G
	20	16	20.0	3.5	1	R/LAG551.31-161603-20	16	16.0	11.5	10	0.03	T-Max Q-Cut	N151.3-200-20- 4G
			.787	.138			.630	.630	.453	145		T-Max Q-Cut	N151.3-200-20- 4G
	25	16	22.0	5.6	1	R/LAG551.31-161605-25	16	15.9	13.6	10	0.02	T-Max Q-Cut	N151.3-265-25- 4G
			.866	.220			.630	.626	.535	145		T-Max Q-Cut	N151.3-265-25- 4G

SL head (screw mounted) -size 20

SSC	CZC _{MS}	DMIN ₁	CDX	CNCS	Ordering code	Dimensions, mm, inch						PRODFAM	MIID
						DCON _{MS}	LF	LF ₁	WF	WF ₁	BAR		
	25	20	32.0	11.6	1	R/LAG551.31-201011-25	20	9.9	21.6	10	0.04	T-Max Q-Cut	N151.3-265-25- 4G
			1.260	.457			.787	.390	.850	145		T-Max Q-Cut	N151.3-265-25- 4G
	25	20	25.0	4.6	1	R/LAG551.31-202004-25	20	19.9	14.6	10	0.04	T-Max Q-Cut	N151.3-265-25- 4G
			.984	.181			.787	.783	.575	145		T-Max Q-Cut	N151.3-265-25- 4G
	30	20	25.0	4.5	1	R/LAG551.31-202004-30	20	19.5	14.5	10	0.04	T-Max Q-Cut	N151.3-300-30- 4G
			.984	.177			.787	.768	.571	145		T-Max Q-Cut	N151.3-300-30- 4G

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



B6



J19



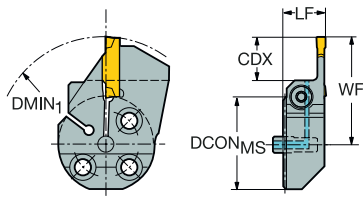
J9



J16

Head for grooving

SL head (screw mounted) -size 25



SSC	CZC _{MS}	DMIN ₁	CDX	CNSC	Ordering code	Dimensions, mm, inch						PRODFAM	MIID		
						DCON _{MS}	LF	LF ₁	WF	WF ₁	BAR			NM	KG
G	25	147.0	13.0	1	570-25R/L123G13C	25	14.0		32.6	WF ₁	10	3.0	0.08	CoroCut 1-2	N123G2-0300-0003-TF
						.984	.551		1.283		145			CoroCut 1-2	N123G2-0300-0003-TF
D	25	145.0	12.0	1	570-25R/L123D12B	25	14.0		30.9	10	2.0	0.08	CoroCut 1-2	N123D2-0150-0002-CM	
						.984	.551		1.215	145			CoroCut 1-2	N123D2-0150-0002-CM	
	E	25	139.0	15.0	1	570-25R/L123E15B	25	14.0		33.9	10	2.0	0.08	CoroCut 1-2	N123E2-0200-GM
							.984	.551		1.333	145			CoroCut 1-2	N123E2-0200-GM
F	25	143.0	15.0	1	570-25R/L123F15B	25	14.0		33.9	10	2.0	0.08	CoroCut 1-2	N123F2-0250-GM	
						.984	.551		1.333	145			CoroCut 1-2	N123F2-0250-GM	
G	25	147.0	18.0	1	570-25R/L123G18B	25	14.0		37.6	10	3.0	0.09	CoroCut 1-2	N123G2-0300-GM	
						.984	.551		1.480	145			CoroCut 1-2	N123G2-0300-GM	
T	25	6.4	1	570-25L123T06B	25	14.0		26.0	10	3.0	0.08	CoroCut 3	N123T3-0150-CM		
					.984	.551		1.024	145			CoroCut 3	N123T3-0150-CM		
U	25	14.0	1	570-25R123U06B	25		14.0		26.0	10	3.0	0.08	CoroCut 3	N123U3-0150-CM	
					.984		.551		1.024	145			CoroCut 3	N123U3-0150-CM	
3	25	42.0	8.2	1	570-25R/LSMAL3	25	14.0		26.8	10	1.2	0.08	CoroCut XS	MACR 3 200-N	
						.984	.551		1.055	145			CoroCut XS	MACR 3 200-N	
30	25	40.0	14.5	1	R/LAG551.31-251214-30	25	12.0		27.0	10		0.06	T-Max Q-Cut	N151.3-300-30-4G	
						.984	.472		1.063	145			T-Max Q-Cut	N151.3-300-30-4G	
	30	25	32.0	6.5	1	R/LAG551.31-252506-30	25	24.5		19.0	10		0.08	T-Max Q-Cut	N151.3-300-30-4G
							.984	.965		.748	145			T-Max Q-Cut	N151.3-300-30-4G

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B6



J19

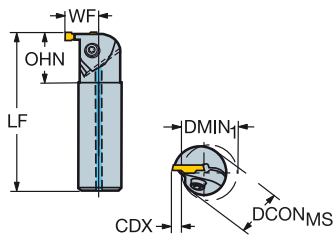


J9



J16

Boring bar for grooving



Cylindrical shank without clamping features -metric: 16

								Dimensions, mm						PRODFAM	MIID
	CZC _{MS}	CW	DMIN ₁	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	BAR	NM	KG		
	16	1.50	25.0	90°	25.0	1	R/LAG123D04-16B	16	150.0	12.5	10	3.0	0.22	CoroCut 1-2	N123D2-0150-0002-CM
	16	2.00	12.0	90°	27.0	1	R/LAG151.32-16M12-20	16	150.0	10.0	10	2.5	0.22	T-Max Q-Cut	N151.3-200-20-4G
	16	2.00	20.0	90°	24.0	1	R/LAG151.32-16M-20	16	150.0	11.5	10	2.5	0.22	T-Max Q-Cut	N151.3-200-20-4G
	16	2.65	15.0	90°	27.0	1	R/LAG151.32-16M15-25	16	150.0	12.0	10	2.5	0.21	T-Max Q-Cut	N151.3-265-25-4G
	16	2.65	20.0	90°	24.2	1	R/LAG151.32-16M-25	16	150.0	11.6	10	3.0	0.21	T-Max Q-Cut	N151.3-265-25-4G

Cylindrical shank with 3 flats -metric: 16

								Dimensions, mm										PRODFAM	MIID
	CZC _{MS}	DMIN ₁	OHX	OHN	CNSC	Ordering code	DCON _{MS}	H	BD	LF	WF	HF	THCA	BAR	NM	KG			
	11	16	12.0	48.0	20.9	0	R154.0KF-16-1220-11B	16	15.0	12.0	125.0	10.0	0.0	0°	0.9	0.19	T-Max U-Lock	L154.0G-11..	

For spare parts, visit www.sandvik.coromant.com

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B6



J19

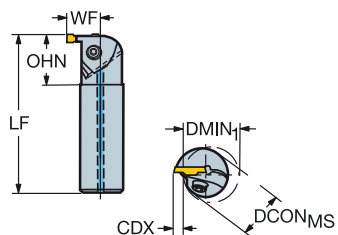


J9



J16

Boring bar for grooving



Cylindrical shank without clamping features -metric: 20

									Ordering code	Dimensions, mm							PRODFAM	MIID	
	SSC	CZC _{MS}	CDX	DMIN ₁	KAPR	OHX	OHN	CNSC		DCON _{MS}	BD	WB	LF	WF	BAR	NM			KG
	D	20	5.00	32.0	90°	80.0	30.0	1	R/LAG123D05-20B	20	20.0	180.0	15.3	10	3.0	0.43	CoroCut 1-2	N123D2-0150-0002-CM	
	E	20	5.00	32.0	90°	80.0	30.0	1	R/LAG123E05-20B	20	20.0	180.0	15.3	10	3.5	0.42	CoroCut 1-2	N123E2-0200- GM	
	G	20	6.00	32.0	90°	80.0	30.0	1	R/LAG123G06-20B	20	20.0	180.0	15.3	10	4.0	0.42	CoroCut 1-2	N123G2-0300- GM	
	20	20	4.50	25.0	90°	80.0	30.0	1	R/LAG151.32-20Q-20	20	20.0	180.0	14.5	10	2.5	0.42	T-Max Q-Cut	N151.3-200-20- 4G	
	25	20	4.60	25.0	90°	80.0	30.0	1	R/LAG151.32-20Q-25	20	20.0	180.0	14.6	10	3.0	0.42	T-Max Q-Cut	N151.3-265-25- 4G	
	30	20	4.50	16.0	90°	80.0	21.5	1	R/LAG151.32-20Q16-30	20		11.0	180.0	14.3	10	2.5	0.40	T-Max Q-Cut	N151.3-300-30- 4G
	30	20	4.50	25.0	90°	80.0	32.2	1	R/LAG151.32-20Q-30	20	20.0	180.0	14.5	10	3.5	0.41	T-Max Q-Cut	N151.3-300-30- 4G	

Cylindrical shank without clamping features -metric: 25

									Ordering code	Dimensions, mm							PRODFAM	MIID
	SSC	CZC _{MS}	CDX	DMIN ₁	KAPR	OHX	OHN	CNSC		DCON _{MS}	BD	WB	LF	WF	BAR	NM		
	E	25	7.00	32.0	90°	100.0	35.0	1	R/LAG123E07-25B	25	25.0	200.0	19.8	10	3.5	0.72	CoroCut 1-2	N123E2-0200- GM
	G	25	7.00	32.0	90°	100.0	35.0	1	R/LAG123G07-25B	25	25.0	200.0	19.8	10	4.0	0.71	CoroCut 1-2	N123G2-0300- GM
	25	25	6.10	32.0	90°	100.0	32.2	1	R/LAG151.32-25R-25	25	25.0	200.0	18.6	10	3.0	0.70	T-Max Q-Cut	N151.3-265-25- 4G
	30	25	6.00	32.0	90°	100.0	30.0	1	R/LAG151.32-25R-30	25	25.0	200.0	18.5	10	3.5	0.70	T-Max Q-Cut	N151.3-300-30- 4G

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



B6



J19

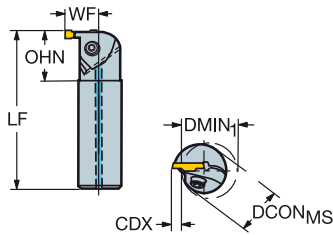


J9





J16

Boring bar for grooving

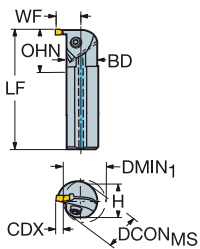


Cylindrical shank without clamping features -inch: 5/8


							Dimensions, inch									
SSC	CZC _{MS}	DMIN ₁	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	WB	LF	WF	PSI	FT/LBS	LBS	PRODFAM	MIID	
	D	5/8	.984	90°	.984	1	R/LAG123D016-10B	.625		5.906	.489	145	2.2	0.52	CoroCut 1-2	N123D2-0150-0002-CM
	20	5/8	.472	90°	1.063	1	RAG151.32-D10M47-20	.625	.374	5.906	.394	145	1.8	0.44	T-Max Q-Cut	N151.3-200-20- 4G
	25	5/8	.591	90°	1.063	1	RAG151.32-D10M59-25	.625	.413	5.906	.472	145	1.8	0.49	T-Max Q-Cut	N151.3-265-25- 4G

For spare parts, visit www.sandvik.coromant.com


R = Right hand, L = Left hand



Cylindrical shank with 3 flats -inch: 5/8

							Dimensions, inch									
SSC	CZC _{MS}	DMIN ₁	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FT/LBS	LBS	PRODFAM	MIID	
	20	5/8	.787	90°	.950	1	RAG151.32-D10-20	.625	.560	6.000	.453	145	1.4	0.45	T-Max Q-Cut	N151.3-200-20- 4G
	25	5/8	.787	90°	.950	1	R/LAG151.32-D10-25	.625	.560	6.000	.457	145	1.6	0.40	T-Max Q-Cut	N151.3-265-25- 4G

Cylindrical shank with 3 flats -inch: 3/4

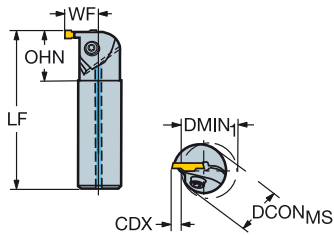
							Dimensions, inch									
SSC	CZC _{MS}	DMIN ₁	KAPR	OHN	CNSC	Ordering code	DCON _{MS}	H	LF	WF	PSI	FT/LBS	LBS	PRODFAM	MIID	
	20	3/4	.984	90°	1.180	1	RAG151.32-D12-20	.750	.710	7.000	.571	145	1.4	0.84	T-Max Q-Cut	N151.3-200-20- 4G
	25	3/4	.984	90°	1.180	1	R/LAG151.32-D12-25	.750	.710	7.000	.575	145	1.6	0.82	T-Max Q-Cut	N151.3-265-25- 4G
	30	3/4	.984	90°	1.180	1	R/LAG151.32-D12-30	.750	.710	7.000	.571	145	1.9	0.82	T-Max Q-Cut	N151.3-300-30- 4G

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Boring bar for grooving



Cylindrical shank without clamping features -inch: 3/4

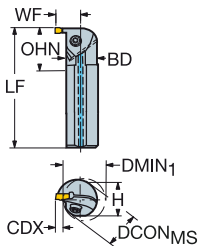
	SSC	CZC _{MS}	DMIN ₁	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID	
								DCON _{MS}	WB	LF	WF	PSI	FT/LBS			LBS
	D	3/4	1.260	90°	1.181	1	R/LAG123D020-12B	.750	7.087	.592	145	2.2	0.79	CoroCut 1-2	N123D2-0150-0002-CM	
	E	3/4	1.260	90°	1.181	1	R/LAG123E020-12B	.750	7.087	.592	145	2.6	0.84	CoroCut 1-2	N123E2-0200- GM	
	G	3/4	1.260	90°	1.181	1	R/LAG123G024-12B	.750	7.087	.600	145	3.0	0.78	CoroCut 1-2	N123G2-0300- GM	
	25	3/4	.591	90°	1.890	1	RAG151.32-D12-M59-25	.750	.413	6.000	.453	145	1.6	0.60	T-Max Q-Cut	N151.3-265-25- 4G
	30	3/4	.630	90°	1.220	1	RAG151.32-D12Q63-30	.750	.433	7.087	.551	145	1.8	0.75	T-Max Q-Cut	N151.3-300-30- 4G

Cylindrical shank without clamping features -inch: 1

	SSC	CZC _{MS}	DMIN ₁	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID
								DCON _{MS}	WB	LF	WF	PSI	FT/LBS		
	E	1	1.260	90°	1.378	1	R/LAG123E028-16B	1.000	7.874	.785	145	2.6	1.23	CoroCut 1-2	N123E2-0200- GM
	G	1	1.260	90°	1.378	1	R/LAG123G030-16B	1.000	7.874	.778	145	3.0	1.60	CoroCut 1-2	N123G2-0300- GM

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Cylindrical shank with 3 flats -inch: 1

	SSC	CZC _{MS}	DMIN ₁	KAPR	OHN	CNSC	Ordering code	Dimensions, inch						PRODFAM	MIID	
								DCON _{MS}	H	LF	WF	PSI	FT/LBS			LBS
	25	1	1.260	90°	1.270	1	RAG151.32-D16-25	1.000	.910	8.000	.732	145	1.6	1.47	T-Max Q-Cut	N151.3-265-25- 4G
	30	1	1.260	90°	1.270	1	RAG151.32-D16-30	1.000	.910	8.000	.728	145	1.9	1.47	T-Max Q-Cut	N151.3-300-30- 4G

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



B6



J19



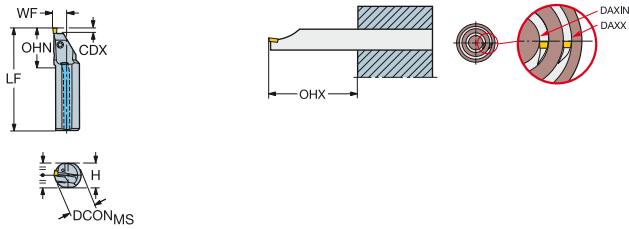
J9




J16

Boring bar for face grooving

Cylindrical shank with 3 flats -metric: 25



											Dimensions, mm							PRODFAM	MIID		
	SSC	CZC _{MS}	CDX	DAXIN	DAXX	KAPR	OHX	OHN	CNSC	Ordering code	DCON _{MS}	H	BD	LF	WF	HF	BAR			NM	KG
	25	25	5.3	18.0	101.0	90°	62.5	31.4	1	R/LAF151.37-25-024A25	25	23.0	25.0	200.0	12.8	0.1	10	3.0	0.62	T-Max Q-Cut	N151.3-300-25-7G
	30	25	12.0	16.0	55.0	90°	62.5	31.4	1	R/LAF151.37-25-025A30	25	23.0	25.0	200.0	12.8	0.1	10	3.5	0.62	T-Max Q-Cut	N151.3-400-30-7G
	30	25	5.3	16.0	101.0	90°	62.5	31.4	1	R/LAF151.37-25-024A30	25	23.0	25.0	200.0	12.8	0.1	10	3.0	0.63	T-Max Q-Cut	N151.3-400-30-7G

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



B6



J19



J9



J16

A

CoroTurn® XS

B

Internal turning, face grooving and threading of small components

C

High quality holes

This precision ground tool is perfect when producing small holes with high quality. The large variety of adaptors fit most types of sliding head machines. The tools are designed for exact insert location which enables high precision and repeatability.

ISO application area:



D

Application

- Internal turning
- Copying
- Backboring
- Profiling
- Grooving
- Face grooving
- Pre-parting
- Threading

E

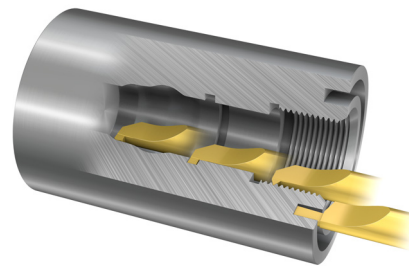
Benefits and features

- High precision
- Close tolerances
- Good accessibility when changing inserts
- Wide variety of insert widths
- Sharp cutting edges
- All inserts fit into the same tool holder
- High quality ground inserts and holders
- Full profile inserts for high quality threads in one operation
- Designed to maintain the tool holder intact in case of insert breakage.
- Available with precision coolant

F

G

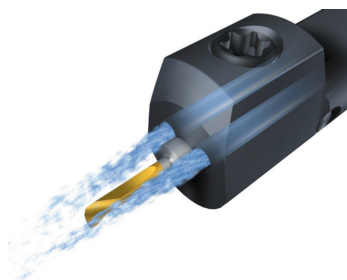
www.sandvik.coromant.com/coroturnxs



H

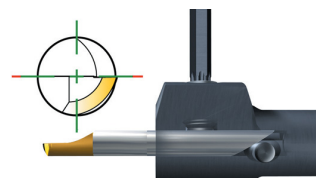
Internal coolant

- The adaptors are designed with internal precision coolant supply.
- Selectable coolant direction for better chip evacuation and safe machining



Locking precision

Precise location into the boring bar due to a locating pin.



I

J

CoroCut® MB

For internal machining with high precision

Internal machining with high precision

The sharp cutting edges of CoroCut MB are perfect for internal machining with high quality demands at low feed and speed. The system is easy to index for fast set-up of both tools and inserts, keeping the machine down-time to a minimum. For long overhangs steel shanks and carbide shanks are available for up to $5.5 \times$ bar diameter.

ISO application area:

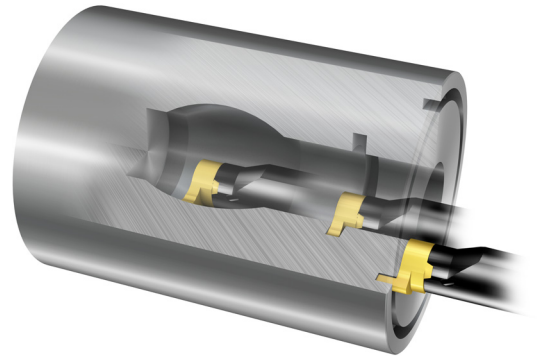


Application

- For internal machining of small holes
- Pre-parting
- Grooving
- Face grooving
- Profiling
- Turning
- Copying
- Back boring
- Threading

Benefits and features

- Vibration free machining
- Fast set up for both tool and insert
- Stable high precision interface between interface and tool holder
- Front-mounted exchangeable cutting tool
- Sharp cutting edges
- Geometries and grades for all materials
- Carbide shanks for long overhangs
- Through coolant
- Easy fix clamping
- Grooving tools in a large variety of widths and corner radii – also for standardized grooves such as O-rings and circlip grooves.



www.sandvik.coromant.com/corocutmb

EasyFix

Cylindrical steel and carbide boring bars to be used with EasyFix sleeves for exact centre height.

CoroCut® MB boring bars

For stability and accessibility the bars are designed with an eccentric head with oval cross section.

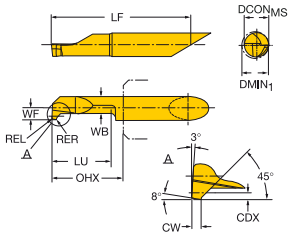
A

Solid carbide tool for pre-parting

CoroTurn XS -metric: 5

ENG

B



C

	CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM
										1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF	
	5	1.00	0.7	0.04	0.04	5.2	15.0	18.0	CXS-05GX100-5215R/L	*	*	*	*	*	5	3.8	37.3	2.5	CoroTurn XS
		.039	.028	.002	.002	.205	.591	.709		*	*	*	*	*	.197	.148	1.467	.096	CoroTurn XS
	5	1.00	0.7	0.04	0.04	5.2	20.0	23.0	CXS-05GX100-5220R	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
		.039	.028	.002	.002	.205	.787	.906		*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	1.00	0.7	0.04	0.04	5.2	25.0	28.0	CXS-05GX100-5225R/L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS
		.039	.028	.002	.002	.205	.984	1.102		*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
	5	1.00	0.7	0.04	0.04	5.2	30.0	33.0	CXS-05GX100-5230R	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS
	.039	.028	.002	.002	.205	1.181	1.299		*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS	

R = Right hand, L = Left hand

E

F

G

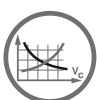
H

I

J



D2



B99



B109



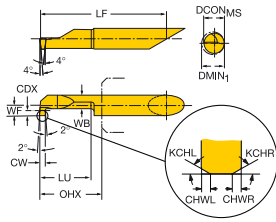
J19



J9

Solid carbide tool for grooving

CoroTurn XS -metric: 4



	CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM
										1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF	
	4	0.50	0.4	0.04	0.04	2.0	9.0	12.0	CXS-04G050-2009L	*	*	*	*	*	4	1.2	26.3	2.0	CoroTurn XS
		.020	.016	.002	.002	.079	.354	.472		*	*	*	*	*	.157	.045	1.033	.077	CoroTurn XS
	4	0.50	0.4	0.04	0.04	2.0	12.0	15.0	CXS-04G050-2012R/L	*	*	*	*	*	4	1.2	29.3	2.0	CoroTurn XS
		.020	.016	.002	.002	.079	.472	.591		*	*	*	*	*	.157	.045	1.152	.077	CoroTurn XS
	4	0.70	0.6	0.04	0.04	3.0	16.0	19.0	CXS-04G070-3016R/L	*	*	*	*	*	4	2.0	33.3	2.0	CoroTurn XS
		.028	.024	.002	.002	.118	.630	.748		*	*	*	*	*	.157	.077	1.309	.077	CoroTurn XS
	4	0.78	0.8	0.04	0.04	4.2	10.0	13.0	CXS-04G078-4210R	*	*	*	*	*	4	3.0	27.3	2.0	CoroTurn XS
		.031	.031	.002	.002	.165	.394	.512		*	*	*	*	*	.157	.116	1.073	.077	CoroTurn XS
	4	0.78	0.8	0.04	0.04	4.2	15.0	18.0	CXS-04G078-4215R/L	*	*	*	*	*	4	3.0	32.3	2.0	CoroTurn XS
		.031	.031	.002	.002	.165	.591	.709		*	*	*	*	*	.157	.116	1.270	.077	CoroTurn XS
	4	0.78	0.8	0.04	0.04	4.2	20.0	23.0	CXS-04G078-4220R/L	*	*	*	*	*	4	3.0	37.3	2.0	CoroTurn XS
		.031	.031	.002	.002	.165	.787	.906		*	*	*	*	*	.157	.116	1.467	.077	CoroTurn XS
	4	0.78	0.8	0.04	0.04	4.2	25.0	28.0	CXS-04G078-4225R/L	*	*	*	*	*	4	3.0	42.3	2.0	CoroTurn XS
		.031	.031	.002	.002	.165	.984	1.102		*	*	*	*	*	.157	.116	1.663	.077	CoroTurn XS
	4	1.00	0.8	0.04	0.04	4.2	10.0	13.0	CXS-04G100-4210R/L	*	*	*	*	*	4	3.0	27.3	2.0	CoroTurn XS
		.039	.031	.002	.002	.165	.394	.512		*	*	*	*	*	.157	.116	1.073	.077	CoroTurn XS
4	1.00	0.8	0.04	0.04	4.2	15.0	18.0	CXS-04G100-4215R/L	*	*	*	*	*	4	3.0	32.3	2.0	CoroTurn XS	
	.039	.031	.002	.002	.165	.591	.709		*	*	*	*	*	.157	.116	1.270	.077	CoroTurn XS	
4	1.00	0.8	0.04	0.04	4.2	20.0	23.0	CXS-04G100-4220R/L	*	*	*	*	*	4	3.0	37.3	2.0	CoroTurn XS	
	.039	.031	.002	.002	.165	.787	.906		*	*	*	*	*	.157	.116	1.467	.077	CoroTurn XS	

R = Right hand, L = Left hand



D2



B99



B109



J19



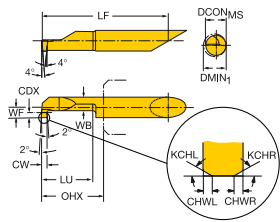
J9



A

Solid carbide tool for grooving

CoroTurn XS -metric: 5



C

CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM
									1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF	
5	0.78	1.0	0.04	0.04	5.2	10.0	13.0	CXS-05G078-5210R	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS
	.031	.039	.002	.002	.205	.394	.512		*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS
5	0.78	1.0	0.04	0.04	5.2	15.0	18.0	CXS-05G078-5215R/L	*	*	*	*	*	5	3.8	37.3	2.5	CoroTurn XS
	.031	.039	.002	.002	.205	.591	.709		*	*	*	*	*	.197	.148	1.467	.096	CoroTurn XS
5	0.78	1.0	0.04	0.04	5.2	20.0	23.0	CXS-05G078-5220R/L	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
	.031	.039	.002	.002	.205	.787	.906		*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
5	0.78	1.0	0.04	0.04	5.2	25.0	28.0	CXS-05G078-5225R/L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS
	.031	.039	.002	.002	.205	.984	1.102		*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
5	0.78	1.0	0.04	0.04	5.2	30.0	33.0	CXS-05G078-5230R/L	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS
	.031	.039	.002	.002	.205	1.181	1.299		*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS
5	0.78	1.0	0.04	0.04	5.2	35.0	38.0	CXS-05G078-5235R/L	*	*	*	*	*	5	3.8	57.3	2.5	CoroTurn XS
	.031	.039	.002	.002	.205	1.378	1.496		*	*	*	*	*	.197	.148	2.254	.096	CoroTurn XS
5	1.00	1.0	0.04	0.04	5.2	10.0	13.0	CXS-05G100-5210R	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS
	.039	.039	.002	.002	.205	.394	.512		*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS
5	1.00	1.0	0.04	0.04	5.2	20.0	23.0	CXS-05G100-5220R/L	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
	.039	.039	.002	.002	.205	.787	.906		*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
5	1.00	1.0	0.04	0.04	5.2	25.0	28.0	CXS-05G100-5225L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS
	.039	.039	.002	.002	.205	.984	1.102		*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
5	1.00	1.0	0.04	0.04	5.2	30.0	33.0	CXS-05G100-5230R/L	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS
	.039	.039	.002	.002	.205	1.181	1.299		*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS
5	1.00	1.0	0.04	0.04	5.2	35.0	38.0	CXS-05G100-5235R/L	*	*	*	*	*	5	3.8	57.3	2.5	CoroTurn XS
	.039	.039	.002	.002	.205	1.378	1.496		*	*	*	*	*	.197	.148	2.254	.096	CoroTurn XS
5	1.17	1.0	0.04	0.04	5.2	10.0	13.0	CXS-05G117-5210R/L	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS
	.046	.039	.002	.002	.205	.394	.512		*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS
5	1.17	1.0	0.04	0.04	5.2	15.0	18.0	CXS-05G117-5215R/L	*	*	*	*	*	5	3.8	37.3	2.5	CoroTurn XS
	.046	.039	.002	.002	.205	.591	.709		*	*	*	*	*	.197	.148	1.467	.096	CoroTurn XS
5	1.17	1.0	0.04	0.04	5.2	20.0	23.0	CXS-05G117-5220R/L	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
	.046	.039	.002	.002	.205	.787	.906		*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
5	1.17	1.0	0.04	0.04	5.2	25.0	28.0	CXS-05G117-5225R/L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS
	.046	.039	.002	.002	.205	.984	1.102		*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
5	1.17	1.0	0.04	0.04	5.2	30.0	33.0	CXS-05G117-5230L	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS
	.046	.039	.002	.002	.205	1.181	1.299		*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS
5	1.17	1.0	0.04	0.04	5.2	35.0	38.0	CXS-05G117-5235R/L	*	*	*	*	*	5	3.8	57.3	2.5	CoroTurn XS
	.046	.039	.002	.002	.205	1.378	1.496		*	*	*	*	*	.197	.148	2.254	.096	CoroTurn XS
5	1.50	1.0	0.04	0.04	5.2	10.0	13.0	CXS-05G150-5210R/L	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS
	.059	.039	.002	.002	.205	.394	.512		*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS
5	1.50	1.0	0.04	0.04	5.2	15.0	18.0	CXS-05G150-5215R/L	*	*	*	*	*	5	3.8	37.3	2.5	CoroTurn XS
	.059	.039	.002	.002	.205	.591	.709		*	*	*	*	*	.197	.148	1.467	.096	CoroTurn XS
5	1.50	1.0	0.04	0.04	5.2	20.0	23.0	CXS-05G150-5220R	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
	.059	.039	.002	.002	.205	.787	.906		*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
5	1.50	1.0	0.04	0.04	5.2	25.0	28.0	CXS-05G150-5225L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS
	.039	.039	.002	.002	.205	.984	1.102		*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
5	1.50	1.0	0.04	0.04	5.2	30.0	33.0	CXS-05G150-5230R/L	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS
	.039	.039	.002	.002	.205	1.181	1.299		*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS
5	1.50	1.0	0.04	0.04	5.2	35.0	38.0	CXS-05G150-5235R/L	*	*	*	*	*	5	3.8	57.3	2.5	CoroTurn XS
	.059	.039	.002	.002	.205	1.378	1.496		*	*	*	*	*	.197	.148	2.254	.096	CoroTurn XS
5	1.57	1.0	0.04	0.04	5.2	10.0	13.0	CXS-05G157-5210L	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS
	.062	.039	.002	.002	.205	.394	.512		*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS
5	1.57	1.0	0.04	0.04	5.2	15.0	13.0	CXS-05G157-5215R/L	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS
	.062	.039	.002	.002	.205	.591	.512		*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS
5	1.57	1.0	0.04	0.04	5.2	20.0	23.0	CXS-05G157-5220R/L	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
	.062	.039	.002	.002	.205	.787	.906		*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
5	1.57	1.0	0.04	0.04	5.2	25.0	28.0	CXS-05G157-5225R/L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS
	.062	.039	.002	.002	.205	.984	1.102		*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
5	1.57	1.0	0.04	0.04	5.2	30.0	33.0	CXS-05G157-5230R/L	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS
	.062	.039	.002	.002	.205	1.181	1.299		*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS
5	1.57	1.0	0.04	0.04	5.2	10.0	13.0	CXS-05G198-5210L	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS
	.062	.039	.002	.002	.205	.394	.512		*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS

R = Right hand, L = Left hand



D2



B99



B109



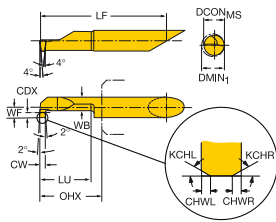
J19



J9

Solid carbide tool for grooving

CoroTurn XS -metric: 5



	CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM	
										1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF		
	5	1.98	1.0	0.04	0.04	5.2	15.0	18.0	CXS-05G198-5215R/L	*	*	*	*	*	5	3.8	37.3	2.5	CoroTurn XS	
				.078	.039	.002	.002	.205	.591	.709	*	*	*	*	*	.197	.148	1.467	.096	CoroTurn XS
	5	1.98	1.0	0.04	0.04	5.2	20.0	23.0	CXS-05G198-5220L	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS	
				.078	.039	.002	.002	.205	.787	.906	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	1.98	1.0	0.04	0.04	5.2	25.0	28.0	CXS-05G198-5225R/L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS	
				.078	.039	.002	.002	.205	.984	1.102	*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
	5	1.98	1.0	0.04	0.04	5.2	30.0	33.0	CXS-05G198-5230R/L	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS	
				.078	.039	.002	.002	.205	1.181	1.299	*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS
	5	2.00	1.0	0.04	0.04	5.2	10.0	13.0	CXS-05G200-5210R	*	*	*	*	*	5	3.8	32.3	2.5	CoroTurn XS	
				.079	.039	.002	.002	.205	.394	.512	*	*	*	*	*	.197	.148	1.270	.096	CoroTurn XS
	5	2.00	1.0	0.04	0.04	5.2	15.0	18.0	CXS-05G200-5215L	*	*	*	*	*	5	3.8	37.3	2.5	CoroTurn XS	
				.079	.039	.002	.002	.205	.591	.709	*	*	*	*	*	.197	.148	1.467	.096	CoroTurn XS
	5	2.00	1.0	0.04	0.04	5.2	20.0	23.0	CXS-05G200-5220R/L	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS	
				.079	.039	.002	.002	.205	.787	.906	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	2.00	1.0	0.04	0.04	5.2	25.0	28.0	CXS-05G200-5225L	*	*	*	*	*	5	3.8	47.3	2.5	CoroTurn XS	
				.079	.039	.002	.002	.205	.984	1.102	*	*	*	*	*	.197	.148	1.860	.096	CoroTurn XS
5	2.00	0.7	0.04	0.04	5.2	30.0	33.0	CXS-05G200-5230R/L	*	*	*	*	*	5	3.8	52.3	2.5	CoroTurn XS		
			.039	.028	.002	.002	.205	1.181	1.299	*	*	*	*	*	.197	.148	2.057	.096	CoroTurn XS	

R = Right hand, L = Left hand



D2



B99



B109



J19



J9



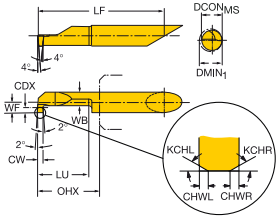
A

Solid carbide tool for grooving

CoroTurn XS -metric: 6

ENG

B



C

									P	M	N	S	O	Dimensions, mm, inch					
	CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code	1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF	PRODFAM
	6	0.78	1.8	0.04	0.04	6.2	10.0	13.0	CXS-06G078-6210R	*	*	*	*	*	6	4.0	32.3	3.0	CoroTurn XS
		.031	.071	.002	.002	.244	.394	.512		*	*	*	*	*	.236	.156	1.270	.116	CoroTurn XS
	6	0.78	1.8	0.04	0.04	6.2	15.0	18.0	CXS-06G078-6215R/L	*	*	*	*	*	6	4.0	37.3	3.0	CoroTurn XS
		.031	.071	.002	.002	.244	.591	.709		*	*	*	*	*	.236	.156	1.467	.116	CoroTurn XS
	6	0.78	1.8	0.04	0.04	6.2	20.0	23.0	CXS-06G078-6220L	*	*	*	*	*	6	4.0	42.3	3.0	CoroTurn XS
		.031	.071	.002	.002	.244	.787	.906		*	*	*	*	*	.236	.156	1.663	.116	CoroTurn XS
	6	0.78	1.8	0.04	0.04	6.2	25.0	28.0	CXS-06G078-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.031	.071	.002	.002	.244	.984	1.102		*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	0.78	1.8	0.04	0.04	6.2	30.0	33.0	CXS-06G078-6230L	*	*	*	*	*	6	4.0	52.3	3.0	CoroTurn XS
		.031	.071	.002	.002	.244	1.181	1.299		*	*	*	*	*	.236	.156	2.057	.116	CoroTurn XS
	6	0.78	1.8	0.04	0.04	6.2	35.0	38.0	CXS-06G078-6235R/L	*	*	*	*	*	6	4.0	57.3	3.0	CoroTurn XS
		.031	.071	.002	.002	.244	1.378	1.496		*	*	*	*	*	.236	.156	2.254	.116	CoroTurn XS
	6	1.00	1.8	0.04	0.04	6.2	10.0	13.0	CXS-06G100-6210R	*	*	*	*	*	6	4.0	32.3	3.0	CoroTurn XS
		.039	.071	.002	.002	.244	.394	.512		*	*	*	*	*	.236	.156	1.270	.116	CoroTurn XS
	6	1.00	1.8	0.04	0.04	6.2	15.0	18.0	CXS-06G100-6215L	*	*	*	*	*	6	4.0	37.3	3.0	CoroTurn XS
		.039	.071	.002	.002	.244	.591	.709		*	*	*	*	*	.236	.156	1.467	.116	CoroTurn XS
	6	1.00	1.8	0.04	0.04	6.2	25.0	28.0	CXS-06G100-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.039	.071	.002	.002	.244	.984	1.102		*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.00	1.8	0.04	0.04	6.2	35.0	38.0	CXS-06G100-6235R	*	*	*	*	*	6	4.0	57.3	3.0	CoroTurn XS
		.039	.071	.002	.002	.244	1.378	1.496		*	*	*	*	*	.236	.156	2.254	.116	CoroTurn XS
	6	1.00	1.8	0.04	0.04	6.2	40.0	43.0	CXS-06G100-6240R/L	*	*	*	*	*	6	4.0	62.3	3.0	CoroTurn XS
		.039	.071	.002	.002	.244	1.575	1.693		*	*	*	*	*	.236	.156	2.451	.116	CoroTurn XS
	6	1.17	1.8	0.04	0.04	6.2	10.0	13.0	CXS-06G117-6210R/L	*	*	*	*	*	6	4.0	32.3	3.0	CoroTurn XS
		.046	.071	.002	.002	.244	.394	.512		*	*	*	*	*	.236	.156	1.270	.116	CoroTurn XS
	6	1.17	1.8	0.04	0.04	6.2	15.0	18.0	CXS-06G117-6215R	*	*	*	*	*	6	4.0	37.3	3.0	CoroTurn XS
		.046	.071	.002	.002	.244	.591	.709		*	*	*	*	*	.236	.156	1.467	.116	CoroTurn XS
	6	1.17	1.8	0.04	0.04	6.2	20.0	23.0	CXS-06G117-6220R/L	*	*	*	*	*	6	4.0	42.3	3.0	CoroTurn XS
		.046	.071	.002	.002	.244	.787	.906		*	*	*	*	*	.236	.156	1.663	.116	CoroTurn XS
	6	1.17	1.8	0.04	0.04	6.2	25.0	28.0	CXS-06G117-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.046	.071	.002	.002	.244	.984	1.102		*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.17	1.8	0.04	0.04	6.2	30.0	33.0	CXS-06G117-6230R/L	*	*	*	*	*	6	4.0	52.3	3.0	CoroTurn XS
		.046	.071	.002	.002	.244	1.181	1.299		*	*	*	*	*	.236	.156	2.057	.116	CoroTurn XS
	6	1.17	1.8	0.04	0.04	6.2	35.0	38.0	CXS-06G117-6235L	*	*	*	*	*	6	4.0	57.3	3.0	CoroTurn XS
		.046	.071	.002	.002	.244	1.378	1.496		*	*	*	*	*	.236	.156	2.254	.116	CoroTurn XS
	6	1.17	1.8	0.04	0.04	6.2	40.0	43.0	CXS-06G117-6240R/L	*	*	*	*	*	6	4.0	62.3	3.0	CoroTurn XS
		.046	.071	.002	.002	.244	1.575	1.693		*	*	*	*	*	.236	.156	2.451	.116	CoroTurn XS
	6	1.50	1.8	0.04	0.04	6.2	10.0	13.0	CXS-06G150-6210R	*	*	*	*	*	6	4.0	32.3	3.0	CoroTurn XS
		.059	.071	.002	.002	.244	.394	.512		*	*	*	*	*	.236	.156	1.270	.116	CoroTurn XS
	6	1.50	1.8	0.04	0.04	6.2	15.0	18.0	CXS-06G150-6215L	*	*	*	*	*	6	4.0	37.3	3.0	CoroTurn XS
		.059	.071	.002	.002	.244	.591	.709		*	*	*	*	*	.236	.156	1.467	.116	CoroTurn XS
	6	1.50	1.8	0.04	0.04	6.2	25.0	28.0	CXS-06G150-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.059	.071	.002	.002	.244	.984	1.102		*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.50	1.8	0.04	0.04	6.2	30.0	33.0	CXS-06G150-6230R/L	*	*	*	*	*	6	4.0	52.3	3.0	CoroTurn XS
		.059	.071	.002	.002	.244	1.181	1.299		*	*	*	*	*	.236	.156	2.057	.116	CoroTurn XS
	6	1.50	1.8	0.04	0.04	6.2	35.0	38.0	CXS-06G150-6235R/L	*	*	*	*	*	6	4.0	57.3	3.0	CoroTurn XS
		.059	.071	.002	.002	.244	1.378	1.496		*	*	*	*	*	.236	.156	2.254	.116	CoroTurn XS
	6	1.57	1.8	0.04	0.04	6.2	10.0	13.0	CXS-06G157-6210R/L	*	*	*	*	*	6	4.0	32.3	3.0	CoroTurn XS
		.062	.071	.002	.002	.244	.394	.512		*	*	*	*	*	.236	.156	1.270	.116	CoroTurn XS
	6	1.57	1.8	0.04	0.04	6.2	15.0	18.0	CXS-06G157-6215R/L	*	*	*	*	*	6	4.0	37.3	3.0	CoroTurn XS
		.062	.071	.002	.002	.244	.591	.709		*	*	*	*	*	.236	.156	1.467	.116	CoroTurn XS
	6	1.57	1.8	0.04	0.04	6.2	20.0	23.0	CXS-06G157-6220R	*	*	*	*	*	6	4.0	42.3	3.0	CoroTurn XS
		.062	.071	.002	.002	.244	.787	.906		*	*	*	*	*	.236	.156	1.663	.116	CoroTurn XS
	6	1.57	1.8	0.04	0.04	6.2	25.0	28.0	CXS-06G157-6225R	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.062	.071	.002	.002	.244	.984	1.102		*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.57	1.8	0.04	0.04	6.2	30.0	33.0	CXS-06G157-6230L	*	*	*	*	*	6	4.0	52.3	3.0	CoroTurn XS
		.062	.071	.002	.002	.244	1.181	1.299		*	*	*	*	*	.236	.156	2.057	.116	CoroTurn XS

R = Right hand, L = Left hand

J



D2



B99



B109



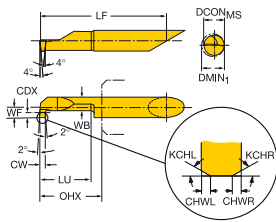
J19



J9

Solid carbide tool for grooving

CoroTurn XS -metric: 6



	CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM	
										1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF		
	6	1.57	1.8	0.04	0.04	6.2	35.0	38.0	CXS-06G157-6235R/L	*	*	*	*	*	6	4.0	57.3	3.0	CoroTurn XS	
			.062	.071	.002	.002	.244	1.378	1.496		*	*	*	*	*	.236	.156	2.254	.116	CoroTurn XS
	6	1.57	1.8	0.04	0.04	6.2	40.0	43.0	CXS-06G157-6240R/L	*	*	*	*	*	6	4.0	62.3	3.0	CoroTurn XS	
			.062	.071	.002	.002	.244	1.575	1.693		*	*	*	*	*	.236	.156	2.451	.116	CoroTurn XS
	6	1.98	1.8	0.04	0.04	6.2	10.0	13.0	CXS-06G198-6210R	*	*	*	*	*	6	4.0	32.3	3.0	CoroTurn XS	
			.078	.071	.002	.002	.244	.394	.512		*	*	*	*	*	.236	.156	1.270	.116	CoroTurn XS
	6	1.98	1.8	0.04	0.04	6.2	15.0	18.0	CXS-06G198-6215R	*	*	*	*	*	6	4.0	37.3	3.0	CoroTurn XS	
			.078	.071	.002	.002	.244	.591	.709		*	*	*	*	*	.236	.156	1.467	.116	CoroTurn XS
	6	1.98	1.8	0.04	0.04	6.2	25.0	28.0	CXS-06G198-6225R	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS	
			.078	.071	.002	.002	.244	.984	1.102		*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.98	1.8	0.04	0.04	6.2	35.0	38.0	CXS-06G198-6235R/L	*	*	*	*	*	6	4.0	57.3	3.0	CoroTurn XS	
			.078	.071	.002	.002	.244	1.378	1.496		*	*	*	*	*	.236	.156	2.254	.116	CoroTurn XS
	6	2.00	1.8	0.04	0.04	6.2	10.0	13.0	CXS-06G200-6210R	*	*	*	*	*	6	4.0	32.3	3.0	CoroTurn XS	
			.079	.071	.002	.002	.244	.394	.512		*	*	*	*	*	.236	.156	1.270	.116	CoroTurn XS
	6	2.00	1.8	0.04	0.04	6.2	15.0	18.0	CXS-06G200-6215R/L	*	*	*	*	*	6	4.0	37.3	3.0	CoroTurn XS	
			.079	.071	.002	.002	.244	.591	.709		*	*	*	*	*	.236	.156	1.467	.116	CoroTurn XS
6	2.00	1.8	0.04	0.04	6.2	25.0	28.0	CXS-06G200-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS		
		.079	.071	.002	.002	.244	.984	1.102		*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS	
6	2.00	1.8	0.04	0.04	6.2	30.0	33.0	CXS-06G200-6230R/L	*	*	*	*	*	6	4.0	52.3	3.0	CoroTurn XS		
		.079	.071	.002	.002	.244	1.181	1.299		*	*	*	*	*	.236	.156	2.057	.116	CoroTurn XS	

R = Right hand, L = Left hand



D2



B99



B109



J19

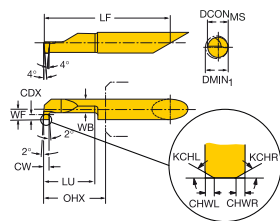


J9



Solid carbide tool for grooving

CoroTurn XS -metric: 7



B

C

										P	M	N	S	O	Dimensions, mm, inch					
										1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF	PRODFAM	
CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code												
	7	0.78	2.5	0.04	0.04	7.2	10.0	13.0	CXS-07G078-7210R/L	★	★	★	★	★	7	4.3	32.3	3.5	CoroTurn XS	
			.031	.098	.002	.002	.283	.394	.512		★	★	★	★	★	.276	.167	1.270	.136	CoroTurn XS
	7	0.78	2.5	0.04	0.04	7.2	15.0	18.0	CXS-07G078-7215R/L	★	★	★	★	★	7	4.3	37.3	3.5	CoroTurn XS	
			.031	.098	.002	.002	.283	.591	.709		★	★	★	★	★	.276	.167	1.467	.136	CoroTurn XS
	7	0.78	2.5	0.04	0.04	7.2	20.0	23.0	CXS-07G078-7220L	★	★	★	★	★	7	4.3	42.3	3.5	CoroTurn XS	
			.031	.098	.002	.002	.283	.787	.906		★	★	★	★	★	.276	.167	1.663	.136	CoroTurn XS
	7	0.78	2.5	0.04	0.04	7.2	25.0	28.0	CXS-07G078-7225R/L	★	★	★	★	★	7	4.3	47.3	3.5	CoroTurn XS	
			.031	.098	.002	.002	.283	.984	1.102		★	★	★	★	★	.276	.167	1.860	.136	CoroTurn XS
	7	0.78	2.5	0.04	0.04	7.2	30.0	33.0	CXS-07G078-7230R/L	★	★	★	★	★	7	4.3	52.3	3.5	CoroTurn XS	
			.031	.098	.002	.002	.283	1.181	1.299		★	★	★	★	★	.276	.167	2.057	.136	CoroTurn XS
	7	0.78	2.5	0.04	0.04	7.2	35.0	38.0	CXS-07G078-7235R/L	★	★	★	★	★	7	4.3	57.3	3.5	CoroTurn XS	
			.031	.098	.002	.002	.283	1.378	1.496		★	★	★	★	★	.276	.167	2.254	.136	CoroTurn XS
7	0.78	2.5	0.04	0.04	7.2	40.0	43.0	CXS-07G078-7240R/L	★	★	★	★	★	7	4.3	62.3	3.5	CoroTurn XS		
		.031	.098	.002	.002	.283	1.575	1.693		★	★	★	★	★	.276	.167	2.451	.136	CoroTurn XS	
7	1.00	2.5	0.04	0.04	7.2	10.0	13.0	CXS-07G100-7210R	★	★	★	★	★	7	4.3	32.3	3.5	CoroTurn XS		
		.039	.098	.002	.002	.283	.394	.512		★	★	★	★	★	.276	.167	1.270	.136	CoroTurn XS	
7	1.00	2.5	0.04	0.04	7.2	15.0	18.0	CXS-07G100-7215R/L	★	★	★	★	★	7	4.3	37.3	3.5	CoroTurn XS		
		.039	.098	.002	.002	.283	.591	.709		★	★	★	★	★	.276	.167	1.467	.136	CoroTurn XS	
7	1.00	2.5	0.04	0.04	7.2	25.0	28.0	CXS-07G100-7225R/L	★	★	★	★	★	7	4.3	47.3	3.5	CoroTurn XS		
		.039	.098	.002	.002	.283	.984	1.102		★	★	★	★	★	.276	.167	1.860	.136	CoroTurn XS	
7	1.00	2.5	0.04	0.04	7.2	30.0	33.0	CXS-07G100-7230R/L	★	★	★	★	★	7	4.3	52.3	3.5	CoroTurn XS		
		.039	.098	.002	.002	.283	1.181	1.299		★	★	★	★	★	.276	.167	2.057	.136	CoroTurn XS	
7	1.00	2.5	0.04	0.04	7.2	35.0	38.0	CXS-07G100-7235R/L	★	★	★	★	★	7	4.3	57.3	3.5	CoroTurn XS		
		.039	.098	.002	.002	.283	1.378	1.496		★	★	★	★	★	.276	.167	2.254	.136	CoroTurn XS	
7	1.17	2.5	0.04	0.04	7.2	40.0	43.0	CXS-07G100-7240R/L	★	★	★	★	★	7	4.3	62.3	3.5	CoroTurn XS		
		.046	.098	.002	.002	.283	1.575	1.693		★	★	★	★	★	.276	.167	2.451	.136	CoroTurn XS	
7	1.17	2.5	0.04	0.04	7.2	10.0	13.0	CXS-07G117-7210R	★	★	★	★	★	7	4.3	32.3	3.5	CoroTurn XS		
		.046	.098	.002	.002	.283	.394	.512		★	★	★	★	★	.276	.167	1.270	.136	CoroTurn XS	
7	1.17	2.5	0.04	0.04	7.2	15.0	18.0	CXS-07G117-7215R	★	★	★	★	★	7	4.3	37.3	3.5	CoroTurn XS		
		.046	.098	.002	.002	.283	.591	.709		★	★	★	★	★	.276	.167	1.467	.136	CoroTurn XS	
7	1.17	2.5	0.04	0.04	7.2	25.0	28.0	CXS-07G117-7225R	★	★	★	★	★	7	4.3	47.3	3.5	CoroTurn XS		
		.046	.098	.002	.002	.283	.984	1.102		★	★	★	★	★	.276	.167	1.860	.136	CoroTurn XS	
7	1.17	2.5	0.04	0.04	7.2	30.0	33.0	CXS-07G117-7230R/L	★	★	★	★	★	7	4.3	52.3	3.5	CoroTurn XS		
		.046	.098	.002	.002	.283	1.181	1.299		★	★	★	★	★	.276	.167	2.057	.136	CoroTurn XS	
7	1.17	2.5	0.04	0.04	7.2	35.0	38.0	CXS-07G117-7235R/L	★	★	★	★	★	7	4.3	57.3	3.5	CoroTurn XS		
		.046	.098	.002	.002	.283	1.378	1.496		★	★	★	★	★	.276	.167	2.254	.136	CoroTurn XS	
7	1.17	2.5	0.04	0.04	7.2	40.0	43.0	CXS-07G117-7240R/L	★	★	★	★	★	7	4.3	62.3	3.5	CoroTurn XS		
		.046	.098	.002	.002	.283	1.575	1.693		★	★	★	★	★	.276	.167	2.451	.136	CoroTurn XS	
7	1.50	2.5	0.04	0.04	7.2	10.0	13.0	CXS-07G150-7210R	★	★	★	★	★	7	4.3	32.3	3.5	CoroTurn XS		
		.059	.098	.002	.002	.283	.394	.512		★	★	★	★	★	.276	.167	1.270	.136	CoroTurn XS	
7	1.50	2.5	0.04	0.04	7.2	15.0	18.0	CXS-07G150-7215R/L	★	★	★	★	★	7	4.3	37.3	3.5	CoroTurn XS		
		.059	.098	.002	.002	.283	.591	.709		★	★	★	★	★	.276	.167	1.467	.136	CoroTurn XS	
7	1.50	2.5	0.04	0.04	7.2	25.0	28.0	CXS-07G150-7225R/L	★	★	★	★	★	7	4.3	47.3	3.5	CoroTurn XS		
		.059	.098	.002	.002	.283	.984	1.102		★	★	★	★	★	.276	.167	1.860	.136	CoroTurn XS	
7	1.50	2.5	0.04	0.04	7.2	30.0	33.0	CXS-07G150-7230L	★	★	★	★	★	7	4.3	52.3	3.5	CoroTurn XS		
		.059	.098	.002	.002	.283	1.181	1.299		★	★	★	★	★	.276	.167	2.057	.136	CoroTurn XS	
7	1.50	2.5	0.04	0.04	7.2	35.0	38.0	CXS-07G150-7235R	★	★	★	★	★	7	4.3	57.3	3.5	CoroTurn XS		
		.059	.098	.002	.002	.283	1.378	1.496		★	★	★	★	★	.276	.167	2.254	.136	CoroTurn XS	
7	1.50	2.5	0.04	0.04	7.2	40.0	43.0	CXS-07G150-7240R/L	★	★	★	★	★	7	4.3	62.3	3.5	CoroTurn XS		
		.059	.098	.002	.002	.283	1.575	1.693		★	★	★	★	★	.276	.167	2.451	.136	CoroTurn XS	
7	1.57	2.5	0.04	0.04	7.2	10.0	13.0	CXS-07G157-7210R	★	★	★	★	★	7	4.3	32.3	3.5	CoroTurn XS		
		.062	.098	.002	.002	.283	.394	.512		★	★	★	★	★	.276	.167	1.270	.136	CoroTurn XS	
7	1.57	2.5	0.04	0.04	7.2	15.0	18.0	CXS-07G157-7215R/L	★	★	★	★	★	7	4.3	37.3	3.5	CoroTurn XS		
		.062	.098	.002	.002	.283	.591	.709		★	★	★	★	★	.276	.167	1.467	.136	CoroTurn XS	
7	1.57	2.5	0.04	0.04	7.2	20.0	23.0	CXS-07G157-7220L	★	★	★	★	★	7	4.3	42.3	3.5	CoroTurn XS		
		.062	.098	.002	.002	.283	.787	.906		★	★	★	★	★	.276	.167	1.663	.136	CoroTurn XS	
7	1.57	2.5	0.04	0.04	7.2	25.0	28.0	CXS-07G157-7225R	★	★	★	★	★	7	4.3	47.3	3.5	CoroTurn XS		
		.062	.098	.002	.002	.283	.984	1.102		★	★	★	★	★	.276	.167	1.860	.136	CoroTurn XS	
7	1.57	2.5	0.04	0.04	7.2	30.0	33.0	CXS-07G157-7230R/L	★	★	★	★	★	7	4.3	52.3	3.5	CoroTurn XS		
		.062	.098	.002	.002	.283	1.181	1.299		★	★	★	★	★	.276	.167	2.057	.136	CoroTurn XS	

R = Right hand, L = Left hand



D2



B99



B109



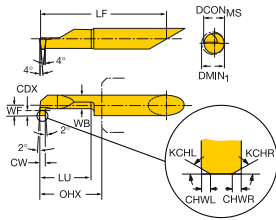
J19



J9

Solid carbide tool for grooving

CoroTurn XS -metric: 7



	CZC _{MS}	CW	CDX	CHWL	CHWR	DMIN ₁	LU	OHX	Ordering code	P M N S O					Dimensions, mm, inch				PRODFAM
										1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF	
	7	1.57	2.5	0.04	0.04	7.2	35.0	38.0	CXS-07G157-7235R/L	*	*	*	*	*	7	4.3	57.3	3.5	CoroTurn XS
		.062	.098	.002	.002	.283	1.378	1.496		*	*	*	*	*	.276	.167	2.254	.136	CoroTurn XS
	7	1.57	2.5	0.04	0.04	7.2	40.0	43.0	CXS-07G157-7240R/L	*	*	*	*	*	7	4.3	62.3	3.5	CoroTurn XS
		.062	.098	.002	.002	.283	1.575	1.693		*	*	*	*	*	.276	.167	2.451	.136	CoroTurn XS
	7	1.98	2.5	0.04	0.04	7.2	10.0	13.0	CXS-07G198-7210R/L	*	*	*	*	*	7	4.3	32.3	3.5	CoroTurn XS
		.078	.098	.002	.002	.283	.394	.512		*	*	*	*	*	.276	.167	1.270	.136	CoroTurn XS
	7	1.98	2.5	0.04	0.04	7.2	15.0	18.0	CXS-07G198-7215R/L	*	*	*	*	*	7	4.3	37.3	3.5	CoroTurn XS
		.078	.098	.002	.002	.283	.591	.709		*	*	*	*	*	.276	.167	1.467	.136	CoroTurn XS
	7	1.98	2.5	0.04	0.04	7.2	20.0	23.0	CXS-07G198-7220L	*	*	*	*	*	7	4.3	42.3	3.5	CoroTurn XS
		.078	.098	.002	.002	.283	.787	.906		*	*	*	*	*	.276	.167	1.663	.136	CoroTurn XS
	7	1.98	2.5	0.04	0.04	7.2	25.0	28.0	CXS-07G198-7225L	*	*	*	*	*	7	4.3	47.3	3.5	CoroTurn XS
		.078	.098	.002	.002	.283	.984	1.102		*	*	*	*	*	.276	.167	1.860	.136	CoroTurn XS
	7	1.98	2.5	0.04	0.04	7.2	30.0	33.0	CXS-07G198-7230R/L	*	*	*	*	*	7	4.3	52.3	3.5	CoroTurn XS
		.078	.098	.002	.002	.283	1.181	1.299		*	*	*	*	*	.276	.167	2.057	.136	CoroTurn XS
	7	1.98	2.5	0.04	0.04	7.2	35.0	38.0	CXS-07G198-7235R/L	*	*	*	*	*	7	4.3	57.3	3.5	CoroTurn XS
		.078	.098	.002	.002	.283	1.378	1.496		*	*	*	*	*	.276	.167	2.254	.136	CoroTurn XS
	7	2.00	2.5	0.04	0.04	7.2	10.0	13.0	CXS-07G200-7210R	*	*	*	*	*	7	4.3	32.3	3.5	CoroTurn XS
		.079	.098	.002	.002	.283	.394	.512		*	*	*	*	*	.276	.167	1.270	.136	CoroTurn XS
	7	2.00	2.5	0.04	0.04	7.2	15.0	18.0	CXS-07G200-7215R/L	*	*	*	*	*	7	4.3	37.3	3.5	CoroTurn XS
		.079	.098	.002	.002	.283	.591	.709		*	*	*	*	*	.276	.167	1.467	.136	CoroTurn XS
	7	2.00	2.5	0.04	0.04	7.2	20.0	23.0	CXS-07G200-7220R/L	*	*	*	*	*	7	4.3	42.3	3.5	CoroTurn XS
		.079	.098	.002	.002	.283	.787	.906		*	*	*	*	*	.276	.167	1.663	.136	CoroTurn XS
	7	2.00	2.5	0.04	0.04	7.2	25.0	28.0	CXS-07G200-7225R/L	*	*	*	*	*	7	4.3	47.3	3.5	CoroTurn XS
		.079	.098	.002	.002	.283	.984	1.102		*	*	*	*	*	.276	.167	1.860	.136	CoroTurn XS
	7	2.00	2.5	0.04	0.04	7.2	35.0	38.0	CXS-07G200-7235R/L	*	*	*	*	*	7	4.3	57.3	3.5	CoroTurn XS
		.079	.098	.002	.002	.283	1.378	1.496		*	*	*	*	*	.276	.167	2.254	.136	CoroTurn XS

R = Right hand, L = Left hand



D2



B99



B109



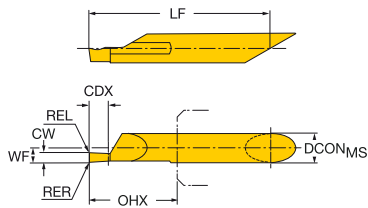
J19



J9

Solid carbide tool for face grooving

ENG



CoroTurn XS -metric: 6

	CZC _{MS}	CW	CDX	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
						1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	6	1.00	2.0	18.0	CXS-06F100-6215AR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.039	.079	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	1.50	3.0	18.0	CXS-06F150-6215AR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.059	.118	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	2.00	4.0	18.0	CXS-06F200-6215AR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.079	.157	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	2.50	5.0	18.0	CXS-06F250-6215AR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.098	.197	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	3.00	6.0	18.0	CXS-06F300-6215AR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.118	.236	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	1.00	2.0	18.0	CXS-06F100-6215BR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.039	.079	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	1.50	3.0	18.0	CXS-06F150-6215BR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.059	.118	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	2.00	4.0	18.0	CXS-06F200-6215BR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.079	.157	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	2.50	5.0	18.0	CXS-06F250-6215BR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.098	.197	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS
	6	3.00	6.0	18.0	CXS-06F300-6215BR/L	*	*	*	*	*	6	37.3	3.0	CoroTurn XS
		.118	.236	.709		*	*	*	*	*	.236	1.469	.116	CoroTurn XS

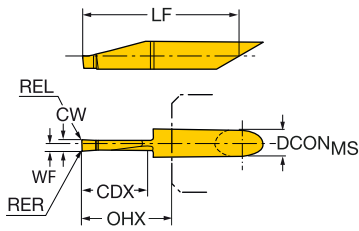
CoroTurn XS -metric: 8

	CZC _{MS}	CW	CDX	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
						1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	8	2.00	15.0	20.0	CXS-08F200-8015AR/L	*	*	*	*	*	8	44.3	1.6	CoroTurn XS
		.079	.591	.787		*	*	*	*	*	.315	1.742	.062	CoroTurn XS
	8	2.50	10.0	15.0	CXS-08F250-8010AR/L	*	*	*	*	*	8	39.3	1.8	CoroTurn XS
		.098	.394	.591		*	*	*	*	*	.315	1.545	.072	CoroTurn XS
	8	3.00	10.0	15.0	CXS-08F300-8010AR/L	*	*	*	*	*	8	39.3	2.1	CoroTurn XS
		.118	.394	.591		*	*	*	*	*	.315	1.545	.081	CoroTurn XS
	8	3.00	15.0	20.0	CXS-08F300-8015AR/L	*	*	*	*	*	8	44.3	2.1	CoroTurn XS
		.118	.591	.787		*	*	*	*	*	.315	1.742	.081	CoroTurn XS
	8	4.00	10.0	15.0	CXS-08F400-8010AR/L	*	*	*	*	*	8	39.3	2.5	CoroTurn XS
		.157	.394	.591		*	*	*	*	*	.315	1.545	.098	CoroTurn XS
	8	4.00	15.0	20.0	CXS-08F400-8015AR/L	*	*	*	*	*	8	44.3	2.5	CoroTurn XS
		.157	.591	.787		*	*	*	*	*	.315	1.742	.098	CoroTurn XS

R = Right hand, L = Left hand



Solid carbide tool for face grooving



CoroTurn XS -metric: 10

	CZC _{MS}	CW	CDX	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
						1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	10	3.00	20.0	28.0	CXS-10F300-10020AR/L	*	*	*	*	*	10	52.3	2.1	CoroTurn XS
		.118	.787	1.102		*	*	*	*	*	.394	2.057	.081	CoroTurn XS
	10	3.00	25.0	33.0	CXS-10F300-10025AR/L	*	*	*	*	*	10	57.3	2.1	CoroTurn XS
		.118	.984	1.299		*	*	*	*	*	.394	2.254	.081	CoroTurn XS
	10	3.00	30.0	38.0	CXS-10F300-10030AR/L	*	*	*	*	*	10	62.3	2.1	CoroTurn XS
		.118	1.181	1.496		*	*	*	*	*	.394	2.451	.081	CoroTurn XS
	10	4.00	20.0	28.0	CXS-10F400-10020AR/L	*	*	*	*	*	10	52.3	2.7	CoroTurn XS
		.157	.787	1.102		*	*	*	*	*	.394	2.057	.104	CoroTurn XS
	10	4.00	25.0	33.0	CXS-10F400-10025AR/L	*	*	*	*	*	10	57.3	2.7	CoroTurn XS
		.157	.984	1.299		*	*	*	*	*	.394	2.254	.104	CoroTurn XS
	10	4.00	30.0	38.0	CXS-10F400-10030AR/L	*	*	*	*	*	10	62.3	2.7	CoroTurn XS
		.157	1.181	1.496		*	*	*	*	*	.394	2.451	.104	CoroTurn XS
	10	5.00	20.0	28.0	CXS-10F500-10020AR/L	*	*	*	*	*	10	52.3	3.1	CoroTurn XS
		.197	.787	1.102		*	*	*	*	*	.394	2.057	.122	CoroTurn XS
	10	5.00	25.0	33.0	CXS-10F500-10025AR/L	*	*	*	*	*	10	57.3	3.1	CoroTurn XS
		.197	.984	1.299		*	*	*	*	*	.394	2.254	.122	CoroTurn XS
	10	5.00	30.0	38.0	CXS-10F500-10030AR/L	*	*	*	*	*	10	62.3	3.1	CoroTurn XS
		.197	1.181	1.496		*	*	*	*	*	.394	2.451	.122	CoroTurn XS

R = Right hand, L = Left hand



D2



B99



B109

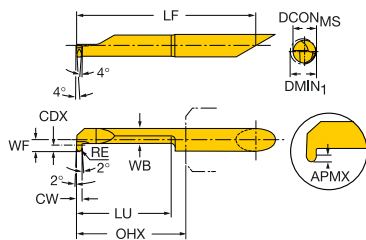


J19



J9

Solid carbide tool for profiling



CoroTurn XS -metric: 4

	CZC _{MS}	CW	CDX	RE	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM
									1025	1025	1025	1025	DCON _{MS}	WB	LF	WF		
	4	1.17	0.8	0.58	4.2	15.0	18.0	CXS-04R058-4215R	*	*	*	*	*	4	3.0	32.3	2.0	CoroTurn XS
		.046	.031	.023	.165	.591	.709	CXS-04R100-4215R/L	*	*	*	*	*	.157	.116	1.270	.077	CoroTurn XS
	4	1.00	0.8	0.50	4.2	15.0	18.0	CXS-04R100-4215R/L	*	*	*	*	*	4	3.0	32.3	2.0	CoroTurn XS
		.039	.031	.020	.165	.591	.709	CXS-04R100-4215R/L	*	*	*	*	*	.157	.116	1.270	.077	CoroTurn XS

CoroTurn XS -metric: 5

	CZC _{MS}	CW	CDX	RE	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM
									1025	1025	1025	1025	DCON _{MS}	WB	LF	WF		
	5	1.17	1.0	0.58	5.2	20.0	23.0	CXS-05R058-5220R/L	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
		.046	.039	.023	.205	.787	.906	CXS-05R081-5220R	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	1.63	1.0	0.81	5.2	20.0	23.0	CXS-05R081-5220R	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
		.064	.039	.032	.205	.787	.906	CXS-05R099-5220R	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	1.98	1.0	0.99	5.2	20.0	23.0	CXS-05R099-5220R	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
		.078	.039	.039	.205	.787	.906	CXS-05R100-5220R	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	1.00	1.0	0.50	5.2	20.0	23.0	CXS-05R100-5220R	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
		.039	.039	.020	.205	.787	.906	CXS-05R150-5220R	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	1.50	1.0	0.75	5.2	20.0	23.0	CXS-05R150-5220R	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
		.059	.039	.030	.205	.787	.906	CXS-05R200-5220R	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS
	5	2.00	1.0	1.00	5.2	20.0	23.0	CXS-05R200-5220R	*	*	*	*	*	5	3.8	42.3	2.5	CoroTurn XS
		.079	.039	.039	.205	.787	.906	CXS-05R200-5220R	*	*	*	*	*	.197	.148	1.663	.096	CoroTurn XS

CoroTurn XS -metric: 6

	CZC _{MS}	CW	CDX	RE	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch				PRODFAM
									1025	1025	1025	1025	DCON _{MS}	WB	LF	WF		
	6	1.17	1.8	0.58	6.2	25.0	28.0	CXS-06R058-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.046	.071	.023	.244	.984	1.102	CXS-06R081-6225R	*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.63	1.8	0.81	6.2	25.0	28.0	CXS-06R081-6225R	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.064	.071	.032	.244	.984	1.102	CXS-06R099-6225R	*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.98	1.8	0.99	6.2	25.0	28.0	CXS-06R099-6225R	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.078	.071	.039	.244	.984	1.102	CXS-06R100-6225R/L	*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.00	1.8	0.50	6.2	25.0	28.0	CXS-06R100-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.039	.071	.020	.244	.984	1.102	CXS-06R150-6225R	*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	1.50	1.8	0.75	6.2	25.0	28.0	CXS-06R150-6225R	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.059	.071	.030	.244	.984	1.102	CXS-06R200-6225R/L	*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS
	6	2.00	1.8	1.00	6.2	25.0	28.0	CXS-06R200-6225R/L	*	*	*	*	*	6	4.0	47.3	3.0	CoroTurn XS
		.079	.071	.039	.244	.984	1.102	CXS-06R200-6225R/L	*	*	*	*	*	.236	.156	1.860	.116	CoroTurn XS

R = Right hand, L = Left hand



D2



B99



B109

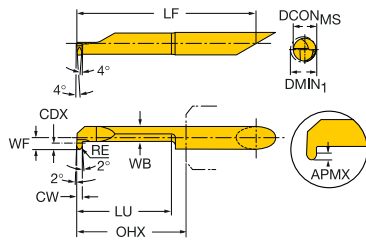


J19



J9

Solid carbide tool for profiling



CoroTurn XS -metric: 7

	CZC _{MS}	CW	CDX	RE	DMIN ₁	LU	OHX	Ordering code	P M N S O					Dimensions, mm, inch				PRODFAM
									1025	1025	1025	1025	1025	DCON _{MS}	WB	LF	WF	
									*	*	*	*	*					
	7	1.17	2.5	0.58	7.2	30.0	33.0	CXS-07R058-7230R	*	*	*	*	*	7	4.3	52.3	3.5	CoroTurn XS
		.046	.098	.023	.283	1.181	1.299		*	*	*	*	*	.276	.167	2.057	.136	CoroTurn XS
	7	1.63	2.5	0.81	7.2	30.0	33.0	CXS-07R081-7230R	*	*	*	*	*	7	4.3	52.3	3.5	CoroTurn XS
		.064	.098	.032	.283	1.181	1.299		*	*	*	*	*	.276	.167	2.057	.136	CoroTurn XS
	7	1.98	2.5	0.99	7.2	30.0	33.0	CXS-07R099-7230R	*	*	*	*	*	7	4.3	52.3	3.5	CoroTurn XS
		.078	.098	.039	.283	1.181	1.299		*	*	*	*	*	.276	.167	2.057	.136	CoroTurn XS
	7	1.00	2.5	0.50	7.2	30.0	33.0	CXS-07R100-7230R/L	*	*	*	*	*	7	4.3	52.3	3.5	CoroTurn XS
		.039	.098	.020	.283	1.181	1.299		*	*	*	*	*	.276	.167	2.057	.136	CoroTurn XS
	7	1.50	2.5	0.75	7.2	30.0	33.0	CXS-07R150-7230R	*	*	*	*	*	7	4.3	52.3	3.5	CoroTurn XS
		.059	.098	.030	.283	1.181	1.299		*	*	*	*	*	.276	.167	2.057	.136	CoroTurn XS
	7	2.00	2.5	1.00	7.2	30.0	33.0	CXS-07R200-7230R/L	*	*	*	*	*	7	4.3	52.3	3.5	CoroTurn XS
		.079	.098	.039	.283	1.181	1.299		*	*	*	*	*	.276	.167	2.057	.136	CoroTurn XS

R = Right hand, L = Left hand



D2



B99



B109



J19



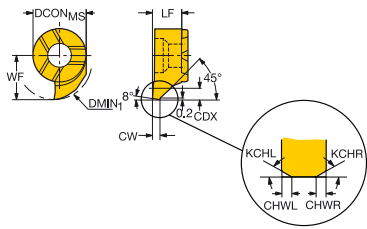
J9

A


Solid carbide head for pre-parting

CoroCut MB -size 07

B



C

	CZC _{MS}	CW	CHWL	CHWR	CDX	DMIN ₁	KAPR	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
										1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	07	1.00	0.04	0.04	0.7	10.0	90°	3.9	MB-07GX100-00-10R/L	*	*	*	*	*	7	3.9	5.8	CoroCut MB
		.039	.002	.002	.028	.394	90°	.154		*	*	*	*	*	.276	.154	.228	CoroCut MB

D

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand

E

F

G

H

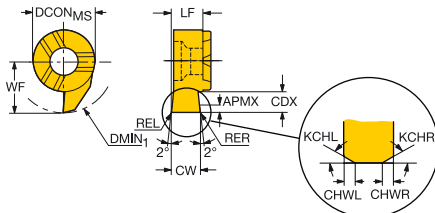
I

J



Solid carbide head for grooving

CoroCut MB -size 07



CZC _{MS}	CW	RER	REL	CHWL	CHWR	CDX	DMIN ₁	KAPR	OHX	Ordering code	Material					Dimensions, mm, inch			PRODFAM	
											P	M	N	S	H	O	DCON _{MS}	LF		WF
07	1.00			0.04	0.04	1.8	10.0	90°	3.9	MB-07G100-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.039			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	1.00			0.04	0.04	2.8	11.0	90°	3.9	MB-07G100-00-11R					*	*	7	3.9	6.8	CoroCut MB
	.039			.002	.002	.110	.433	90°	.154						*	*	.276	.154	.268	CoroCut MB
07	1.00			0.04	0.04	2.8	11.0	90°	3.9	MB-07G100-00-11R/L	*	*	*	*	*	*	7	3.9	6.8	CoroCut MB
	.039			.002	.002	.110	.433	90°	.154		*	*	*	*	*	*	.276	.154	.268	CoroCut MB
07	1.00			0.04	0.04	3.1	12.0	90°	3.9	MB-07G100-00-12R/L	*	*	*	*	*	*	7	3.9	7.4	CoroCut MB
	.039			.002	.002	.122	.472	90°	.154		*	*	*	*	*	*	.276	.154	.291	CoroCut MB
07	1.50			0.04	0.04	1.8	10.0	90°	3.9	MB-07G150-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.059			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	1.50			0.04	0.04	2.8	11.0	90°	3.9	MB-07G150-00-11R					*	*	7	3.9	6.8	CoroCut MB
	.059			.002	.002	.110	.433	90°	.154						*	*	.276	.154	.268	CoroCut MB
07	1.50			0.04	0.04	2.8	11.0	90°	3.9	MB-07G150-00-11R/L	*	*	*	*	*	*	7	3.9	6.8	CoroCut MB
	.059			.002	.002	.110	.433	90°	.154		*	*	*	*	*	*	.276	.154	.268	CoroCut MB
07	1.50			0.04	0.04	3.4	12.0	90°	3.9	MB-07G150-00-12R/L	*	*	*	*	*	*	7	3.9	7.4	CoroCut MB
	.059			.002	.002	.134	.472	90°	.154		*	*	*	*	*	*	.276	.154	.291	CoroCut MB
07	2.00			0.04	0.04	1.8	10.0	90°	3.9	MB-07G200-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.079			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	2.00			0.04	0.04	2.8	11.0	90°	3.9	MB-07G200-00-11R/L	*	*	*	*	*	*	7	3.9	6.8	CoroCut MB
	.079			.002	.002	.110	.433	90°	.154		*	*	*	*	*	*	.276	.154	.268	CoroCut MB
07	2.00			0.04	0.04	3.4	12.0	90°	3.9	MB-07G200-00-12R/L	*	*	*	*	*	*	7	3.9	7.4	CoroCut MB
	.079			.002	.002	.134	.472	90°	.154		*	*	*	*	*	*	.276	.154	.291	CoroCut MB
07	2.50			0.04	0.04	1.8	10.0	90°	3.9	MB-07G250-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.098			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	2.50			0.04	0.04	2.8	11.0	90°	3.9	MB-07G250-00-11R/L	*	*	*	*	*	*	7	3.9	6.8	CoroCut MB
	.098			.002	.002	.110	.433	90°	.154		*	*	*	*	*	*	.276	.154	.268	CoroCut MB
07	3.00			0.04	0.04	1.8	10.0	90°	3.9	MB-07G300-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.118			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	3.00			0.04	0.04	2.8	11.0	90°	3.9	MB-07G300-00-11R/L	*	*	*	*	*	*	7	3.9	6.8	CoroCut MB
	.118			.002	.002	.110	.433	90°	.154		*	*	*	*	*	*	.276	.154	.268	CoroCut MB
07	3.18			0.04	0.04	1.8	10.0	90°	3.9	MB-07G318-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.125			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	3.18			0.04	0.04	2.8	11.0	90°	3.9	MB-07G318-00-11R/L	*	*	*	*	*	*	7	3.9	6.8	CoroCut MB
	.125			.002	.002	.110	.433	90°	.154		*	*	*	*	*	*	.276	.154	.268	CoroCut MB
07	0.73			0.04	0.04	1.2	10.0	90°	3.8	MB-07G070-00-10R/L	*	*	*	*	*	*	7	3.8	5.8	CoroCut MB
	.029			.002	.002	.047	.394	90°	.150		*	*	*	*	*	*	.276	.150	.228	CoroCut MB
07	0.83			0.04	0.04	1.3	10.0	90°	3.8	MB-07G080-00-10R/L	*	*	*	*	*	*	7	3.8	5.8	CoroCut MB
	.033			.002	.002	.051	.394	90°	.150		*	*	*	*	*	*	.276	.150	.228	CoroCut MB
07	0.93			0.04	0.04	1.5	10.0	90°	3.8	MB-07G090-00-10R/L	*	*	*	*	*	*	7	3.8	5.8	CoroCut MB
	.037			.002	.002	.059	.394	90°	.150		*	*	*	*	*	*	.276	.150	.228	CoroCut MB
07	1.20			0.04	0.04	1.8	10.0	90°	3.9	MB-07G120-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.047			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	1.40			0.04	0.04	1.8	10.0	90°	3.9	MB-07G140-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.055			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB
07	1.70			0.04	0.04	1.8	10.0	90°	3.9	MB-07G170-00-10R/L	*	*	*	*	*	*	7	3.9	5.8	CoroCut MB
	.067			.002	.002	.071	.394	90°	.154		*	*	*	*	*	*	.276	.154	.228	CoroCut MB

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



B99



B109



J19

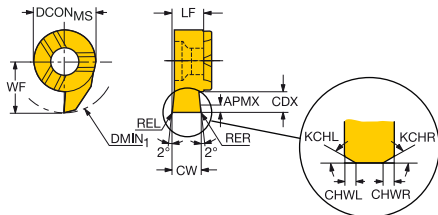


J9



Solid carbide head for grooving

CoroCut MB -size 09



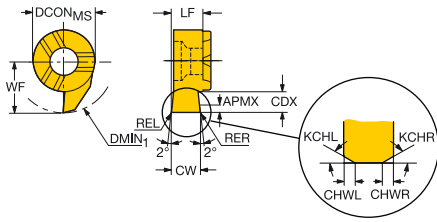
CZC _{MS}	CW	RER	REL	CHWL	CHWR	CDX	DMIN ₁	KAPR	OHX	Ordering code	P M N S O					Dimensions, mm, inch			PRODFAM
											1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
09	1.00			0.04	0.04	4.0	14.0	92°	5.2	MB-09G100-00-14R/L	*	*	*	*	*	9	5.2	9.0	CoroCut MB
	.039			.002	.002	.157	.551	92°	.205		*	*	*	*	*	.354	.205	.354	CoroCut MB
09	1.50			0.04	0.04	4.0	14.0	90°	5.3	MB-09G150-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.059			.002	.002	.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	1.50			0.04	0.04	5.5	16.0	90°	5.2	MB-09G150-00-16R/L	*	*	*	*	*	9	5.2	10.5	CoroCut MB
	.059			.002	.002	.217	.630	90°	.205		*	*	*	*	*	.354	.205	.413	CoroCut MB
09	1.50			0.04	0.04	6.5	17.0	90°	5.2	MB-09G150-00-17R/L	*	*	*	*	*	9	5.2	11.5	CoroCut MB
	.059			.002	.002	.256	.669	90°	.205		*	*	*	*	*	.354	.205	.453	CoroCut MB
09	1.50	0.20	0.20			4.0	16.0	92°	5.3	MB-09G150-02-16R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.059	.008	.008			.157	.630	92°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	2.00			0.04	0.04	4.0	14.0	90°	5.3	MB-09G200-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.079			.002	.002	.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	2.00			0.04	0.04	5.5	16.0	90°	5.2	MB-09G200-00-16R/L	*	*	*	*	*	9	5.2	10.5	CoroCut MB
	.079			.002	.002	.217	.630	90°	.205		*	*	*	*	*	.354	.205	.413	CoroCut MB
09	2.00			0.04	0.04	6.5	17.0	90°	5.2	MB-09G200-00-17R/L	*	*	*	*	*	9	5.2	11.5	CoroCut MB
	.079			.002	.002	.256	.669	90°	.205		*	*	*	*	*	.354	.205	.453	CoroCut MB
09	2.00	0.20	0.20			4.0	14.0	90°	5.3	MB-09G200-02-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.079	.008	.008			.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	2.00	0.20	0.20			5.5	16.0	90°	5.2	MB-09G200-02-16R/L	*	*	*	*	*	9	5.2	10.5	CoroCut MB
	.079	.008	.008			.217	.630	90°	.205		*	*	*	*	*	.354	.205	.413	CoroCut MB
09	2.50			0.04	0.04	4.0	14.0	90°	5.3	MB-09G250-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.098			.002	.002	.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	2.50			0.04	0.04	5.5	16.0	90°	5.2	MB-09G250-00-16R/L	*	*	*	*	*	9	5.2	10.5	CoroCut MB
	.098			.002	.002	.217	.630	90°	.205		*	*	*	*	*	.354	.205	.413	CoroCut MB
09	2.50			0.04	0.04	6.5	17.0	90°	5.2	MB-09G250-00-17R/L	*	*	*	*	*	9	5.2	11.5	CoroCut MB
	.098			.002	.002	.256	.669	90°	.205		*	*	*	*	*	.354	.205	.453	CoroCut MB
09	2.50	0.20	0.20			5.5	16.0	90°	5.2	MB-09G250-02-16R/L	*	*	*	*	*	9	5.2	10.5	CoroCut MB
	.098	.008	.008			.217	.630	90°	.205		*	*	*	*	*	.354	.205	.413	CoroCut MB
09	3.00			0.04	0.04	4.0	14.0	90°	5.3	MB-09G300-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.118			.002	.002	.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	3.00			0.04	0.04	5.5	16.0	90°	5.2	MB-09G300-00-16R/L	*	*	*	*	*	9	5.2	10.5	CoroCut MB
	.118			.002	.002	.217	.630	90°	.205		*	*	*	*	*	.354	.205	.413	CoroCut MB
09	3.00			0.04	0.04	6.5	17.0	90°	5.2	MB-09G300-00-17R/L	*	*	*	*	*	9	5.2	11.5	CoroCut MB
	.118			.002	.002	.256	.669	90°	.205		*	*	*	*	*	.354	.205	.453	CoroCut MB
09	3.00	0.20	0.20			5.5	16.0	90°	5.2	MB-09G300-02-16R/L	*	*	*	*	*	9	5.2	10.5	CoroCut MB
	.118	.008	.008			.217	.630	90°	.205		*	*	*	*	*	.354	.205	.413	CoroCut MB
09	3.18			0.04	0.04	4.0	14.0	92°	5.3	MB-09G318-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.125			.002	.002	.157	.551	92°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	3.18	0.20	0.20			4.0	14.0	92°	5.3	MB-09G318-02-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.125	.008	.008			.157	.551	92°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	0.73			0.04	0.04	1.2	14.0	90°	5.2	MB-09G070-00-14R/L	*	*	*	*	*	9	5.2	9.0	CoroCut MB
	.029			.002	.002	.047	.551	90°	.205		*	*	*	*	*	.354	.205	.354	CoroCut MB
09	0.83			0.04	0.04	1.3	14.0	90°	5.2	MB-09G080-00-14R/L	*	*	*	*	*	9	5.2	9.0	CoroCut MB
	.033			.002	.002	.051	.551	90°	.205		*	*	*	*	*	.354	.205	.354	CoroCut MB
09	0.93			0.04	0.04	1.5	14.0	90°	5.2	MB-09G090-00-14R/L	*	*	*	*	*	9	5.2	9.0	CoroCut MB
	.037			.002	.002	.059	.551	90°	.205		*	*	*	*	*	.354	.205	.354	CoroCut MB
09	1.20			0.04	0.04	4.0	14.0	90°	5.3	MB-09G120-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.047			.002	.002	.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	1.40			0.04	0.04	4.0	14.0	90°	5.3	MB-09G140-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.055			.002	.002	.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
09	1.70			0.04	0.04	4.0	14.0	90°	5.3	MB-09G170-00-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
	.067			.002	.002	.157	.551	90°	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB


CZC_{MS} to correspond with CZC_{WS} on adaptor. R = Right hand, L = Left hand



Solid carbide head for grooving

CoroCut MB -size 11



	CZC _{MS}	CW	RER	REL	CHWL	CHWR	CDX	DMIN ₁	KAPR	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
												1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	11	1.50	0.20	0.20			8.0	20.0	90°	5.6	MB-11G150-02-20R/L	*	*	*	*	*	11	5.6	14.0	CoroCut MB
		.059	.008	.008			.315	.787	90°	.220		*	*	*	*	*	.433	.220	.551	CoroCut MB
	11	2.00	0.20	0.20			8.0	20.0	90°	5.6	MB-11G200-02-20R/L	*	*	*	*	*	11	5.6	14.0	CoroCut MB
		.079	.008	.008			.315	.787	90°	.220		*	*	*	*	*	.433	.220	.551	CoroCut MB
	11	2.50	0.20	0.20			8.0	20.0	90°	5.6	MB-11G250-02-20R/L	*	*	*	*	*	11	5.6	14.0	CoroCut MB
		.098	.008	.008			.315	.787	90°	.220		*	*	*	*	*	.433	.220	.551	CoroCut MB
	11	3.00	0.20	0.20			8.0	20.0	90°	5.6	MB-11G300-02-20R/L	*	*	*	*	*	11	5.6	14.0	CoroCut MB
		.118	.008	.008			.315	.787	90°	.220		*	*	*	*	*	.433	.220	.551	CoroCut MB
	11	3.18	0.20	0.20			8.0	20.0	90°	5.6	MB-11G318-02-20R/L	*	*	*	*	*	11	5.6	14.0	CoroCut MB
		.125	.008	.008			.315	.787	90°	.220		*	*	*	*	*	.433	.220	.551	CoroCut MB
	11	4.00	0.20	0.20			8.0	20.0	90°	5.6	MB-11G400-02-20R/L	*	*	*	*	*	11	5.6	14.0	CoroCut MB
		.157	.008	.008			.315	.787	90°	.220		*	*	*	*	*	.433	.220	.551	CoroCut MB

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



B99



B109



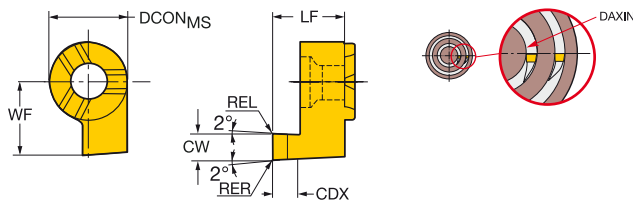
J19



J9

Solid carbide head for face grooving

CoroCut MB -size 09



	CZC _{MS}	CW	RER	REL	CDX	DAXIN	KAPR	OHX	Ordering code	P M N S O					Dimensions, mm, inch			PRODFAM
										1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	09	1.00	0.00	0.00	1.5	12.0	90°	8.3	MB-09FA100-00-14R/L	*	*	*	*	*	9	8.3	9.0	CoroCut MB
		.039	.000	.000	.059	.472	90°	.327		*	*	*	*	*	.354	.327	.354	CoroCut MB
	09	1.50	0.20	0.20	2.5	11.0	90°	8.3	MB-09FA150-02-14R/L	*	*	*	*	*	9	8.3	9.0	CoroCut MB
		.059	.008	.008	.098	.433	90°	.327		*	*	*	*	*	.354	.327	.354	CoroCut MB
	09	2.00	0.20	0.20	5.0	10.0	90°	10.3	MB-09FA200-02-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB
		.079	.008	.008	.197	.394	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB
	09	2.50	0.20	0.20	5.0	9.0	90°	10.3	MB-09FA250-02-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB
		.098	.008	.008	.197	.354	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB
09	3.00	0.20	0.20	5.0	8.0	90°	10.3	MB-09FA300-02-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB	
	.118	.008	.008	.197	.315	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB	
09	3.18	0.20	0.20	5.0	7.6	90°	10.3	MB-09FA318-02-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB	
	.125	.008	.008	.197	.301	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB	
	09	1.00	0.50	0.50	1.5	12.0	90°	8.3	MB-09FAR100-05-14R/L	*	*	*	*	*	9	8.3	9.0	CoroCut MB
		.039	.020	.020	.059	.472	90°	.327		*	*	*	*	*	.354	.327	.354	CoroCut MB
	09	1.50	0.75	0.75	2.5	11.0	90°	8.3	MB-09FAR150-075-14R/L	*	*	*	*	*	9	8.3	9.0	CoroCut MB
		.059	.030	.030	.098	.433	90°	.327		*	*	*	*	*	.354	.327	.354	CoroCut MB
	09	2.00	1.00	1.00	5.0	10.0	90°	10.3	MB-09FAR200-10-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB
		.079	.039	.039	.197	.394	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB
	09	2.50	1.25	1.25	5.0	9.0	90°	10.3	MB-09FAR250-125-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB
		.098	.049	.049	.197	.354	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB
09	3.00	1.50	1.50	5.0	8.0	90°	10.3	MB-09FAR300-15-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB	
	.118	.059	.059	.197	.315	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB	
	09	1.00	0.00	0.00	1.5	10.0	90°	8.3	MB-09FB100-00-14R/L	*	*	*	*	*	9	8.3	7.0	CoroCut MB
		.039	.000	.000	.059	.394	90°	.327		*	*	*	*	*	.354	.327	.276	CoroCut MB
	09	1.50	0.20	0.20	2.5	9.0	90°	8.3	MB-09FB150-02-14R/L	*	*	*	*	*	9	8.3	7.5	CoroCut MB
		.059	.008	.008	.098	.354	90°	.327		*	*	*	*	*	.354	.327	.295	CoroCut MB
	09	2.00	0.20	0.20	5.0	8.0	90°	10.3	MB-09FB200-02-14R/L	*	*	*	*	*	9	10.3	8.0	CoroCut MB
		.079	.008	.008	.197	.315	90°	.406		*	*	*	*	*	.354	.406	.315	CoroCut MB
	09	2.50	0.20	0.20	5.0	7.0	90°	10.3	MB-09FB250-02-14R/L	*	*	*	*	*	9	10.3	8.5	CoroCut MB
		.098	.008	.008	.197	.276	90°	.406		*	*	*	*	*	.354	.406	.335	CoroCut MB
09	3.00	0.20	0.20	5.0	6.0	90°	10.3	MB-09FB300-02-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB	
	.118	.008	.008	.197	.236	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB	
09	3.18	0.20	0.20	5.0	5.6	90°	10.3	MB-09FB318-02-12R/L	*	*	*	*	*	9	10.3	9.2	CoroCut MB	
	.125	.008	.008	.197	.222	90°	.406		*	*	*	*	*	.354	.406	.361	CoroCut MB	
	09	1.00	0.50	0.50	1.5	10.0	90°	8.3	MB-09FBR100-05-12R/L	*	*	*	*	*	9	8.3	7.0	CoroCut MB
		.039	.020	.020	.059	.394	90°	.327		*	*	*	*	*	.354	.327	.276	CoroCut MB
	09	1.50	0.75	0.75	2.5	9.0	90°	8.3	MB-09FBR150-075-14R/L	*	*	*	*	*	9	8.3	7.5	CoroCut MB
		.059	.030	.030	.098	.354	90°	.327		*	*	*	*	*	.354	.327	.295	CoroCut MB
	09	2.00	1.00	1.00	5.0	8.0	90°	10.3	MB-09FBR200-10-14R/L	*	*	*	*	*	9	10.3	8.0	CoroCut MB
		.079	.039	.039	.197	.315	90°	.406		*	*	*	*	*	.354	.406	.315	CoroCut MB
	09	2.50	1.25	1.25	5.0	7.0	90°	10.3	MB-09FBR250-125-14R/L	*	*	*	*	*	9	10.3	8.5	CoroCut MB
		.098	.049	.049	.197	.276	90°	.406		*	*	*	*	*	.354	.406	.335	CoroCut MB
09	3.00	1.50	1.50	5.0	6.0	90°	10.3	MB-09FBR300-15-14R/L	*	*	*	*	*	9	10.3	9.0	CoroCut MB	
	.118	.059	.059	.197	.236	90°	.406		*	*	*	*	*	.354	.406	.354	CoroCut MB	

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



B99



B109



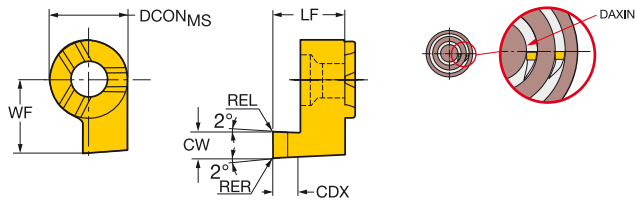
J19



J9

Solid carbide head for face grooving

CoroCut MB -size 11



	CZC _{MS}	CW	RER	REL	CDX	DAXIN	OHX	Ordering code	P M N S O				Dimensions, mm, inch			PRODFAM	
									1025	1025	1025	1025	DCON _{MS}	LF	WF		
	11	3.00	0.20	0.20	10.0	10.0	15.8	MB-11FA300-02-16R/L	*	*	*	*	*	11	15.8	11.0	CoroCut MB
		.118	.008	.008	.394	.394	.622		*	*	*	*	*	.433	.622	.433	CoroCut MB
	11	4.00	0.20	0.20	10.0	8.0	15.8	MB-11FA400-02-16R/L	*	*	*	*	*	11	15.8	11.5	CoroCut MB
		.157	.008	.008	.394	.315	.622		*	*	*	*	*	.433	.622	.453	CoroCut MB
	11	3.00	0.20	0.20	10.0	10.0	15.8	MB-11FB300-02-16R/L	*	*	*	*	*	11	15.8	11.0	CoroCut MB
		.118	.008	.008	.394	.394	.622		*	*	*	*	*	.433	.622	.433	CoroCut MB
	11	4.00	0.20	0.20	10.0	8.0	15.8	MB-11FB400-02-16R/L	*	*	*	*	*	11	15.8	12.0	CoroCut MB
		.157	.008	.008	.394	.315	.622		*	*	*	*	*	.433	.622	.472	CoroCut MB

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



B99



B109



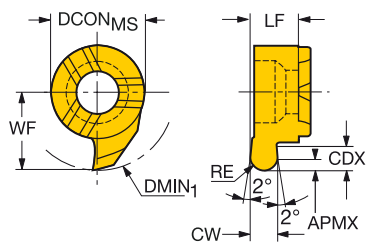
J19



J9



Solid carbide head for profiling



CoroCut MB -size 07

	CZC _{MS}	CW	RE	CDX	DMIN ₁	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
								1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	07	0.80	0.4	1.8	10.0	3.9	MB-07R080-04-10R/L	*	*	*	*	*	7	3.9	5.8	CoroCut MB
		.031	.016	.071	.394	.154		*	*	*	*	*	.276	.154	.228	CoroCut MB
	07	1.20	0.6	1.8	10.0	3.9	MB-07R120-06-10R/L	*	*	*	*	*	7	3.9	5.8	CoroCut MB
		.047	.024	.071	.394	.154		*	*	*	*	*	.276	.154	.228	CoroCut MB
	07	1.80	0.9	1.8	10.0	3.9	MB-07R180-09-10R/L	*	*	*	*	*	7	3.9	5.8	CoroCut MB
		.071	.035	.071	.394	.154		*	*	*	*	*	.276	.154	.228	CoroCut MB
	07	2.00	1.0	1.8	10.0	3.9	MB-07R200-10-10R/L	*	*	*	*	*	7	3.9	5.8	CoroCut MB
		.079	.039	.071	.394	.154		*	*	*	*	*	.276	.154	.228	CoroCut MB

CoroCut MB -size 09

	CZC _{MS}	CW	RE	CDX	DMIN ₁	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
								1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	09	0.80	0.4	1.8	14.0	5.2	MB-09R080-04-14R/L	*	*	*	*	*	9	5.2	9.0	CoroCut MB
		.031	.016	.071	.551	.205		*	*	*	*	*	.354	.205	.354	CoroCut MB
	09	1.20	0.6	4.0	14.0	5.3	MB-09R120-06-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
		.047	.024	.157	.551	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
	09	1.80	0.9	4.0	14.0	5.3	MB-09R180-09-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
		.071	.035	.157	.551	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
	09	2.00	1.0	4.0	14.0	5.3	MB-09R200-10-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
		.079	.039	.157	.551	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB
	09	2.20	1.1	4.0	14.0	5.3	MB-09R220-11-14R/L	*	*	*	*	*	9	5.3	9.0	CoroCut MB
		.087	.043	.157	.551	.209		*	*	*	*	*	.354	.209	.354	CoroCut MB

CoroCut MB -size 11

	CZC _{MS}	CW	RE	CDX	DMIN ₁	OHX	Ordering code	P	M	N	S	O	Dimensions, mm, inch			PRODFAM
								1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	
	11	3.00	1.5	6.0	18.0	5.6	MB-11R300-15-18R/L	*	*	*	*	*	11	5.6	12.0	CoroCut MB
		.118	.059	.236	.709	.220		*	*	*	*	*	.433	.220	.472	CoroCut MB
	11	3.18	1.6	6.0	18.0	5.6	MB-11R318-16-18R/L	*	*	*	*	*	11	5.6	12.0	CoroCut MB
		.125	.063	.236	.709	.220		*	*	*	*	*	.433	.220	.472	CoroCut MB
	11	4.00	2.0	6.0	18.0	5.6	MB-11R400-20-18R/L	*	*	*	*	*	11	5.6	12.0	CoroCut MB
		.157	.079	.236	.709	.220		*	*	*	*	*	.433	.220	.472	CoroCut MB

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



B99



B109



J19



J9

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO P	CMC No.	Steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CT525	GC3115	GC4325
MC No.	CMC No.	Material	N/mm ²	HB	$h_{ex}, \text{mm} = \text{feed } f_n, \text{mm/r}$		
					Cutting speed (v_c), m/min		
P1.1.Z.AN	01.1	C = 0.1–0.25%	1500	125	235-170	355-185	340-180
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	220-155	330-140	315-140
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	210-145	300-125	290-120
P2.1.Z.AN	02.1	Low-alloy ≤5% Non-hardened	1700	180	205-145	290-135	280-130
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	185-120	270-105	265-100
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	150-100	220-85	215-80
P3.0.Z.AN	03.11	High-alloy >5% Annealed	1950	200	130-100	260-115	255-105
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	80-55	205-75	195-75
P1.5.C.UT	06.1	Castings Unalloyed	1550	180	150-100	175-75	165-70
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	135-85	200-90	190-85
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	115-70	160-75	130-95
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	2900	250	75-50	90-50	85-45
ISO M	CMC No.	Stainless steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
MC No.	CMC No.	Material	N/mm ²	HB	CT525	GC1105	GC1005
					$h_{ex}, \text{mm} = \text{feed } f_n, \text{mm/r}$		
Cutting speed (v_c), m/min							
P5.0.Z.AN	05.11	Ferritic/martensitic Bars/forged Non-hardened	1800	200	195-135	235-110	400-175
P5.0.Z.PH	05.12	PH-hardened	2850	330	135-95	185-85	215-95
P5.0.Z.HT	05.13	Hardened	2350	330	150-100	200-90	255-110
M1.0.Z.AQ	05.21	Austenitic Bars/forged	1800	180	190-130	265-125	435-190
M1.0.Z.PH	05.22	PH-hardened	2850	330	115-80	185-90	235-100
M2.0.Z.AQ	05.23	Super austenitic	2250	200	130-90	200-95	260-115
M3.1.Z.AQ	05.51	Austenitic-ferritic (Duplex) Bars/forged Non-weldable ≥ 0.05%C	2000	230	115-90	225-105	335-145
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	90-70	185-90	300-130
P5.0.C.UT	15.11	Ferritic/martensitic Cast Non-hardened	1700	200	165-115	-	-
P5.0.C.HT	15.13	Hardened	2150	330	110-75	-	-
M1.0.C.UT	15.21	Austenitic Cast	1700	180	160-110	-	-
	15.22	PH-hardened	2450	330	95-65	-	-
M3.1.C.AQ	15.51	Austenitic-ferritic (Duplex) Cast Non-weldable ≥ 0.05%C	1800	230	100-80	-	-
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	80-60	-	-
ISO K	CMC No.	Cast iron	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
MC No.	CMC No.	Material	N/mm ²	HB	GC3115	GC4225	GC1125
					$h_{ex}, \text{mm} = \text{feed } f_n, \text{mm/r}$		
Cutting speed (v_c), m/min							
K1.1.C.NS	07.1	Malleable Ferritic (short chipping)	790	130	340-170	320-170	255-125
	07.2	Pearlitic (long chipping)	900	230	250-115	235-110	170-95
K2.1.C.UT	08.1	Grey Low tensile strength	890	180	290-140	275-130	210-110
K2.2.C.UT	08.2	High tensile strength	970	220	250-120	240-115	175-90
K3.1.C.UT	09.1	Nodular SG iron Ferritic	900	160	260-115	250-105	185-95
K3.3.C.UT	09.2	Pearlitic	1350	250	205-100	195-90	150-75
K3.4.C.UT	09.3	Martensitic	2100	380	145-70	140-70	100-55

PARTING AND GROOVING

Cutting data

							TOUGHNESS >>>>
GC1115	GC1125	GC1025	GC1135	GC1145	GC235		
0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5		
360-180 325-145 290-130	295-145 265-115 235-105	235-115 210-90 185-85	205-100 180-75 175-70	200-100 185-75 175-70	165-130 150-120 140-105		
290-135 250-115 200-95	235-110 205-95 165-75	185-85 165-75 135-60	175-80 155-70 125-55	180-85 165-70 130-55	140-110 120-85 95-70		
255-115 185-75	205-95 150-65	170-75 120-50	155-70 105-45	160-75 105-45	70-60 45-33		
- - - -	135-65 160-85 120-50 70-40	110-55 130-65 80-45 55-30	105-50 120-60 90-40 50-29	110-50 125-65 85-38 -	100-70 90-55 80-45 100-80		
							TOUGHNESS >>>>
GC1115	GC1125	GC1025	GC1135	GC1145	GC235	H13A	
0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	
235-110 185-85 200-90	190-85 150-65 160-70	160-70 120-55 130-55	145-65 110-45 120-50	150-60 110-45 125-50	130-100 90-70 100-75	90-70 60-40 70-50	
265-125 185-90 200-95	215-100 150-70 160-75	175-80 120-55 130-60	165-70 105-50 115-55	165-65 110-50 105-50	125-95 75-55 85-65	100-65 50-33 65-45	
225-105 185-90	180-85 150-70	145-70 120-55	135-60 110-50	145-60 115-50	125-95 95-70	- -	
215-100 -	175-80 145-65	140-65 120-50	130-60 110-45	140-55 115-45	110-85 70-55	75-60 50-38	
230-110 150-80	185-90 120-65	150-70 95-50	135-60 90-45	145-60 90-45	105-80 65-50	70-45 45-29	
195-95 155-80	155-75 125-65	125-60 105-50	115-55 95-45	120-55 95-45	110-85 85-60	- -	
							TOUGHNESS >>>>
GC1025	H13A	GC1135					
0.05-0.5	0.05-0.5	0.05-0.5					
205-100 140-75	100-85 70-55	320-170 235-110					
170-85 140-70	80-65 80-60	275-130 240-115					
150-80 120-60 85-45	70-55 60-45 40-30	250-105 195-90 140-70					

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO N	CMC No.	Non-ferrous material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CD10	GC1005	H10
MC No.	CMC No.	Material	N/mm ²	HB	$h_{ex}, \text{mm} = \text{feed } f_n, \text{mm/r}$		
					0.05-0.5	0.06-0.31	0.05-0.8
					Cutting speed (v_c), m/min		
N1.2.Z.UT N1.2.Z.AG	30.11 30.12	Aluminium alloys Wrought or wrought and coldworked, non-aging	400 650	60 100	2100 (2650 - 265) 2100 (2650 - 265)	1900 (2400 - 240) 1900 (2400 - 240)	1800 (2250-225) 1800 (2250-225)
N1.3.C.UT N1.3.C.AG	30.21 30.22	Aluminium alloys Cast, non aging Cast or cast and aged	600 700	75 90	2100 (2650 - 265) 2100 (2650 - 265)	1900 (2400 - 240) 1900 (2400 - 240)	1800 (2250-225) 1800 (2250-225)
N1.4.C.NS	30.41 30.42	Aluminium alloys Cast, 13-15% Si Cast, 16-22% Si	700 700	130 130	1600 (2000 - 200) 800 (1000 - 100)	500 (630 - 65) 350 (440 - 45)	450 (560-55) 300 (375-38)
N3.3.U.UT N3.2.C.UT N3.1.U.UT	33.1 33.2 33.3	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb Brass, leaded bronzes, $\leq 1\%$ Pb Bronze and non-leaded copper incl. electrolytic copper	550 550 1350	110 90 100	600 (750 - 75) 600 (750 - 75) 300 (375 - 38)	500 (630 - 65) 500 (630 - 65) 300 (375 - 38)	500 (630-65) 500 (630-65) 300 (375-38)
ISO S	CMC No.	Heat resistant super alloys	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					S05F	GC1105	GC1005
MC No.	CMC No.	Material	N/mm ²	HB	$h_{ex}, \text{mm} = \text{feed } f_n, \text{mm/r}$		
					0.05-0.3	0.05-0.3	0.05-0.3
					Cutting speed (v_c), m/min		
S1.0.U.AN S1.0.U.AG	20.11 20.12	Iron base Annealed or solution treated Aged or solution treated and aged	2400 2500	200 280	200-135 165-110	180-120 150-100	70-38 150-100
S2.0.Z.AN S2.0.Z.AG	20.21 20.22	Nickel base Annealed or solution treated Aged or solution treated and aged	2650 2900	250 350	100-60 90-60	90-55 80-50	90-55 80-50
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	80-50	70-45	70-45
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31 20.32 20.33	Cobalt alloys Annealed or solution treated Solution treated and aged Cast or cast and aged	2700 3000 3100	200 300 320	100-65 90-55 80-50	90-60 80-50 70-45	90-60 80-50 70-45
S4.1.Z.UT S4.2.Z.AN S4.3.Z.AG	23.1 23.21 23.22	Titanium alloys Commercial pure (99.5% Ti) α , near α and $\alpha + \beta$ alloys, annealed $\alpha + \beta$ alloys in aged conditions, β alloys, annealed or aged	1300 1400 1400	Rm ¹⁾ 400 950 1050	- - -	- - -	- - -
ISO H	CMC No.	Material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CB20	CC670	CB7015
MC No.	CMC No.	Hardened material	N/mm ²	HB	$h_{ex}, \text{mm} = \text{feed } f_n, \text{mm/r}$		
					0.05-0.1	0.05-0.1	0.05-0.1
					Cutting speed (v_c), m/min		
H1.3.Z.HA	04.1	Extra hard steel Hardened and tempered	4300	60 HRC	125-120	110-100	145-135
H2.0.C.UT	10.1	Chilled Cast or cast and aged	2250	400	200-195	110-100	-

1) Rm = ultimate tensile strength measured in MPa.

PARTING AND GROOVING

Cutting data

TOUGHNESS >>>>									
GC1125	GC1025	H13A							
0.05-0.8	0.05-0.8	0.05-0.8							
1500 (1900 - 190) 1500 (1900 - 190)	1500 (1900 - 190) 1500 (1900 - 190)	1500 (1900 - 190) 1500 (1900 - 190)							
1500 (1900 - 190) 1500 (1900 - 190)	1500 (1900 - 190) 1500 (1900 - 190)	1500 (1900 - 190) 1500 (1900 - 190)							
400 (500 - 50) 250 (315 - 31)	400 (500 - 50) 250 (315 - 31)	400 (500 - 50) 250 (315 - 31)							
350 (440 - 45) 400 (500 - 50) 250 (315 - 31)	350 (440 - 45) 400 (500 - 50) 250 (315 - 31)	350 (440 - 45) 400 (500 - 50) 250 (315 - 31)							
TOUGHNESS >>>>									
H10	GC1115	GC1125	GC1025	H13A	GC1135	GC1145	GC235	CC670	CB7015
0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3
- -	100-55 70-40	80-45 55-33	60-35 45-28	50-37 40-26	50-29 40-26	45-34 45-30	50-37 40-26	- -	- -
- -	65-40 60-32	50-32 45-26	45-28 40-22	30-23 20-13	40-26 35-21	29-23 19-13	30-23 20-13	600-320 500-250	400-300 350-250
-	45-23	35-18	30-16	20-13	25-10	20-13	20-13	250-120	200-125
- - -	70-50 60-32 45-23	55-38 45-26 35-18	50-33 40-22 30-16	35-27 23-15 20-13	45-28 35-17 25-14	34-23 23-12 19-13	35-27 23-15 20-13	410-220 350-210 320-150	250-150 250-150 200-125
190-150 80-60 70-55	310-140 100-55 95-45	220-100 80-45 75-37	190-95 65-37 60-32	175-145 70-60 65-55	170-80 65-35 60-30	- - -	- - -	- - -	- - -
TOUGHNESS >>>>									

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO P	CMC No.	Steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CT525	GC3115	GC4325
					h_{ex} , inch = feed, f_n inch/r		
MC No.	Material	lbs/in ²	HB	Cutting speed (V_c) ft/min			
P1.1.Z.AN	01.1	C = 0.1–0.25%	216,500	125	770-550	1150-610	1100-590
P1.2.Z.AN	01.2	C = 0.25–0.55%	233,000	150	720-510	1050-460	1050-460
P1.3.Z.AN	01.3	C = 0.55–0.80%	247,000	170	690-475	980-405	950-395
P2.1.Z.AN	02.1	Low-alloy ≤5% Non-hardened	249,500	180	670-475	950-440	920-415
P2.5.Z.HT	02.2	Hardened and tempered	268,000	275	600-400	880-335	860-320
P2.5.Z.HT	02.2	Hardened and tempered	298,000	350	485-320	710-270	700-255
P3.5.Z.AN	03.11	High-alloy >5% Annealed	282,000	200	425-320	840-375	830-345
P3.5.Z.HT	03.21	Hardened tool steel	435,000	325	260-180	670-245	640-235
P1.5.C.UT	06.1	Castings Unalloyed	225,000	180	490-330	570-235	540-230
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230,500	200	440-280	650-290	620-280
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	300,500	225	375-230	520-245	425-315
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	420,500	250	245-165	290-155	275-145
ISO M	CMC No.	Stainless steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CT525	GC1105	GC1005
					h_{ex} , inch = feed, f_n inch/r		
					.002-.020	.002-.020	.002-.020
MC No.	Material	lbs/in ²	HB	Cutting speed (V_c) ft/min			
P5.0.Z.AN	05.11	Ferritic/martensitic Bars/forged Non-hardened	262,000	200	640-440	770-360	1300-570
P5.0.Z.PH	05.12	PH-hardened	411,500	330	450-310	610-280	710-305
P5.0.Z.HT	05.13	Hardened	340,000	330	485-330	660-295	840-365
M1.0.Z.AQ	05.21	Austenitic Bars/forged	259,000	180	620-430	870-410	1450-610
M1.0.Z.PH	05.22	PH-hardened	414,000	330	370-255	610-295	770-330
M2.0.Z.AQ	05.23	Super austenitic	328,000	200	420-290	660-315	860-370
M3.1.Z.AQ	05.51	Austenitic-ferritic (Duplex) Bars/forged Non-weldable ≥ 0.05%C	286,500	230	375-295	740-345	1100-475
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	295-225	610-295	980-420
P5.0.C.UT	15.11	Ferritic/martensitic Cast Non-hardened	246,500	200	540-375	-	-
P5.0.C.HT	15.13	Hardened	311,000	330	355-245	-	-
M1.0.C.UT	15.21	Austenitic Cast	248,000	180	520-360	-	-
	15.22	PH-hardened	356,000	330	320-220	-	-
M3.1.C.AQ	15.51	Austenitic-ferritic (Duplex) Cast Non-weldable ≥ 0.05%C	258,000	230	335-260	-	-
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,500	260	260-200	-	-
ISO K	CMC No.	Cast iron	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC3115	GC4325	GC1125
					h_{ex} , inch = feed, f_n inch/r		
					.002-.020	.002-.020	.002-.020
MC No.	Material	lbs/in ²	HB	Cutting speed (V_c) ft/min			
K1.1.C.NS	07.1	Malleable Ferritic (short chipping)	115,000	130	1100-560	1050-550	830-415
	07.2	Pearlitic (long chipping)	131,000	230	810-370	760-350	560-310
K2.1.C.UT	08.1	Grey Low tensile strength	130,000	180	950-450	900-430	680-365
K2.2.C.UT	08.2	High tensile strength	140,500	220	810-395	780-370	570-295
K3.1.C.UT	09.1	Nodular SG iron Ferritic	130,000	160	850-375	810-350	600-320
K3.3.C.UT	09.2	Pearlitic	194,500	250	670-325	640-300	485-250
K3.4.C.UT	09.3	Martensitic	307,500	380	470-230	450-220	330-180

A

PARTING AND GROOVING

Cutting data

ENG

B

TOUGHNESS >>>>						
GC1115	GC1125	GC1025	GC1135	GC1145	GC235	
.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	

C

1200-580 1050-470 950-415	960-475 860-380 770-340	770-370 680-295 610-270	670-330 590-250 570-235	650-330 600-245 570-225	530-430 490-385 460-345	
940-450 820-375 660-305	770-365 660-305 530-245	600-280 540-245 435-195	570-260 500-220 400-180	580-275 530-230 425-185	460-355 390-275 315-220	
830-380 600-250	670-305 490-205	550-250 395-160	500-225 335-140	520-235 350-140	230-205 145-110	
- - -	440-210 520-275 395-170	365-175 425-220 265-155	335-160 390-200 295-130	360-170 410-205 280-120	325-220 295-185 260-155	
-	225-130	180-95	160-95	-	325-260	

D

TOUGHNESS >>>>						
GC1115	GC1125	GC1025	GC1135	GC1145	GC235	H13A
.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	.002-.020

E

770-355 600-275 650-295	620-285 480-220 520-235	520-230 385-170 420-185	470-210 350-150 385-165	485-195 365-150 410-170	425-320 300-225 320-245	295-225 195-130 220-170
870-415 600-290 650-315	700-335 485-230 520-250	570-270 385-180 415-200	530-230 340-160 370-180	530-215 355-165 335-160	415-315 245-185 280-210	320-215 160-110 215-145

F

730-350 610-295	580-280 490-235	475-225 390-185	440-190 360-165	470-195 375-165	410-310 310-230	- -
700-325 -	560-260 470-215	455-205 390-170	425-190 360-150	450-175 375-150	360-275 235-180	250-190 165-125
750-365 495-260	600-290 395-205	485-230 310-160	445-190 295-145	470-195 300-140	350-265 210-160	230-155 140-95

G

640-305 510-265	510-245 405-210	410-190 335-165	375-170 300-145	- -	365-275 270-205	- -
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H

TOUGHNESS >>>>						
GC1025	H13A	GC1135				
.002-.020	.002-.020	.002-0.020				
670-325 455-255	325-275 230-175	1050-550 760-350				
560-280 460-235	265-210 260-200	900-430 780-370				
490-225 390-200 270-140	230-175 195-145 135-100	810-350 640-300 450-220				

I

J

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO N	CMC No.	Non-ferrous material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CD10	GC1005	H10
					$h_{ex}, \text{inch} \approx \text{feed}, f_n \text{inch/r}$		
					Cutting speed (V_c) ft/min		
MC No.	CMC No.	Material	lbs/in ²	HB			
N1.2.Z.UT N1.2.Z.AG	30.11 30.12	Aluminium alloys Wrought or wrought and coldworked, non-aging	58,000 94,500	60 100	6900 (8650-860) 6900 (8650-860)	6250 (7800-780) 6250 (7800-780)	5900 (7400-740) 5900 (7400-740)
N1.3.C.UT N1.3.C.AG	30.21 30.22	Aluminium alloys Cast, non aging Cast or cast and aged	87,000 101,500	75 90	6900 (8650-860) 6900 (8650-860)	6250 (7800-780) 6250 (7800-780)	5900 (7400-740) 5900 (7400-740)
N1.4.C.NS	30.41 30.42	Cast, 13-15% Si Cast, 16-22% Si	101,500 101,500	130 130	5250 (6550-660) 2600 (3250-325)	1650 (2050-205) 1150 (1450-145)	1500 (1900-190) 980 (1250-125)
N3.3.U.UT N3.2.C.UT N3.1.U.UT	33.1 33.2 33.3	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb Brass, leaded bronzes, $\leq 1\%$ Pb Bronze and non-leaded copper incl. electrolytic copper	79,500 80,000 196,000	110 90 100	1950 (2450-245) 1950 (2450-245) 980 (1250-125)	1650 (2050-205) 1650 (2050-205) 980 (1250-125)	1650 (2050-205) 1650 (2050-205) 980 (1250-125)
ISO S	CMC No.	Heat resistant super alloys	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					S05F	GC1105	GC1005
					$h_{ex}, \text{inch} \approx \text{feed}, f_n \text{inch/r}$		
					Cutting speed (V_c) ft/min		
MC No.	CMC No.	Material	lbs/in ²	HB			
S1.0.U.AN S1.0.U.AG	20.11 20.12	Iron base Annealed or solution treated Aged or solution treated and aged	348,000 359,000	200 280	660-435 550-360	590-385 490-320	590-385 490-320
S2.0.Z.AN S2.0.Z.AG	20.21 20.22	Nickel base Annealed or solution treated Aged or solution treated and aged	383,000 420,500	250 350	330-200 295-200	295-185 265-165	295-185 265-165
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	255-160	235-150	235-150
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31 20.32 20.33	Cobalt alloys Annealed or solution treated Solution treated and aged Cast or cast and aged	391,500 432,000 450,500	200 300 320	330-215 295-180 255-160	295-185 265-165 235-150	295-185 265-165 235-150
Titanium S4.1.Z.UT	23.1	Commercial pure (99.5% Ti)	188,500	Rm¹⁾ 400	-	-	-
S4.2.Z.AN	23.21	Titanium alloys α , near α and $\alpha + \beta$ alloys, annealed	203,000	950	-	-	-
S4.3.Z.AG	23.22	$\alpha + \beta$ alloys in aged condition, β alloys, annealed or aged	203,000	1050	-	-	-
ISO H	CMC No.	Hardened material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CB20	CC670	CB7015
					$h_{ex}, \text{inch} \approx \text{feed}, f_n \text{inch/r}$		
					Cutting speed (V_c) ft/min		
MC No.	CMC No.	Material	lbs/in ²	HB			
H1.3.Z.HA	04.1	Extra hard steel Hardened and tempered	625,500	60 HRC	420-400	355-320	475-450
H2.0.C.UT	10.1	Chilled Cast or cast and aged	326,500	400	650-640	360-325	-

1) Rm = ultimate tensile strength measured in MPa.

PARTING AND GROOVING

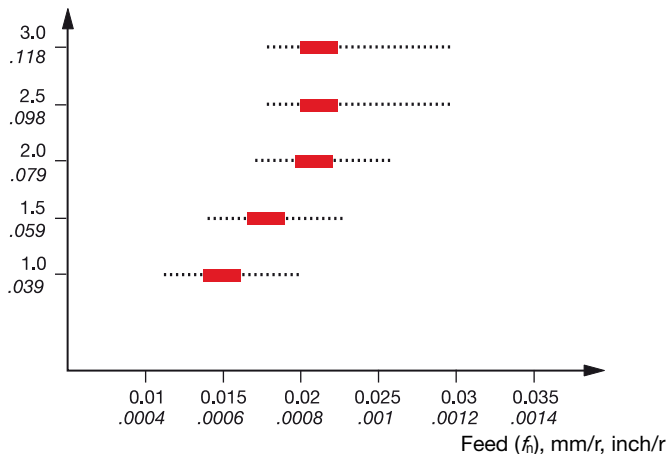
Cutting data

TOUGHNESS >>>>									
GC1125	GC1025	H13A							
.002-.031	002-.031	.002-.031							
4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)							
4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)							
1300 (1650-165) 820 (1050-105)	1300 (1650-165) 820 (1050-105)	1300 (1650-165) 820 (1050-105)							
1150 (1450-145) 1300 (1650-165) 820 (1050-105)	1150 (1450-145) 1300 (1650-165) 820 (1050-105)	1150 (1450-145) 1300 (1650-165) 820 (1050-105)							
TOUGHNESS >>>>									
H10	GC1115	GC1125	GC1025	H13A	GC1135	GC1145	GC235	CC670	CB7015
.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012
- -	330-180 235-135	260-140 185-110	195-115 145-90	165-120 130-85	165-95 130-85	150-145 115-75	165-120 130-85	- -	- -
- -	215-130 190-105	170-105 150-85	145-90 130-75	100-75 65-45	130-85 115-70	95-75 65-40	100-75 65-45	1950-1050 1650-810	1300-980 1150-820
-	140-75	115-60	100-50	65-45	80-31	65-40	65-45	820-390	650-410
- - -	235-155 190-105 140-75	185-125 150-85 115-60	165-110 130-75 100-50	115-90 75-50 65-45	145-90 115-55 80-45	115-75 75-37 65-40	115-90 75-50 65-45	1350-720 1150-680 1050-490	820-490 820-490 650-410
620-485	1000-455	720-325	620-310	570-470	550-265	-	-	-	-
255-195	330-180	265-140	210-120	235-190	-	-	-	-	-
230-180	310-155	245-120	200-105	215-175	-	-	-	-	-
TOUGHNESS >>>>									

CoroTurn® XS

Grooving and face grooving

Insert width (W1), mm

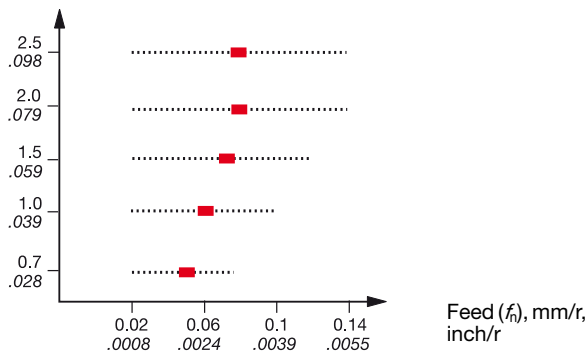


■ = Recommended starting value.

CoroCut® XS

Parting off

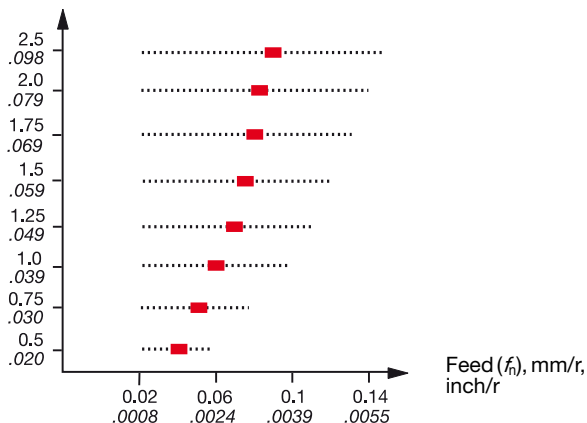
Insert width (CW), mm, inch



■ = Recommended starting value.

Grooving

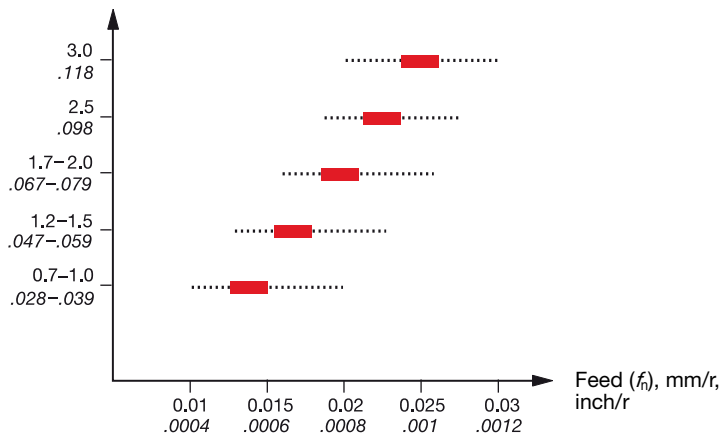
Insert width (CW), mm, inch



CoroCut® MB

Grooving and face grooving

Insert width (CW), mm, inch



■ = Recommended starting value.

Cutting speed recommendations

Cutting speed (v_c), m/min

Grade	P	M	N	S
Grade 1025	60-200	60-180	90-400	20-50

Grade	H
Grade CB7015	60-200

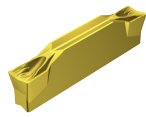
A

CoroCut® 1-2

ENG

Parting

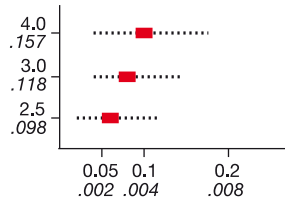
B



123-CF

**Radial feed**

Insert width (CW), mm, inch



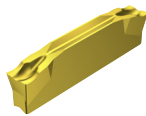
Low feed choice

Feed (f_r), mm/r, inch/r**Positive geometry for low feed**

First choice for thin walled components and small diameters.

Small corner radii and positive geometry reduce pip and burr on component in stainless steel and sticky materials. Wiper corners for high surface finish.

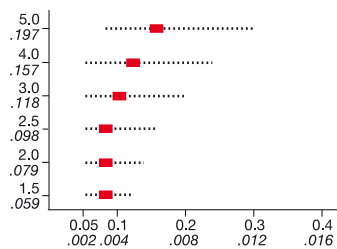
D



123-CM

Radial feed

Insert width (CW), mm, inch



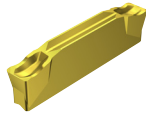
Medium feed choice

Feed (f_r), mm/r, inch/r**First choice, universal geometry**

First choice for parting off to centre at good conditions in most materials and light intermittent applications such as parting hexagonal bars.

E

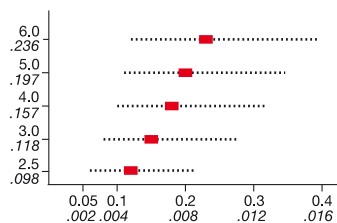
F



123-CR

Radial feed

Insert width (CW), mm, inch



High feed choice

Feed (f_r), mm/r, inch/r**Rough machining**

Strong cutting edges, reduce risk of edge fractures.

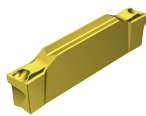
Suitable for parting off bars and interrupted cuts.

For steel and cast iron, but also suitable for stainless steels when there is a need for strong edges.

Available as CoroCut 1 and 2-edged inserts.

G

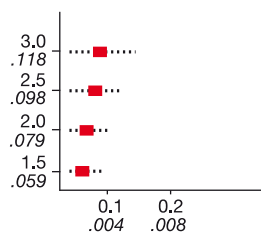
H



123-CS

Radial feed

Insert width (CW), inch



Low feed

Feed (f_r), mm/r, inch/r

■ = Recommended starting value.

For cutting speed recommendations, see page B91**Pip and burr free machining.**

Ideal solution for minimizing pips and burrs on components thanks to the sharp cutting edge and front angles of 10° and 15°.

Recommended for small components.

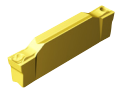
Suitable for free cutting steel.

Available as CoroCut 2-edge inserts.

J

CoroCut® 1-2

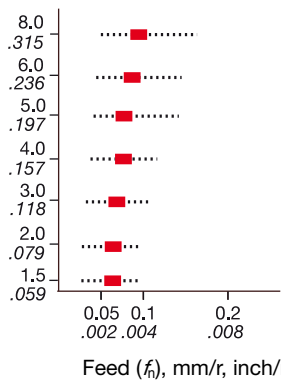
Grooving



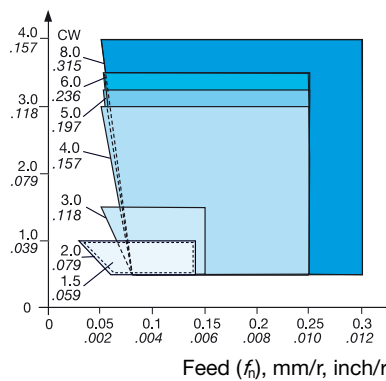
123-GF

Low feed choice

Radial feed
Insert width (CW), mm, inch



Axial feed
Cutting depth (a_p), mm, inch



For precision grooves

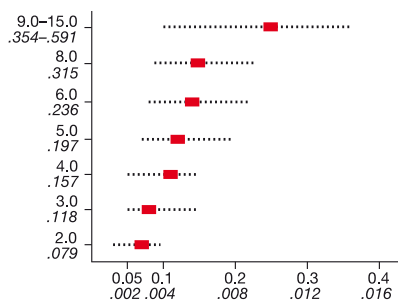
Good accuracy and repeatability due to tight tolerances on inserts.
 Low cutting forces and good surface finishing due to sharp cutting edge.
 Large number of different widths.
 Designed for side turning.
 Available as CoroCut 2-edge inserts.
 Can be ordered as Tailor Made with different insert width and corner radii.



123-GM

Medium feed choice

Radial feed
Insert width (CW), mm, inch



Grooving in all materials

Outstanding chip control.
 Reduces chip width giving good surfaces.

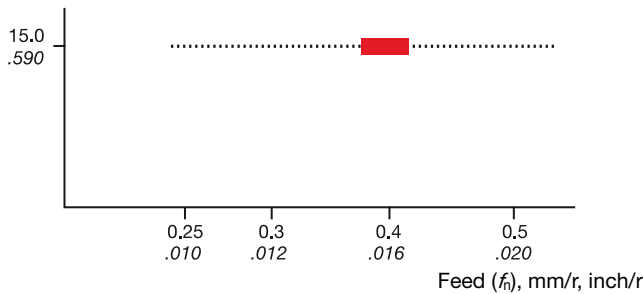
M Seat size
 CW, mm (inch)
 9-11 (.354-.433)

Feed (f_n), mm/r, inch/r



123-GR

Radial feed
Insert width (CW), mm, inch



Rough grooving, strong cutting edge for tough conditions like grooving through cast skin.
 Good for widening of grooves.

■ = Recommended starting value.

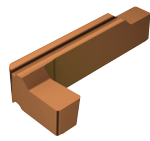
For cutting speed recommendations, see page B91

A

CoroCut® 1-2

Grooving

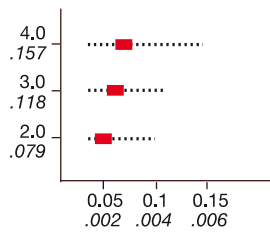
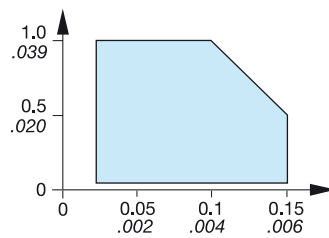
B



123-GS

Radial feed

Insert width (CW), mm, inch

**Axial feed**Cutting depth (a_p), mm, inch

Allround geometry for grooving with low feed in most materials.
Periphery ground with sharp cutting edge.

C

Low feed choice

Feed (f_n), mm/r, inch/rFeed (f_n), mm/r, inch/r

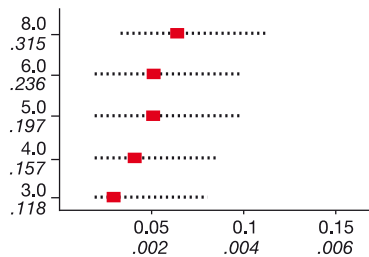
D



123-S

Radial feed

Insert width (CW), mm, inch



Alternative for finish grooving of hardened materials and heat resistant super alloys
Maintains close tolerances and gives excellent finish on components.
Available as CoroCut 1-edged inserts.

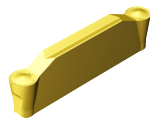
E

Cubic boron nitride tipped

Feed (f_n), mm/r, inch/r

Profiling

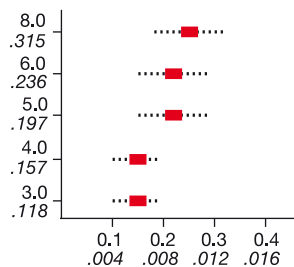
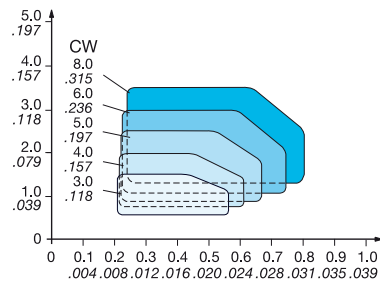
F



123-RM

Radial feed

Insert width (CW), mm, inch

**Axial feed**Cutting depth (a_p), mm, inch

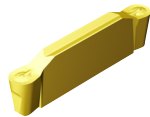
Excellent for profiling in all materials
Outstanding chip control even at low feeds and small depths of cut.
Good surface finish.
Available as CoroCut 1 and 2-edged inserts.

G

Medium feed choice

Feed (f_n), mm/r, inch/rFeed (f_n), mm/r, inch/r

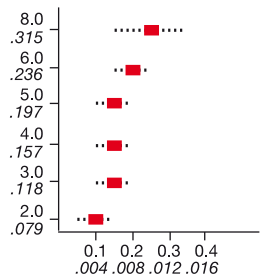
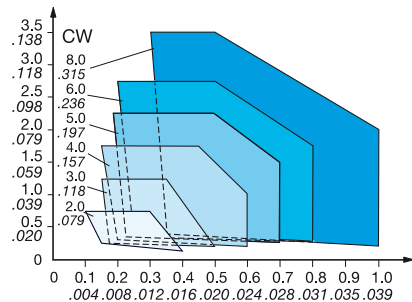
H



123-RO

Radial feed

Insert width (CW), mm, inch

**Axial feed**Cutting depth (a_p), mm, inch

Excellent for profiling in stainless steel, HRSA and other sticky materials
HRSA and other sticky materials.
Outstanding chip control at low feeds and small depths of cut.
Good surface finish. Sharp cutting edge.
Available as CoroCut 2-edge inserts.

■ = Recommended starting value.

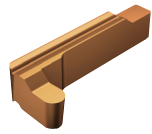
For cutting speed recommendations, see page B91

J

CoroCut® 1-2

Profiling

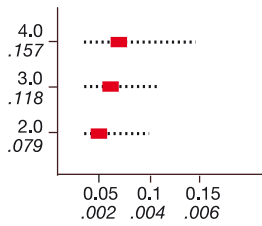
Allround geometry for profiling with low chip thickness in most materials.
Periphery ground with sharp cutting edge.



123-RS

Radial feed

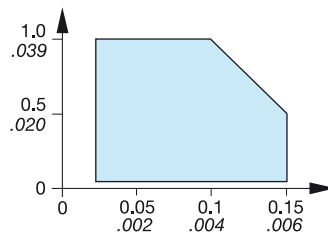
Insert width (CW), mm, inch



Feed (f_r), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inch



Feed (f_r), mm/r, inch/r

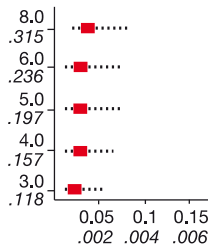


123-RE

Cubic boron nitride tipped

Radial feed

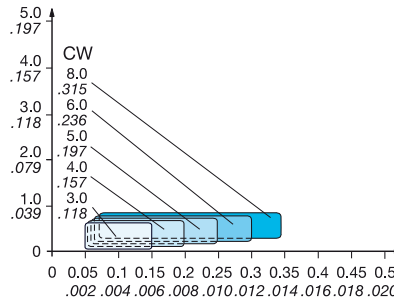
Insert width (CW), mm, inch



Feed (f_r), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inch



Feed (f_r), mm/r, inch/r

Alternative for finish profiling of hardened materials

Gives outstanding productivity and exceptional surface finish.
Available as CoroCut 1- edged inserts.

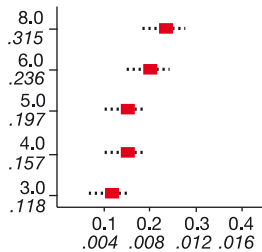


123-RS

Diamond tipped

Radial feed

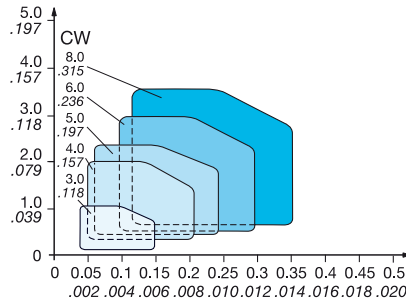
Insert width (CW), inch



Feed (f_r), inch/r

Axial feed

Cutting depth (a_p), inch



Feed (f_r), inch/r

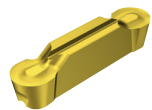
Alternative for finish profiling of non-ferrous materials.

Gives outstanding productivity and exceptional surface finish.
For use under stable conditions.
Available as CoroCut 1-edged inserts.

Aluminium profiling

First choice for profiling in non-ferrous materials.

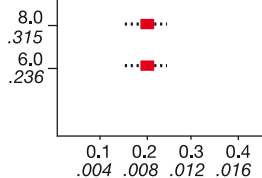
Good chip flow giving good surface finish.
Sharp cutting edge.
Available as CoroCut 2-edge inserts.



123-AM

Radial feed

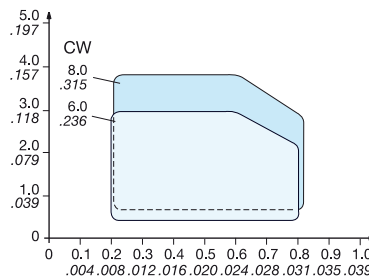
Insert width (CW), mm, inch



Feed (f_r), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inch



Feed (f_r), mm/r, inch/r

■ = Recommended starting value.

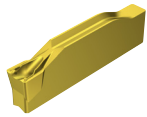
For cutting speed recommendations, see page B91

A

CoroCut® 1-2

Turning and plunge turning

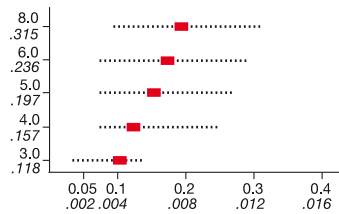
B



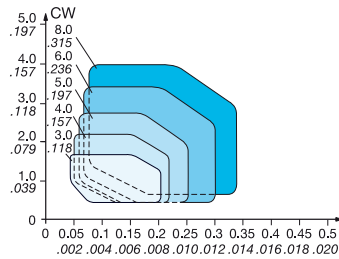
123-TF

Radial feed

Insert width (CW), mm, inch



Low feed choice

Feed (f_r), mm/r, inch/r**Axial feed**Cutting depth (a_p), mm, inchFeed (f_r), mm/r, inch/r

Suitable for all turning operations in stainless steels.

The positive geometry eliminates the risk of built-up edge.

Good chip control and surface finish.

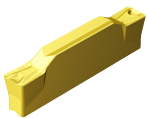
Wiper design on the side.

Available as CoroCut 1 and 2-edged inserts.

First choice for face grooving.

C

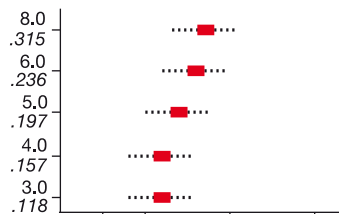
D



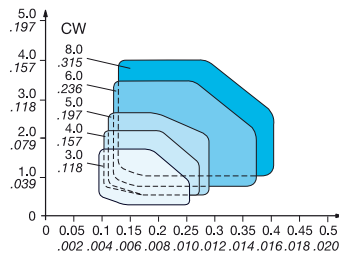
123-TM

Radial feed

Insert width (CW), mm, inch



Medium feed choice

Feed (f_r), mm/r, inch/r**Axial feed**Cutting depth (a_p), mm, inchFeed (f_r), mm/r, inch/r**General turning operations**

The positive geometry eliminates the risk of built-up edge.

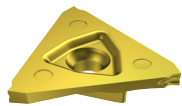
Available as CoroCut 2-edge inserts.

E

F

CoroCut® 3-edge inserts

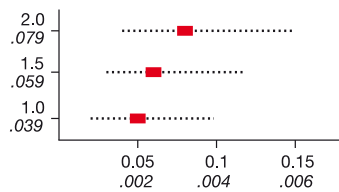
Shallow parting



123-CM

Radial feed

Insert width (CW), mm, inch

Feed (f_r), mm/r, inch/r**First choice for shallow parting**

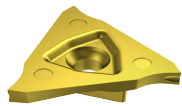
First choice in most materials

Sharp edge line, chip breaking geometry

To be used at normal cutting speeds 100 – 250 m/min (330 – 820 ft/min)

G

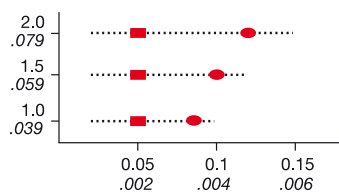
H



123-CS

Radial feed

Insert width (CW), mm, inch

Feed (f_r), mm/r, inch/r**First choice for shallow parting at low speeds**

For sticky materials and ball bearing materials
Extremely sharp edge line with an open chip former

To be used for non-ferrous materials at normal cutting speeds 100 – 250 m/min (330 – 820 ft/min)

Right (R) or left (L) hand inserts to be used for pip and burr free machining

I

■ = Recommended starting value at normal speeds

● = Recommended starting value at low speeds

For cutting speed recommendations, see page B91

J

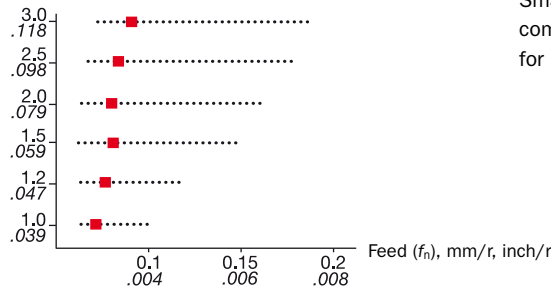
CoroCut® QD

QD-N..-CF



Radial feed

Cutting width (CW), mm, inch



Positive geometry for low feed

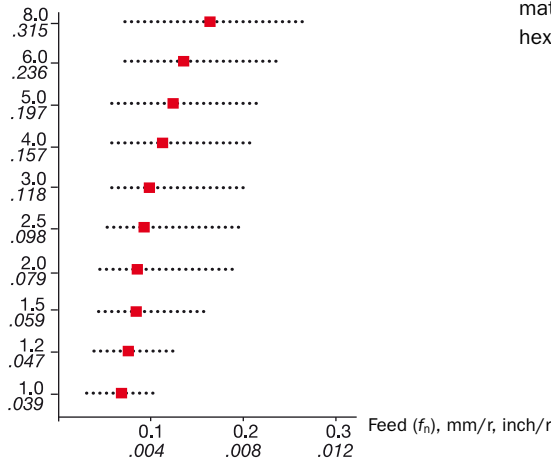
First choice for thin walled components and small diameters. Small corner radii and positive geometry reduce pip and burr on component in stainless steel and sticky materials. Wiper corners for high surface finish.

QD-N..-CM



Radial feed

Cutting width (CW), mm, inch



First choice, universal geometry

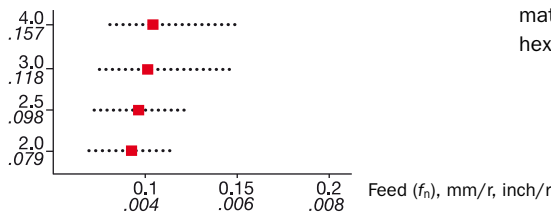
First choice for parting off to centre at good conditions in most materials and light intermittent applications such as parting hexagonal bars.

QD-R/L..-CM



Radial feed

Cutting width (CW), mm, inch



Universal geometry

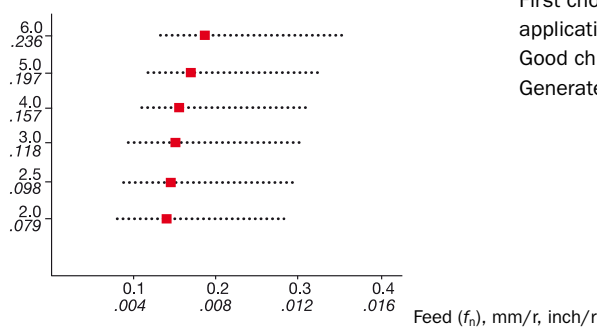
For reducing pip and burr in parting off at good conditions in most material and light intermittent applications such as parting hexagonal bars.

QD-N..-CR



Radial feed

Cutting width (CW), mm, inch



Strong geometry, negative cutting edge

First choice for parting off to centre at rough conditions and applications with severe intermittence. Good chip control at high feed. Generates flat groove bottom.

■ = Recommended starting value.

For cutting speed recommendations, see page B91

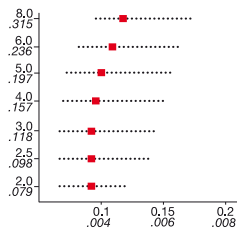
A

CoroCut® QD

QD-N.-CL

Radial feed

Cutting width (CW), mm, inch

Feed (f_n), mm/r, inch/r**Aggressive geometry for long chipping material**

Good chip breaking in low carbon steel, bearing steel and other sticky materials

Low-medium feeds.

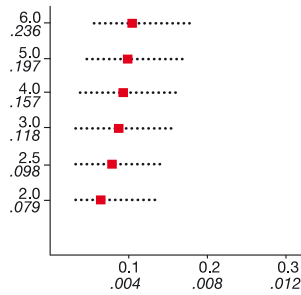
B

C

QD-N.-CO

Radial feed

Cutting width (CW), mm, inch

Feed (f_n), mm/r, inch/r**Optimizer geometry – front ground, sharp cutting edge**

First choice for HRSA (ISO S) materials, duplex stainless steels & non ferrous metals

Low cutting forces, reduce built-up edge and minimize risk for vibrations.

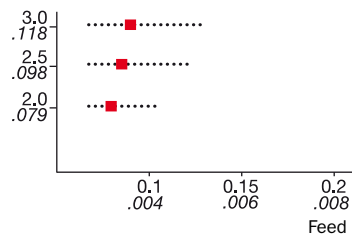
D

E

QD-R/L.-CO

Radial feed

Cutting width (CW), mm, inch

Feed (f_n), mm/r, inch/r**Optimizer geometry – front ground, sharp cutting edge**

For reducing pip and burr in parting off at good conditions in most material and light intermittent applications such as parting hexagonal bars.

Low cutting forces, reduce built-up edge and minimize risk for vibrations.

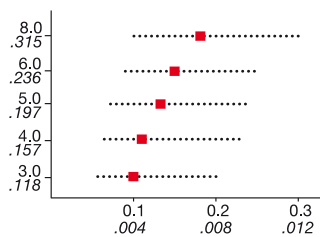
F

G

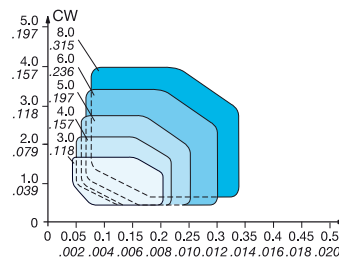
QD-N.-TF

Radial feed

Cutting width (CW), mm, inch

Feed (f_n), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inchFeed (f_n), mm/r, inch/r**First choice geometry for turning wider grooves**

Our most universal geometry, for turning of grooves in all materials.

Positive geometry gives low cutting forces and good chip control.

Good surface finish thanks to wiper design.

Generates flat bottom grooves.

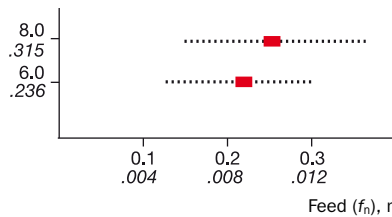
Wiper

H

QD-N.-GM

Radial feed

Cutting width (CW), mm, inch

Feed (f_n), mm/r, inch/r**Grooving in all materials**

Outstanding chip control.

Reduces chip width giving good surfaces.

I

J

For cutting speed recommendations, see page B91

CoroCut® 3

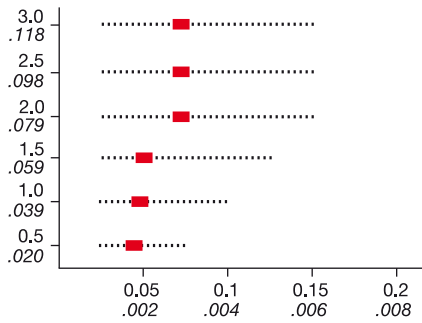
Grooving



123-GS

Radial feed

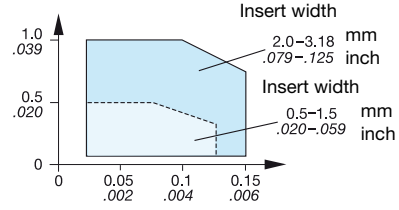
Insert width (W1), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

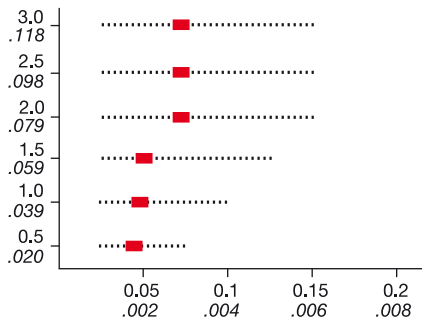
Profiling



123-RS

Radial feed

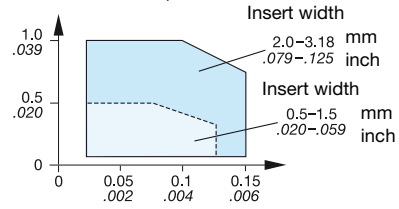
Insert width (W1), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inch



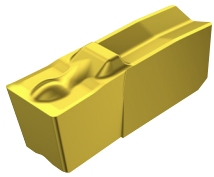
Feed (f_n), mm/r, inch/r

- = Recommended starting value at normal speeds
- = Recommended starting value at low speeds

For cutting speed recommendations, see page B91

T-Max Q-Cut®

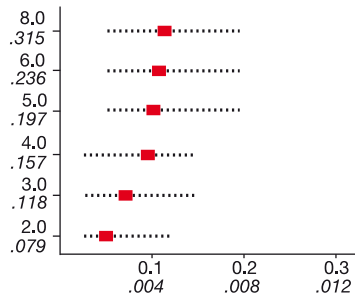
Internal grooving



151.3-4G

Radial feed

Insert width (W1), mm, inch



Low feed choice

Feed (f_n), mm/r, inch/r**Note:**

Inserts type 151.3 (-4G, -7G and -7P) can only be used with holders type F151.37 or bars type AG151.32

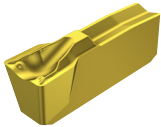
Alternative choice for internal grooving of smallest bores.

Good accuracy and repeatability due to tight tolerances on inserts.

Low cutting forces and good chip control in a wide range of materials.

Sharp cutting edge.

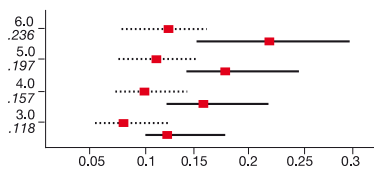
Face grooving



151.3-7G

Radial feed

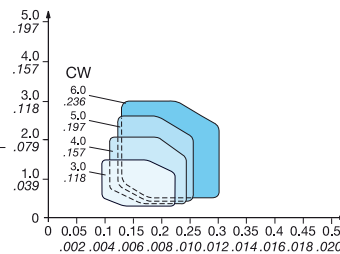
Insert width (W1), mm, inch



Medium feed choice

Feed (f_n), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inchFeed (f_n), mm/r, inch/r**First choice for face grooving.**

Good chip control both when cutting first groove and opening up. Smaller diameter grooves can be cut. Excellent stability.

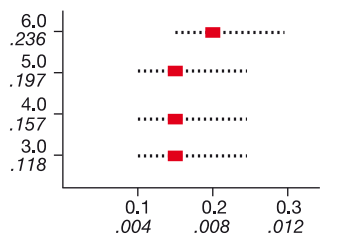
For face grooving in all materials.

First choice for internal turning/grooving

Good chip control. Generates good surface finish, due to Wiper design.

Radial feed

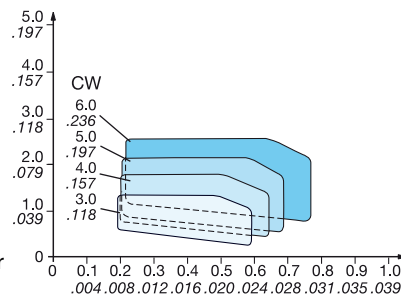
Insert width (W1), mm, inch



151.3-7P

Feed (f_n), mm/r, inch/r

Axial feed

Cutting depth (a_p), mm, inchFeed (f_n), mm/r, inch/r**For profiling in face grooving operations.**

Good chip control in both axial and radial direction.

Well suited also for internal profiling operations.

■ = Recommended starting value.

For cutting speed recommendations, see page B91

Grades for parting and grooving



Steel, cast steel, long chipping malleable iron

Basic grades



GC1125 (HC) - P30 (P15-P45)

This PVD-coated cemented carbide is an excellent allround grade. A good choice for parting-off tubes in steel. Also very good in grooving and turning operations. Speeds and feeds from medium to low.



GC4325 (HC) - P25 (P10-P40)

A CVD-coated carbide grade for finishing to roughing of steel and steel castings. This grade can handle continuous cuts as well as interrupted cuts at high metal removal rates. A grade for a broad application area. Equipped with Inveio™ coating technology.



GC1135 (HC) – P25 (P10-P45)

A CVD-coated carbide grade for toughness demanding operations such as cut-off to centre and interrupted cuts. Back up alternative when grooving and turning. Very good bulk and edge line toughness. To be used at low to medium cutting speeds.



GC2135 (HC) - P35 (P20-P50)

A CVD-coated carbide grade for toughness demanding operations such as cut-off to centre and interrupted cuts. Back up alternative when grooving and turning. Very good bulk and edge line toughness. To be used at low to medium cutting speeds.

Complementary grades



GC1105 (HC) - P15 (P05-P25)

A PVD-coated carbide grade, recommended only for Small Part Machining. To be used as a complementary grade. At low feed rate or medium cutting speed.



GC1145 (HC) - P45 (P25-P50)

A PVD-coated carbide grade with very high demands on toughness behavior. It is suitable in parting off operations and applications demanding very good edge line toughness. Works well in smearing materials. To be used at low cutting speeds.



CT525 (HT) – P10 (P01-P15)

An uncoated cermet grade with excellent resistance to oxidation and smearing. For high quality surface finishes when grooving low alloyed and alloyed steels under fairly good conditions. Moderate cutting speeds and feeds.



GC1025 (HC) – P25 (P15–P45)

A PVD-coated carbide grade excellent as all-round grade for Small Part Machining. This grade works very well in low carbon steel and other smearing materials. Speeds and feeds from medium to low.



GC1115 (HC) – P15 (P05-P25)

A PVD-coated carbide grade. Recommended to be used at low feedrate or medium cutting speed.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).

CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for parting and grooving

M Austenitic/ferritic/martensitic stainless steel, cast steel, manganese steel, alloy cast iron, malleable iron, free cutting steel.

Basic grades



GC1135 (HC) – M25 (M10-M35)

CVD-coated carbide grade for parting-off and other toughness demanding operations. Very good bulk and edge line toughness. To be used at medium to low cutting speeds.



GC1145 (HC) – M40 (M30-M40)

A PVD-coated carbide grade with very high demands on toughness behavior. It is suitable in parting off operations and applications demanding very good edge line toughness. Works well in smearing materials. The substrate has an extremely good bulk toughness and should be used at low cutting speeds or in combination with high precision coolant tools.



GC2135 (HC) – M30 (M20-M40)

A CVD-coated carbide grade for parting-off and other toughness demanding operations. Very good bulk and edge line toughness. To be used at medium to low cutting speeds.



GC1125 (HC) – M25 (M15-M35)

A PVD-coated carbide grade. This grade has a combination of high wear resistance and good edge security. For grooving and turning operations and also good for parting-off, especially tubes. Medium to low cutting speeds



GC1105 (HC) - M15 (M05 - M20)

A PVD-coated carbide grade that have high hot hardness and good resistance against plastic deformation, guarantees high performance with even flank wear. Suitable for grooving, and profiling at stable conditions with high speeds.

Complementary grades



H13A (HW) – M15 (M10-M30)

An uncoated carbide grade with good abrasive wear resistance and toughness for grooving.



GC1025 (HC) - M25 (M15-M35)

A PVD-coated carbide grade with a combination of high wear resistance and good edge security. To be used for grooving and parting off in Small Part Machining. Medium to low cutting speeds.



GC1115 (HC) – M15 (M05-M25)

A PVD-coated carbide grade. The grade has high hot hardness and good resistance against plastic deformation combined with good edge line security. This guarantees toughness, even flank wear and high performance of the edge. For profiling and grooving operations.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).

CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for parting and grooving



Cast iron, chilled cast iron, short chipping malleable iron.

Basic grades



GC4325 (HC) - K25 (K10 - K35)

An all-round CVD-coated grade with excellent combination of high wear resistance and good edge security. To be used in grooving and turning operations at medium to high cutting speeds. Also good in parting off tubes.



GC3115 (HC) – K15 (K05-K25)

A CVD-coated grade for high cutting speeds in grooving and turning under good conditions. Due to its excellent hot hardness also effective on hard cast-iron.



GC1125 (HC) - K30 (K15-K35)

A PVD-coated allround grade for toughness demanding operations and interrupted cuts. This grade has a good edge security due to the superior coating. To be used at medium to low cutting speeds



GC1135 (HC) - K20 (K10-K30)

CVD-coated carbide grade for parting-off and other toughness demanding operations. Very good bulk and edge line toughness. To be used at medium to low cutting speeds.

Complementary grades



GC3020 (HC) – K15 (K05-K25)

A very high wear resistant CVD-coated grade for high cutting speeds in grooving and turning under good conditions. Due to its excellent hot hardness it is also effective on hard cast-iron.



H13A (HW) – K20 (K10-K30)

A uncoated grade with good abrasive wear resistance and toughness. For parting/grooving operations



GC1025 (HC) - K30 (K15-K35)

A PVD-coated allround grade for toughness demanding operations and interrupted cuts. To be used at medium to low cutting speeds.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al_2O_3).

CM Mixed ceramics containing primarily aluminium oxide (Al_2O_3) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si_3N_4)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

A

Grades for parting and grooving

N

Non ferrous metals

B

Basic grades



GC1125 (HC) - N25 (N15-N35)

A PVD-coated grade for toughness demanding operations, recommended for interrupted cuts.

Complementary grades



GC1105 (HC) - N15 (N05-N25)

A PVD-coated grade with excellent adhesion on sharp edges, guarantees toughness, even flank wear and high performance.

C



H13A (HW) – N20 (N10-N30)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness. For parting and grooving.



GC1025 (HC) - N25 (N15-N30)

A PVD-coated grade for toughness demanding operations. Recommended for Small Part Machining.

D



H10 (HW) – N10 (N05-N15)

Uncoated carbide grade with good edge sharpness. Recommended for intermittent cuts.

E



CD10 (DP) – N01 (N01-N15)

A polycrystalline diamond (PCD) grade recommended for profiling of abrasive non-ferrous metals and non-metallic materials at stable conditions. Very good surface finish.

F

G

H

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).

CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

J

Grades for parting and grooving

S

Heat resistant and super alloys

Basic grades



GC1105 (HC) - S15 (S10-S20)

A PVD-coated carbide grade with high hot hardness and good resistance against plastic deformation giving even flank wear and outstanding performance. First choice for grooving and profiling.



GC1145 (HC) – S40 (S30-S40)

A PVD-coated carbide grade. First choice for parting off when demand on secure edge line is needed. To be used at low cutting speeds



S05F (HC) - S10 (S05-S15)

A CVD-coated carbide grade. To be used both for high speed finishing and roughing profiling operations.



GC1125 (HC) - S25 (S15-S35)

A PVD-coated grade for toughness demanding operations, recommended for interrupted cuts. To be used at low cutting speeds



H13A (HW) – S15 (S10-S30)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness for parting and grooving. First choice in titanium.

Complementary grades



CB7015 (BN) – S15 (S05-S25)

A cubic boron nitride composite suited for heat resistant super alloys. This grade allows sharp edges optimized for surface finish and low depth of cuts.



GC1115 (HC) – S20 (S10-S25)

A PVD-coated carbide grade with high hardness and combined with superior edge line security. Good resistance against notch makes the grade suitable to use in difficult materials.



GC1135 (HC) – S25 (S10-S35)

A CVD-coated carbide grade for toughness demanding operations. To be used at low cutting speeds.



GC2135 (HC) – S30 (S20–S40)

A CVD-coated carbide grade for toughness demanding operations such as cut-off to centre and interrupted cuts.



H10 (HW) – S15 (S10-S20)

Uncoated carbide grade with good edge sharpness. Recommended for finishing in Titanium.



GC1025 (HC) - S25 (S15-S35)

A PVD-coated grade for toughness demanding operations. Recommended for Small Part Machining. To be used at low cutting speeds.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).

CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for parting and grooving

H Hardened materials

B Basic grades



CB7015 (BN) - H15 (H05-H20)

A cubic boron nitride composite for hardened ferrous materials. Suitable for both continuous and interrupted cuts.



CB7025 (BN) - H15 (H10-H20)

A cubic boron nitride composite for hardened ferrous material. Suitable for cuts with substantial interruptions at medium speeds in case hardened steels, bearing steels.

C

D

E

F

G

H

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

- HW Uncoated hardmetal containing primarily tungsten carbide (WC)
- HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
- HC Hardmetals as above, but coated

Ceramics:

- CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).
- CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.
- CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)
- CC Ceramics as above, but coated.

Diamond:

- DP Polycrystalline diamond¹⁾

Boron nitride:

- BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for parting and grooving

	ISO	ANSI		
P Steel	01	C8		▲
	10			
	20	C7	GC 4325	
	30	C6	GC 1125	
	40		GC 1135	
	50	C5	GC 2135	GC 1145
M Stainless steel	10	-	GC 1105	▲
	20	-		
	30	-	GC 1125	
	40	-	GC 1135	
			GC 1145	GC 2135
K Cast iron	01	C4		▲
	10	C3	GC 3115	
	20	C2	GC 4325	
	30	C1	GC 1125	
	40			
N Non-ferrous metals	01	C4	CD10	▲
	10	C3	H10	
	20	C2	H13A	
	30	C1	GC 1125	
			GC 1025	GC 1105
S Heat resistant and super alloys	10	-	S05F	▲
	20	-	GC 1105	
	30	-	H13A	
	40	-	GC 1145	
			GC 1125	GC 1025
H Hardened materials	01	C4		▲
	10	C3	CB 7015	
	20	C2	CB 7025	
	30	C1		

The position and form of the grade symbols indicate the suitable field of application.

Centre of the field of application.



Recommended field of application.

▲ Wear resistance

▼ Toughness



= Basic grades



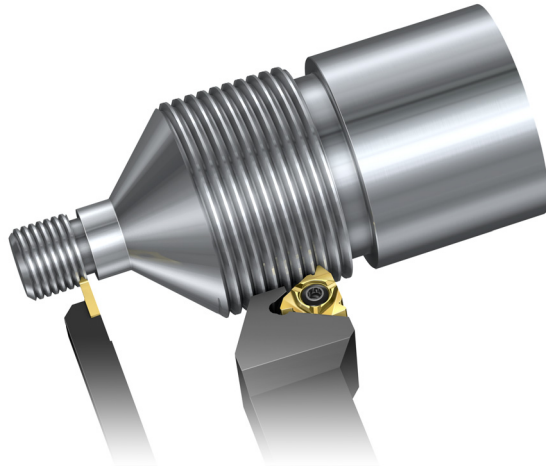
= Complementary grades

Thread turning

External threading

CoroCut® XS

Thread forms: M, UN, WH, NT and V profile 60°
Diameter: 1–8 mm (.040–.315 inch)



CoroThread® 266

Multi- or single-point profiles
Diameter: 8–40 mm (.315–1.570 inch)
Thread forms: M, UN, WH, PT, NT, NF, RN, MJ, UNJ, TR, AC, SA, V-Profile 60° and 55°



Internal threading

CoroTurn® XS

Pitches: 0.5–3 mm (32–16 threads/in)
Min. hole diameter: 4 mm (.157 inch)
Thread forms: M, UN, WH, NT, TR and V-Profile 60°



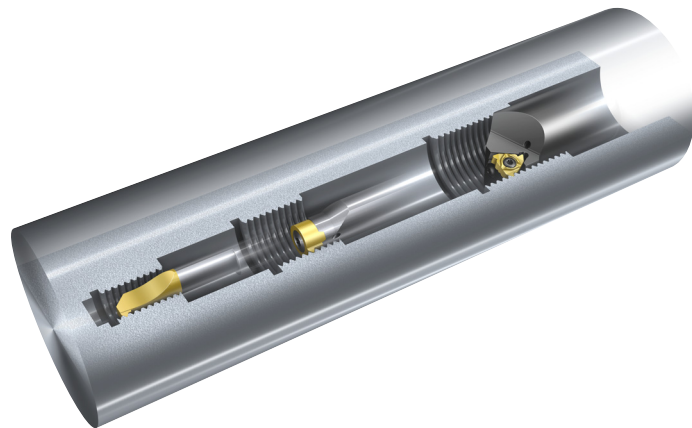
T-Max® U-Lock

Pitches: 0.5–2 mm (12–32 threads/in)
Min. hole diameter: 12 mm (.472 inch)
Thread forms: M, UN, WH, NT, V-Profile 60° and 55°



CoroCut® MB

Pitches: 0.5–3 mm (32–8 threads/in)
Min. hole diameter: 10 mm (.394 inch)
Thread forms: M, UN, NPT, TR, AC, SA



CoroThread® 266 C6

Inserts C7-C28
External tools C41-C49

T-Max® U-Lock C29

Inserts C30-C35
Internal tools C50-C51

CoroCut® XS C36

Inserts C37-C40
External tools B47-B64

CoroTurn® XS C52

Cutting tools C53-C58
Adaptors D2




CoroCut® MB C59


Cutting tools C60-C65
Adaptors D2

ENG



Tool overview

External tools



		CoroThread® 266		
		QS™-HP shank tools	QS™ shank tools	Rectangular shank tools
				
CZC _{MS}				
Metric	10 x 10		C41	C41
	12 x 12	C42	C42	C43
	16 x 16	C43	C44	C44
Inch	3/8 x 3/8		C45	C45
	1/2 x 1/2	C46	C46	C47
	5/8 x 5/8	C47		C48
	3/4 x 3/4			C48

		CoroThread® 266	
		CoroTurn® SL head	
			
CZC _{MS}			
Metric	20	C49	
	25	C49	

Internal tools

		T-Max® U-Lock	
		Cylindrical shank without clamping features	Cylindrical shank with 3 flats
		Solid carbide boring bar	Boring bar
			
CZC _{MS}			
Metric	10	C50	
	12	C50	
	16		C50
Inch	3/8	C51	
	1/2	C51	
	5/8		C51

Cutting tools

	CoroTurn® XS	CoroCut® MB
	Solid carbide tool	Solid carbide head
		
V-profile 60° Non-topping	C53	C60
Metric 60° Full form	C54	C61
UN 60° Full form	C55	C62
Whitworth 55° (BSW, BSF, BSP) Full form	C56	C63
NPT 60° (NPSC, NPTR, LINE PIPE) Full form	C57	C64
ISO Trapezoidal 30° Chamfered crest form	C58	
ACME 29° partial profile		C65

Insert overview

Threading profiles

	V-profile 60° Non-topping		V-profile 55° Non-topping		Metric 60° Full form		UN 60° Full form		Whitworth 55° (BSW, BSF, BSP) Full form		
	Internal	External	Internal	External	Internal	External	Internal	External	Internal	External	
					ISO 965-1998 Tolerance class 6		ISO 5864-1978 Tolerance class 2A, ext. Tolerance class 2B, int.		ISO 228-1982 BS 2779-1973 BS 84-1956 Class A tolerance		
CoroThread® 266		C7	C8	C8			C9-C11		C12-C14		C15-C16
T-Max U-Lock®	C30		C31		C32			C33		C34	
CoroCut® XS		C37					C38		C39		
CoroTurn® XS	C53				C54			C55		C56	
CoroCut® MB	C60				C61			C62		C63	
	NPT 60° (NPSC, NPTR, LINE PIPE) Full form		BSPT 55° Full form		NPTF 60° Full form		Round 30° Full form		MJ 60° Full form		
	Internal	External	Internal	External	Internal	External	Internal	External	Internal	External	
	ANSI B.1.20.1-1983		ISO 7/1 BS21:1985		ANSI B1.20.3-1976 Tolerance class 2		DIN 405. Tolerance class 7 on effective dia. Tolerance class 6 on major (external) and minor (internal) dia.		ISO 5855-1983 Tolerance class 4 on pitch diameter. Tolerance class 6 on major (external) and minor (internal) dia.		
CoroThread® 266		C17-C18		C19		C20		C21		C22	
T-Max U-Lock®	C35										
CoroCut® XS		C40									
CoroTurn® XS	C57										
CoroCut® MB	C64										
	UNJ 60° Full form		ISO Trapezoidal 30° Chamfered crest form		ACME 29° Chamfered crest form		STUB-ACME 29° Chamfered crest form		API Round 60° Full form		
	Internal	External	Internal	External	Internal	External	Internal	External	Internal	External	
	ISO 3161-1977 BS 4084-1978 Tolerance class 3A		ISO 2901-2904 DIN 103-1977 Tolerance class 7		ANSI B1.5-1988 Tolerance class 2G		ANSI B1.8-1988 Tolerance class 2G		API spec.5B		
CoroThread® 266		C23		C24		C25		C26		C27	
T-Max U-Lock®											
CoroCut® XS											
CoroTurn® XS			C58								
CoroCut® MB					C25			C65			

CoroThread® 266

B Ultra-rigid thread turning for all types of threads

Highly productive threading

When talking about thread turning CoroThread 266 has a solution for any component. The three-edged system includes almost every thread profile, and the excellent insert stability secures high thread quality while at the same time allowing for increased cutting data.

C Application

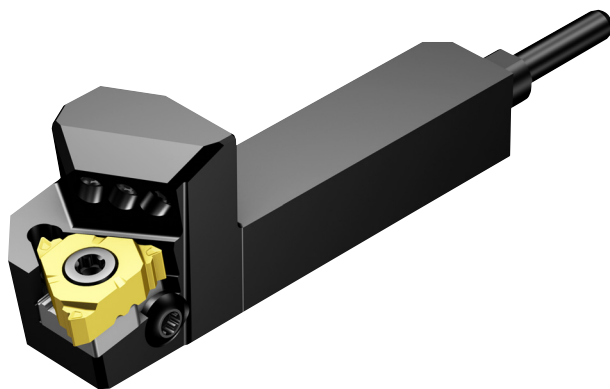
- External threading

D ISO application area:



E Benefits and features

- Reduced machine- and downtime
- Excellent surface finish due to the exceptional stability
- Three sharp cutting edges for high-quality threads
- Multi-point inserts available, require fewer passes resulting in increased productivity
- Large standard product range of tools and thread profile inserts
- Unique guide rail interface between the insert and tip seat
- Good edge indexing
- Easy to mount the insert correctly



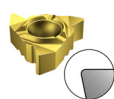
www.sandvik.coromant.com/corothread266

F Inserts

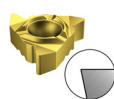
- Insert geometries and grades for all materials
- Tailor Made inserts for almost any thread form or pitch

G Tools

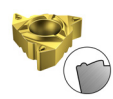
- QS Shank tools
- Shank tools
- CoroTurn® SL heads



Standard
A-geometry



Sharp
F-geometry



Chip-breaking
C-geometry

H Three different threading insert types

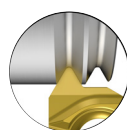
I Full profile

High productivity



I V-profile

Minimum tool
inventory



I Multi-point

Economical mass
production



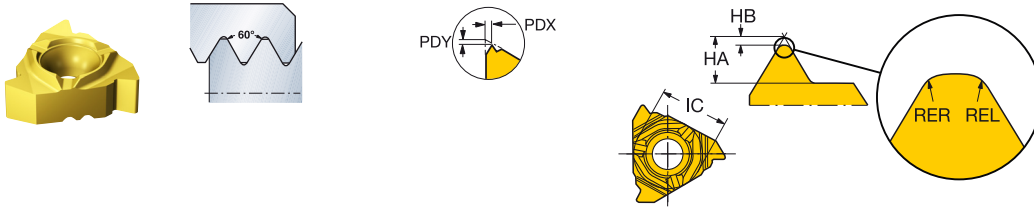
J Secure iLock™ clamping

The slotted insert sits rigidly on the T-rails in the pocket eliminating any insert movement caused by cutting force variations.




CoroThread® 266 insert for thread turning


V-profile 60° Non-topping



External right-hand threads

 TPN TPX TPIN TPIX NT	Ordering code	Material						Dimensions, mm, inch										
		P	M	K	N	S	H	RER	REL	HA	HB	PDX	PDY					
16 3/8 1.0 2.0 12.0 24.0 1	266RG-16VM01A001EE	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	7015	0.13	0.13	1.68	0.14	1.00	1.03
1.0 2.0 12.0 24.0 1	266RG-16VM01A001M	★	☆	★	☆	★	☆	★	☆	★	☆	★	0.13	0.13	1.68	0.14	1.00	1.03
1.0 2.0 12.0 24.0 1	266RG-16VM01C001M	★	★	★	★	★	★	★	★	★	★	★	0.13	0.13	1.68	0.14	1.00	1.03
1.0 2.0 12.0 24.0 1	266RG-16VM01F001E	★	★	★	★	★	★	★	★	★	★	★	0.13	0.13	1.68	0.14	1.00	1.03
1.5 3.0 8.0 16.0 1	266RG-16VM01A002EE											★	0.20	0.20	2.64	0.20	1.50	1.03
1.5 3.0 8.0 16.0 1	266RG-16VM01A002M	★	☆	★	☆	★	☆	★	☆	★	☆	★	0.20	0.20	2.64	0.20	1.50	1.03
1.5 3.0 8.0 16.0 1	266RG-16VM01C002M	★	★	★	★	★	★	★	★	★	★	★	0.20	0.20	2.64	0.20	1.50	1.03
1.5 3.0 8.0 16.0 1	266RG-16VM01F002E	★	★	★	★	★	★	★	★	★	★	★	0.20	0.20	2.64	0.20	1.50	1.03

External left-hand threads

 TPN TPX TPIN TPIX NT	Ordering code	Material						Dimensions, mm, inch										
		P	M	K	N	S	H	RER	REL	HA	HB	PDX	PDY					
16 3/8 1.0 2.0 12.0 24.0 1	266LG-16VM01A001M	★	☆	★	☆	★	☆	★	☆	★	☆	★	0.13	0.13	1.68	0.14	1.00	1.03
1.5 3.0 8.0 16.0 1	266LG-16VM01A002M	★	☆	★	☆	★	☆	★	☆	★	☆	★	0.20	0.20	2.64	0.20	1.50	0.99

R = Right hand, L = Left hand



C4



C74



C85



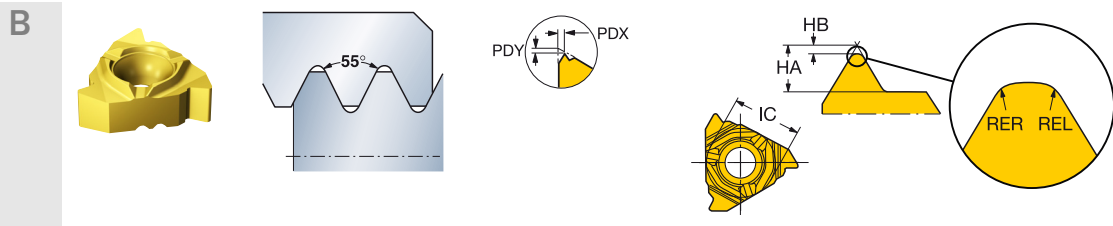
J19



J9

CoroThread® 266 insert for thread turning

V-profile 55° Non-topping



C External right-hand threads

						P	M	K	N	S	H	Dimensions, mm, inch								
D	TPIN	TPIX	NT	Ordering code							RER	REL	HA	HB	PDX	PDY				
					1125	1135	1125	1135	1125	1135	1125	1135	1125	1135						
16	3/8	14.0	28.0	1	266RG-16VW01A001M	*	*	*	*	*	*	0.11	0.11	1.68	0.14	1.00	1.03			
	14.0	28.0	1	266RG-16VW01C001M	*	*	*	*	*	*	0.11	0.11	1.68	0.13	1.00	1.03				
14.0	28.0	1	266RG-16VW01F001E	*	*	*	*	*	*	0.11	0.11	1.68	0.14	1.00	1.01					
8.0	14.0	1	266RG-16VW01A002M	*	*	*	*	*	*	0.23	0.23	2.79	0.26	1.50	1.03					
E	8.0	14.0	1	266RG-16VW01C002M	*	*	*	*	*	*	0.23	0.23	2.79	0.26	1.50	1.03				
8.0	14.0	1	266RG-16VW01F002E	*	*	*	*	*	*	0.23	0.23	2.79	0.26	1.50	0.99					

External left-hand threads

						P	M	K	N	S	H	Dimensions, mm, inch					
F	TPIN	TPIX	NT	Ordering code							RER	REL	HA	HB	PDX	PDY	
					1125	1135	1125	1135	1125	1135	1125	1135					
16	3/8	14.0	28.0	1	266LG-16VW01A001M	*	*	*	*	*	*	0.11	0.11	1.68	0.13	1.00	1.03
8.0	14.0	1	266LG-16VW01A002M	*	*	*	*	*	*	0.23	0.23	2.79	0.26	1.50	1.03		

R = Right hand, L = Left hand

G

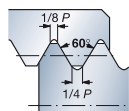
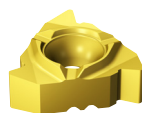
H

I

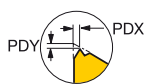


CoroThread® 266 insert for thread turning

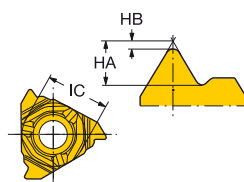
Metric 60° Full form




STDNO
TCTR



ISO 965-1998
IT 6



External right-hand threads

	TP	NT	Ordering code	Material						Dimensions, mm, inch								
				P	M	K	N	S	H	HA	HB	PDX	PDY					
				1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135			
16	3/8	0.50	1	266RG-16MM01A050M	★	☆	☆	★	★	★	★	★	☆	☆	0.37	0.08	0.50	1.32
		.020													.0146	.0032	.020	.052
	0.75	1	266RG-16MM01A075M	★	☆	☆	★	★	★	★	★	★	☆	☆	0.56	0.11	0.50	1.32
		.030													.0220	.0043	.020	.052
	0.80	1	266RG-16MM01F080E	★	☆	☆	★	★	★	★	★	★	☆	☆	0.60	0.11	0.60	1.32
		.031													.0236	.0043	.024	.052
	1.00	1	266RG-16MM01A100M	★	☆	☆	★	★	★	★	★	★	☆	☆	0.75	0.15	0.80	1.32
		.039													.0295	.0059	.031	.052
	1.00	1	266RG-16MM01C100M	★	☆	☆	★	★	★	★	★	★	☆	☆	0.75	0.15	0.80	1.32
		.039													.0295	.0059	.031	.052
	1.00	1	266RG-16MM01F100E	★	☆	☆	★	★	★	★	★	★	☆	☆	0.75	0.15	0.80	1.32
		.039													.0295	.0059	.031	.052
	1.25	1	266RG-16MM01A125M	★	☆	☆	★	★	★	★	★	★	☆	☆	0.93	0.19	0.80	1.32
		.049													.0366	.0075	.031	.052
	1.25	1	266RG-16MM01C125M	★	☆	☆	★	★	★	★	★	★	☆	☆	0.93	0.19	0.80	1.32
		.049													.0366	.0075	.031	.052
	1.25	1	266RG-16MM01F125E	★	☆	☆	★	★	★	★	★	★	☆	☆	0.93	0.19	0.80	1.32
		.049													.0366	.0075	.031	.052
	1.50	1	266RG-16MM01A150M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.12	0.22	1.00	1.32
		.059													.0441	.0087	.039	.052
	1.50	1	266RG-16MM01C150M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.12	0.22	1.00	1.33
		.059													.0441	.0087	.039	.052
	1.50	1	266RG-16MM01F150E	★	☆	☆	★	★	★	★	★	★	☆	☆	1.12	0.22	1.00	1.32
		.059													.0441	.0087	.039	.052
	1.75	1	266RG-16MM01A175M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.31	0.25	1.20	1.32
		.069													.0516	.0098	.047	.052
	1.75	1	266RG-16MM01C175M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.31	0.25	1.20	1.33
		.069													.0516	.0098	.047	.052
	1.75	1	266RG-16MM01F175E	★	☆	☆	★	★	★	★	★	★	☆	☆	1.31	0.25	1.20	1.32
		.069													.0516	.0098	.047	.052
	2.00	1	266RG-16MM01A200M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.50	0.29	1.40	1.32
		.079													.0591	.0114	.055	.052
	2.00	1	266RG-16MM01C200M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.50	0.29	1.40	1.33
		.079													.0591	.0114	.055	.052
	2.00	1	266RG-16MM01F200E	★	☆	☆	★	★	★	★	★	★	☆	☆	1.50	0.29	1.40	1.32
		.079													.0591	.0114	.055	.052
	2.50	1	266RG-16MM01A250M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.87	0.36	1.40	1.32
		.098													.0736	.0142	.055	.052
	2.50	1	266RG-16MM01C250M	★	☆	☆	★	★	★	★	★	★	☆	☆	1.87	0.36	1.40	1.33
		.098													.0736	.0142	.055	.052
	2.50	1	266RG-16MM01F250E	★	☆	☆	★	★	★	★	★	★	☆	☆	1.87	0.36	1.40	1.32
		.098													.0736	.0142	.055	.052
	3.00	1	266RG-16MM01A300M	★	☆	☆	★	★	★	★	★	★	☆	☆	2.25	0.42	1.80	1.32
		.118													.0886	.0165	.071	.052
	3.00	1	266RG-16MM01C300M	★	☆	☆	★	★	★	★	★	★	☆	☆	2.25	0.42	1.80	1.33
		.118													.0886	.0165	.071	.052
	3.00	1	266RG-16MM01F300E	★	☆	☆	★	★	★	★	★	★	☆	☆	2.25	0.42	1.80	1.32
		.118													.0886	.0165	.071	.052



C4



C74



C85



J19

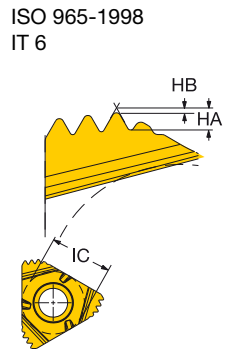
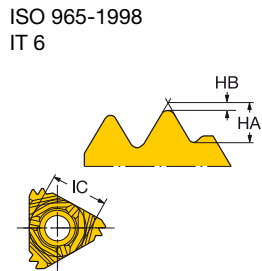
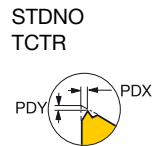
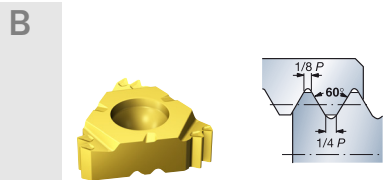


J9



CoroThread® 266 insert for thread turning

Metric 60° Full form



C

External right-hand threads - multipoint insert

TP	NT	Ordering code	P		M		K		N		S		Dimensions, mm, inch								
			1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	HA	HB	PDX	PDY					
16	3/8	1.00	3	266RG-16MM03A100M	*	*	*	*	*	*	*	*	0.75	0.15	2.50	1.62	.039	.0295	.0059	.098	.064
1.25	2	266RG-16MM02A125M	*	*	*	*	*	*	*	*	*	*	0.96	0.09	2.25	1.41	.049	.0378	.0035	.089	.056
1.50	2	266RG-16MM02A150M	*	*	*	*	*	*	*	*	*	*	1.12	0.22	2.20	1.42	.059	.0441	.0087	.087	.056
1.75	2	266RG-16MM02A175M	*	*	*	*	*	*	*	*	*	*	0.93	0.19	1.90	1.33	.069	.0366	.0075	.075	.052
2.00	2	266RG-16MM02A200M	*	*	*	*	*	*	*	*	*	*	1.50	0.29	2.90	1.91	.079	.0591	.0114	.114	.075

F

G

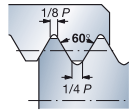
H

I

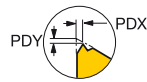


CoroThread® 266 insert for thread turning

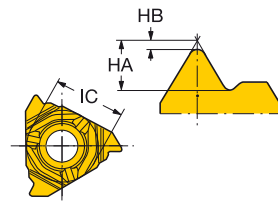
Metric 60° Full form



STDNO
TCTR



ISO 965-1998
IT 6



External left-hand threads

TP	NT	Ordering code	Dimensions, mm, inch											
			P	M	K	N	S	H	HA	HB	PDX	PDY		
16	3/8	0.50	1	266LG-16MM01A050M	*	*	*	*	*	*	0.37	0.08	0.50	1.32
		.020									.0146	.0032	.020	.052
	0.75	1	266LG-16MM01A075M	*	*	*	*	*	*	*	0.56	0.11	0.50	1.32
		.030									.0220	.0043	.020	.052
	1.00	1	266LG-16MM01A100M	*	*	*	*	*	*	*	0.75	0.15	0.80	1.32
		.039									.0295	.0059	.031	.052
	1.25	1	266LG-16MM01A125M	*	*	*	*	*	*	*	0.93	0.19	0.80	1.32
		.049									.0366	.0075	.031	.052
	1.50	1	266LG-16MM01A150M	*	*	*	*	*	*	*	1.12	0.22	1.00	1.32
		.059									.0441	.0087	.039	.052
	1.75	1	266LG-16MM01A175M	*	*	*	*	*	*	*	1.31	0.25	1.20	1.32
		.069									.0516	.0098	.047	.052
	2.00	1	266LG-16MM01A200M	*	*	*	*	*	*	*	1.50	0.29	1.40	1.32
		.079									.0591	.0114	.055	.052
	2.50	1	266LG-16MM01A250M	*	*	*	*	*	*	*	1.87	0.36	1.40	1.32
		.098									.0736	.0142	.055	.052
	3.00	1	266LG-16MM01A300M	*	*	*	*	*	*	*	2.25	0.42	1.80	1.32
		.118									.0886	.0165	.071	.052



C4



C74



C85



J19



J9

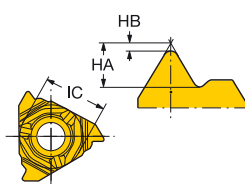
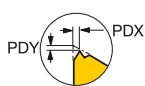
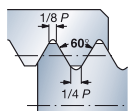
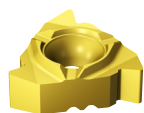
CoroThread® 266 insert for thread turning

UN 60° Full form

B

STDNO
TCTR

ISO 5864-1978
2A



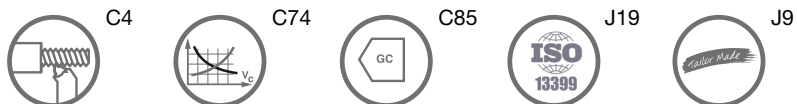
C

External right-hand threads

D

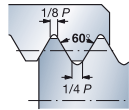
TPI	NT	Ordering code	P		M		K		N		S		H		Dimensions, mm, inch					
			1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	HA	HB	PDX	PDY		
16	3/8	32.0	1	266RG-16UN01A320M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	0.59	0.10	0.50	1.30
	28.0	1	266RG-16UN01A280M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	0.68	0.12	0.80	1.32	
	24.0	1	266RG-16UN01A240M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	0.79	0.14	0.08	1.30	
	24.0	1	266RG-16UN01C240M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	0.79	0.14	0.80	1.33	
	24.0	1	266RG-16UN01F240E	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	0.79	0.14	0.80	1.30	
	20.0	1	266RG-16UN01A200M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	0.95	0.16	0.08	1.30	
	20.0	1	266RG-16UN01C200M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	0.95	0.16	0.80	1.33	
	20.0	1	266RG-16UN01F200E	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	0.95	0.16	0.80	1.30	
	18.0	1	266RG-16UN01A180M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	1.05	0.18	1.00	1.30	
	18.0	1	266RG-16UN01C180M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.05	0.18	1.00	1.33	
	18.0	1	266RG-16UN01F180E	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.05	0.18	1.00	1.30	
	16.0	1	266RG-16UN01A160M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	1.19	0.20	1.00	1.30	
	16.0	1	266RG-16UN01C160M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.19	0.20	1.00	1.33	
	16.0	1	266RG-16UN01F160E	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.19	0.20	1.00	1.30	
	14.0	1	266RG-16UN01A140M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	1.35	0.23	1.20	1.30	
	14.0	1	266RG-16UN01C140M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.35	0.23	1.20	1.33	
	14.0	1	266RG-16UN01F140E	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.35	0.23	1.20	1.30	
	13.0	1	266RG-16UN01A130M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	1.46	0.25	1.40	1.30	
	12.0	1	266RG-16UN01A120M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	1.58	0.28	1.40	1.30	
	12.0	1	266RG-16UN01C120M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.58	0.28	1.40	1.33	
	12.0	1	266RG-16UN01F120E	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	1.58	0.28	1.40	1.30	
	11.0	1	266RG-16UN01A110M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	1.72	0.30	1.40	1.30	
	10.0	1	266RG-16UN01A100M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	1.90	0.33	1.40	1.30	
	9.0	1	266RG-16UN01A090M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	2.11	0.37	1.80	1.30	
	8.0	1	266RG-16UN01A080M	★	☆	☆	☆	★	★	☆	☆	★	★	☆	☆	2.38	0.41	1.80	1.30	
	8.0	1	266RG-16UN01C080M	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	2.38	0.41	1.80	1.33	
	8.0	1	266RG-16UN01F080E	★	☆	★	☆	★	★	☆	☆	★	★	☆	☆	2.38	0.41	1.80	1.30	

J

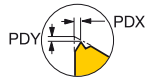


CoroThread® 266 insert for thread turning

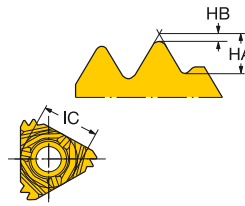
UN 60° Full form



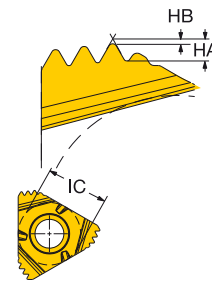
STDNO
TCTR



ISO 5864-1978
2A

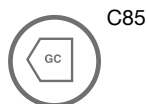
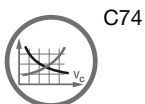


ISO 5864-1978
2A



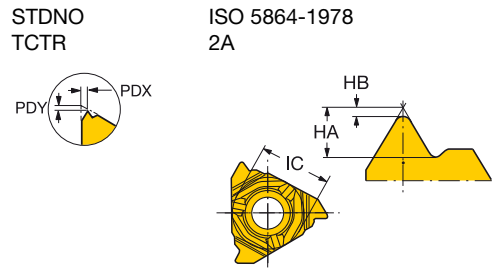
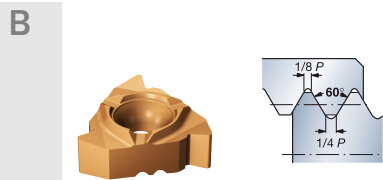
External right-hand threads - multipoint insert

		P	M	K	N	S	Dimensions, mm, inch						
16	3/8	18.0	3	266RG-16UN03A180M	*	*	*	*	*	HA	HB	PDX	PDY
					*	*	*	*	*	1.05	0.18	3.45	2.12
					*	*	*	*	*	.0413	.0071	.136	.083
					*	*	*	*	*	1.19	0.20	2.40	1.52
					*	*	*	*	*	.0469	.0079	.094	.060
					*	*	*	*	*	1.35	0.23	2.70	1.77
					*	*	*	*	*	.0532	.0091	.106	.070
					*	*	*	*	*	1.58	0.28	3.10	1.91
					*	*	*	*	*	.0622	.0110	.122	.075



CoroThread® 266 insert for thread turning

UN 60° Full form



C

External left-hand threads

D

TPI	NT	Ordering code	P M K N S H					Dimensions, mm, inch				
			1/25	1/25	1/25	1/25	1/25	HA	HB	PDX	PDY	
16	3/8	266LG-16UN01A320M	*	*	*	*	*	*	0.59	0.10	0.50	1.32
28.0	1	266LG-16UN01A280M	*	*	*	*	*	*	0.68	0.12	0.80	1.32
24.0	1	266LG-16UN01A240M	*	*	*	*	*	*	0.79	0.14	0.80	1.30
20.0	1	266LG-16UN01A200M	*	*	*	*	*	*	0.95	0.16	0.80	1.30
18.0	1	266LG-16UN01A180M	*	*	*	*	*	*	1.05	0.18	1.00	1.30
16.0	1	266LG-16UN01A160M	*	*	*	*	*	*	1.19	0.20	1.00	1.30
14.0	1	266LG-16UN01A140M	*	*	*	*	*	*	1.35	0.23	1.20	1.30
13.0	1	266LG-16UN01A130M	*	*	*	*	*	*	1.46	0.25	1.40	1.32
12.0	1	266LG-16UN01A120M	*	*	*	*	*	*	1.58	0.28	1.40	1.30
11.0	1	266LG-16UN01A110M	*	*	*	*	*	*	1.72	0.30	1.40	1.30
10.0	1	266LG-16UN01A100M	*	*	*	*	*	*	1.90	0.33	1.40	1.30
9.0	1	266LG-16UN01A090M	*	*	*	*	*	*	2.11	0.37	1.80	1.32
8.0	1	266LG-16UN01A080M	*	*	*	*	*	*	2.38	0.41	1.80	1.30

E

F

G

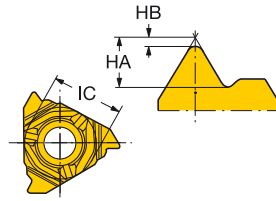
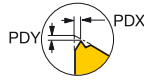
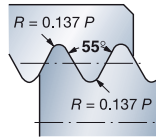


CoroThread® 266 insert for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

STDNO
STDNO
STDNO
TCTR

ISO 228-1982
BS-2779-1973
BS-84-1957
CLASS A



External right-hand threads

TPI	NT	Ordering code	P		M		K		N		S		H		Dimensions, mm, inch			
			1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	HA	HB	PDX	PDY
16	3/8	28.0	1	266RG-16WH01A280M	★	☆	★	☆	★	☆	★	☆	★	☆	0.72	0.13	0.80	1.32
															.0283	.0051	.031	.052
		26.0	1	266RG-16WH01A260M	★	☆	★	☆	★	☆	★	☆	★	☆	0.77	0.14	2.30	1.51
															.0304	.0054	.091	.059
		20.0	1	266RG-16WH01A200M	★	☆	★	☆	★	☆	★	☆	★	☆	1.01	0.18	0.80	1.32
															.0398	.0071	.031	.052
		19.0	1	266RG-16WH01A190M	★	☆	★	☆	★	☆	★	☆	★	☆	1.06	0.19	0.80	1.32
															.0417	.0075	.031	.052
		19.0	1	266RG-16WH01C190M	★	☆	★	☆	★	☆	★	☆	★	☆	1.06	0.19	0.80	1.33
															.0417	.0075	.031	.052
		19.0	1	266RG-16WH01F190E	★	☆	★	☆	★	☆	★	☆	★	☆	1.06	0.19	0.80	1.32
															.0417	.0075	.031	.052
		18.0	1	266RG-16WH01A180M	★	☆	★	☆	★	☆	★	☆	★	☆	1.12	0.20	1.00	1.32
															.0441	.0079	.039	.052
		16.0	1	266RG-16WH01A160M	★	☆	★	☆	★	☆	★	☆	★	☆	1.26	0.23	1.00	1.32
															.0496	.0091	.039	.052
		14.0	1	266RG-16WH01A140M	★	☆	★	☆	★	☆	★	☆	★	☆	1.44	0.26	1.20	1.32
															.0567	.0102	.047	.052
		14.0	1	266RG-16WH01C140M	★	☆	★	☆	★	☆	★	☆	★	☆	1.44	0.26	1.20	1.33
															.0567	.0102	.047	.052
		14.0	1	266RG-16WH01F140E	★	☆	★	☆	★	☆	★	☆	★	☆	1.44	0.26	1.20	1.32
															.0567	.0102	.047	.052
		12.0	1	266RG-16WH01A120M	★	☆	★	☆	★	☆	★	☆	★	☆	1.68	0.31	1.40	1.32
															.0661	.0122	.055	.052
		11.0	1	266RG-16WH01A110M	★	☆	★	☆	★	☆	★	☆	★	☆	1.83	0.34	1.40	1.32
															.0720	.0134	.055	.052
		11.0	1	266RG-16WH01C110M	★	☆	★	☆	★	☆	★	☆	★	☆	1.83	0.34	1.40	1.33
															.0720	.0134	.055	.052
		11.0	1	266RG-16WH01F110E	★	☆	★	☆	★	☆	★	☆	★	☆	1.83	0.34	1.40	1.32
															.0720	.0134	.055	.052
		10.0	1	266RG-16WH01A100M	★	☆	★	☆	★	☆	★	☆	★	☆	2.02	0.37	1.40	1.32
															.0795	.0146	.055	.052
		9.0	1	266RG-16WH01A090M	★	☆	★	☆	★	☆	★	☆	★	☆	2.24	0.42	1.80	1.32
															.0882	.0165	.071	.052
		8.0	1	266RG-16WH01A080M	★	☆	★	☆	★	☆	★	☆	★	☆	2.52	0.47	1.80	1.32
															.0992	.0185	.071	.052



C4



C74



C85



J19



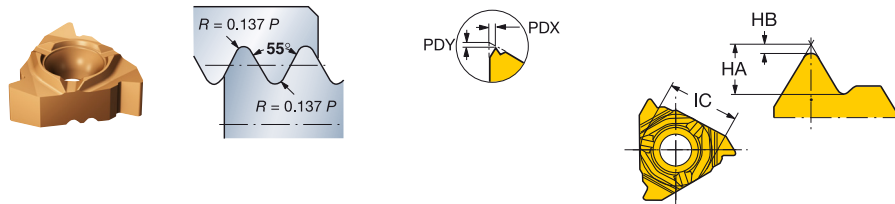
J9

CoroThread® 266 insert for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

STDNO
STDNO
STDNO
TCTR

ISO 228-1982
BS-2779-1973
BS-84-1957
CLASS A



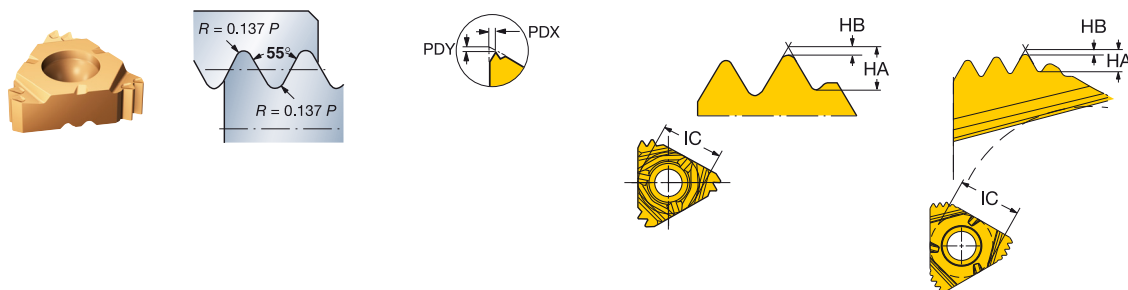
External left-hand threads

		P	M	K	N	S	H	Dimensions, mm, inch					
IC	TPI	NT	Ordering code	1125	1125	1125	1125	HA	HB	PDX	PDY		
16	3/8	19.0	1	266LG-16WH01A190M	*	*	*	*	*	1.06	0.19	0.80	1.32
								.0417	.0075	.031	.052		
		14.0	1	266LG-16WH01A140M	*	*	*	*	*	1.44	0.26	1.20	1.32
								.0567	.0102	.047	.052		
		11.0	1	266LG-16WH01A110M	*	*	*	*	*	1.83	0.34	1.40	1.32
								.0720	.0134	.055	.052		

STDNO
STDNO
STDNO
TCTR

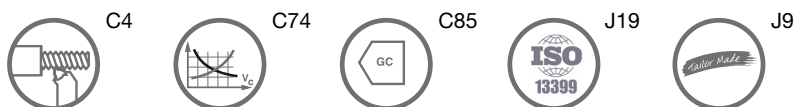
ISO 228-1982
BS-2779-1973
BS-84-1957
CLASS A

ISO 228-1982
BS-2779-1973
BS-84-1957
CLASS A



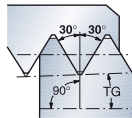
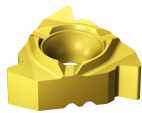
External right-hand threads - multipoint insert

		P	M	K	N	S	Dimensions, mm, inch				
IC	TPI	NT	Ordering code	1125	1125	1125	1125	HA	HB	PDX	PDY
16	3/8	19.0	3	266RG-16WH03A190M	*	*	*	1.06	0.19	3.30	2.02
								.0417	.0075	.130	.079
		14.0	2	266RG-16WH02A140M	*	*	*	1.44	0.26	2.70	1.73
								.0567	.0102	.106	.068

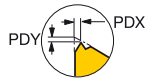


CoroThread® 266 insert for thread turning

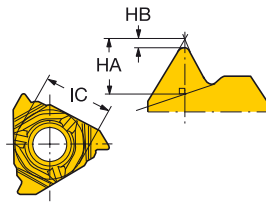
NPT 60° (NPSC, NPTR, LINE PIPE) Full form



STDNO

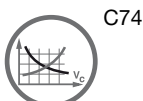


ANSI B.1.20.1-1983



External right-hand threads

TPI	NT	Ordering code	Material						Dimensions, mm, inch									
			P	M	K	N	S	H	HA	HB	PDX	PDY	TG					
			1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135				
16	3/8	266RG-16NT01A270M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	0.76	0.05	0.80	1.03	0.03
														<i>.0299</i>	<i>.0020</i>	<i>.031</i>	<i>.041</i>	
	18.0	266RG-16NT01A180M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	1.14	0.08	1.00	1.03	0.03
														<i>.0449</i>	<i>.0032</i>	<i>.039</i>	<i>.041</i>	
	14.0	266RG-16NT01A140M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	1.46	0.09	1.20	1.03	0.03
														<i>.0575</i>	<i>.0035</i>	<i>.047</i>	<i>.041</i>	
	14.0	266RG-16NT01C140M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	1.46	0.09	1.20	1.03	0.03
														<i>.0575</i>	<i>.0035</i>	<i>.047</i>	<i>.041</i>	
	14.0	266RG-16NT01F140E	★	☆	☆	★	★	☆	★	★	☆	☆	☆	1.46	0.09	1.20	1.03	0.03
														<i>.0575</i>	<i>.0035</i>	<i>.047</i>	<i>.041</i>	
	11.5	266RG-16NT01A115M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	1.79	0.11	1.40	1.03	0.03
														<i>.0705</i>	<i>.0043</i>	<i>.055</i>	<i>.041</i>	
	11.5	266RG-16NT01C115M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	1.79	0.11	1.40	1.03	0.03
														<i>.0705</i>	<i>.0043</i>	<i>.055</i>	<i>.041</i>	
	11.5	266RG-16NT01F115E	★	☆	☆	★	★	☆	★	★	☆	☆	☆	1.79	0.11	1.40	1.03	0.03
														<i>.0705</i>	<i>.0043</i>	<i>.055</i>	<i>.041</i>	
	8.0	266RG-16NT01A080M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	2.57	0.14	1.60	1.03	0.03
														<i>.1012</i>	<i>.0055</i>	<i>.063</i>	<i>.041</i>	
	8.0	266RG-16NT01C080M	★	☆	☆	★	★	☆	★	★	☆	☆	☆	2.57	0.14	1.60	1.03	0.03
														<i>.1012</i>	<i>.0055</i>	<i>.063</i>	<i>.041</i>	

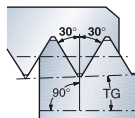


CoroThread® 266 insert for thread turning

NPT 60° (NPSC, NPTR, LINE PIPE) Full form

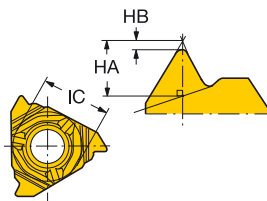
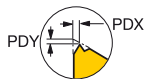
ENG

B



STDNO

ANSI B.1.20.1-1983



C

External left-hand threads

D

		Dimensions, mm, inch										
		P	M	K	N	S	H	HA	HB	PDX	PDY	TG
	TPI NT	1125	1125	1125	1125	1125	1125					
16 3/8	27.0 1	★	★	★	★	★	★	0.76	0.05	0.80	1.03	0.03
	Ordering code	266LG-16NT01A270M						.0299	.0020	.031	.041	
	18.0 1	★	★	★	★	★	★	1.14	0.08	1.00	1.03	0.03
	Ordering code	266LG-16NT01A180M						.0449	.0032	.039	.041	
	14.0 1	★	★	★	★	★	★	1.46	0.09	1.20	1.03	0.03
	Ordering code	266LG-16NT01A140M						.0575	.0035	.047	.041	
	11.5 1	★	★	★	★	★	★	1.79	0.11	1.40	1.03	0.03
	Ordering code	266LG-16NT01A115M						.0705	.0043	.055	.041	
	8.0 1	★	★	★	★	★	★	2.57	0.14	1.60	1.03	0.03
	Ordering code	266LG-16NT01A080M						.1012	.0055	.063	.041	

E

F

G

H

I

J



C4



C74



C85



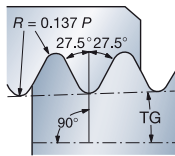
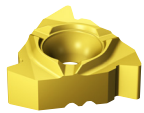
J19



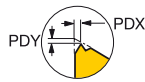
J9

CoroThread® 266 insert for thread turning

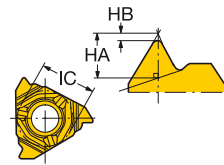
BSPT 55° Full form



STDNO
STDNO



ISO 7/1
BS21:1985



External right-hand threads

TPI	NT	Ordering code	Dimensions, mm, inch																
			P	M	K	N	S	H											
16	3/8	28.0	1	266RG-16PT01A280E	1125	1135	1125	1135	1125	1135	1125	1135	1125	1135	HA	HB	PDX	PDY	TG
					★	☆	★	☆	★	☆	★	☆	★	☆	0.70	0.13	0.80	1.32	0.03
															.0276	.0051	.031	.052	
		19.0	1	266RG-16PT01A190E	★	☆	★	☆	★	☆	★	☆	★	☆	1.04	0.19	0.80	1.32	0.03
															.0409	.0075	.031	.052	
		14.0	1	266RG-16PT01A140E	★	☆	★	☆	★	☆	★	☆	★	☆	1.41	0.26	1.20	1.32	0.03
															.0555	.0102	.047	.052	
		11.0	1	266RG-16PT01A110E	★	☆	★	☆	★	☆	★	☆	★	☆	1.80	0.34	1.40	1.32	0.03
															.0709	.0134	.055	.052	
		8.0	1	266RG-16PT01A080E	★	☆	★	☆	★	☆	★	☆	★	☆	2.47	0.47	1.80	1.32	0.03
															.0972	.0185	.071	.052	

External left-hand threads

TPI	NT	Ordering code	Dimensions, mm, inch															
			P	M	K	N	S	H										
16	3/8	19.0	1	266LG-16PT01A190E	1125	1135	1125	1135	1125	1135	HA	HB	PDX	PDY	TG			
					★	☆	★	☆	★	☆	1.04	0.19	0.80	1.32	0.03			
															.0409	.0075	.031	.052
		14.0	1	266LG-16PT01A140E	★	☆	★	☆	★	☆	1.41	0.26	1.20	1.32	0.03			
															.0555	.0102	.047	.052
		11.0	1	266LG-16PT01A110E	★	☆	★	☆	★	☆	1.80	0.34	1.40	1.32	0.03			
															.0709	.0134	.055	.052

R = Right hand, L = Left hand



C4



C74



C85



J19



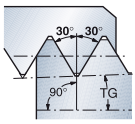
J9



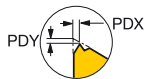
CoroThread® 266 insert for thread turning

NPTF 60° Full form

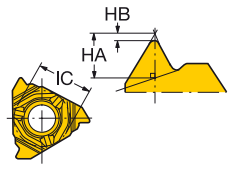
B



STDNO
TCTR



ANSI B1.20.3-1976
IT 2



C

External right-hand threads

D

		P	M	K	N	S	H	Dimensions, mm, inch					
		1/25	1/25	1/25	1/25	1/25	1/25	HA	HB	PDX	PDY	TG	
	TPI NT	Ordering code											
16 3/8	27.0 1	★	★	★	★	★	★	0.75	0.11	0.80	1.03	0.03	
								.0295	.0043	.031	.041		
	18.0 1	★	★	★	★	★	★	1.14	0.13	1.00	1.03	0.03	
								.0449	.0051	.039	.041		
	14.0 1	★	★	★	★	★	★	1.49	0.13	1.20	1.03	0.03	
								.0587	.0051	.047	.041		
	11.5 1	★	★	★	★	★	★	1.81	0.17	1.40	1.03	0.03	
								.0713	.0067	.055	.041		
	8.0 1	★	★	★	★	★	★	2.60	0.21	1.60	1.03	0.03	
								.1024	.0083	.063	.041		

E

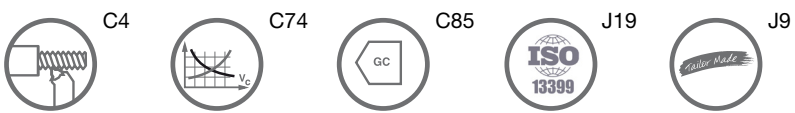
F

G

H

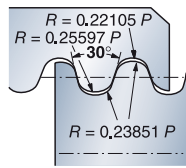
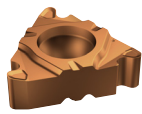
I

J

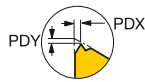


CoroThread® 266 insert for thread turning

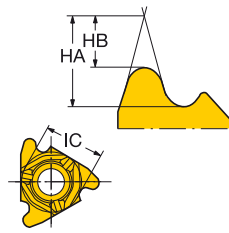
Round 30° Full form



STDNO
TCTR



DIN 405
IT 7-6



External right-hand threads

TPI	NT	Ordering code	Material					Dimensions, mm, inch						
			P	M	K	N	S	H	HA	HB	PDX	PDY		
16	3/8	10.0	1	266RG-16RN01A100M	★	★	★	★	★	☆	2.97	1.72	0.85	1.33
											.1169	.0677	.033	.052
	8.0	1	266RG-16RN01A080M	★	★	★	★	★	☆	3.72	2.14	1.05	1.38	
											.1465	.0843	.041	.054
	8.0	1	266RG-16RN01F080E	★	★	★	★	★	☆	3.72	2.14	1.05	1.37	
											.1465	.0843	.041	.054
	6.0	1	266RG-16RN01A060M	★	★	★	★	★	☆	4.98	2.86	1.50	1.43	
											.1961	.1126	.059	.056
	6.0	1	266RG-16RN01F060E	★	★	★	★	★	☆	4.98	2.86	1.50	1.43	
											.1961	.1126	.059	.056

External left-hand threads

TPI	NT	Ordering code	Material					Dimensions, mm, inch						
			P	M	K	N	S	H	HA	HB	PDX	PDY		
16	3/8	10.0	1	266LG-16RN01A100M	★	★	★	★	☆	2.97	1.72	0.85	1.32	
											.1169	.0677	.033	.052
	8.0	1	266LG-16RN01A080M	★	★	★	★	★	☆	3.72	2.14	1.05	1.32	
											.1465	.0843	.041	.052
	6.0	1	266LG-16RN01A060M	★	★	★	★	★	☆	4.98	2.86	1.50	1.43	
											.1961	.1126	.059	.056

R = Right hand, L = Left hand



C4



C74



C85



J19



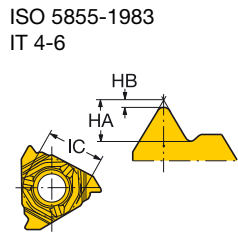
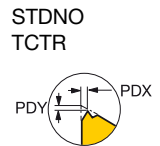
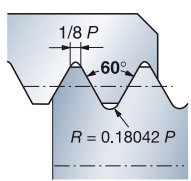
J9



CoroThread® 266 insert for thread turning

MJ 60° Full form

B



C

External right-hand threads

D

		P M K N S H					Dimensions, mm, inch				
TP	NT	Ordering code	1125	1125	1125	1125	1125	HA	HB	PDX	PDY
16	3/8	266RG-16MJ01A150E	*	*	*	*	*	1.12	0.25	1.00	1.32
								.0441	.0098	.039	.052
	2.00	266RG-16MJ01A200E	*	*	*	*	*	1.50	0.34	1.40	1.32
								.0591	.0134	.055	.052

E

External left-hand threads

F

		P M K N S H					Dimensions, mm, inch				
TP	NT	Ordering code	1125	1125	1125	1125	1125	HA	HB	PDX	PDY
16	3/8	266LG-16MJ01A150E	*	*	*	*	*	1.12	0.25	1.00	1.32
								.0441	.0098	.039	.052
	2.00	266LG-16MJ01A200E	*	*	*	*	*	1.50	0.34	1.40	1.32
								.0591	.0134	.055	.052

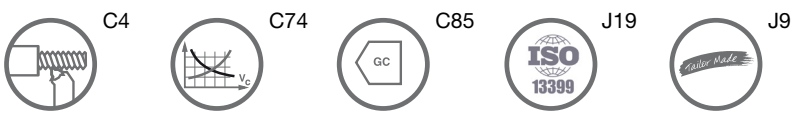
R = Right hand, L = Left hand

G

H

I

J

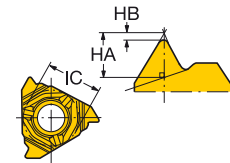
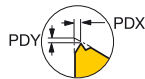
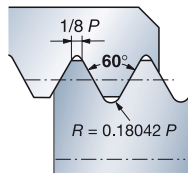


CoroThread® 266 insert for thread turning

UNJ 60° Full form

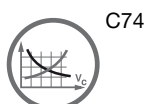
STDNO
STDNO
TCTR

ISO 3161-1977
BS 4084-1977
3A



External right-hand threads

		P	M	K	N	S	H	Dimensions, mm, inch				
		1/25	1/25	1/25	1/25	1/25	1/25	HA	HB	PDX	PDY	
	TPI NT	Ordering code										
16	3/8 32.0 1	★	★	★	★	★	★	0.59	0.13	0.50	1.32	
								.0232	.0051	.020	.052	
	28.0 1	★	★	★	★	★	★	0.67	0.15	0.80	1.32	
								.0264	.0059	.031	.052	
	24.0 1	★	★	★	★	★	★	0.79	0.18	0.80	1.32	
								.0311	.0071	.031	.052	
	20.0 1	★	★	★	★	★	★	0.94	0.21	1.00	1.32	
								.0370	.0083	.039	.052	
	18.0 1	★	★	★	★	★	★	1.05	0.23	1.00	1.32	
								.0413	.0091	.039	.052	
	16.0 1	★	★	★	★	★	★	1.18	0.26	1.00	1.32	
								.0465	.0102	.039	.052	
	14.0 1	★	★	★	★	★	★	1.35	0.30	1.20	1.32	
								.0532	.0118	.047	.052	
	12.0 1	★	★	★	★	★	★	1.58	0.36	1.40	1.32	
								.0622	.0142	.055	.052	
	10.0 1	★	★	★	★	★	★	1.89	0.42	1.40	1.32	
								.0744	.0165	.055	.052	
	8.0 1	★	★	★	★	★	★	2.38	0.53	1.80	1.32	
								.0937	.0209	.071	.052	



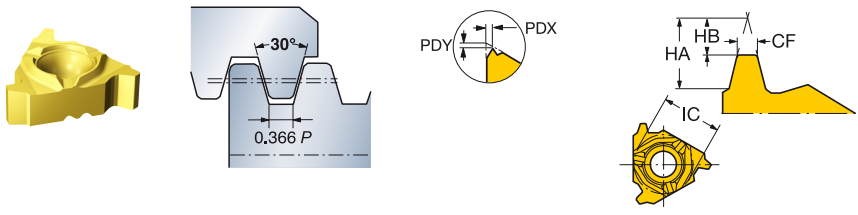
CoroThread® 266 insert for thread turning

ISO Trapezoidal 30° Chamfered crest form

B

STDNO
STDNO
TCTR

ISO 2901-2904
DIN 103-1977
IT 7



C

External right-hand threads

D

		P	M	K	N	S	H	Dimensions, mm, inch							
		1135	1135	1135	1135	1135	1135	CF	HA	HB	PDX	PDY			
16	3/8	1.50	1	266RG-16TR01F150E	*	*	*	*	*	*	0.5	1.85	0.88	1.00	1.32
		.059						.019	.0728	.0346	.039	.052			
		2.00	1	266RG-16TR01F200E	*	*	*	*	*	*	0.6	2.44	1.13	1.10	1.32
		.079						.024	.0961	.0445	.043	.052			
		3.00	1	266RG-16TR01F300E	*	*	*	*	*	*	1.0	3.63	1.82	1.60	1.23
		.118						.039	.1429	.0717	.063	.048			

E

External left-hand threads

F

		P	M	K	N	S	H	Dimensions, mm, inch							
		1135	1135	1135	1135	1135	1135	CF	HA	HB	PDX	PDY			
16	3/8	1.50	1	266LG-16TR01F150E	*	*	*	*	*	*	0.5	1.85	0.88	1.00	1.32
		.059						.019	.0728	.0346	.039	.052			
		2.00	1	266LG-16TR01F200E	*	*	*	*	*	*	0.6	2.44	1.13	1.10	1.33
		.079						.024	.0961	.0445	.043	.052			
		3.00	1	266LG-16TR01F300E	*	*	*	*	*	*	1.0	3.63	1.82	1.60	1.23
		.118						.039	.1429	.0717	.063	.048			

R = Right hand, L = Left hand

G

H

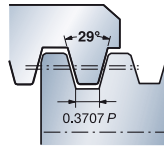
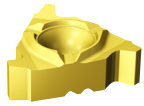
I

J

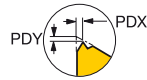


CoroThread® 266 insert for thread turning

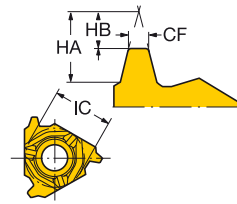
ACME 29° Chamfered crest form



STDNO
TCTR



ANSI B1.5-1988
2G



External right-hand threads

TPI	NT	Ordering code	Material					Dimensions, mm, inch					
			P	M	K	N	S	H	CF	HA	HB	PDX	PDY
16	3/8	266RG-16AC01F160E	*	*	*	*	*	*	0.5	1.98	1.04	1.00	1.33
									.021	.0780	.0409	.039	.052
	14.0	266RG-16AC01F140E	*	*	*	*	*	*	0.6	2.26	1.21	1.10	1.33
									.025	.0890	.0476	.043	.052
	12.0	266RG-16AC01F120E	*	*	*	*	*	*	0.7	2.64	1.43	1.20	1.33
									.029	.1039	.0563	.047	.052
	10.0	266RG-16AC01F100E	*	*	*	*	*	*	0.8	3.16	1.61	1.30	1.32
									.033	.1244	.0634	.051	.052
	8.0	266RG-16AC01F080E	*	*	*	*	*	*	1.1	3.94	2.08	1.50	1.23
									.043	.1551	.0819	.059	.048

External left-hand threads

TPI	NT	Ordering code	Material					Dimensions, mm, inch					
			P	M	K	N	S	H	CF	HA	HB	PDX	PDY
16	3/8	266LG-16AC01F120E	*	*	*	*	*	*	0.7	2.64	1.43	1.20	1.33
									.029	.1039	.0563	.047	.052
	10.0	266LG-16AC01F100E	*	*	*	*	*	*	0.8	3.16	1.61	1.30	1.33
									.033	.1244	.0634	.051	.052
	8.0	266LG-16AC01F080E	*	*	*	*	*	*	1.1	3.94	2.08	1.50	1.23
									.043	.1551	.0819	.059	.048

R = Right hand, L = Left hand



C4



C74



C85



J19



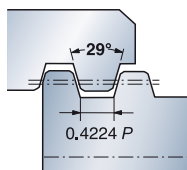
J9



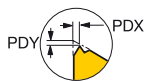
CoroThread® 266 insert for thread turning

STUB-ACME 29° Chamfered crest form

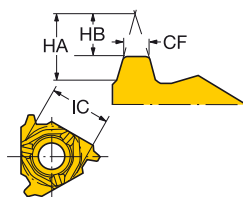
B



STDNO
TCTR



ANSI B1.8-1988
2G



C

External right-hand threads

		P	M	K	N	S	H	Dimensions, mm, inch								
IC	TPI	NT	Ordering code	1135	1135	1135	1135	CF	HA	HB	PDX	PDY				
	16	3/8	16.0	1	266RG-16SA01F160E	*	*	*	*	*	*	0.6	1.86	1.21	1.50	1.23
								.025	.0732	.0476	.059	.048				
								0.7	2.12	1.40	1.85	1.30				
								.028	.0835	.0551	.073	.051				
								0.9	2.47	1.65	1.10	1.32				
								.033	.0972	.0650	.043	.052				
	10.0	1	266RG-16SA01F100E	*	*	*	*	1.0	2.95	1.87	1.20	1.32				
								.038	.1161	.0736	.047	.052				
								1.2	3.67	2.39	1.50	1.53				
								.049	.1445	.0941	.059	.060				

E

External left-hand threads

		P	M	K	N	S	H	Dimensions, mm, inch								
IC	TPI	NT	Ordering code	1135	1135	1135	1135	CF	HA	HB	PDX	PDY				
	16	3/8	16.0	1	266LG-16SA01F160E	*	*	*	*	*	*	0.6	1.86	1.21	1.30	1.30
								.025	.0732	.0476	.051	.051				
								0.7	2.12	1.40	1.10	1.32				
								.028	.0835	.0551	.043	.052				
								0.9	2.47	1.65	1.50	1.30				
								.033	.0972	.0650	.059	.051				
	10.0	1	266LG-16SA01F100E	*	*	*	*	1.0	2.95	1.87	1.30	1.30				
								.038	.1161	.0736	.051	.051				
								1.2	3.67	2.89	1.10	1.30				
								.049	.1445	.1138	.043	.051				

G

R = Right hand, L = Left hand

H

I

J



C4



C74



C85



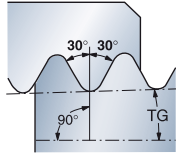
J19



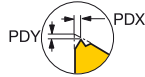
J9

CoroThread® 266 insert for thread turning

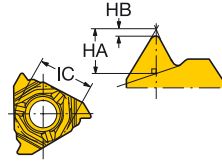
API Round 60° Full form



STDNO

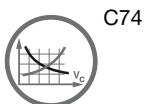


API SPEC. 5B



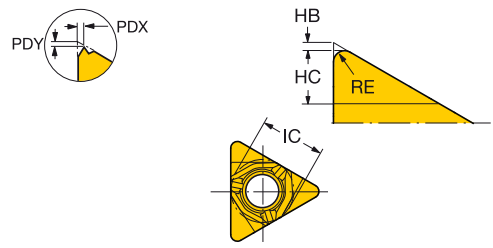
External right-hand threads

		P M K N S H					Dimensions, mm, inch				
TPI	NT	Ordering code	1125	1125	1125	1125	HA	HB	PDX	PDY	TG
16	3/8	266RG-16RD01A100E	*	*	*	*	1.76	0.36	1.30	1.35	0.03
	10.0	266RG-16RD01C100M	*	*	*	*	1.76	0.36	1.30	1.35	0.03
	8.0	266RG-16RD01A080E	*	*	*	*	2.23	0.43	1.50	1.35	0.03
	8.0	266RG-16RD01C080M	*	*	*	*	2.23	0.43	1.50	1.35	0.03



CoroThread® 266 carbide blank

Blanks



External threads

	DSGN	Ordering code	P	M	K	N	S	Dimensions, mm, inch		
			H13A	H13A	H13A	H13A	H13A	HB	HC	RE
16 3/8 1	266R/LG-160000-300-BG		☆	☆	☆	☆	☆	0.70	3.20	1.00
								.0256	.1262	.0394

Note: Precaution should be taken when grinding cemented carbide products. See page J17 for safety information. R = Right hand, L = Left hand

D

E

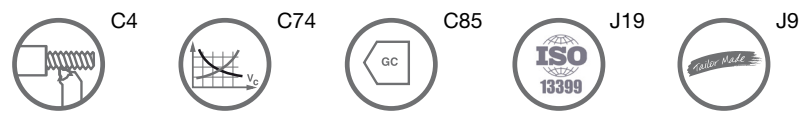
F

G

H

I

J



T-Max® U-Lock

Internal threading

T-Max® U-Lock is a complement to the CoroThread® 266 rigid indexable insert threading system. It provides a specialized solution for 11 mm (.433 inch) internal threading applications in two different geometries: all-round and sharp.

ISO application area:



Application

- Internal threading
- Circlip grooving

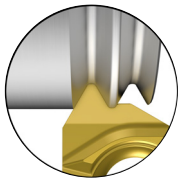
Benefits and features

- Indexable inserts
- Three sharp cutting edges for high quality threads

www.sandvik.coromant.com/tmaxulock

Inserts

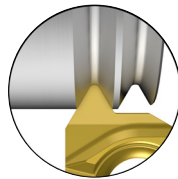
- Metric 60°
- UN 60°
- WhithWorth 55°
- NPT 60



- Insert geometries and grades for all materials
- Tailor Made inserts for almost any thread form or pitch

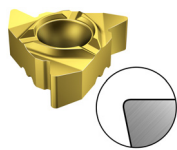
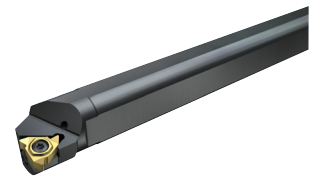
Inserts

- V-profile 60° and 55°
- Circlip grooving

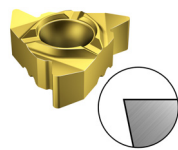


Tools

- Boring bars

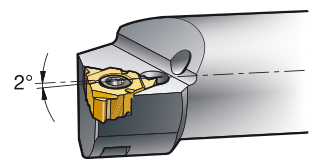


Standard geometry



Sharp F-geometry

The tool holders for inserts with size 11 are made for a 2° inclination angle and no shim



B39



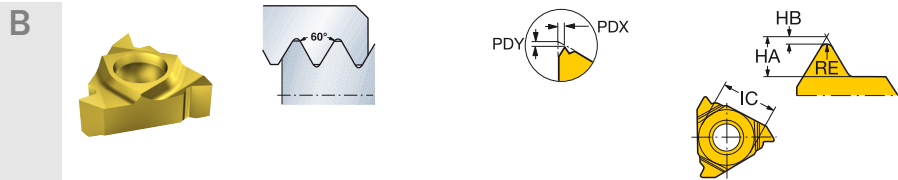
B5



J9

T-Max® U-Lock insert for thread turning

V-profile 60° Non-topping



C

Internal right-hand threads

							P	M	K	N	S	H	Dimensions, mm, inch				
	TPN	TPX	TPIN	TPIX	NT	Ordering code	1020 4125	1020 4125	1020 4125	1020 4125	1020 4125	1020 4125	RE	HA	HB	PDX	PDY
11	1/4	1.0	2.0	12.0	24.0	R166.0L-11VM01-001	★	☆	★	☆	★	☆	0.06	1.45	0.06	0.90	0.68
													.002	.0571	.0024	.035	.027
		1.0	2.0	12.0	24.0	R166.0L-11VM01C001	★	★	★	★	★	☆	0.06	1.45	0.06	0.90	0.68
													.002	.0571	.0024	.035	.027

D

Internal left-hand threads

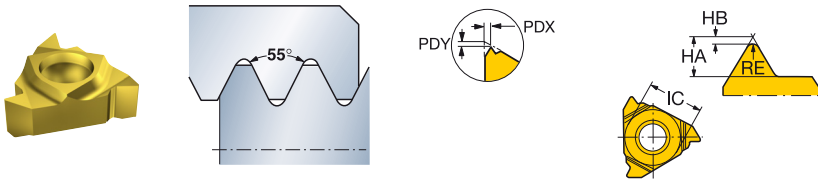
							P	M	K	N	S	H	Dimensions, mm, inch				
	TPN	TPX	TPIN	TPIX	NT	Ordering code	1020	1020	1020	1020	1020	RE	HA	HB	PDX	PDY	
11	1/4	1.0	2.0	12.0	24.0	L166.0L-11VM01-001	★	★	★	★	☆	0.06	1.45	0.06	0.90	0.06	
												.002	.0571	.0024	.035	.002	

R = Right hand, L = Left hand




T-Max® U-Lock insert for thread turning


V-profile 55° Non-topping



Internal right-hand threads

 TPIN TPIX NT	Ordering code	Dimensions, mm, inch														
		P	M	K	N	S	H	RE	HA	HB	PDX	PDY				
11 1/4 14.0 28.0 1	R166.0L-11VW01-001	1020	4125	1020	4125	1020	4125	1020	4125	1020	4125	0.11	1.60	0.12	0.95	0.68
		★	☆	★	☆	★	☆	★	☆	★	☆	.004	.0630	.0047	.037	.027

Internal left-hand threads

 TPIN TPIX NT	Ordering code	Dimensions, mm, inch										
		P	M	K	N	S	H	RE	HA	HB	PDX	PDY
11 1/4 14.0 28.0 1	L166.0L-11VW01-001	1020	1020	1020	1020	1020	1020	0.11	1.60	0.12	0.95	0.12
		★	★	★	★	★	★	.004	.0630	.0047	.037	.005

R = Right hand, L = Left hand



C50



C74



C85



J19

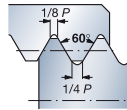
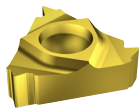


J9

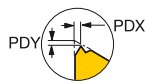


T-Max® U-Lock insert for thread turning

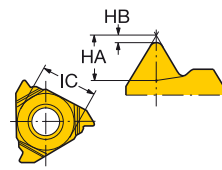
UN 60° Full form



STDNO
TCTR



ISO 5864-1978
2B



Internal right-hand threads

TPI	NT	Ordering code	Material					Dimensions, mm, inch				
			P	M	K	N	S	H	HA	HB	PDX	PDY
11	1/4	R166.0L-11UN01-320	*	*	*	*	*	*	0.50	0.04	0.60	0.68
									.0197	.0016	.024	.027
	28.0	R166.0L-11UN01-280	*	*	*	*	*	*	0.58	0.05	0.80	0.68
									.0228	.0020	.031	.027
	24.0	R166.0L-11UN01-240	*	*	*	*	*	*	0.67	0.06	0.85	0.68
									.0264	.0024	.033	.027
	20.0	R166.0L-11UN01-200	*	*	*	*	*	*	0.80	0.07	0.90	0.68
									.0315	.0028	.035	.027
	18.0	R166.0L-11UN01-180	*	*	*	*	*	*	0.89	0.08	1.00	0.68
									.0350	.0032	.039	.027
	16.0	R166.0L-11UN01-160	*	*	*	*	*	*	1.00	0.09	1.00	0.68
									.0394	.0035	.039	.027
	14.0	R166.0L-11UN01-140	*	*	*	*	*	*	1.13	0.11	1.05	0.68
									.0445	.0043	.041	.027

Internal left-hand threads

TPI	NT	Ordering code	Material					Dimensions, mm, inch				
			P	M	K	N	S	H	HA	HB	PDX	PDY
11	1/4	L166.0L-11UN01-320	*	*	*	*	*	*	0.50	0.04	0.60	0.68
									.0197	.0016	.024	.027
	28.0	L166.0L-11UN01-280	*	*	*	*	*	*	0.58	0.05	0.80	0.68
									.0228	.0020	.031	.027
	24.0	L166.0L-11UN01-240	*	*	*	*	*	*	0.67	0.06	0.85	0.68
									.0264	.0024	.033	.027
	20.0	L166.0L-11UN01-200	*	*	*	*	*	*	0.80	0.07	0.90	0.68
									.0315	.0028	.035	.027
	18.0	L166.0L-11UN01-180	*	*	*	*	*	*	0.89	0.08	1.00	0.68
									.0350	.0032	.039	.027
	16.0	L166.0L-11UN01-160	*	*	*	*	*	*	1.00	0.09	1.00	0.68
									.0394	.0035	.039	.027
	14.0	L166.0L-11UN01-140	*	*	*	*	*	*	1.13	0.11	1.05	0.68
									.0445	.0043	.041	.027

R = Right hand, L = Left hand



C50



C74



C85



J19

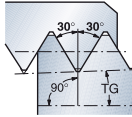
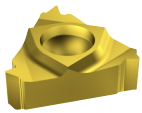


J9

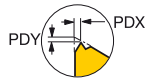


T-Max® U-Lock insert for thread turning

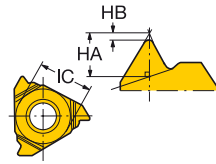
NPT 60° (NPSC, NPTR, LINE PIPE) Full form



STDNO



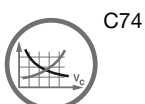
ANSI B.1.20.1-1983



Internal right-hand threads

		P M K N S H					Dimensions, mm, inch							
IC	TPI	NT	Ordering code	1020	1020	1020	1020	1020	HA	HB	PDX	PDY	TG	
11	1/4	18.0	1	R166.0L-11NT01F180	★	★	★	★	★	1.14	0.08	0.85	0.67	0.06
									.0449	.0032	.033	.026		
	14.0	1	R166.0L-11NT01F140	★	★	★	★	★	1.46	0.09	0.95	0.67	0.06	
									.0575	.0035	.037	.026		

The insert can give a slightly bigger truncation for LINE PIPE 14 t.p.i.



CoroCut® XS

B For external machining of small and slender components

C High precision components

CoroCut XS inserts offer low cutting forces thanks to the extremely sharp cutting edges. This means, at low feeds CoroCut XS is excellent for producing high precision components with close tolerances. As a bonus, all inserts fit the same tool holder keeping the tool inventory small.

D ISO application area:



E Application

- Parting off
- External threading
- External grooving
- Turning

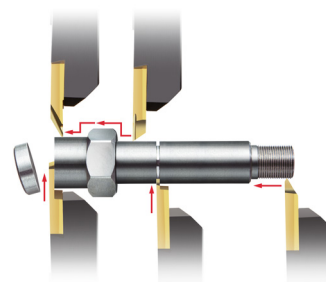
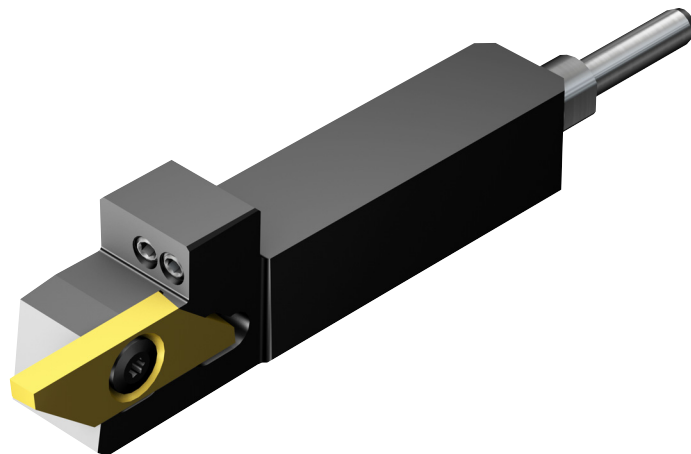
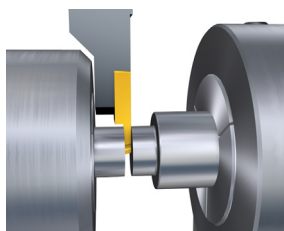
F Benefits and features

- High precision
- Close tolerances
- Good accessibility when changing inserts
- Wide variety of insert widths
- Sharp cutting edges
- All inserts fit into the same tool holder
- High quality ground inserts and holders
- Full profile inserts for high quality threads in one operation
- Designed to maintain the tool holder intact in case of insert breakage.
- Available with precision coolant

G www.sandvik.coromant.com/corocutxs

H Holders

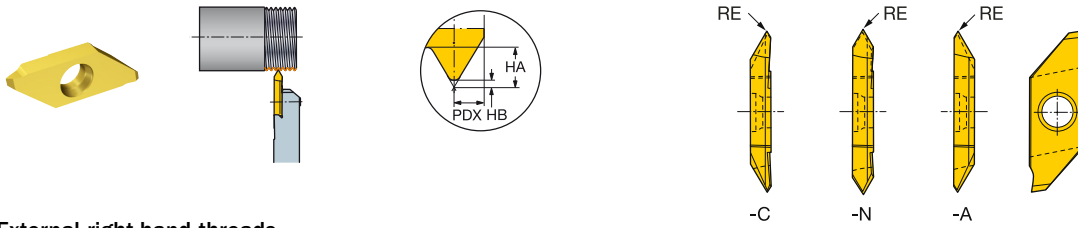
Dedicated holders for parting off close to sub spindle are available in high precision square shank style.



A30

CoroCut® XS insert for thread turning

V-profile 60° Non-topping



External right-hand threads

SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	P		M		K		N		S		O		Dimensions, mm, inch								
							1025	1105	H13A	1025	1105	H13A	1025	1105	H13A	1025	1105	H13A	1025	1105	H13A	1105	RE	HA	HB	PDX	
3	0.4	1.0	24.0	72.0	1	MATR 3 60-A	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	0.05	0.75	0.05	0.60
	0.4	1.0	24.0	72.0	1	MATR 3 60-C	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	0.05	0.75	0.05	0.60
	0.4	2.0	12.0	72.0	1	MATR 3 60-N	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	0.05	1.50	0.05	1.59
																							.002	.0295	.0020	.024	
																							.002	.0295	.0020	.024	
																							.002	.0591	.0020	.063	

External left-hand threads

SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	P		M		K		N		S		O		Dimensions, mm, inch								
							1025	1105	H13A	1025	1105	H13A	1025	1105	H13A	1025	1105	H13A	1025	1105	H13A	1105	RE	HA	HB	PDX	
3	0.4	1.0	24.0	72.0	1	MATL 3 60-A	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	0.05	0.75	0.05	0.60
	0.4	1.0	24.0	72.0	1	MATL 3 60-C	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	0.05	0.75	0.05	0.60
	0.4	2.0	12.0	72.0	1	MATL 3 60-N	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	☆	☆	★	0.05	1.50	0.05	1.59
																							.002	.0295	.0020	.024	
																							.002	.0295	.0020	.024	
																							.002	.0591	.0020	.063	

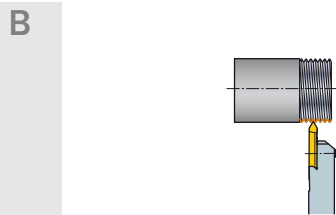
SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand

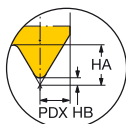


CoroCut® XS insert for thread turning

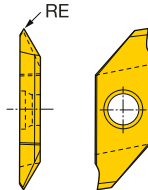
Metric 60° fullform



STDNO
TCTR



ISO 965-1998
IT 6



C External right-hand threads

SSC	TP	NT	Ordering code	P M N S O				Dimensions, mm, inch				
				1105	1105	1105	1105	RE	HA	HB	PDX	
3	0.20	1	MATR 3-MM01F-020-A	*	*	*	*	*	0.03	0.14	0.02	0.23
	.008								.001	.0055	.0008	.009
	0.25	1	MATR 3-MM01F-025-A	*	*	*	*	*	0.04	0.18	0.03	0.28
	.010								.002	.0071	.0012	.011
	0.30	1	MATR 3-MM01F-030-A	*	*	*	*	*	0.04	0.22	0.03	0.28
	.012								.002	.0087	.0012	.011
	0.35	1	MATR 3-MM01F-035-A	*	*	*	*	*	0.05	0.25	0.04	0.32
	.014								.002	.0098	.0016	.013
	0.40	1	MATR 3-MM01F-040-A	*	*	*	*	*	0.06	0.29	0.04	0.38
	.016								.002	.0114	.0016	.015
	0.45	1	MATR 3-MM01F-045-A	*	*	*	*	*	0.06	0.32	0.05	0.38
	.018								.002	.0126	.0020	.015
	0.50	1	MATR 3-MM01F-050-A	*	*	*	*	*	0.07	0.36	0.05	0.48
	.020								.003	.0142	.0020	.019
	0.70	1	MATR 3-MM01F-070-A	*	*	*	*	*	0.10	0.51	0.08	0.38
	.028								.004	.0201	.0032	.015
	0.75	1	MATR 3-MM01F-075-A	*	*	*	*	*	0.11	0.54	0.08	0.38
	.030								.004	.0213	.0032	.015
	0.80	1	MATR 3-MM01F-080-A	*	*	*	*	*	0.11	0.58	0.09	0.38
	.031								.004	.0228	.0035	.015
	1.00	1	MATR 3-MM01F-100-A	*	*	*	*	*	0.12	0.72	0.11	0.38
	.039								.005	.0283	.0043	.015
	1.25	1	MATR 3-MM01F-125-A	*	*	*	*	*	0.15	0.90	0.14	0.38
	.049								.006	.0354	.0055	.015
	1.50	1	MATR 3-MM01F-150-A	*	*	*	*	*	0.22	1.08	0.16	0.38
	.059								.009	.0425	.0063	.015

G External left-hand threads

SSC	TP	NT	Ordering code	P M N S O				Dimensions, mm, inch				
				1105	1105	1105	1105	RE	HA	HB	PDX	
3	0.40	1	MATL 3-MM01F-040-A	*	*	*	*	*	0.06	0.29	0.04	0.38
	.016								.002	.0114	.0016	.015
	0.50	1	MATL 3-MM01F-050-A	*	*	*	*	*	0.07	0.36	0.05	0.38
	.020								.003	.0142	.0020	.015
	0.70	1	MATL 3-MM01F-070-A	*	*	*	*	*	0.10	0.51	0.08	0.38
	.028								.004	.0201	.0032	.015
	0.75	1	MATL 3-MM01F-075-A	*	*	*	*	*	0.11	0.54	0.08	0.38
	.030								.004	.0213	.0032	.015
	0.80	1	MATL 3-MM01F-080-A	*	*	*	*	*	0.11	0.58	0.09	0.38
	.031								.004	.0228	.0035	.015
	1.00	1	MATL 3-MM01F-100-A	*	*	*	*	*	0.12	0.72	0.11	0.38
	.039								.005	.0283	.0043	.015
	1.25	1	MATL 3-MM01F-125-A	*	*	*	*	*	0.15	0.90	0.14	0.38
	.049								.006	.0354	.0055	.015
	1.50	1	MATL 3-MM01F-150-A	*	*	*	*	*	0.22	1.08	0.16	0.38
	.059								.009	.0425	.0063	.015

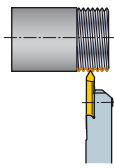
I SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand

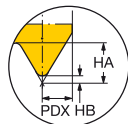


CoroCut® XS insert for thread turning

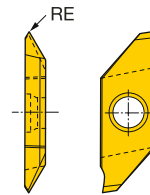
UN 60° Full form



STDNO
TCTR



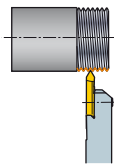
ISO 5864-1978
2A



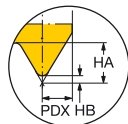
External right-hand threads

SSC	TPI	NT	Ordering code	P M N S O					Dimensions, mm, inch							
				RE	HA	HB	PDX	RE	HA	HB	PDX					
3	80.0	1	MATR 3-UN01F-800-A	*	*	*	*	*	0.04	0.22	0.04	0.38	.002	.0087	.0016	.015
	72.0	1	MATR 3-UN01F-720-A	*	*	*	*	*	0.05	0.27	0.05	0.38	.002	.0106	.0020	.015
	64.0	1	MATR 3-UN01F-640-A	*	*	*	*	*	0.06	0.31	0.06	0.38	.002	.0122	.0024	.015
	56.0	1	MATR 3-UN01F-560-A	*	*	*	*	*	0.06	0.35	0.06	0.38	.002	.0138	.0024	.015
	48.0	1	MATR 3-UN01F-480-A	*	*	*	*	*	0.07	0.38	0.07	0.38	.003	.0150	.0028	.015
	40.0	1	MATR 3-UN01F-400-A	*	*	*	*	*	0.09	0.51	0.09	0.38	.004	.0201	.0035	.015
	32.0	1	MATR 3-UN01F-320-A	*	*	*	*	*	0.10	0.59	0.10	0.38	.004	.0232	.0039	.015

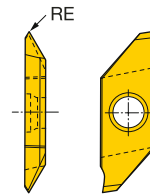
Whitworth 55° (BSW, BSF, BSP) Full form



STDNO
STDNO
STDNO
TCTR



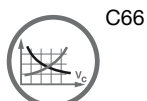
ISO 228-1982
BS-2779-1973
BS 84-1955
CLASS A



External right-hand threads

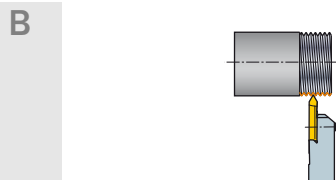
SSC	TPI	NT	Ordering code	P M N S O					Dimensions, mm, inch							
				RE	HA	HB	PDX	RE	HA	HB	PDX					
3	28.0	1	MATR 3-WH01F-280-A	*	*	*	*	*	0.13	0.72	0.13	0.38	.005	.0283	.0051	.015
	19.0	1	MATR 3-WH01F-190-A	*	*	*	*	*	0.19	1.06	0.19	0.38	.007	.0417	.0075	.015

SSC = To correspond with SSC on holder.

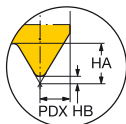


CoroCut® XS insert for thread turning

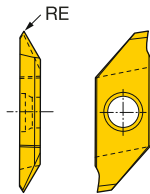
NPT 60° (NPSC, NPTR, LINE PIPE) Full form



STDNO



ANSI B.1.20.1-1983



External right-hand threads

C

SSC	TPI	NT	Ordering code	P M N S O					Dimensions, mm, inch			
				1105	1105	1105	1105	1105	RE	HA	HB	PDX
3	27.0	1	MATR 3-NT01F-270-A	*	*	*	*	*	0.05	0.76	0.05	0.38
									<i>.002</i>	<i>.0299</i>	<i>.0020</i>	<i>.015</i>
	18.0	1	MATR 3-NT01F-180-A	*	*	*	*	*	0.08	1.14	0.08	0.38
									<i>.003</i>	<i>.0449</i>	<i>.0032</i>	<i>.015</i>
	14.0	1	MATR 3-NT01F-140-A	*	*	*	*	*	0.09	1.46	0.09	0.38
									<i>.004</i>	<i>.0575</i>	<i>.0035</i>	<i>.015</i>

SSC = To correspond with SSC on holder.

E

F

G

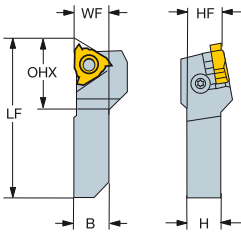
H

I

J

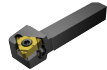


Shank tool for thread turning

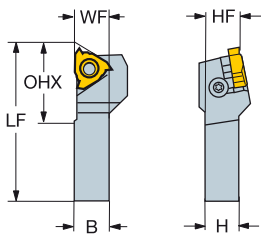


QS shank coupling -metric: 10 x 10

		Dimensions, mm											
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	NM	KG	PRODFAM	MIID



For spare parts, visit www.sandvik.coromant.com



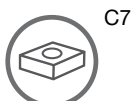
Rectangular shank -metric: 10 x 10

		Dimensions, mm											
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	NM	KG	PRODFAM	MIID

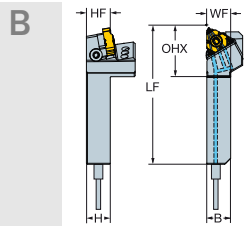


For spare parts, visit www.sandvik.coromant.com

N = Neutral, R = Right hand, L = Left hand



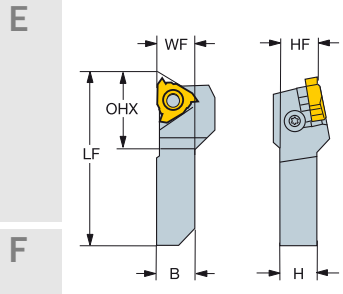
Shank tool for thread turning



C QS-HP shank coupling -metric: 12 x 12

		Dimensions, mm														
C		CZC _{MS}	OHX	CNCS	Ordering code	B	H	LF	WF	HF	THCA	BAR	NM	KG	PRODFAM	MIID
D																

For spare parts, visit www.sandvik.coromant.com



F QS shank coupling -metric: 12 x 12

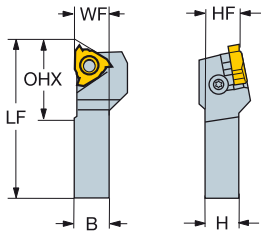
		Dimensions, mm												
F		CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	NM	KG	PRODFAM	MIID
G														

For spare parts, visit www.sandvik.coromant.com



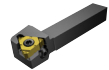
J

Shank tool for thread turning



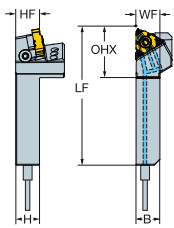
Rectangular shank -metric: 12 x 12

		Dimensions, mm												
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	NM	KG	PRODFAM	MIID	
														12 x 12



For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand

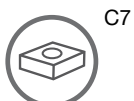


QS-HP shank coupling -metric: 16 x 16

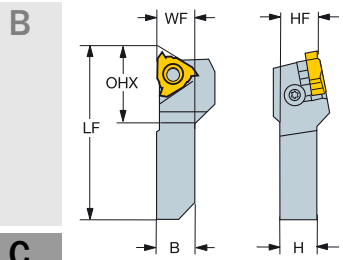
		Dimensions, mm													
16	CZC _{MS}	OHX	CNSC	Ordering code	B	H	LF	WF	HF	THCA	BAR	NM	KG	PRODFAM	MIID




For spare parts, visit www.sandvik.coromant.com



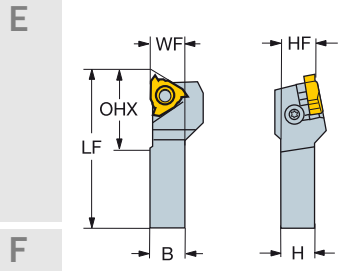
Shank tool for thread turning




C QS shank coupling -metric: 16 x 16

		Dimensions, mm												
		CZC _{MS} OHX		Ordering code	B	H	LF	WF	HF	THCA	NM	KG	PRODFAM	MIID
	16	16 x 16	23.3	QS-266RFA-1616-16	16.0	16.0	70.0	16.0	16.0	1°	3.0	0.16	CoroThread 266	266.RG-16..

For spare parts, visit www.sandvik.coromant.com



F Rectangular shank -metric: 16 x 16

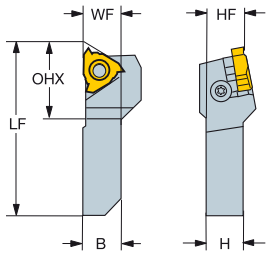
		Dimensions, mm												
		CZC _{MS} OHX		Ordering code	B	H	LF	WF	HF	THCA	NM	KG	PRODFAM	MIID
	16	16 x 16	23.3	266R/LFA-1616-16-S	16.0	16.0	125.0	16.0	16.0	1°	3.0	0.28	CoroThread 266	266.LG-16..

For spare parts, visit www.sandvik.coromant.com


R = Right hand, L = Left hand



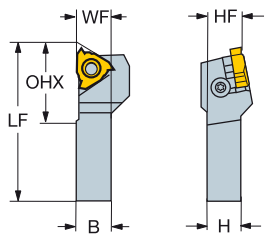
Shank tool for thread turning




QS shank coupling -inch: 3/8 x 3/8

		Dimensions, inch											
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	FT/LBS	LBS	PRODFAM	MIID
													

For spare parts, visit www.sandvik.coromant.com



Rectangular shank -inch: 3/8 x 3/8

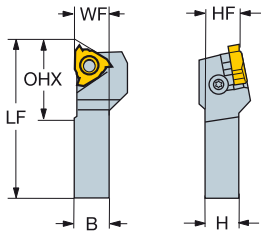
		Dimensions, inch											
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	FT/LBS	LBS	PRODFAM	MIID
													

For spare parts, visit www.sandvik.coromant.com


R = Right hand, L = Left hand



Shank tool for thread turning

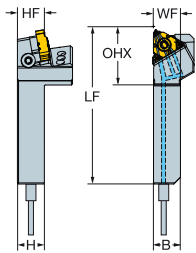


Rectangular shank -inch: 1/2 x 1/2


		Dimensions, inch												
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	FT/LBS		PRODFAM	MIID	
										PSI	LBS			
16	1/2 x 1/2	.841	266R/LFA-083-S	.500	.500	5.000	.500	.500	1°	2.2	0.32	CoroThread 266	266.LG-16..	
														

For spare parts, visit www.sandvik.coromant.com

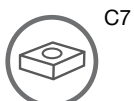
R = Right hand, L = Left hand



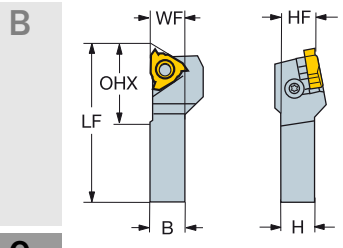
QS-HP shank coupling -inch: 5/8 x 5/8

		Dimensions, inch													
16	CZC _{MS}	OHX	CNCS	Ordering code	B	H	LF	WF	HF	THCA	FT/LBS		PRODFAM	MIID	
											PSI	LBS			
16	5/8 x 5/8	.984	1	QS-266RFA-103HP	.625	.625	2.756	.625	.625	1°	1160	2.2	0.42	CoroThread 266	266.RG-16..
															

For spare parts, visit www.sandvik.coromant.com



Shank tool for thread turning



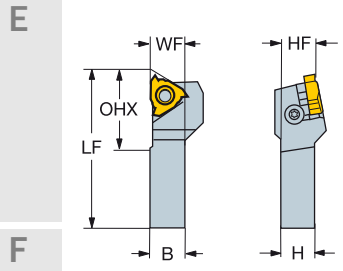
C Rectangular shank -inch: 5/8 x 5/8

		Dimensions, inch											
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	FT/LBS	LBS	PRODFAM	MIID



For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



F Rectangular shank -inch: 3/4 x 3/4

		Dimensions, inch											
16	CZC _{MS}	OHX	Ordering code	B	H	LF	WF	HF	THCA	FT/LBS	LBS	PRODFAM	MIID

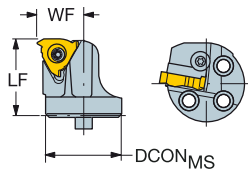


For spare parts, visit www.sandvik.coromant.com



Head for thread turning

SL head for external threading (screw mounted) -size 20



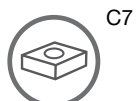
				Dimensions, mm, inch									
	CZC _{MS}	CNCS	Ordering code	DCON _{MS}	LF	WF	THCA	BAR	NM	KG	PRODFAM	MIID	
													16
	16				.787	.984	.551	1°				CoroThread 266	266.RG-16..
												CoroThread 266	266.RG-16..

SL head for external threading (screw mounted) -size 25

				Dimensions, mm, inch									
	CZC _{MS}	CNCS	Ordering code	DCON _{MS}	LF	WF	THCA	BAR	NM	KG	PRODFAM	MIID	
													16
	16				.984	.984	.669	1°	145			CoroThread 266	266.RG-16..
												CoroThread 266	266.RG-16..

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



C7



J19



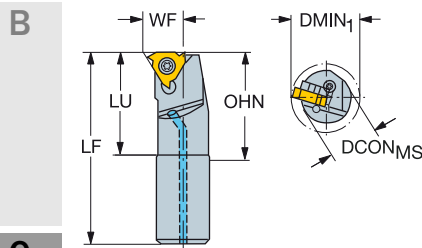
J16




J9

Solid carbide boring bar for thread turning


ENG

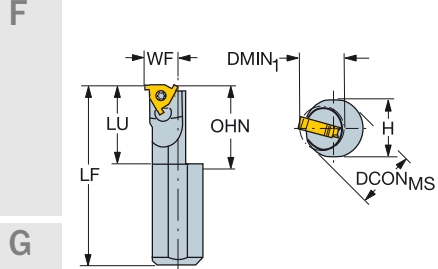


C Cylindrical shank without clamping features -metric: 10


		Dimensions, mm													
CZC _{MS}	DMIN ₁	LU	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	THCA	BAR	NM	KG	PRODFAM	MIID	
															11
															

E Cylindrical shank without clamping features -metric: 12

		Dimensions, mm													
CZC _{MS}	DMIN ₁	LU	OHN	CNSC	Ordering code	DCON _{MS}	LF	WF	THCA	BAR	NM	KG	PRODFAM	MIID	
															11
															



H Cylindrical shank with 3 flats -metric: 16

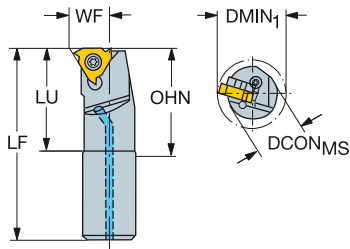
		Dimensions, mm												
CZC _{MS}	DMIN ₁	LU	OHN	Ordering code	DCON _{MS}	H	LF	WF	THCA	NM	KG	PRODFAM	MIID	
														11
														

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



Solid carbide boring bar for thread turning

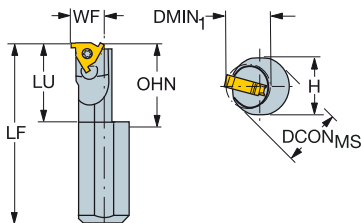


Cylindrical shank without clamping features -inch: 3/8

		Dimensions, inch												
		CZC _{MS}	DMIN ₁	OHN	Ordering code	DCON _{MS}	H	LF	WF	THCA	FT/ LBS	LBS	PRODFAM	MIID
	11	3/8	.500	.880	R/L166.0KF-D06C-2C	.375	.359	6.000	.295	1°	0.7	0.29	T-Max U-Lock	L166.0L-11..

Cylindrical shank without clamping features -inch: 1/2

		Dimensions, inch												
		CZC _{MS}	DMIN ₁	OHN	Ordering code	DCON _{MS}	H	LF	WF	THCA	FT/ LBS	LBS	PRODFAM	MIID
	11	1/2	.630	.930	R/L166.0KF-D08C-2C	.500	.484	8.000	.354	1°	0.7	0.66	T-Max U-Lock	L166.0L-11..



Cylindrical shank with 3 flats -inch: 5/8

		Dimensions, inch												
		CZC _{MS}	DMIN ₁	OHN	Ordering code	DCON _{MS}	H	LF	WF	THCA	FT/ LBS	LBS	PRODFAM	MIID
	11	5/8	.630	1.030	R166.0KF-D10-D1016-2B	.625	.563	6.000	.413	1°	0.7	0.40	T-Max U-Lock	R166.0L-11..
	11	5/8	.500	.820	R/L166.0KF-D10-D0812-2B	.625	.570	5.000	.394	1°	0.7	0.41	T-Max U-Lock	L166.0L-11..

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



C30



J19



J9

A

B

CoroTurn® XS

Internal turning, face grooving and threading of small components

C

High quality holes

This precision ground tool is perfect when producing small holes with high quality. The large variety of adaptors fit most types of sliding head machines.

The tools are designed for exact insert location which enables high precision and repeatability.

ISO application area:



D

Application

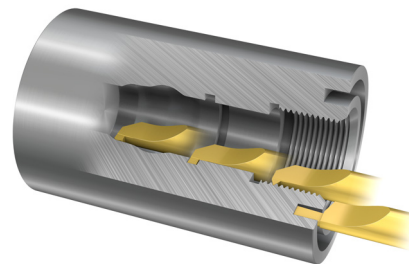
- Internal turning
- Copying
- Backboring
- Profiling
- Grooving
- Face grooving
- Pre-parting
- Threading

E

Benefits and features

- Optimized for machining of small high quality features
- High precision and repeatability
- Reliable and easy-to-use clamping system
- Precision ground tools for high repeatability
- Longer tool life by minimized micro vibrations with cylindrical carbide shank adaptors
- Clamping nut ensures easy change of cutting tool with cylindrical carbide shank adaptors

F



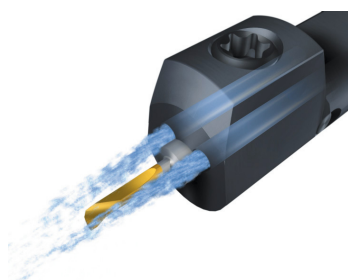
G

www.sandvik.coromant.com/coroturnxs

H

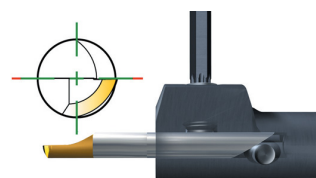
Internal coolant

- The adaptors are designed with internal precision coolant supply.
- Selectable coolant direction for better chip evacuation and safe machining



Locking precision

Precise location into the boring bar due to a locating pin.

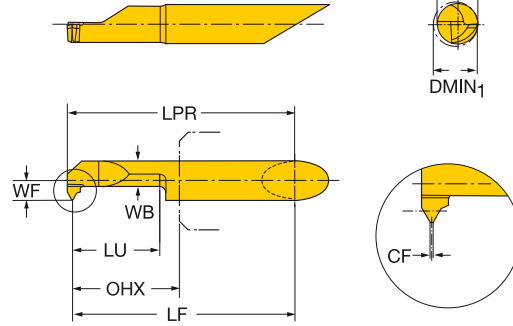
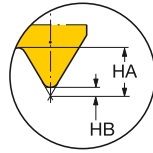


I

J

CoroTurn® XS solid carbide tool for thread turning

V-profile 60° Non-topping



Internal right-hand threads

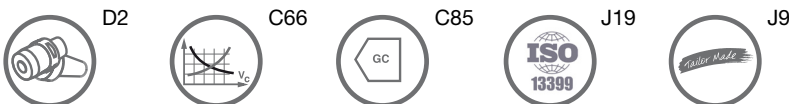
CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	H	Dimensions, mm, inch																
									1025	1025	1025	1025	7015	DCON _{MS}	WB	CF	LPR	LF	WF	HA	HB									
	4	0.50	0.70	36.0	48.0	4.2	15.0	17.6	CXS-04TH050VM-4215R	*	*	*	*	*	4	3.0	0.1	32.7	32.3	2.0	0.5	0.1	.157	.116	.002	1.287	1.272	.077	.018	.002
		.020	.028			.165	.591	.693							5	3.8	0.1	37.7	37.3	2.5	0.5	0.1	.197	.148	.002	1.485	1.469	.096	.019	.002
	5	0.50	0.75	36.0	48.0	5.2	15.0	17.6	CXS-05TH050VM-5215R	*	*	*	*	*	5	3.7	0.1	37.8	37.3	2.4	0.7	0.1	.197	.144	.004	1.486	1.469	.093	.026	.003
		.020	.030			.205	.591	.692							5	3.6	0.1	37.9	37.3	2.3	0.8	0.1	.197	.140	.005	1.490	1.469	.089	.031	.004
	5	0.75	1.00	24.0	36.0	5.1	15.0	17.6	CXS-05TH070VM-5115R	*	*	*	*	*	5	3.6	0.1	37.9	37.3	2.3	0.8	0.1	.197	.140	.005	1.490	1.469	.089	.031	.004
		.030	.039			.201	.591	.691							5	3.6	0.1	37.9	37.3	2.3	0.8	0.1	.197	.140	.005	1.490	1.469	.089	.031	.004
	5	1.00	1.25	20.0	24.0	4.8	15.0	17.5	CXS-05TH100VM-4815R	*	*	*	*	*	5	3.6	0.1	37.9	37.3	2.3	0.8	0.1	.197	.140	.005	1.490	1.469	.089	.031	.004
		.039	.049			.189	.591	.687							6	3.6	0.1	37.9	37.3	3.0	0.8	0.1	.236	.140	.005	1.490	1.469	.116	.031	.004
	6	1.00	1.25	20.0	24.0	6.2	15.0	17.5	CXS-06TH100VM-6215R	*	*	*	*	*	6	3.6	0.1	37.9	37.3	3.0	0.8	0.1	.236	.140	.005	1.490	1.469	.116	.031	.004
		.039	.049			.244	.591	.687							6	3.6	0.2	38.1	37.3	3.0	1.0	0.1	.236	.140	.006	1.502	1.469	.116	.038	.005
	6	1.25	1.50	18.0	20.0	6.2	15.0	17.2	CXS-06TH125VM-6215R	*	*	*	*	*	6	3.6	0.2	38.1	37.3	3.0	1.0	0.1	.236	.140	.006	1.502	1.469	.116	.038	.005
		.049	.059			.244	.591	.676							6	3.6	0.2	38.3	37.3	3.0	1.1	0.2	.236	.140	.007	1.507	1.469	.116	.045	.006
6	1.50	1.75	16.0	18.0	6.2	15.0	17.2	CXS-06TH150VM-6215R	*	*	*	*	*	6	3.6	0.2	38.3	37.3	3.0	1.1	0.2	.236	.140	.007	1.507	1.469	.116	.045	.006	
	.059	.069			.244	.591	.676																							

Internal left-hand threads

CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	H	Dimensions, mm, inch																	
									1025	1025	1025	1025	7015	DCON _{MS}	WB	CF	LPR	LF	WF	HA	HB										
	4	0.50	0.70	36.0	48.0	4.2	15.0	17.6	CXS-04TH050VM-4215L	*	*	*	*	*	4	3.0	0.1	32.7	32.3	2.0	0.5	0.1	.157	.116	.002	1.287	1.272	.077	.018	.002	
		.020	.028			.165	.591	.693							5	3.6	0.1	37.9	37.3	2.3	0.8	0.1	.197	.140	.005	1.490	1.469	.089	.031	.004	
	5	1.00	1.25	20.0	24.0	4.8	15.0	17.5	CXS-05TH100VM-4815L	*	*	*	*	*	5	3.6	0.1	37.9	37.3	2.3	0.8	0.1	.197	.140	.005	1.490	1.469	.089	.031	.004	
		.039	.049			.189	.591	.687							5	3.6	0.1	37.9	37.3	2.3	0.8	0.1	.197	.140	.005	1.490	1.469	.089	.031	.004	
	6	1.00	1.25	20.0	24.0	6.2	15.0	17.5	CXS-06TH100VM-6215L	*	*	*	*	*	6	3.6	0.1	37.9	37.3	3.0	0.8	0.1	.236	.140	.005	1.490	1.469	.116	.031	.004	
		.039	.049			.244	.591	.687							6	3.6	0.2	38.1	37.3	3.0	1.0	0.1	.236	.140	.006	1.502	1.469	.116	.038	.005	
	6	1.25	1.50	18.0	20.0	6.2	15.0	17.2	CXS-06TH125VM-6215L	*	*	*	*	*	6	3.6	0.2	38.1	37.3	3.0	1.0	0.1	.236	.140	.006	1.502	1.469	.116	.038	.005	
		.049	.059			.244	.591	.676							6	3.6	0.2	38.3	37.3	3.0	1.1	0.2	.236	.140	.007	1.507	1.469	.116	.045	.006	
	6	1.50	1.75	16.0	18.0	6.2	15.0	17.2	CXS-06TH150VM-6215L	*	*	*	*	*	6	3.6	0.2	38.3	37.3	3.0	1.1	0.2	.236	.140	.007	1.507	1.469	.116	.045	.006	
		.059	.069			.244	.591	.676																							

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



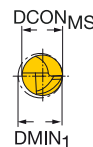
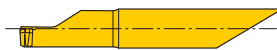
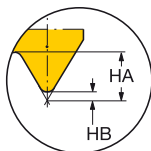
CoroTurn® XS solid carbide tool for thread turning

Metric 60° Full form

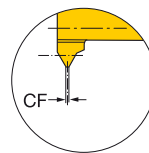
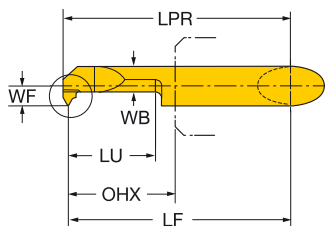
ENG

B

TCTR IT 6



C

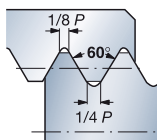


Internal right-hand threads

D

CZC _{MS}	TP	DMIN ₁	LU	OHX	Ordering code	P	M	N	S	Dimensions, mm, inch							
						1025	1025	1025	1025	DCON _{MS}	WB	CF	LPR	LF	WF	HA	HB
4	0.5	4.2	15.0	17.6	CXS-04TH050MM-4215R	*	*	*	*	4	3.5	0.1	32.7	32.3	2.0	0.5	0.1
	.020	.165	.591	.693						.157	.136	.002	1.287	1.272	.077	.018	.002
5	0.5	5.2	15.0	17.6	CXS-05TH050MM-5215R	*	*	*	*	5	4.5	0.1	37.7	37.3	2.5	0.5	0.1
	.020	.205	.591	.693						.197	.175	.002	1.484	1.469	.096	.018	.002
4	0.7	4.2	15.0	17.5	CXS-04TH070MM-4215R	*	*	*	*	4	3.3	0.1	32.8	32.3	1.9	0.8	0.1
	.028	.165	.591	.689						.157	.128	.003	1.291	1.272	.075	.030	.003
5	0.8	5.1	15.0	17.5	CXS-05TH075MM-5115R	*	*	*	*	5	4.2	0.1	37.8	37.3	2.4	0.8	0.1
	.030	.201	.591	.689						.197	.163	.004	1.488	1.469	.094	.031	.003
4	0.8	4.0	15.0	17.5	CXS-04TH080MM-4015R	*	*	*	*	4	3.0	0.1	32.8	32.3	1.9	0.8	0.1
	.031	.157	.591	.689						.157	.118	.004	1.291	1.272	.073	.033	.004
5	1.0	4.8	15.0	17.4	CXS-05TH100MM-4815R	*	*	*	*	5	3.6	0.1	37.9	37.3	2.3	1.0	0.1
	.039	.189	.591	.685						.197	.140	.005	1.492	1.469	.089	.039	.004
6	1.0	6.2	15.0	17.4	CXS-06TH100MM-6215R	*	*	*	*	6	5.1	0.1	37.9	37.3	3.0	1.0	0.1
	.039	.244	.591	.685						.236	.199	.005	1.492	1.469	.116	.039	.004
6	1.3	6.2	15.0	17.3	CXS-06TH125MM-6215R	*	*	*	*	6	4.8	0.2	38.0	37.3	3.0	1.3	0.1
	.049	.244	.591	.681						.236	.189	.006	1.496	1.469	.116	.050	.005
6	1.5	6.2	15.0	17.2	CXS-06TH150MM-6215R	*	*	*	*	6	4.5	0.2	38.1	37.3	3.0	1.6	0.2
	.059	.244	.591	.677						.236	.177	.007	1.500	1.469	.116	.063	.006
6	1.8	6.2	15.0	17.1	CXS-06TH175MM-6215R	*	*	*	*	6	4.3	0.2	38.2	37.3	3.0	1.8	0.2
	.069	.244	.591	.673						.236	.169	.008	1.504	1.469	.116	.072	.007
6	2.0	6.2	15.0	17.0	CXS-06TH200MM-6215R	*	*	*	*	6	4.1	0.3	38.3	37.3	3.0	2.1	0.2
	.079	.244	.591	.669						.236	.161	.010	1.508	1.469	.116	.081	.009

E



F

G

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand

H

I

J



D2



C66



C85



J19

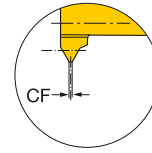
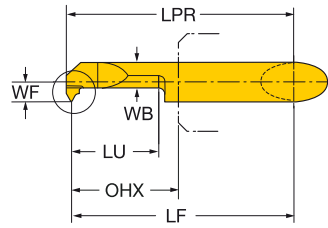
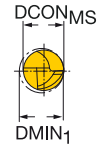
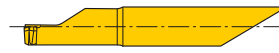
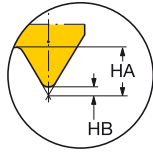


J9

CoroTurn® XS solid carbide tool for thread turning

UN 60° Full form

TCTR 2B



Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	LU	OHX	Ordering code	P M N S				Dimensions, mm, inch								
						1025	1025	1025	1025	DCON _{MS}	WB	CF	LPR	LF	WF	HA	HB	
						★	★	★	★									
	4	32.0	4.0	15.0	17.5	CXS-04TH320UN-4015R	★	★	★	★	4	3.0	0.1	32.9	32.3	1.9	0.9	0.1
			.157	.591	.687						.157	.116	.004	1.293	1.272	.073	.035	.004
	4	28.0	4.0	15.0	17.4	CXS-04TH280UN-4015R	★	★	★	★	4	3.0	0.1	32.9	32.3	1.9	0.9	0.1
			.157	.591	.685						.157	.116	.004	1.295	1.272	.073	.035	.004
	4	24.0	4.2	15.0	17.4	CXS-04TH240UN-4215R	★	★	★	★	4	3.1	0.1	33.0	32.3	2.0	1.0	0.1
			.165	.591	.683						.157	.120	.005	1.297	1.272	.077	.040	.004
	5	20.0	5.2	15.0	17.3	CXS-05TH200UN-5215R	★	★	★	★	5	4.0	0.2	38.0	37.3	2.5	1.1	0.1
			.205	.591	.681						.197	.156	.006	1.496	1.469	.096	.044	.005
	6	18.0	6.2	15.0	17.3	CXS-06TH180UN-6215R	★	★	★	★	6	4.9	0.2	38.1	37.3	3.0	1.3	0.2
			.244	.591	.679						.236	.191	.007	1.498	1.469	.116	.049	.006
	6	16.0	6.2	15.0	15.2	CXS-06TH160UN-6215R	★	★	★	★	6	4.8	0.2	38.2	37.3	3.0	1.4	0.2
			.244	.591	.596						.236	.187	.008	1.502	1.469	.116	.054	.006

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand



D2



C66



C85



J19

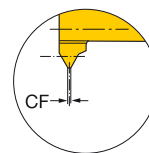
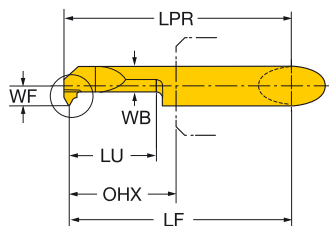
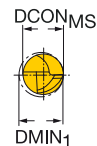
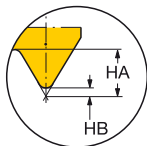


J9

CoroTurn® XS solid carbide tool for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

TCTR CLASS A



Internal right-hand threads

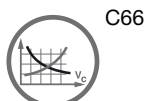
CZC _{MS}	TPI	DMIN ₁	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm, inch								
							1025	1025	1025	1025	DCON _{MS}	WB	LPR	LF	WF	HA	HB		
	5	28.0	5.2	15.0	0.120	17.2	CXS-05TH28WH-5215R	*	*	*	*	5	3.8	38.1	37.3	2.5	0.7	0.1	
			.205	.591	.005	.677							.197	.148	1.500	1.469	.096	.029	.006
	6	28.0	6.2	15.0	0.120	17.2	CXS-06TH28WH-6215R	*	*	*	*	6	4.0	38.1	37.3	3.0	0.7	0.1	
			.244	.591	.005	.677							.236	.156	1.500	1.469	.116	.029	.006
	5	26.0	5.2	15.0	0.150	17.2	CXS-05TH26WH-5215R	*	*	*	*	5	3.8	38.1	37.3	2.5	0.8	0.2	
			.205	.591	.006	.677							.197	.148	1.500	1.469	.096	.031	.006
	5	24.0	5.2	15.0	0.150	17.2	CXS-05TH24WH-5215R	*	*	*	*	5	3.8	38.1	37.3	2.5	0.9	0.2	
			.205	.591	.006	.677							.197	.148	1.500	1.469	.096	.033	.007
	6	22.0	6.2	15.0	0.160	17.0	CXS-06TH22WH-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	0.9	0.2	
			.244	.591	.006	.669							.236	.156	1.508	1.469	.116	.036	.007
	6	20.0	6.2	15.0	0.170	17.0	CXS-06TH20WH-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	1.0	0.2	
			.244	.591	.007	.669							.236	.156	1.508	1.469	.116	.040	.008
6	19.0	6.2	15.0	0.180	17.0	CXS-06TH19WH-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	1.1	0.2		
		.244	.591	.007	.669							.236	.156	1.508	1.469	.116	.042	.008	

Internal left-hand threads

CZC _{MS}	TPI	DMIN ₁	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm, inch							
							1025	1025	1025	1025	DCON _{MS}	WB	LPR	LF	WF	HA	HB	
	6	19.0	6.2	15.0	0.180	17.0	CXS-06TH19WH-6215L	*	*	*	*	6	4.0	38.3	37.3	3.0	1.1	0.2
			.244	.591	.007	.669							.236	.156	1.508	1.469	.116	.042

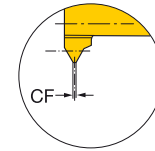
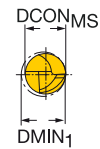
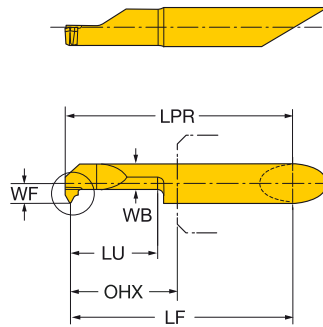
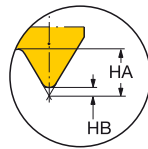
CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



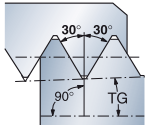
CoroTurn® XS solid carbide tool for thread turning

NPT 60° (NPSC, NPTR, LINE PIPE) Full form



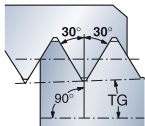
Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm, inch						
							1025	1025	1025	1025	DCON _{MS}	WB	LPR	LF	WF	HA	HB
6	27.0	6.2	15.0	0.070	17.2	CXS-06TH27NT-6215R	*	*	*	*	6	4.0	38.1	37.3	3.0	1.6	0.0
											.236	.156	1.500	1.469	.116	.064	.001
6	18.0	6.2	15.0	0.100	17.2	CXS-06TH18NT-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	1.6	0.0
											.236	.156	1.508	1.469	.116	.065	.002



Internal left-hand threads

CZC _{MS}	TPI	DMIN ₁	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm, inch						
							1025	1025	1025	1025	DCON _{MS}	WB	LPR	LF	WF	HA	HB
6	18.0	6.2	15.0	0.100	17.0	CXS-06TH18NT-6215L	*	*	*	*	6	4.0	38.3	37.3	3.0	1.6	0.0
											.236	.156	1.508	1.469	.116	.065	.002



CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



C66



C85



J19

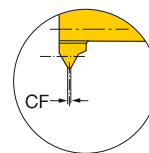
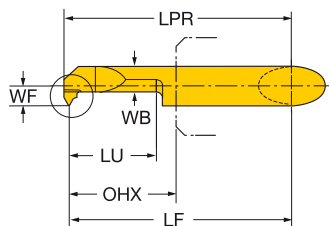
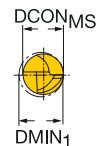
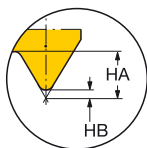


J9

CoroTurn® XS solid carbide tool for thread turning

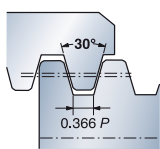
ISO Trapezoidal 30° Chamfered crest form

TCTR IT 7



C Internal right-hand threads

CZC _{MS}	TP	DMIN ₁	LU	OHX	Ordering code	P M N S			Dimensions, mm, inch							
						1025	1025	1025	DCON _{MS}	WB	CF	LPR	LF	WF	HA	HB
6	1.5	6.2	20.0	17.4	CXS-06TH150TR-6220R	*	*	*	6	4.9	0.5	38.2	37.6	3.0	1.8	0.9
	.059	.244	.787	.685					.236	.193	.019	1.504	1.480	.116	.071	.036
6	2.0	6.2	20.0	17.3	CXS-06TH200TR-6220R	*	*	*	6	4.6	0.6	38.4	37.6	3.0	2.4	1.2
	.079	.244	.787	.679					.236	.179	.024	1.510	1.480	.116	.095	.046
7	3.0	7.2	30.0	16.9	CXS-07TH300TR-7230R	*	*	*	7	4.6	1.0	53.4	52.3	3.5	3.5	1.8
	.118	.283	1.181	.665					.276	.179	.038	2.100	2.057	.136	.139	.070



CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand



CoroCut® MB

For internal machining with high precision

Internal machining with high precision

The sharp cutting edges of CoroCut MB are perfect for internal machining with high quality demands at low feed and speed. The system is easy to index for fast set-up of both tools and inserts, keeping the machine down-time to a minimum. For long overhangs steel shanks and carbide shanks are available for up to $5.5 \times$ bar diameter.

ISO application area:

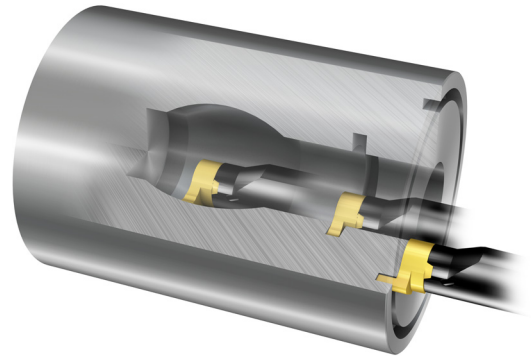


Application

- For internal machining of small holes
- Pre-parting
- Grooving
- Face grooving
- Profiling
- Turning
- Copying
- Back boring
- Threading

Benefits and features

- Vibration free machining
- Fast set up for both tool and insert
- Stable high precision interface between interface and tool holder
- Front-mounted exchangeable cutting tool
- Sharp cutting edges
- Geometries and grades for all materials
- Carbide shanks for long overhangs
- Through coolant
- Easy fix clamping
- Grooving tools in a large variety of widths and corner radii – also for standardized grooves such as O-rings and circlip grooves.



www.sandvik.coromant.com/corocutmb

EasyFix

Cylindrical steel and carbide boring bars to be used with EasyFix sleeves for exact centre height.

CoroCut® MB boring bars

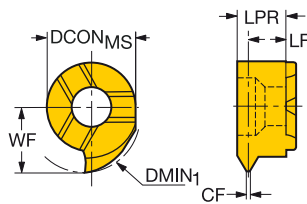
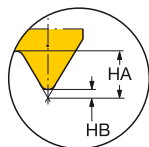
For stability and accessibility the bars are designed with an eccentric head with oval cross section.

CoroCut® MB solid carbide head for thread turning

V-profile 60° Non-topping

ENG

B



C

Internal right-hand threads

D

CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm, inch								
							1025	1025	1025	1025	DCON _{MS}	CF	LPR	LF	WF	HA	HB		
							*	*	*	*									
	07	0.50	0.75	34.0	51.0	10.0	MB-07TH050VM-10R	*	*	*	*	7	0.1	3.8	3.4	5.8	0.5	0.1	
		.020	.030			.394						.276	.002	.150	.134	.228	.018	.002	
	07	1.00	1.25	20.0	25.0	10.0	MB-07TH100VM-10R	*	*	*	*	7	0.1	3.8	3.2	5.8	0.8	0.1	
		.039	.049			.394							.276	.005	.150	.126	.228	.031	.004
	07	1.50	1.75	15.0	17.0	10.0	MB-07TH150VM-10R	*	*	*	*	7	0.2	3.8	3.0	5.8	1.1	0.2	
		.059	.069			.394							.276	.007	.150	.118	.228	.044	.006
07	2.00	2.50	10.0	13.0	10.0	MB-07TH200VM-10R	*	*	*	*	7	0.3	3.8	2.8	5.8	1.6	0.2		
	.079	.098			.394							.276	.010	.150	.108	.228	.064	.009	
07	2.50	3.00	8.0	10.0	10.0	MB-07TH250VM-10R	*	*	*	*	7	0.3	3.8	2.6	5.8	2.0	0.3		
	.098	.118			.394							.276	.012	.150	.100	.228	.077	.011	

E

Internal left-hand threads

F

CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm, inch								
							1025	1025	1025	1025	DCON _{MS}	CF	LPR	LF	WF	HA	HB		
							*	*	*	*									
	07	0.50	0.75	34.0	51.0	10.0	MB-07TH050VM-10L	*	*	*	*	7	0.1	3.8	3.4	5.8	0.5	0.1	
		.020	.030			.394						.276	.002	.150	.134	.228	.018	.002	
	07	1.00	1.25	20.0	25.0	10.0	MB-07TH100VM-10L	*	*	*	*	7	0.1	3.8	3.2	5.8	0.8	0.1	
		.039	.049			.394							.276	.005	.150	.126	.228	.031	.004
	07	1.50	1.75	15.0	17.0	10.0	MB-07TH150VM-10L	*	*	*	*	7	0.2	3.8	3.0	5.8	1.1	0.2	
		.059	.069			.394							.276	.007	.150	.118	.228	.044	.006
07	2.00	2.50	10.0	13.0	10.0	MB-07TH200VM-10L	*	*	*	*	7	0.3	3.8	2.8	5.8	1.6	0.2		
	.079	.098			.394							.276	.010	.150	.108	.228	.064	.009	
07	2.50	3.00	8.0	10.0	10.0	MB-07TH250VM-10L	*	*	*	*	7	0.3	3.8	2.6	5.8	2.0	0.3		
	.098	.118			.394							.276	.012	.150	.100	.228	.077	.011	

G

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand

H

I

J



D2



C66



C85



J19



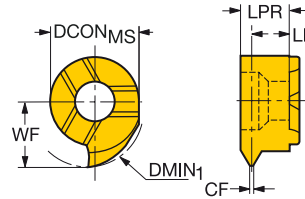
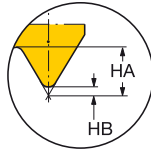
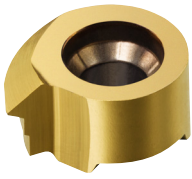
J9

CoroCut® MB solid carbide head for thread turning

Metric 60° Full form

TCTR

IT 6



Internal right-hand threads

CZC _{MS}	TP	DMIN ₁	Ordering code	P M N S H				Dimensions, mm, inch								
				1025	1025	1025	1025	7015	DCON _{MS}	CF	LPR	LF	WF	HA	HB	
				*	*	*	*	*								
	07	0.5	10.0	MB-07TH050MM-10R	*	*	*	*	*	7	0.1	3.8	3.4	5.8	0.5	0.1
		.020	.394							.276	.002	.150	.134	.228	.018	.002
	07	1.0	10.0	MB-07TH100MM-10R	*	*	*	*	*	7	0.1	3.8	3.2	5.8	0.9	0.1
		.039	.394							.276	.005	.150	.126	.228	.035	.004
	07	1.5	10.0	MB-07TH150MM-10R	*	*	*	*	*	7	0.2	3.8	3.0	5.8	1.4	0.2
		.059	.394							.276	.007	.150	.118	.228	.054	.006
	07	1.8	10.0	MB-07TH175MM-10R	*	*	*	*	*	7	0.2	3.8	2.9	5.8	1.1	0.2
	.069	.394							.276	.008	.150	.114	.228	.044	.007	
07	2.0	10.0	MB-07TH200MM-10R	*	*	*	*	*	7	0.3	3.8	2.8	5.8	1.3	0.2	
	.079	.394							.276	.010	.150	.108	.228	.051	.009	
07	2.5	10.0	MB-07TH250MM-10R	*	*	*	*	*	7	0.3	3.8	2.6	5.8	1.6	0.3	
	.098	.394							.276	.012	.150	.100	.228	.064	.011	

Internal left-hand threads

CZC _{MS}	TP	DMIN ₁	Ordering code	P M N S H				Dimensions, mm, inch								
				1025	1025	1025	1025	7015	DCON _{MS}	CF	LPR	LF	WF	HA	HB	
				*	*	*	*	*								
	07	0.5	10.0	MB-07TH050MM-10L	*	*	*	*	*	7	0.1	3.8	3.4	5.8	0.5	0.1
		.020	.394							.276	.002	.150	.134	.228	.018	.002
	07	1.0	10.0	MB-07TH100MM-10L	*	*	*	*	*	7	0.1	3.8	3.2	5.8	0.9	0.1
		.039	.394							.276	.005	.150	.126	.228	.035	.004
	07	1.5	10.0	MB-07TH150MM-10L	*	*	*	*	*	7	0.2	3.8	3.0	5.8	1.4	0.2
		.059	.394							.276	.007	.150	.118	.228	.054	.006
	07	1.8	10.0	MB-07TH175MM-10L	*	*	*	*	*	7	0.2	3.8	2.9	5.8	1.1	0.2
	.069	.394							.276	.008	.150	.114	.228	.044	.007	
07	2.0	10.0	MB-07TH200MM-10L	*	*	*	*	*	7	0.3	3.8	2.8	5.8	1.3	0.2	
	.079	.394							.276	.010	.150	.108	.228	.051	.009	
07	2.5	10.0	MB-07TH250MM-10L	*	*	*	*	*	7	0.3	3.8	2.6	5.8	1.6	0.3	
	.098	.394							.276	.012	.150	.100	.228	.064	.011	

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



C66



C85



J19

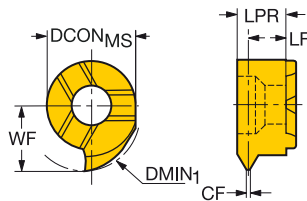
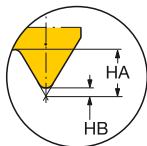
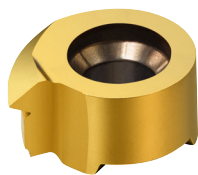


J9

CoroCut® MB solid carbide head for thread turning

UN 60° Full form

TCTR 2B



Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	Ordering code	Dimensions, mm, inch				DCON _{MS}	CF	LPR	LF	WF	HA	HB	
				P	M	N	S								
				1025	1025	1025	1025								
	07	32.0	10.0	MB-07TH320UN-10R	*	*	*	*	7	0.1	3.8	3.4	5.8	0.9	0.1
									.276	.004	.150	.134	.228	.035	.004
	07	28.0	10.0	MB-07TH280UN-10R	*	*	*	*	7	0.1	3.8	3.4	5.8	0.9	0.1
									.276	.004	.150	.134	.228	.035	.004
	07	24.0	10.0	MB-07TH240UN-10R	*	*	*	*	7	0.1	3.8	3.3	5.8	1.0	0.1
									.276	.005	.150	.130	.228	.040	.004
	07	20.0	10.0	MB-07TH200UN-10R	*	*	*	*	7	0.2	3.8	3.2	5.8	1.1	0.1
									.276	.006	.150	.126	.228	.044	.005
	07	18.0	10.0	MB-07TH180UN-10R	*	*	*	*	7	0.2	3.8	3.2	5.8	1.3	0.2
								.276	.007	.150	.126	.228	.049	.006	
07	16.0	10.0	MB-07TH160UN-10R	*	*	*	*	7	0.2	3.8	3.1	5.8	1.4	0.2	
								.276	.007	.150	.122	.228	.054	.006	
07	14.0	10.0	MB-07TH140UN-10R	*	*	*	*	7	0.2	3.8	3.2	5.8	1.6	0.2	
								.276	.009	.150	.126	.228	.063	.007	

Internal left-hand threads

CZC _{MS}	TPI	DMIN ₁	Ordering code	Dimensions, mm, inch				DCON _{MS}	CF	LPR	LF	WF	HA	HB	
				P	M	N	S								
				1025	1025	1025	1025								
	07	28.0	10.0	MB-07TH280UN-10L	*	*	*	*	7	0.1	3.8	3.4	5.8	0.9	0.1
									.276	.004	.150	.134	.228	.035	.004
	07	24.0	10.0	MB-07TH240UN-10L	*	*	*	*	7	0.1	3.8	3.3	5.8	1.0	0.1
									.276	.005	.150	.130	.228	.040	.004
	07	20.0	10.0	MB-07TH200UN-10L	*	*	*	*	7	0.2	3.7	3.2	5.8	1.1	0.1
									.276	.006	.146	.126	.228	.044	.005
	07	18.0	10.0	MB-07TH180UN-10L	*	*	*	*	7	0.2	3.8	3.2	5.8	1.3	0.2
									.276	.007	.150	.126	.228	.049	.006
	07	16.0	10.0	MB-07TH160UN-10L	*	*	*	*	7	0.2	3.8	3.1	5.8	1.4	0.2
								.276	.007	.150	.122	.228	.054	.006	
07	14.0	10.0	MB-07TH140UN-10L	*	*	*	*	7	0.2	3.8	3.2	5.8	1.6	0.2	
								.276	.009	.150	.126	.228	.063	.007	

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



C66



C85



J19

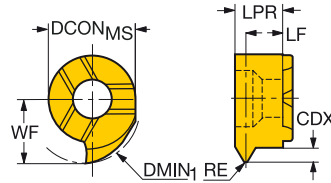
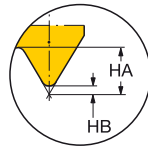


J9

CoroCut® MB solid carbide head for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

TCTR CLASS A



Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	P M N S			Dimensions, mm, inch						
					1025	1025	1025	DCON _{MS}	LPR	LF	WF	HA	HB	
	07	19.0	10.0	0.180	MB-07TH190WH-10R	*	*	*	7	3.8	2.8	5.8	1.1	0.2
									.276	.150	.110	.228	.042	.008
	07	14.0	10.0	0.240	MB-07TH140WH-10R	*	*	*	7	3.8	2.6	5.8	1.4	0.3
									.276	.150	.102	.228	.057	.011
07	11.0	10.0	0.310	MB-07TH110WH-10R	*	*	*	7	3.8	2.3	5.8	1.8	0.4	
									.276	.150	.091	.228	.072	.014

Internal left-hand threads

CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	P M N S			Dimensions, mm, inch						
					1025	1025	1025	DCON _{MS}	LPR	LF	WF	HA	HB	
	07	19.0	10.0	0.180	MB-07TH190WH-10L	*	*	*	7	3.8	2.8	5.8	1.1	0.2
									.276	.150	.110	.228	.042	.008
	07	14.0	10.0	0.240	MB-07TH140WH-10L	*	*	*	7	3.8	2.6	5.8	1.4	0.3
									.276	.150	.102	.228	.057	.011
07	11.0	10.0	0.310	MB-07TH110WH-10L	*	*	*	7	3.8	2.3	5.8	1.8	0.4	
									.276	.150	.091	.228	.072	.014

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



D2



C66



C85



J19



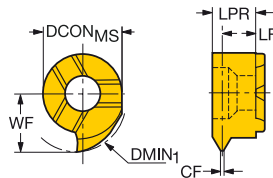
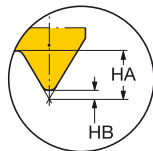
J9



CoroCut® MB solid carbide head for thread turning

NPT 60° (NPSC, NPTR, LINE PIPE) Full form

ENG



C Internal right-hand threads

D	CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	P	M	N	S	Dimensions, mm, inch						
						1025	1025	1025	1025	DCON _{MS}	LPR	LF	WF	HA	HB	
	07	18.0	10.0	0.050	MB-07TH180NT-10R	*	*	*	*	7	3.8	2.9	5.8	1.4	0.0	
				.394	.002						.276	.150	.114	.228	.057	.002
	07	14.0	10.0	0.070	MB-07TH140NT-10R	*	*	*	*	7	3.8	2.7	5.8	1.5	0.1	
				.394	.003						.276	.150	.106	.228	.061	.002

E Internal left-hand threads

F	CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	P	M	N	S	Dimensions, mm, inch						
						1025	1025	1025	1025	DCON _{MS}	LPR	LF	WF	HA	HB	
	07	18.0	10.0	0.050	MB-07TH180NT-10L	*	*	*	*	7	3.8	2.9	5.8	1.4	0.0	
				.394	.002						.276	.150	.114	.228	.057	.002
	07	14.0	10.0	0.070	MB-07TH140NT-10L	*	*	*	*	7	3.8	2.7	5.8	1.5	0.1	
				.394	.003						.276	.150	.106	.228	.061	.002

G CZC_{MS} to correspond with CZC_{WS} on adaptor. R = Right hand, L = Left hand

H

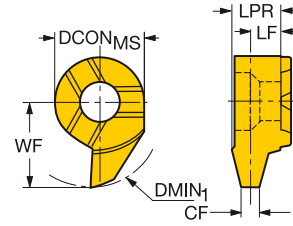
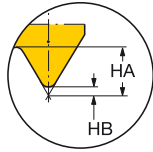
I



CoroCut® MB solid carbide head for thread turning

ACME 29° partial profile

TCTR 2G

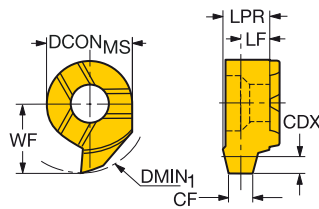
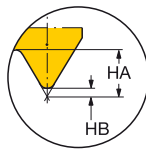


Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	Ordering code	Dimensions, mm, inch				DCON _{MS}	CF	LPR	LF	WF	HA	HB		
				P	M	N	S									
	07	16.0	11.0	MB-07TH160AC-11R	1025	1025	1025	1025	7	0.5	3.9	3.3	6.8	2.1	1.0	
			.433			*	*	*	*	.276	.020	.154	.130	.268	.081	.040
	07	14.0	11.0	MB-07TH140AC-11R	1025	1025	1025	1025	7	0.6	3.9	3.2	6.8	2.3	1.2	
			.433			*	*	*	*	.276	.024	.154	.126	.268	.092	.046
	07	12.0	11.0	MB-07TH120AC-11R	1025	1025	1025	1025	7	0.7	3.9	3.1	6.8	2.7	1.4	
			.433			*	*	*	*	.276	.028	.154	.122	.268	.106	.054
07	10.0	11.0	MB-07TH100AC-11R	1025	1025	1025	1025	7	0.8	3.9	3.0	6.8	3.3	1.6		
		.433			*	*	*	*	.276	.031	.154	.118	.268	.131	.061	
07	8.0	11.0	MB-07TH080AC-11R	1025	1025	1025	1025	7	1.0	3.9	2.8	6.8	4.1	2.0		
		.433			*	*	*	*	.276	.041	.154	.110	.268	.161	.078	

STUB-ACME 29° partial profile

TCTR 2G



Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	Ordering code	Dimensions, mm, inch				DCON _{MS}	CF	LPR	LF	WF	HA	HB		
				P	M	N	S									
	07	16.0	10.0	MB-07TH160SA-10R	1025	1025	1025	1025	7	0.6	4.0	3.4	5.8	1.9	1.1	
			.394			*	*	*	*	.276	.023	.157	.132	.228	.074	.045
	07	14.0	10.0	MB-07TH140SA-10R	1025	1025	1025	1025	7	0.7	4.0	3.3	5.8	2.2	1.3	
			.394			*	*	*	*	.276	.027	.157	.128	.228	.085	.052
	07	12.0	10.0	MB-07TH120SA-10R	1025	1025	1025	1025	7	0.8	4.0	3.2	5.8	2.5	1.6	
			.394			*	*	*	*	.276	.032	.157	.126	.228	.099	.063
07	10.0	10.0	MB-07TH100SA-10R	1025	1025	1025	1025	7	0.9	3.9	3.1	5.8	3.0	1.8		
		.394			*	*	*	*	.276	.037	.154	.120	.228	.118	.071	
07	8.0	10.0	MB-07TH080SA-10R	1025	1025	1025	1025	7	1.2	3.7	2.5	5.8	3.7	2.3		
		.394			*	*	*	*	.276	.047	.146	.096	.228	.146	.091	

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand



D2



C66



C85



J19



J9



CoroCut® MB

Threading, (Infeed recommendations)

Thread	Insert	a_p mm	a_p inch	nap
V-profile 60°	MB-07TH050VM-10R/L	0.33	.013	4
	MB-07TH100VM-10R/L	0.64	.025	5
	MB-07TH150VM-10R/L	0.89	.035	6
	MB-07TH200VM-10R/L	1.19	.047	8
	MB-07TH250VM-10R/L	1.50	.059	10
Metric 60°	MB-07TH050MM-10R/L	0.33	.013	4
	MB-07TH100MM-10R/L	0.64	.025	5
	MB-07TH150MM-10R/L	0.89	.035	6
	MB-07TH175MM-10R/L	1.07	.042	8
	MB-07TH200MM-10R/L	1.19	.047	8
	MB-07TH250MM-10R/L	1.50	.059	10
UN 60°	MB-07TH320UN-10R/L	0.48	.019	4
	MB-07TH280UN-10R/L	0.58	.023	5
	MB-07TH240UN-10R/L	0.66	.026	5
	MB-07TH200UN-10R/L	0.79	.031	6
	MB-07TH180UN-10R/L	0.86	.034	6
	MB-07TH160UN-10R/L	0.94	.037	7
	MB-07TH140UN-10R/L	1.09	.043	8
Whitworth 55°	MB-07TH190WH-10R/L	0.91	.036	6
	MB-07TH140WH-10R/L	1.21	.048	8
	MB-07TH110WH-10R/L	1.54	.061	9
NPT 60°	MB-07TH180NT-10R/L	1.11	.044	8
	MB-07TH140NT-10R/L	1.42	.056	10

Thread	Insert	a_p mm	a_p inch	nap
ACME 29°	MB-07TH160AC-11R	0.96	.038	6
	MB-07TH140AC-11R	1.09	.043	7
	MB-07TH120AC-11R	1.24	.049	8
	MB-07TH100AC-11R	1.60	.063	10
	MB-07TH080AC-11R	1.90	.075	12
STUB-ACME 29°	MB-07TH160SA-10R	0.66	.026	5
	MB-07TH140SA-10R	0.74	.029	5
	MB-07TH120SA-10R	0.81	.032	6
	MB-07TH100SA-10R	1.09	.043	7
	MB-07TH080SA-10R	1.27	.050	8

CoroTurn® XS

Threading, (Infeed recommendations)

Thread	Pitch	TPI	a_p mm	a_p inch	nap
	mm				
Metric 60° (MM)	0.50		0.26	.0106	7
	0.70		0.38	.0150	8
	0.75		0.40	.0161	8
	0.80		0.43	.0169	8
	1.00		0.55	.0217	11
	1.25		0.68	.0268	11
	1.50		0.81	.0319	13
	1.75		0.95	.0374	14
	2.00		1.08	.0425	18
	UN 60°		48	0.29	.0114
		36	0.38	.0150	8
		32	0.43	.0169	8
		28	0.49	.0193	9
		24	0.56	.0224	11
		20	0.69	.0272	11
		18	0.76	.0299	12
		16	0.86	.0339	13
		28	0.60	.0236	10
		26	0.65	.0256	11
		24	0.68	.0268	11
		22	0.74	.0291	12
		20	0.82	.0323	14
		19	0.87	.0343	14
NPT 60° (NT)			27	0.71	.0280
		18	1.06	.0417	18
ISO Trapezoidal 30°	1.50		0.86	.0340	6
	2.00		1.17	.0460	8
	3.00		1.70	.0670	12

a_p = total depth of thread
 nap = number of infeeds

CoroCut® XS

Metric 60°

Pitch, mm	a_p mm	a_p inch	nap
0.20	0.12	.005	4
0.25	0.15	.006	4
0.30	0.18	.007	4
0.35	0.20	.008	4
0.40	0.25	.010	4
0.45	0.28	.011	4
0.50	0.28	.011	4
0.75	0.46	.018	4
1.00	0.61	.024	5
1.25	0.74	.029	6
1.50	0.89	.035	6
1.75	1.07	.042	8
2.00	1.22	.048	8

Can be used for thread types:

- ISO metric 60°
- UN 60°
- NPT

 a_p = total depth of thread nap = number of passes a_p = total depth of thread nap = number of passes

UN 60°

Pitch, TPI	a_p mm	a_p inch	nap
72	0.22	.0086	4
64	0.25	.0098	4
56	0.28	.0110	4
48	0.33	.0129	4
44	0.36	.0142	4
40	0.40	.0157	4
36	0.43	.0169	4
32	0.49	.0193	5
28	0.56	.0220	5
24	0.65	.0256	5
20	0.80	.0315	6
18	0.86	.0339	6
16	0.97	.0382	7
14	1.12	.0441	8
13	1.19	.0469	8
12	1.30	.0512	9

Cutting speed recommendations

Cutting speed (v_c), m/min (ft/min)

Grade 1025

P**M****N****S**

60-200 60-180 90-400 20-50
 (195-655) (195-590) (295-1310) (65-165)

Grade CB7015

H

60-200
 (195-655)

Cutting speed recommendations, metric values

ISO P								
MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	Grades			
					GC1125	GC1135	GC1020	H13A
					Cutting speed (v_c), m/min			
P1.1.Z.AN	01.1	Unalloyed steel C = 0.1–0.25%	1500	125	230	205	185	160
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	195	170	155	130
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	180	160	145	125
Low-alloy steel (alloying elements ≤5%)								
P2.1.Z.AN	02.1	Non-hardened	1700	180	155	140	125	115
P2.1.Z.AN	02.12	Ball bearing steel	1800	210	145	125	115	105
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	120	105	95	80
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	95	85	75	65
High-alloy steel (alloying elements >5%)								
P3.0.Z.AN	03.11	Annealed	1950	200	140	120	110	105
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	115	100	80	70
Steel castings								
P1.5.C.UT	06.1	Unalloyed	1550	180	220	200	180	170
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	150	130	120	95
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	120	105	95	85
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	2900	250	40	38	35	33
ISO M								
Bars/forged Ferritic/martensitic								
P5.0.Z.AN	05.11	Non-hardened	1800	200	160	145	130	90
P5.0.Z.PH	05.12	PH-hardened	2850	330	115	100	90	70
P5.0.Z.HT	05.13	Hardened	2350	330	105	95	85	65
Bars/forged Austenitic								
M1.0.Z.AQ	05.21	Austenitic	1800	180	140	130	120	75
M1.0.Z.PH	05.22	PH-hardened	2850	330	100	90	80	60
M2.0.Z.AQ	05.23	Super austenitic	2250	200	80	75	70	50
Stainless steel – Bars/forged Austenitic-ferritic (Duplex)								
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	110	100	90	-
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	90	80	70	-
Stainless steel – Cast Ferritic/martensitic								
P5.0.C.UT	15.11	Non-hardened	1700	200	120	100	90	90
	15.12	PH-hardened	2450	330	90	80	70	55
P5.0.C.HT	15.13	Hardened	2150	330	70	65	60	50
Stainless steel – Cast Austenitic								
M1.0.C.UT	15.21	Austenitic	1700	180	120	110	100	80
	15.22	PH-hardened	2450	330	70	65	60	50
M2.0.C.AQ	15.23		2150	200	90	80	70	40
Stainless steel – Cast Austenitic-ferritic (Duplex)								
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	100	95	85	-
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	75	70	65	-
ISO K								
Malleable cast iron								
K1.1.C.NS	07.1	Ferritic (short chipping)	790	130	170	150	135	95
	07.2	Pearlitic (long chipping)	900	230	125	110	100	70
Grey cast iron								
K2.1.C.UT	08.1	Low tensile strength	890	180	160	140	130	85
K2.2.C.UT	08.2	High tensile strength	970	220	140	130	120	80
Nodular SG iron								
K3.1.C.UT	09.1	Ferritic	900	160	140	135	125	110
K3.3.C.UT	09.2	Pearlitic	1350	250	110	100	90	80
K3.4.C.UT	09.3	Martensitic	2100	380	80	75	65	60
ISO N								
Aluminium alloys Wrought/wrought and								
N1.2.Z.UT	30.11	+ cold-worked, non aging	400	60	500	500	500	500
N1.2.Z.AG	30.12	Aged	650	100	500	500	500	450
Aluminium alloys								
N1.3.C.UT	30.21	Cast, non-aging	600	75	500	500	455	425
N1.3.C.AG	30.22	Cast or cast and aged	700	90	400	325	280	250
	30.41	Cast Si 13–15%	700	130	300	270	245	210
N1.4.C.NS	30.42	Cast Si 16–22%	700	130	300	270	245	210
Copper and copper alloys								
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	550	110	500	460	420	370
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	550	90	300	270	245	210
N3.1.U.UT	33.3	Bronze and non-lead copper incl. electrolytic copper	1350	100	210	190	175	150

Cutting speed recommendations, metric values

ISO S									
MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	Grades				
					GC1125	GC1135	GC1020	H13A	CB7015
					Cutting speed (v_c), m/min				
Heat resistant alloys									
Iron base									
S1.0.U.AN	20.11	Annealed or solution treated	2400	200	55	50	45	45	-
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	35	35	30	30	-
Nickel base									
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	25	25	20	19	-
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	15	15	13	13	-
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	13	13	10	11	-
Cobalt alloys									
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	30	30	25	22	-
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	20	18	15	14	-
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	20	18	15	15	-
Titanium alloys									
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	1300	400 Rm	170	160	140	120	-
S4.2.Z.AN	23.21	α , near α and $\alpha + \beta$ alloys, annealed	1400	950 Rm	70	65	60	50	-
S4.3.Z.AG	23.22	α , near α and $\alpha + \beta$ alloys, annealed $\alpha + \beta$ alloys in aged cond, β alloys, annealed or aged	1400	1050 Rm	60	55	50	40	-
ISO H									
Extra hard steel									
H1.1.Z.HA	04.1	Hardened and tempered	2750	47 HRC	60	50	50	-	130
H1.3.Z.HA	04.1		4300	60 HRC	39	32	32	-	130
Chilled cast iron									
H2.0.C.UT	10.1	Cast or cast and aged	2250	400	45	40	35	50	-

Cutting speed recommendations, inch values

ISO P									
MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	Grades				
					GC1125	GC1135	GC1020	H13A	
					Cutting speed (V _c) ft/min				
P1.1.Z.AN	01.1	Unalloyed steel C = 0.1 - 0.25%	216,500	125	760	670	610	520	
P1.2.Z.AN	01.2		C = 0.25 - 0.55%	233,000	150	640	560	510	430
P1.3.Z.AN	01.3		C = 0.55 - 0.80%	247,000	170	590	530	475	410
P2.1.Z.AN	02.1	Low-alloy steel (alloying elements ≤5%) Non-hardened	249,500	180	510	460	405	380	
P2.1.Z.AN	02.12		Ball bearing steel	259,500	210	475	410	375	-
P2.5.Z.HT	02.2		Hardened and tempered	268,000	275	385	350	310	270
P2.5.Z.HT	02.2		Hardened and tempered	298,000	350	310	280	250	220
P3.0.Z.AN	03.11	High-alloy steel (alloying elements >5%) Annealed	282,000	200	460	395	360	345	
P3.0.Z.HT	03.21		Hardened tool steel	435,500	325	375	320	270	230
P1.5.C.UT	06.1	Steel castings Unalloyed	225,000	180	730	660	590	560	
P2.6.C.UT	06.2		Low-alloy (alloying elements ≤5%)	230,500	200	490	425	395	305
P3.0.C.UT	06.3		High-alloy, alloying elements >5%	300,500	225	395	345	310	285
P3.2.C.AQ	06.33		Manganese steel, 12-14% Mn	420,500	250	130	125	115	105
ISO M									
P5.0.Z.AN	05.11	Bars/forged Ferritic/martensitic Non-hardened	262,000	200	520	475	425	295	
P5.0.Z.PH	05.12		PH-hardened	411,500	330	375	330	295	235
P5.0.Z.HT	05.13		Hardened	340,000	330	345	310	280	215
M1.0.Z.AQ	05.21	Bars/forged Austenitic Austenitic	259,000	180	460	425	395	250	
M1.0.Z.PH	05.22		PH-hardened	414,000	330	330	295	260	190
M2.0.Z.AQ	05.23		Super austenitic	328,000	200	260	245	230	170
M3.1.Z.AQ	05.51	Stainless steel - Bars/forged Austenitic-ferritic (Duplex) Non-weldable ≥ 0.05%C	286,500	230	360	330	295	-	
M3.2.Z.AQ	05.52		Weldable < 0.05%C	356,500	260	295	265	230	-
P5.0.C.UT	15.11	Stainless steel - Cast Ferritic/martensitic Non-hardened	246,500	200	395	330	295	300	
P5.0.C.HT	15.12		PH-hardened	354,500	330	295	265	230	-
P5.0.C.HT	15.13		Hardened	311,000	330	230	215	195	160
M1.0.C.UT	15.21	Stainless steel - Cast Austenitic-ferritic (Duplex) Austenitic	248,000	180	395	360	325	265	
M2.0.C.AQ	15.22		PH-hardened	356,000	330	230	215	200	165
M3.1.C.AQ	15.23		Super austenitic	310,500	200	295	265	230	-
M3.2.C.AQ	15.51		Non-weldable ≥ 0.05%C	258,000	230	330	310	280	-
M3.2.C.AQ	15.52		Weldable < 0.05%C	326,500	260	245	230	210	-
ISO K									
K1.1.C.NS	07.1	Malleable cast iron Ferritic (short chipping)	115,000	130	560	490	440	315	
K1.1.C.NS	07.2		Pearlitic (long chipping)	131,000	230	410	360	325	230
K2.1.C.UT	08.1	Grey cast iron Low tensile strength	130,000	180	520	460	425	285	
K2.2.C.UT	08.2		High tensile strength	140,500	220	460	425	390	265
K3.1.C.UT	09.1	Nodular SG iron Ferritic	130,000	160	460	450	410	355	
K3.3.C.UT	09.2		Pearlitic	194,500	250	360	330	290	260
K3.4.C.UT	09.3		Martensitic	307,000	380	260	245	220	195

Cutting speed recommendations, inch values

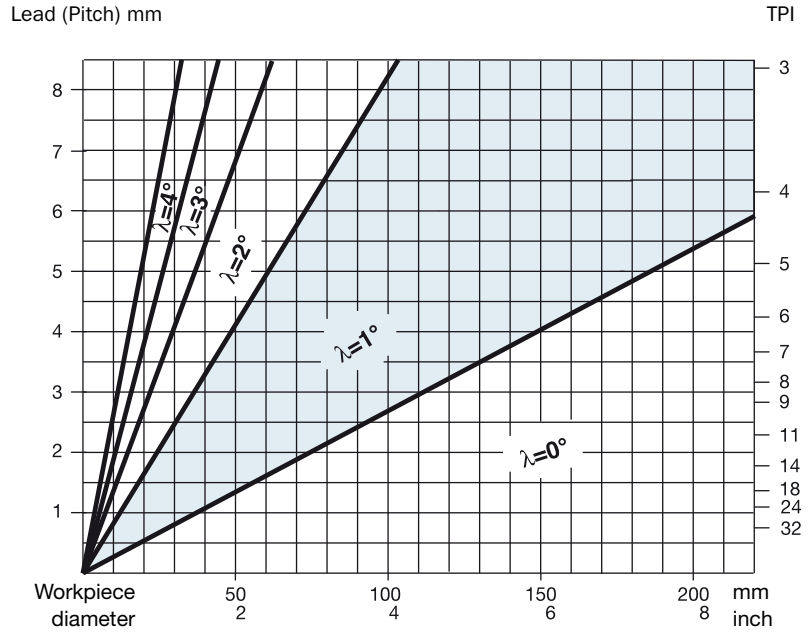
ISO N									
MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	Grades				
					GC1125	GC1135	GC1020	H13A	CB7015
					Cutting speed (V_c) ft/min				
N1.2.Z.UT N1.2.Z.AG	30.11	Aluminium alloys Wrought/wrought and + cold-worked, non aging Aged	58,000	60	1650	1650	1650	1650	
	30.12		94,500	100	1650	1650	1650	1450	
N1.3.C.UT N1.3.C.AG	30.21	Aluminium alloys Cast, non-aging Cast or cast and aged	87,000	75	1650	1650	1500	1400	
	30.22		101,500	90	1300	1050	920	820	
N1.4.C.NS	30.41	Aluminium alloys Cast Si 13-15% Cast Si 16-22%	101,500	130	980	890	800	690	
	30.42		101,500	130	980	890	800	690	
N3.3.U.UT N3.2.C.UT N3.1.U.UT	33.1	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb Brass, leaded bronzes, $\leq 1\%$ Pb Bronze and non-leaded copper incl. electrolytic copper	79,500	110	1650	1500	1400	1200	
	33.2		80,000	90	980	890	800	690	
	33.3		196,000	100	690	620	570	490	
ISO S									
S1.0.U.AN S1.0.U.AG	20.11	Heat resistant super alloys Iron base Annealed or solution treated Aged or solution treated and aged	348,000	200	180	165	145	145	
	20.12		359,000	280	115	115	100	100	
S2.0.Z.AN S2.0.Z.AG	20.21	Nickel base Annealed or solution treated Aged or solution treated and aged	383,000	250	80	80	65	60	
	20.22		420,500	350	50	50	45	45	
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	45	45	33	35	
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31	Cobalt alloys Annealed or solution treated Solution treated and aged Cast or cast and aged	391,500	200	100	100	80	70	
	20.32		432,000	300	65	60	50	45	
	20.33		450,500	320	65	60	50	50	
S4.1.Z.UT S4.2.Z.AN S4.3.Z.AG	23.1	Titanium alloys Commercial pure (99,5% Ti) α , near α and $\alpha + \beta$ alloys, annealed α , near α and $\alpha + \beta$ alloys, annealed $\alpha + \beta$ alloys in aged cond, β alloys, annealed or aged	188,500	400 Rm	560	520	460	395	
	23.21		203,000	950 Rm	230	215	195	-	
	23.22		203,000	1050 Rm	195	180	165	-	
ISO H									
H1.1.Z.HA H1.3.Z.HA	04.1	Extra hard steel Hardened and tempered Hardened and tempered	397,000	47 HRC	200	165	165	-	420
	04.1		625,500	60 HRC	125	105	105	-	420
H2.0.C.UT	10.1	Chilled cast iron Cast or cast and aged	326,500	400	150	130	115	170	-




CoroThread® 266




B The angle of inclination is calculated by using the formula:

$$\lambda = \tan^{-1} \left(\frac{P}{d_2 \times \pi} \right)$$

C P = Pitch
 d_2 = Effective diameter of thread
 λ = Angle of inclination



Pitch range	Insert size	Inclination angle	Shims	
mm	 iC		 For right hand external tool For left hand internal tool	 For left hand external tool For right hand internal tool
0.5-3.0	16	-2° -1° 0° 1° 2° 3° 4°	5322 389-22 5322 389-21 5322 389-10 5322 389-11 ¹⁾ 5322 389-12 5322 389-13 5322 389-14	5322 390-22 5322 390-21 5322 390-10 5322 390-11 ¹⁾ 5322 390-12 5322 390-13 5322 390-14
2.5-7.0	22	-2° -1° 0° 1° 2° 3° 4°	5322 379-22 5322 379-21 5322 379-10 5322 379-11 ¹⁾ 5322 379-12 5322 379-13 5322 379-14	5322 380-22 5322 380-21 5322 380-10 5322 380-11 ¹⁾ 5322 380-12 5322 380-13 5322 380-14
8.0	27	0° 1° 2° 3° 4°	5322 387-10 5322 387-11 ¹⁾ 5322 387-12 5322 387-13 5322 387-14	5322 388-10 5322 388-11 ¹⁾ 5322 388-12 5322 388-13 5322 388-14

Pitch range	Insert size	Inclination angle	Shims for holders 266R/LFA	
mm			 For right hand external tool For left hand internal tool	 For left hand external tool For right hand internal tool
0.5-3.0	16	0° 1° 2° 3° 4°	5322 391-10 5322 391-11 ¹⁾ 5322 391-12 5322 391-13 5322 391-14	5322 392-10 5322 392-11 ¹⁾ 5322 392-12 5322 392-13 5322 392-14

1) Delivered with the tool.

Note!
 The last two figures in the shim code indicate + or - and the effective inclination angle with the shim mounted in the holder. e.g. 5322 379-11 = angle + 1° and 5322 379-21 = angle - 1°.

CoroThread® 266

TPI	Inclination angle				
	4°	3°	2° (-2°)	1° (-1°)	0°
	Thread diameter, inch				
32	<.16	.16-.23	.23-.38	.38-1.14	>1.14
28	<.16	.16-.26	.26-.43	.43-1.30	>1.30
24	<.22	.22-.30	.30-.51	.51-1.52	>1.52
20	<.26	.26-.36	.36-.61	.61-1.82	>1.82
18	<.29	.29-.40	.40-.68	.68-2.03	>2.03
16	<.33	.33-.46	.46-.76	.76-2.28	>2.28
14	<.37	.37-.52	.52-.87	.87-2.61	>2.61
13	<.40	.40-.56	.56-.94	.94-2.81	>2.81
12	<.43	.43-.61	.61-1.01	1.01-3.04	>3.04
11	<.47	.47-.66	.66-1.11	1.11-3.32	>3.32
10	<.52	.52-.73	.73-1.22	1.22-3.65	>3.65
9	<.58	.58-.81	.81-1.35	1.35-4.05	>4.05
8	<.65	.65-.91	.91-1.52	1.52-4.56	>4.56
7	<.74	.74-1.04	1.04-1.74	1.74-5.21	>5.21
6	<.87	.87-1.22	1.22-2.03	2.03-6.08	>6.08
5	<1.04	1.04-1.46	1.46-2.43	2.43-7.30	>7.30
4	<1.30	1.30-1.82	1.82-3.04	3.04-9.12	>9.12
3	<1.74	1.74-2.43	2.43-4.05	4.05-12.15	>12.15

Pitch, mm	Inclination angle				
	4°	3°	2° (-2°)	1° (-1°)	0°
	Thread diameter, inch				
0.50	<.10	.10-.14	.14-.72	.24-.72	>.72
0.75	<.15	.15-.22	.22-.36	.36-1.08	>1.08
1.00	<.20	.20-.29	.29-.48	.48-1.44	>1.44
1.25	<.26	.26-.36	.36-.60	.60-1.80	>1.80
1.50	<.31	.31-.43	.43-.72	.72-2.15	>2.15
1.75	<.36	.36-.50	.50-.84	.84-2.51	>2.51
2.00	<.41	.41-.57	.57-.96	.96-2.87	>2.87
2.50	<.51	.51-.72	.72-1.20	1.20-3.59	>3.59
3.00	<.62	.62-.86	.86-1.44	1.44-4.31	>4.31
3.50	<.72	.72-1.00	1.00-1.68	1.68-5.03	>5.03
4.00	<.82	.82-1.15	1.15-1.92	1.92-5.74	>5.74
4.50	<.92	.92-1.29	1.29-2.15	2.15-6.46	>6.46
5.00	<1.02	1.02-1.44	1.44-2.39	2.39-7.18	>7.18
5.50	<1.13	1.13-1.58	1.58-2.63	2.63-7.90	>7.90
6.00	<1.23	1.23-1.72	1.72-2.87	2.87-8.62	>8.62
7.00	<1.26	1.26-2.00	2.00-3.35	3.35-10.04	>10.04
8.00	<1.64	1.64-2.30	2.30-3.83	3.83-11.84	>11.84

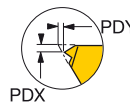
The angle of inclination is calculated by using the formula:

$$\lambda = \tan^{-1} \left(\frac{P}{d_2 \times \pi} \right)$$

P = Pitch

d_2 = Effective diameter of thread

λ = Angle of inclination



Metric version

ISO Metric (MM), external

	Pitch, mm														
	0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
	PDY	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.67	1.67	1.67	1.38	1.08
	PDX	0.50	0.50	0.80	0.80	1.00	1.20	1.40	1.40	1.80	2.50	2.50	2.50	2.50	2.80
No. of infeeds	Radial infeed per pass														
1	0.10	0.16	0.16	0.17	0.20	0.17	0.20	0.20	0.20	0.24	0.24	0.27	0.29	0.27	0.30
2	0.09	0.15	0.15	0.15	0.19	0.17	0.19	0.19	0.19	0.23	0.22	0.25	0.28	0.26	0.29
3	0.08	0.12	0.14	0.14	0.18	0.16	0.18	0.18	0.19	0.22	0.22	0.24	0.27	0.26	0.29
4	0.07	0.07	0.12	0.13	0.16	0.15	0.17	0.17	0.18	0.21	0.21	0.23	0.26	0.25	0.28
5			0.08	0.12	0.14	0.14	0.16	0.17	0.17	0.21	0.21	0.23	0.25	0.25	0.27
6				0.08	0.08	0.13	0.15	0.16	0.17	0.20	0.20	0.22	0.25	0.24	0.26
7						0.11	0.13	0.15	0.16	0.18	0.19	0.21	0.24	0.23	0.26
8						0.08	0.08	0.14	0.15	0.17	0.18	0.20	0.23	0.23	0.25
9								0.12	0.14	0.16	0.17	0.19	0.22	0.22	0.24
10								0.08	0.13	0.15	0.16	0.18	0.20	0.21	0.23
11									0.12	0.13	0.15	0.17	0.19	0.20	0.22
12									0.08	0.08	0.14	0.16	0.17	0.19	0.20
13											0.12	0.14	0.15	0.18	0.19
14											0.08	0.10	0.10	0.16	0.17
15														0.14	0.15
16														0.10	0.10
Total infeed	0.34	0.50	0.65	0.79	0.95	1.11	1.26	1.56	1.88	2.18	2.49	2.79	3.10	3.39	3.70

ISO Metric (MM), internal

	Pitch, mm														
	0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
	PDY	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.64	1.64	1.64	1.35	1.06
	PDX	0.50	0.50	0.80	0.80	1.00	1.20	1.40	1.40	1.80	2.50	2.50	2.50	2.50	2.40
No. of infeeds	Radial infeed per pass														
1	0.10	0.15	0.15	0.16	0.20	0.16	0.19	0.19	0.19	0.22	0.24	0.23	0.26	0.25	0.28
2	0.09	0.14	0.14	0.15	0.18	0.15	0.18	0.18	0.18	0.21	0.22	0.23	0.26	0.25	0.27
3	0.08	0.12	0.13	0.14	0.17	0.15	0.17	0.17	0.18	0.20	0.22	0.22	0.25	0.24	0.26
4	0.07	0.07	0.12	0.13	0.15	0.14	0.16	0.17	0.17	0.20	0.21	0.22	0.24	0.24	0.26
5			0.08	0.11	0.13	0.13	0.15	0.16	0.16	0.19	0.21	0.21	0.24	0.23	0.26
6				0.08	0.08	0.12	0.14	0.15	0.16	0.18	0.20	0.20	0.23	0.22	0.24
7						0.11	0.12	0.14	0.15	0.17	0.19	0.20	0.22	0.22	0.24
8						0.08	0.08	0.13	0.14	0.16	0.18	0.19	0.21	0.22	0.23
9								0.12	0.14	0.15	0.17	0.18	0.20	0.20	0.22
10								0.08	0.12	0.14	0.16	0.17	0.19	0.20	0.21
11									0.11	0.12	0.15	0.16	0.18	0.19	0.20
12									0.08	0.08	0.14	0.15	0.16	0.18	0.19
13											0.12	0.14	0.15	0.17	0.18
14											0.08	0.10	0.10	0.16	0.16
15														0.14	0.15
16														0.10	0.10
Total infeed	0.34	0.48	0.63	0.77	0.92	1.05	1.20	1.48	1.78	2.03	2.31	2.61	2.88	3.19	3.44

ISO inch (UN), external

	Pitch, TPI																		
	32	28	24	20	18	16	14	13	12	11	10	9	8	7	6	5	4.5	4	
	PDY	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.67	1.67	1.38	1.09	0.79
	PDX	0.50	0.80	0.80	0.80	1.00	1.00	1.20	1.40	1.40	1.40	1.40	1.80	1.80	2.50	2.50	2.50	2.65	2.90
No. of infeeds	Radial infeed per pass																		
1	0.17	0.15	0.18	0.18	0.20	0.19	0.18	0.20	0.22	0.21	0.21	0.21	0.22	0.25	0.24	0.29	0.28	0.32	
2	0.16	0.14	0.16	0.17	0.18	0.18	0.18	0.19	0.21	0.20	0.20	0.20	0.21	0.24	0.23	0.29	0.28	0.32	
3	0.13	0.13	0.15	0.15	0.17	0.17	0.17	0.18	0.20	0.19	0.19	0.19	0.20	0.23	0.23	0.28	0.27	0.31	
4	0.08	0.11	0.13	0.14	0.15	0.16	0.16	0.17	0.19	0.18	0.18	0.19	0.20	0.22	0.22	0.27	0.26	0.30	
5		0.08	0.08	0.12	0.13	0.14	0.15	0.16	0.17	0.17	0.17	0.18	0.19	0.21	0.21	0.26	0.26	0.29	
6				0.08	0.08	0.12	0.14	0.14	0.15	0.16	0.16	0.17	0.18	0.20	0.21	0.25	0.25	0.28	
7						0.08	0.12	0.12	0.13	0.15	0.15	0.16	0.17	0.19	0.20	0.24	0.24	0.27	
8							0.08	0.08	0.08	0.13	0.14	0.15	0.16	0.18	0.19	0.23	0.23	0.26	
9									0.08	0.12	0.14	0.15	0.17	0.18	0.22	0.22	0.25		
10										0.08	0.12	0.14	0.15	0.17	0.21	0.22	0.24		
11											0.08	0.12	0.13	0.16	0.19	0.21	0.23		
12													0.08	0.08	0.15	0.18	0.19	0.22	
13															0.14	0.15	0.18	0.20	
14															0.10	0.10	0.17	0.18	
15																	0.15	0.16	
16																	0.10	0.10	
Total infeed	0.54	0.60	0.70	0.84	0.92	1.04	1.17	1.24	1.35	1.47	1.62	1.79	2.02	2.26	2.64	3.17	3.51	3.94	



Inch version

ISO Metric (MM), external

	Pitch, mm														
	0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
PDY	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.066	.054	.043	.035
PDX	.020	.020	.031	.031	.039	.047	.055	.055	.071	.098	.098	.098	.098	.098	.110
No. of infeeds	Radial infeed per pass														
1	.004	.006	.006	.007	.008	.007	.008	.008	.008	.009	.009	.011	.011	.011	.012
2	.004	.006	.006	.006	.007	.007	.007	.007	.007	.009	.009	.010	.011	.010	.011
3	.003	.005	.006	.006	.007	.006	.007	.007	.007	.009	.009	.009	.011	.010	.011
4	.003	.003	.005	.005	.006	.006	.007	.007	.007	.008	.008	.009	.010	.010	.011
5			.003	.005	.006	.006	.006	.007	.007	.008	.008	.009	.010	.010	.011
6				.003	.003	.005	.006	.006	.007	.008	.008	.009	.010	.009	.010
7						.004	.005	.006	.006	.007	.007	.008	.009	.009	.010
8						.003	.003	.006	.006	.007	.007	.008	.009	.009	.010
9								.005	.006	.006	.007	.007	.009	.009	.009
10								.003	.005	.006	.006	.007	.008	.008	.009
11									.005	.005	.006	.007	.007	.008	.009
12									.003	.003	.006	.006	.007	.007	.008
13											.005	.006	.006	.007	.007
14											.003	.004	.004	.006	.007
15														.006	.006
16														.004	.004
Total infeed	.013	.020	.026	.031	.037	.044	.050	.061	.074	.086	.098	.110	.122	.133	.146

ISO Metric (MM), internal

	Pitch, mm														
	0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
PDY	.051	.051	.051	.051	.051	.051	.051	.051	.051	.065	.065	.065	.053	.042	.034
PDX	.020	.020	.031	.031	.039	.047	.055	.055	.071	.098	.098	.098	.098	.098	.094
No. of infeeds	Radial infeed per pass														
1	.004	.006	.006	.006	.008	.006	.007	.007	.007	.009	.009	.009	.010	.010	.011
2	.004	.006	.006	.006	.007	.006	.007	.007	.007	.008	.009	.009	.010	.010	.011
3	.003	.005	.005	.006	.007	.006	.007	.007	.007	.008	.009	.009	.010	.009	.010
4	.003	.003	.005	.005	.006	.006	.006	.007	.007	.008	.008	.009	.009	.009	.010
5			.003	.004	.005	.005	.006	.006	.006	.007	.008	.008	.009	.009	.010
6				.003	.003	.005	.006	.006	.006	.007	.008	.008	.009	.009	.009
7						.004	.005	.006	.006	.007	.007	.008	.009	.009	.009
8						.003	.003	.005	.006	.006	.007	.007	.008	.009	.009
9								.005	.006	.006	.007	.007	.008	.008	.009
10								.003	.005	.006	.006	.007	.007	.008	.008
11									.004	.005	.006	.006	.007	.007	.008
12									.003	.003	.006	.006	.006	.007	.007
13											.005	.006	.006	.007	.007
14											.003	.004	.004	.006	.006
15														.006	.006
16														.004	.004
Total infeed	.013	.019	.025	.030	.036	.041	.047	.058	.070	.080	.091	.103	.113	.126	.135

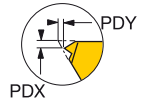
ISO inch (UN), external

	Pitch, TPI																	
	32	28	24	20	18	16	14	13	12	11	10	9	8	7	6	5	4.5	4
PDY	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.054	.043	.031
PDX	.020	.031	.031	.031	.039	.039	.047	.055	.055	.055	.055	.071	.071	.098	.098	.098	.104	.114
No. of infeeds	Radial infeed per pass																	
1	.007	.006	.007	.007	.008	.007	.007	.008	.009	.008	.008	.008	.009	.010	.009	.011	.011	.013
2	.006	.006	.006	.007	.007	.007	.007	.007	.008	.008	.008	.008	.008	.009	.009	.011	.011	.013
3	.005	.005	.006	.006	.007	.007	.007	.007	.008	.007	.007	.007	.008	.009	.009	.011	.011	.012
4	.003	.004	.005	.006	.006	.006	.006	.007	.007	.007	.007	.007	.008	.009	.009	.011	.010	.012
5		.003	.003	.005	.005	.006	.006	.006	.007	.007	.007	.007	.007	.008	.008	.010	.010	.011
6				.003	.003	.005	.006	.006	.006	.006	.007	.007	.007	.008	.008	.010	.010	.011
7						.003	.005	.005	.005	.006	.006	.006	.007	.007	.008	.009	.009	.011
8							.003	.003	.003	.005	.006	.006	.006	.007	.007	.009	.009	.010
9									.003	.005	.006	.006	.007	.007	.009	.009	.010	.010
10										.003	.005	.006	.006	.007	.008	.009	.009	.009
11											.003	.005	.005	.006	.007	.008	.008	.009
12													.003	.003	.006	.007	.007	.009
13															.006	.006	.007	.008
14															.004	.004	.007	.007
15																	.006	.006
16																	.004	.004
Total infeed	.021	.024	.028	.033	.036	.041	.046	.049	.053	.058	.064	.070	.080	.089	.104	.125	.138	.155

A

THREAD TURNING

Infeed recommendations



ENG

Metric version

B

ISO inch (UN), internal

	Pitch, TPI																		
	32	28	24	20	18	16	14	13	12	11	10	9	8	7	6	5	4.5	4	
	PDY	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.64	1.64	1.35	1.06	0.87
	PDX	0.50	0.80	0.80	0.80	1.00	1.00	1.20	1.40	1.40	1.40	1.40	1.80	1.80	2.50	2.50	2.50	2.50	2.60
No. of infeeds	Radial infeed per pass																		
1	0.16	0.14	0.16	0.16	0.18	0.17	0.16	0.18	0.20	0.19	0.19	0.19	0.22	0.21	0.23	0.26	0.25	0.28	
2	0.14	0.13	0.15	0.16	0.17	0.16	0.16	0.16	0.19	0.18	0.18	0.18	0.21	0.21	0.23	0.26	0.25	0.27	
3	0.13	0.12	0.14	0.14	0.16	0.15	0.15	0.15	0.18	0.18	0.17	0.18	0.20	0.20	0.22	0.25	0.24	0.26	
4	0.08	0.11	0.12	0.13	0.14	0.14	0.14	0.14	0.17	0.17	0.17	0.17	0.20	0.19	0.22	0.24	0.24	0.26	
5		0.08	0.08	0.12	0.13	0.13	0.14	0.14	0.16	0.16	0.16	0.16	0.19	0.19	0.21	0.24	0.23	0.25	
6				0.08	0.08	0.12	0.13	0.13	0.14	0.15	0.15	0.16	0.18	0.18	0.20	0.23	0.22	0.24	
7						0.08	0.11	0.11	0.13	0.14	0.14	0.15	0.17	0.18	0.20	0.22	0.22	0.24	
8							0.08	0.08	0.08	0.12	0.13	0.14	0.16	0.17	0.19	0.21	0.21	0.23	
9										0.08	0.12	0.14	0.15	0.16	0.18	0.20	0.20	0.22	
10											0.08	0.12	0.14	0.15	0.17	0.19	0.20	0.21	
11												0.11	0.12	0.14	0.16	0.18	0.19	0.20	
12													0.08	0.08	0.13	0.15	0.16	0.18	
13															0.12	0.14	0.15	0.17	
14															0.08	0.10	0.10	0.16	
15																		0.14	
16																		0.10	
Total infeed		0.51	0.58	0.66	0.78	0.86	0.96	1.07	1.15	1.25	1.36	1.48	1.78	2.03	2.31	2.61	2.88	3.19	3.44

C

D

Whitworth (WH), external and internal

	Pitch, TPI																	
	28	26	20	19	18	16	14	12	11	10	9	8	7	6	5	4.5	4	
	External PDY	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.67	1.67	1.38	0.99	0.59
	External PDX	0.80	0.80	0.80	0.80	1.00	1.00	1.40	1.40	1.40	1.40	1.80	1.80	2.50	2.50	2.50	2.65	2.75
	Internal PDY				1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.30	1.64	1.64	1.35	0.96	0.67	
	Internal PDX				0.80	0.80	1.00	1.20	1.40	1.40	1.40	1.80	1.80	2.50	2.50	2.50	2.65	2.75
No. of infeeds	Radial infeed per pass																	
1	0.16	0.17	0.19	0.20	0.17	0.17	0.20	0.23	0.22	0.22	0.22	0.23	0.26	0.25	0.31	0.30	0.34	
2	0.15	0.16	0.18	0.18	0.16	0.16	0.19	0.22	0.21	0.21	0.21	0.22	0.26	0.25	0.30	0.29	0.33	
3	0.14	0.14	0.16	0.17	0.16	0.15	0.18	0.21	0.20	0.20	0.20	0.21	0.25	0.24	0.29	0.29	0.32	
4	0.12	0.13	0.15	0.15	0.15	0.15	0.17	0.19	0.19	0.19	0.20	0.21	0.24	0.23	0.28	0.28	0.31	
5	0.08	0.08	0.13	0.13	0.13	0.14	0.16	0.18	0.18	0.18	0.19	0.20	0.23	0.23	0.28	0.27	0.30	
6			0.08	0.08	0.12	0.13	0.14	0.16	0.17	0.17	0.18	0.19	0.22	0.22	0.27	0.26	0.29	
7					0.08	0.11	0.12	0.14	0.15	0.16	0.17	0.18	0.20	0.21	0.25	0.25	0.28	
8						0.08	0.08	0.08	0.13	0.15	0.16	0.17	0.19	0.20	0.24	0.25	0.27	
9									0.08	0.13	0.14	0.16	0.18	0.19	0.23	0.24	0.26	
10										0.08	0.12	0.14	0.16	0.18	0.22	0.23	0.25	
11											0.08	0.12	0.14	0.17	0.20	0.22	0.24	
12												0.08	0.08	0.16	0.18	0.20	0.22	
13														0.14	0.16	0.19	0.21	
14														0.10	0.10	0.17	0.19	
15																0.15	0.16	
16																0.10	0.10	
Total infeed		0.64	0.68	0.88	0.92	0.97	1.08	1.23	1.42	1.54	1.70	1.87	2.10	2.39	2.78	3.32	3.69	4.06

F

G

BSPT (PT), external and internal

Round 30° DIN 405 (RN) external

Round 30° DIN 405 (RN) internal

	Pitch, TPI					
	28	19	14	11	8	
	External PDY	1.32	1.32	1.32	1.40	1.32
	External PDX	0.80	0.80	1.20	1.40	1.80
	Internal PDY	1.30	1.30	1.30	1.30	1.30
	Internal PDX	0.80	0.80	1.20	1.40	1.80
No. of infeeds	Radial infeed per pass					
1	0.15	0.19	0.19	0.22	0.22	
2	0.14	0.18	0.18	0.21	0.21	
3	0.13	0.17	0.17	0.20	0.21	
4	0.12	0.15	0.16	0.19	0.20	
5	0.08	0.13	0.15	0.18	0.19	
6		0.08	0.14	0.16	0.18	
7			0.12	0.15	0.17	
8			0.08	0.13	0.16	
9				0.08	0.15	
10					0.14	
11					0.12	
12					0.08	
Total infeed	0.62	0.90	1.20	1.51	2.05	

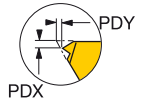
	Pitch, TPI				
	10	8	6	4	
	PDY	1.33	1.33	1.43	1.38
	PDX	0.83	1.05	1.50	2.60
No. of infeeds	Radial infeed per pass				
1	0.21	0.21	0.24	0.30	
2	0.20	0.20	0.23	0.29	
3	0.19	0.19	0.22	0.28	
4	0.18	0.19	0.21	0.27	
5	0.16	0.18	0.20	0.26	
6	0.15	0.17	0.19	0.25	
7	0.13	0.15	0.18	0.24	
8	0.08	0.14	0.17	0.23	
9		0.12	0.16	0.22	
10		0.08	0.15	0.21	
11			0.13	0.19	
12			0.08	0.18	
13				0.15	
14				0.10	
Total infeed	1.30	1.63	2.17	2.95	

	Pitch, TPI				
	10	8	6	4	
	PDY	1.30	1.30	1.45	1.35
	PDX	1.85	1.05	1.35	2.60
No. of infeeds	Radial infeed per pass				
1	0.22	0.21	0.24	0.30	
2	0.21	0.20	0.23	0.29	
3	0.20	0.20	0.22	0.29	
4	0.18	0.19	0.21	0.28	
5	0.17	0.18	0.21	0.27	
6	0.15	0.17	0.20	0.26	
7	0.13	0.16	0.19	0.25	
8	0.08	0.14	0.17	0.24	
9		0.12	0.16	0.23	
10		0.08	0.15	0.21	
11			0.13	0.20	
12			0.08	0.18	
13				0.16	
14				0.10	
Total infeed	.134	1.64	2.18	2.98	

H

I

J



Inch version

ISO inch (UN), internal

		Pitch, TPI																	
		32	28	24	20	18	16	14	13	12	11	10	9	8	7	6	5	4.5	4
PDY	PDY	.051	.051	.051	.051	.051	.051	.051	.051	.051	.051	.051	.051	.051	.065	.065	.053	.042	.034
	PDX	.50	.031	.031	.031	.039	.039	.047	.055	.055	.055	.055	.071	.071	.098	.098	.098	.098	.102
No. of infeeds		Radial infeed per pass																	
1		.006	.006	.006	.006	.007	.007	.006	.007	.008	.007	.007	.007	.009	.008	.009	.010	.010	.011
2		.006	.005	.006	.006	.007	.006	.006	.006	.006	.007	.007	.007	.008	.008	.009	.010	.010	.011
3		.005	.005	.006	.006	.006	.006	.006	.006	.007	.007	.007	.007	.008	.008	.009	.010	.009	.010
4		.003	.004	.005	.005	.006	.006	.006	.006	.007	.007	.007	.007	.008	.007	.009	.009	.009	.010
5			.003	.003	.005	.005	.005	.006	.006	.006	.006	.006	.006	.007	.007	.008	.009	.009	.010
6					.003	.003	.005	.005	.005	.006	.006	.006	.006	.007	.007	.008	.009	.009	.009
7						.003	.004	.004	.005	.006	.006	.006	.006	.007	.007	.008	.009	.009	.009
8							.003	.003	.003	.005	.005	.006	.006	.007	.007	.008	.008	.008	.009
9										.003	.005	.006	.006	.006	.007	.008	.008	.008	.009
10											.003	.005	.006	.006	.007	.007	.007	.008	.008
11												.004	.005	.006	.006	.007	.007	.007	.008
12													.003	.003	.005	.006	.006	.007	.007
13															.005	.006	.006	.007	.007
14															.003	.004	.004	.006	.006
15																		.006	.006
16																		.004	.004
Total infeed		.020	.023	.026	.031	.034	.038	.042	.045	.049	.054	.058	.070	.080	.091	.103	.113	.126	.135

Whitworth (WH), external and internal

		Pitch, TPI																
		28	26	20	19	18	16	14	12	11	10	9	8	7	6	5	4.5	4
External	PDY	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052	.066	.066	.054	.039	.023
	PDX	.031	.031	.031	.031	.039	.039	.055	.055	.055	.055	.071	.071	.098	.098	.098	.104	.108
Internal	PDY				.051	.051	.051	.051	.051	.051	.051	.051	.065	.065	.053	.038	.026	
	PDX				.031	.031	.039	.047	.055	.055	.055	.071	.071	.098	.098	.098	.104	.108
No. of infeeds		Radial infeed per pass																
1		.006	.007	.007	.008	.007	.007	.008	.009	.009	.009	.009	.009	.010	.010	.012	.012	.013
2		.006	.006	.007	.007	.006	.006	.007	.009	.008	.008	.008	.008	.010	.010	.012	.011	.013
3		.006	.006	.006	.007	.006	.006	.007	.008	.008	.008	.008	.008	.010	.009	.011	.011	.013
4		.005	.005	.006	.006	.006	.006	.007	.007	.007	.007	.008	.008	.009	.009	.011	.011	.012
5		.003	.003	.005	.005	.005	.006	.006	.007	.007	.007	.007	.008	.009	.009	.011	.011	.012
6				.003	.003	.005	.005	.006	.006	.007	.007	.007	.007	.009	.009	.011	.010	.011
7						.003	.004	.005	.006	.006	.006	.007	.007	.008	.008	.010	.010	.011
8							.003	.003	.003	.005	.006	.006	.007	.007	.008	.009	.010	.011
9										.003	.005	.006	.006	.007	.007	.009	.009	.010
10											.003	.005	.006	.006	.007	.009	.009	.010
11												.003	.005	.006	.007	.008	.009	.009
12													.003	.003	.006	.007	.008	.009
13															.006	.006	.007	.008
14															.004	.004	.007	.007
15																	.006	.006
16																	.004	.004
Total infeed		.025	.027	.035	.036	.038	.043	.048	.056	.061	.067	.074	.083	.094	.109	.131	.145	.160

BSPT (PT), external and internal

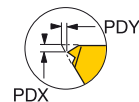
		Pitch, TPI				
		28	19	14	11	8
External	PDY	.052	.052	.052	.055	.052
	PDX	.031	.031	.047	.055	.071
Internal	PDY	.051	.051	.051	.051	.051
	PDX	.031	.031	.047	.055	.071
No. of infeeds		Radial infeed per pass				
1		.006	.007	.007	.009	.009
2		.006	.007	.007	.008	.008
3		.005	.007	.007	.008	.008
4		.005	.006	.006	.007	.008
5		.003	.005	.006	.007	.007
6			.003	.006	.006	.007
7				.005	.006	.007
8				.003	.005	.006
9					.003	.006
10						.006
11						.005
12						.003
Total infeed		.024	.035	.047	.059	.081

Round 30° DIN 405 (RN) external

		Pitch, TPI			
		10	8	6	4
PDY	PDY	.052	.052	.056	.054
	PDX	.033	.041	.059	.102
No. of infeeds		Radial infeed per pass			
1		.008	.008	.009	.012
2		.008	.008	.009	.011
3		.007	.007	.009	.011
4		.007	.007	.008	.011
5		.006	.007	.008	.010
6		.006	.007	.007	.010
7		.005	.006	.007	.009
8		.003	.006	.007	.009
9			.005	.006	.009
10			.003	.006	.008
11				.005	.007
12				.003	.007
13					.006
14					.004
Total infeed		.051	.064	.085	.116

Round 30° DIN 405 (RN) internal

		Pitch, TPI			
		10	8	6	4
PDY	PDY	.051	.051	.057	.053
	PDX	.073	.041	.053	.102
No. of infeeds		Radial infeed per pass			
1		.009	.008	.009	.012
2		.008	.008	.009	.011
3		.008	.008	.009	.011
4		.007	.007	.008	.011
5		.007	.007	.008	.011
6		.006	.007	.008	.010
7		.005	.006	.007	.010
8		.003	.006	.007	.009
9			.005	.006	.009
10			.003	.006	.008
11				.005	.008
12				.003	.007
13					.006
14					.004
Total infeed		.053	.065	.086	.117



Metric version

ACME (AC), external

	Pitch, TPI								
	16	14	12	10	8	6	5	4	3
PDY	1.33	1.33	1.33	1.33	1.50	1.37	1.37	0.76	0.54
PDX	1.00	1.10	1.20	1.30	1.50	1.90	2.10	2.40	3.30
No. of infeeds	Radial infeed per pass								
1	0.22	0.20	0.20	0.20	0.20	0.24	0.26	0.28	0.31
2	0.20	0.19	0.19	0.20	0.20	0.23	0.25	0.28	0.31
3	0.19	0.18	0.18	0.19	0.19	0.23	0.25	0.27	0.30
4	0.17	0.17	0.17	0.18	0.18	0.22	0.24	0.26	0.30
5	0.14	0.15	0.16	0.17	0.18	0.21	0.23	0.26	0.29
6	0.08	0.13	0.15	0.16	0.17	0.20	0.23	0.25	0.28
7		0.08	0.13	0.15	0.16	0.20	0.22	0.24	0.28
8			0.08	0.14	0.15	0.19	0.21	0.23	0.27
9				0.12	0.14	0.18	0.20	0.22	0.26
10				0.08	0.13	0.17	0.19	0.22	0.25
11					0.12	0.16	0.18	0.21	0.24
12					0.08	0.14	0.16	0.19	0.23
13						0.10	0.14	0.18	0.22
14							0.10	0.17	0.21
15								0.15	0.20
16								0.10	0.19
17									0.17
18									0.15
19									.100
Total infeed	0.99	1.10	1.26	1.60	1.91	2.46	2.87	3.51	4.57

NPT (NT), external and internal

	Pitch, TPI				
	27	18	14	11½	8
External PDY	1.03	1.03	1.03	1.03	1.03
External PDX	0.80	1.00	1.20	1.40	1.60
Internal PDY	0.72	1.01	1.01	1.01	1.01
Internal PDX	0.85	1.20	1.20	1.40	1.60
No. of infeeds	Radial infeed per pass				
1	0.15	0.17	0.18	0.18	0.21
2	0.15	0.17	0.17	0.17	0.21
3	0.14	0.16	0.16	0.17	0.20
4	0.13	0.15	0.16	0.16	0.20
5	0.11	0.14	0.15	0.16	0.19
6	0.08	0.13	0.15	0.15	0.18
7		0.11	0.14	0.15	0.18
8		0.08	0.13	0.14	0.17
9			0.11	0.13	0.17
10			0.08	0.12	0.16
11				0.11	0.15
12				0.08	0.14
13					0.13
14					0.11
15					0.08
Total infeed	0.62	0.90	1.20	1.51	2.05

ACME (AC), internal

	Pitch, TPI								
	16	14	12	10	8	6	5	4	3
PDY	1.30	1.30	1.33	1.33	1.14	1.33	0.92	0.81	0.54
PDX	0.80	1.00	1.10	1.20	1.50	2.00	2.20	2.40	3.30
No. of infeeds	Radial infeed per pass								
1	0.22	0.21	0.21	0.21	0.21	0.24	0.26	0.29	0.31
2	0.21	0.20	0.20	0.20	0.20	0.23	0.26	0.28	0.31
3	0.19	0.19	0.19	0.20	0.20	0.23	0.25	0.27	0.30
4	0.17	0.17	0.18	0.19	0.19	0.22	0.24	0.27	0.29
5	0.14	0.16	0.16	0.18	0.18	0.21	0.24	0.26	0.29
6	0.08	0.13	0.15	0.17	0.17	0.21	0.23	0.25	0.28
7		0.08	0.13	0.16	0.17	0.20	0.22	0.24	0.27
8			0.08	0.14	0.16	0.19	0.21	0.23	0.27
9				0.12	0.15	0.18	0.20	0.23	0.26
10				0.08	0.13	0.17	0.19	0.22	0.25
11					0.12	0.16	0.18	0.21	0.24
12					0.08	0.14	0.16	0.20	0.23
13						0.10	0.15	0.18	0.22
14							0.10	0.17	0.21
15								0.15	0.20
16								0.10	0.19
17									0.17
18									0.15
19									.100
Total infeed	1.02	1.14	1.30	1.64	1.95	2.48	2.90	3.54	4.56

NPTF (NT), external and internal

	Pitch, TPI				
	27	18	14	11½	8
External PDY	1.03	1.03	1.03	1.03	1.03
External PDX	0.80	1.00	1.20	1.40	1.60
Internal PDY			1.01	1.01	1.01
Internal PDX			1.20	1.40	1.60
No. of infeeds	Radial infeed per pass				
1	0.14	0.16	0.17	0.17	0.19
2	0.13	0.16	0.17	0.17	0.19
3	0.13	0.15	0.16	0.16	0.18
4	0.12	0.14	0.16	0.16	0.18
5	0.11	0.13	0.15	0.15	0.18
6	0.08	0.12	0.15	0.15	0.17
7		0.11	0.13	0.14	0.17
8		0.08	0.12	0.14	0.16
9			0.11	0.13	0.16
10			0.08	0.12	0.15
11				0.11	0.14
12				0.08	0.14
13					0.13
14					0.12
15					0.11
16					0.08
Total infeed	0.70	1.06	1.41	1.69	2.36

Stub-ACME (SA), external and internal

	Pitch, TPI								
	16	14	12	19	8	6	5	4	3
External PDY	1.32	1.32	1.32	1.32	1.23	1.67	1.67	1.67	1.76
External PDX	0.90	1.00	1.10	1.20	1.50	1.80	2.00	2.40	3.10
Internal PDY		1.64	1.33	1.30	1.20	1.64	1.64	1.64	1.76
Internal PDX		2.40	1.10	1.20	1.50	1.80	2.00	2.40	3.10
No. of infeeds	Radial infeed per pass								
1	0.18	0.20	0.18	0.21	0.22	0.24	0.25	0.24	0.25
2	0.16	0.18	0.17	0.20	0.21	0.23	0.24	0.24	0.24
3	0.15	0.17	0.16	0.19	0.19	0.22	0.23	0.23	0.24
4	0.13	0.14	0.15	0.17	0.18	0.21	0.22	0.22	0.23
5	0.08	0.08	0.13	0.15	0.17	0.19	0.21	0.21	0.22
6			0.08	0.13	0.15	0.18	0.19	0.20	0.22
7				0.08	0.13	0.16	0.18	0.19	0.21
8					0.08	0.14	0.16	0.18	0.20
9						0.08	0.14	0.17	0.19
10							0.09	0.16	0.18
11								0.14	0.17
12								0.09	0.16
13									0.15
14									0.13
15									0.09
Total infeed	0.70	0.77	0.87	1.13	1.33	1.64	1.90	2.27	2.90

MJ, external

	Pitch, mm	
	1.5	2
PDY	1.32	1.32
PDX	1.00	1.40
No. of infeeds	Radial infeed per pass	
1	0.20	0.19
2	0.18	0.18
3	0.17	0.17
4	0.15	0.16
5	0.13	0.15
6	0.08	0.14
7		0.12
8		0.08
Total infeed	0.92	1.21



ENG



Inch version

ACME (AC), external

	Pitch, TPI								
	16	14	12	10	8	6	5	4	3
PDY	.052	.052	.052	.052	.059	.054	.054	.030	.021
	.039	.043	.047	.051	.059	.075	.083	.094	.130
PDX	Radial infeed per pass								
	.009	.008	.008	.008	.008	.009	.010	.011	.012
No. of infeeds	.008	.007	.007	.008	.008	.009	.010	.011	.012
1	.007	.007	.007	.007	.007	.009	.010	.011	.012
2	.007	.007	.007	.007	.007	.009	.009	.010	.012
3	.006	.006	.006	.007	.007	.008	.009	.010	.011
4	.003	.005	.006	.006	.007	.008	.009	.010	.011
5		.003	.005	.006	.006	.008	.009	.009	.011
6			.003	.006	.006	.007	.008	.009	.011
7				.005	.006	.007	.008	.009	.010
8				.003	.005	.007	.007	.009	.010
9					.005	.006	.007	.008	.009
10					.003	.006	.006	.007	.009
11						.004	.006	.007	.009
12							.004	.007	.008
13								.006	.008
14								.004	.007
15									.007
16									.006
17									.004
18									.004
19									.004
Total infeed	.039	.043	.050	.063	.075	.097	.113	.138	.180

NPT (NT), external and internal

	Pitch, TPI				
	27	18	14	11½	8
External PDY	.041	.041	.041	.041	.041
	.031	.039	.047	.055	.063
Internal PDY	.028	.040	.040	.040	.040
	.033	.047	.047	.055	.063
PDX	Radial infeed per pass				
	.006	.007	.007	.007	.008
No. of infeeds	.006	.007	.007	.007	.008
1	.006	.006	.006	.007	.008
2	.006	.006	.006	.006	.008
3	.006	.006	.006	.007	.008
4	.005	.006	.006	.006	.008
5	.004	.006	.006	.006	.007
6	.003	.005	.006	.006	.007
7		.004	.006	.006	.007
8		.003	.005	.006	.007
9			.004	.005	.007
10			.003	.005	.006
11				.004	.006
12				.003	.006
13					.005
14					.004
15					.003
Total infeed	.024	.035	.047	.059	.081

ACME (AC), internal

	Pitch, TPI								
	16	14	12	10	8	6	5	4	3
PDY	.051	.051	.052	.052	.045	.052	.036	.032	.021
	.031	.039	.043	.047	.059	.079	.087	.094	.130
PDX	Radial infeed per pass								
	.009	.008	.008	.008	.008	.009	.010	.011	.012
No. of infeeds	.008	.008	.008	.008	.008	.009	.010	.011	.012
1	.007	.007	.007	.008	.008	.009	.010	.011	.012
2	.007	.007	.007	.007	.007	.009	.009	.011	.011
3	.006	.006	.006	.007	.007	.008	.009	.010	.011
4	.003	.005	.006	.007	.007	.008	.009	.010	.011
5		.003	.005	.006	.007	.008	.009	.009	.011
6			.003	.006	.006	.007	.008	.009	.011
7				.005	.006	.007	.008	.009	.010
8				.003	.005	.007	.007	.009	.010
9					.005	.006	.007	.008	.009
10					.003	.006	.006	.008	.009
11						.004	.006	.007	.009
12							.004	.007	.008
13								.006	.008
14								.004	.007
15									.006
16									.007
17									.006
18									.004
19									.004
Total infeed	.040	.045	.051	.065	.077	.098	.114	.139	.180

NPTF (NT), external and internal

	Pitch, TPI				
	27	18	14	11½	8
External PDY	.041	.041	.041	.041	.041
	.031	.039	.047	.055	.063
Internal PDY			.040	.040	.040
			.047	.055	.063
PDX	Radial infeed per pass				
	.006	.006	.007	.007	.007
No. of infeeds	.005	.006	.007	.007	.007
1	.005	.006	.006	.006	.007
2	.005	.006	.006	.006	.007
3	.005	.006	.006	.006	.007
4	.004	.005	.006	.006	.007
5	.003	.005	.006	.006	.007
6		.004	.005	.006	.007
7		.003	.005	.006	.006
8			.004	.005	.006
9			.003	.005	.006
10				.004	.006
11				.003	.006
12					.005
13					.004
14					.003
15					.005
16					.004
Total infeed	.028	.042	.056	.067	.093

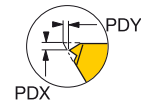
Stub-ACME (SA), external and internal

	Pitch, TPI								
	16	14	12	19	8	6	5	4	3
External PDY	.052	.052	.052	.052	.048	.066	.066	.066	.069
	.035	.039	.043	.047	.059	.071	.079	.094	.122
Internal PDY		.065	.052	.051	.047	.065	.065	.065	.069
		.094	.043	.047	.059	.071	.079	.094	.122
PDX	Radial infeed per pass								
	.007	.008	.007	.008	.009	.009	.010	.009	.010
No. of infeeds	.006	.007	.007	.008	.008	.009	.009	.009	.009
1	.006	.007	.006	.007	.007	.009	.009	.009	.009
2	.005	.006	.006	.007	.007	.008	.009	.009	.009
3	.003	.003	.005	.006	.007	.007	.008	.008	.009
4			.003	.005	.006	.007	.007	.008	.009
5				.003	.005	.006	.007	.007	.008
6					.003	.006	.006	.007	.008
7						.003	.006	.007	.007
8							.004	.006	.007
9								.006	.007
10								.004	.006
11								.006	.007
12								.004	.006
13									.006
14									.005
15									.004
Total infeed	.028	.030	.034	.044	.052	.065	.075	.089	.114

MJ, external

	Pitch, mm	
	1.5	2
PDY	.052	.052
	.039	.055
PDX	Radial infeed per pass	
	.008	.007
No. of infeeds	.007	.007
1	.007	.007
2	.006	.006
3	.005	.006
4	.003	.006
5		.005
6		.005
7		.003
8		.003
Total infeed	.036	.048

A
B
C
D
E
F
G
H
I
J



Metric version

Trapezoidal (TR), external and internal

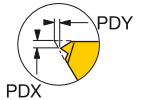
		Pitch, mm							
		1.5	2	3	4	5	6	7	8
External	PDY	1.37	1.37	1.27	1.42	1.42	0.81	0.81	0.54
	PDX	1.00	1.10	1.60	1.90	2.10	2.40	2.40	3.30
Internal	PDY	1.40	1.29	1.45	1.45	0.83	1.03	0.54	
	PDX		1.00	1.60	1.90	2.10	2.40	2.40	3.30
No. of infeeds		Radial infeed per pass							
1		0.22	0.22	0.20	0.24	0.27	0.29	0.34	0.32
2		0.21	0.21	0.19	0.23	0.27	0.29	0.33	0.31
3		0.19	0.20	0.18	0.22	0.26	0.28	0.32	0.31
4		0.17	0.19	0.18	0.22	0.25	0.27	0.32	0.30
5		0.14	0.17	0.17	0.21	0.24	0.27	0.31	0.29
6		0.08	0.16	0.17	0.20	0.23	0.26	0.30	0.29
7			0.13	0.16	0.19	0.22	0.25	0.29	0.28
8			0.08	0.15	0.18	0.21	0.24	0.28	0.27
9				0.14	0.17	0.20	0.23	0.26	0.26
10				0.13	0.16	0.19	0.22	0.25	0.25
11				0.11	0.14	0.17	0.21	0.24	0.25
12				0.08	0.13	0.16	0.20	0.22	0.24
13					0.08	0.13	0.19	0.21	0.23
14						0.08	0.17	0.19	0.22
15							0.15	0.16	0.20
16							0.10	0.10	0.19
17									0.17
18									0.15
19									0.10
Total infeed		1.02	1.36	1.86	2.37	2.88	3.63	4.12	4.62

UNJ, external

		Pitch, TPI									
		32	28	24	20	18	16	14	12	10	8
External	PDY	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32	1.32
	PDX	0.50	0.80	0.80	0.80	1.00	1.00	1.20	1.40	1.40	1.80
No. of infeeds		Radial infeed per pass									
1		0.16	0.14	0.16	0.16	0.18	0.17	0.17	0.20	0.19	0.20
2		0.14	0.13	0.15	0.15	0.17	0.16	0.16	0.19	0.19	0.20
3		0.13	0.12	0.14	0.14	0.16	0.16	0.16	0.18	0.18	0.19
4		0.08	0.11	0.12	0.13	0.15	0.15	0.15	0.17	0.17	0.18
5			0.08	0.08	0.12	0.13	0.13	0.14	0.16	0.16	0.18
6					0.08	0.08	0.12	0.13	0.15	0.15	0.17
7							0.08	0.11	0.13	0.14	0.16
8								0.08	0.08	0.13	0.15
9										0.12	0.14
10										0.08	0.13
11											0.12
12											0.08
Total infeed		0.51	0.57	0.66	0.78	0.87	0.97	1.10	1.27	1.52	1.90

Multi-point

		ISO metric					ISO metric, external				Whitworth (WH)			NPT
		Pitch					Pitch				Pitch			Pitch
External	PDY	1.00	1.5	2.00	2.50	3.00	18	16	14	12	19	14	11	11½
	PDX	1.62	1.42	1.91	1.98	2.79	2.14	1.52	1.79	1.91	2.04	1.73	1.88	1.67
		2.02	2.20	2.90	3.75	4.40	3.45	2.40	2.70	3.10	3.30	2.70	3.40	3.40
No. of infeeds		Radial infeed per pass												
1		0.34	0.36	0.47	0.46	0.55	0.49	0.39	0.44	0.52	0.49	0.47	0.45	0.50
2		0.31	0.33	0.46	0.43	0.52	0.43	0.36	0.41	0.47	0.43	0.43	0.43	0.48
3			0.26	0.33	0.40	0.48		0.29	0.32	0.36		0.33	0.39	0.44
4					0.27	0.33							0.27	0.31
Total infeed		0.65	0.95	1.26	1.56	1.88	0.92	1.04	1.17	1.35	0.92	1.23	1.54	1.73
Internal	PDY	1.00	1.50	2.00	2.50	3.00	18	16	14	12	19	14	11	11½
	PDX	1.63	1.41	1.82	1.98	2.79				1.92		1.72	1.85	1.64
		2.40	2.25	2.85	3.75	4.40				2.95		2.70	3.40	3.40
No. of infeeds		Radial infeed per pass												
1		0.33	0.35	0.46	0.45	0.52				0.47		0.45	0.43	0.50
2		0.30	0.32	0.42	0.42	0.49				0.44		0.41	0.41	0.48
3			0.25	0.32	0.36	0.45				0.34		0.32	0.39	0.44
4					0.25	0.32							0.27	0.31
Total infeed		0.63	0.92	1.20	1.48	1.78				1.25		1.18	1.50	1.73



Inch version

Trapezoidal (TR), external and internal

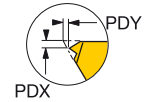
		Pitch, mm								
		1.5	2	3	4	5	6	7	8	
External	PDY	.054	.054	.050	.056	.056	.032	.032	.021	
	PDX	.039	.043	.063	.075	.083	.094	.094	.130	
Internal	PDY		.055	.051	.057	.057	.033	.041	.021	
	PDX		.039	.063	.075	.083	.094	.094	.130	
No. of infeeds		Radial infeed per pass								
1		.009	.009	.008	.009	.011	.011	.013	.013	
2		.008	.008	.007	.009	.011	.011	.013	.012	
3		.007	.008	.007	.009	.010	.011	.013	.012	
4		.007	.007	.007	.009	.010	.011	.013	.012	
5		.006	.007	.007	.008	.009	.011	.012	.011	
6		.003	.006	.007	.008	.009	.010	.012	.011	
7			.005	.006	.007	.009	.010	.011	.011	
8			.003	.006	.007	.008	.009	.011	.011	
9				.006	.007	.008	.009	.010	.010	
10				.005	.006	.007	.009	.010	.010	
11				.004	.006	.007	.008	.009	.010	
12				.003	.005	.006	.008	.009	.009	
13					.003	.005	.007	.008	.009	
14						.003	.007	.007	.009	
15							.006	.006	.008	
16							.004	.004	.007	
17									.007	
18									.006	
19									.004	
Total infeed		.040	.054	.073	.093	.113	.143	.162	.182	

UNJ, external

		Pitch, TPI									
		32	28	24	20	18	16	14	12	10	8
External	PDY	.052	.052	.052	.052	.052	.052	.052	.052	.052	.052
	PDX	.020	.031	.031	.031	.039	.039	.047	.055	.055	.071
No. of infeeds		Radial infeed per pass									
1		.006	.006	.006	.006	.007	.007	.007	.008	.007	.008
2		.006	.005	.006	.006	.007	.006	.006	.007	.007	.008
3		.005	.005	.006	.006	.006	.006	.006	.007	.007	.007
4		.003	.004	.005	.005	.006	.006	.006	.007	.007	.007
5			.003	.003	.005	.005	.005	.006	.006	.006	.007
6					.003	.003	.005	.005	.006	.006	.007
7							.003	.004	.005	.006	.006
8								.003	.003	.005	.006
9										.005	.006
10										.003	.005
11											.005
12											.003
Total infeed		.020	.022	.026	.031	.034	.038	.043	.050	.060	.075

Multi-point

		ISO metric					ISO metric, external				Whitworth (WH)			NPT	
		Pitch					Pitch				Pitch			Pitch	
External	PDY	1.00	1.5	2.00	2.50	3.00	18	16	14	12	19	14	11	11½	
		.064	.056	.075	.078	.110	.084	.060	.070	.075	.080	.068	.074	.066	
		PDX	.080	.087	.114	.148	.173	.136	.094	.106	.122	.130	.106	.134	.134
No. of infeeds		Radial infeed per pass													
1		.013	.014	.019	.018	.022	.019	.015	.017	.020	.019	.019	.018	.020	
2		.012	.013	.018	.017	.020	.017	.014	.016	.019	.017	.017	.017	.019	
3			.010	.013	.016	.019		.011	.013	.014		.013	.015	.017	
4					.011	.013							.011	.012	
Total infeed		.026	.037	.050	.061	.074	.036	.041	.046	.053	.036	.048	.061	.068	
Internal	PDY	Pitch					Pitch				Pitch		Pitch		
		1.00	1.50	2.00	2.50	3.00	18	16	14	12	19	14	11	11½	
		.064	.056	.072	.078	.110				.076		.068	.073	.065	
PDX	.094	.089	.112	.148	.173				.116		.106	.134	.134		
No. of infeeds		Radial infeed per pass													
1		.013	.014	.018	.018	.020					.019		.018	.017	.020
2		.012	.013	.017	.017	.019				.017		.016	.016	.019	
3			.010	.013	.014	.018				.013		.013	.015	.017	
4					.010	.013							.011	.012	
Total infeed		.025	.036	.047	.058	.070				.049		.046	.059	.068	



Metric version

API thread forms

Insert	Pitch, TPI	PDY	PDX	No. of infeeds															Total infeed	
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15		
API 60° V-0.038R				Radial infeed per pass																
266RG-22V381A0402E	4	0.88	2.50	0.36	0.35	0.33	0.32	0.30	0.29	0.27	0.25	0.23	0.20	0.16	0.08					3.08
266RL-22V381A0402E	4	0.87	2.50	0.36	0.35	0.33	0.32	0.30	0.29	0.27	0.25	0.23	0.20	0.16	0.08					3.08
266RG-22V381A0403E	4	0.88	2.50	0.36	0.34	0.33	0.32	0.30	0.29	0.27	0.25	0.23	0.20	0.16	0.08					3.07
266RL-22V381A0403E	4	0.87	2.50	0.36	0.34	0.33	0.32	0.30	0.29	0.27	0.25	0.23	0.20	0.16	0.08					3.07
API 60° V-0.040																				
226RG-22V401A0503E	5	1.38	2.50	0.35	0.33	0.32	0.31	0.29	0.28	0.26	0.24	0.22	0.19	0.16	0.08					2.98
226RL-22V401A0503E	5	1.35	2.50	0.35	0.33	0.32	0.31	0.29	0.28	0.26	0.24	0.22	0.19	0.16	0.08					2.98
API 60° V-0.050																				
266RG-22V501A0402E	4	0.88	2.80	0.34	0.34	0.33	0.31	0.30	0.29	0.28	0.27	0.25	0.24	0.22	0.20	0.18	0.15	0.08		3.74
266RL-22V501A0402E	4	0.87	2.80	0.34	0.34	0.33	0.31	0.30	0.29	0.28	0.27	0.25	0.24	0.22	0.20	0.18	0.15	0.08		3.74
266RG-22V501A0403E	4	0.88	2.80	0.34	0.34	0.32	0.31	0.30	0.29	0.28	0.27	0.25	0.24	0.22	0.20	0.18	0.15	0.08		3.73
266RL-22V501A0403E	4	0.87	2.90	0.34	0.34	0.32	0.31	0.30	0.29	0.28	0.27	0.25	0.24	0.22	0.20	0.18	0.15	0.08		3.73
API Round 60°																				
266RG-22RD01A100E	10	1.32	1.30	0.18	0.18	0.17	0.16	0.16	0.15	0.14	0.13	0.11	0.08							1.40
266RL-22RD01A100E	10	1.30	1.30	0.18	0.18	0.17	0.16	0.16	0.15	0.14	0.13	0.11	0.08							1.40
266RG-22RD01A080E	8	1.32	1.50	0.19	0.19	0.18	0.18	0.17	0.16	0.16	0.15	0.14	0.13	0.11	0.08					1.80
266RL-22RD01A080E	8	1.30	1.50	0.20	0.19	0.18	0.18	0.17	0.16	0.16	0.15	0.14	0.13	0.11	0.08					1.81
API Buttress																				
226RG-22BU01A050E	5	1.87	2.00	0.20	0.19	0.18	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.08						1.65
226RL-22BU01A050E	5	1.67	2.00	0.20	0.19	0.18	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.08						1.65
226RG-22BU01A0501E	5	1.67	2.00	0.20	0.19	0.18	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.08						1.65
226RL-22BU01A0501E	5	1.67	2.00	0.20	0.19	0.18	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.08						1.65



Inch version

API thread forms

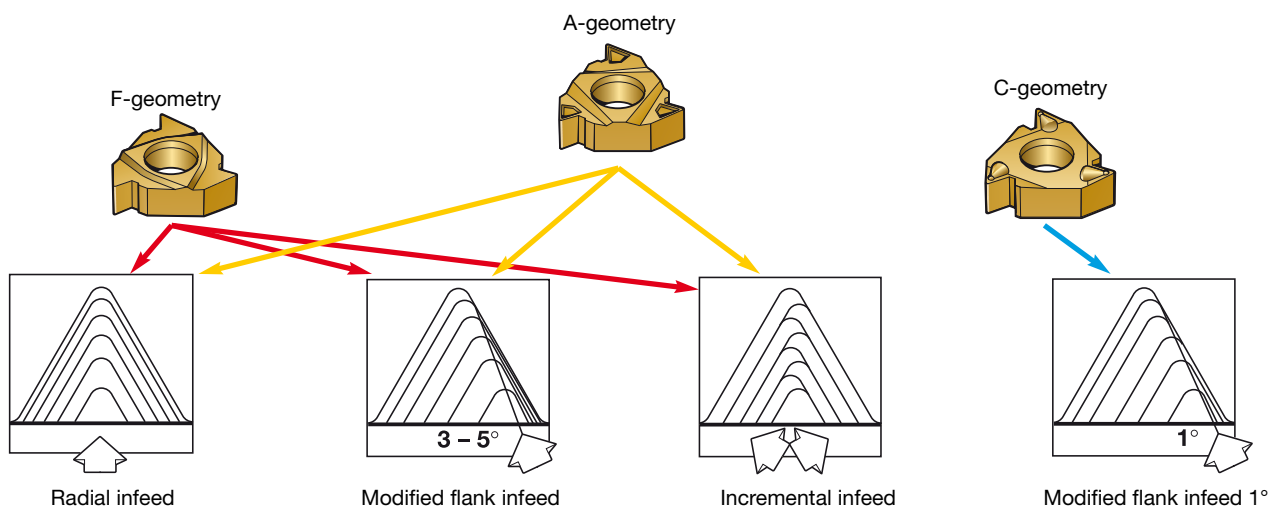
Insert	Pitch, TPI	PDY	PDX	No. of infeeds															Total infeed			
				1	2	3	4	5	6	7	8	9	10	11	12	13	14	15				
API 60° V-0.038R				Radial infeed per pass																		
266RG-22V381A0402E	4	.035	.098	.014	.014	.013	.013	.012	.011	.011	.010	.009	.008	.006	.003							.121
266RL-22V381A0402E	4	.034	.098	.014	.014	.013	.013	.012	.011	.011	.010	.009	.008	.006	.003							.121
266RG-22V381A0403E	4	.035	.098	.014	.013	.013	.013	.012	.011	.011	.010	.009	.008	.006	.003							.121
266RL-22V381A0403E	4	.034	.098	.014	.013	.013	.013	.012	.011	.011	.010	.009	.008	.006	.003							.121
API 60° V-0.040																						
226RG-22V401A0503E	5	.054	.098	.014	.013	.013	.012	.011	.011	.010	.009	.009	.007	.006	.003							.117
226RL-22V401A0503E	5	.053	.098	.014	.013	.013	.012	.011	.011	.010	.009	.009	.007	.006	.003							.117
API 60° V-0.050																						
266RG-22V501A0402E	4	.035	.110	.013	.013	.013	.012	.012	.011	.011	.011	.010	.009	.009	.008	.007	.006	.003				.147
266RL-22V501A0402E	4	.034	.110	.013	.013	.013	.012	.012	.011	.011	.011	.010	.009	.009	.008	.007	.006	.003				.147
266RG-22V501A0403E	4	.035	.110	.013	.013	.013	.012	.012	.011	.011	.011	.010	.009	.009	.008	.007	.006	.003				.147
266RL-22V501A0403E	4	.034	.114	.013	.013	.013	.012	.012	.011	.011	.011	.010	.009	.009	.008	.007	.006	.003				.147
API Round 60°																						
266RG-22RD01A100E	10	.052	.051	.007	.007	.007	.006	.006	.006	.006	.005	.004	.003									.055
266RL-22RD01A100E	10	.051	.051	.007	.007	.007	.006	.006	.006	.006	.005	.004	.003									.055
266RG-22RD01A080E	8	.052	.059	.007	.007	.007	.007	.007	.006	.006	.006	.006	.005	.004	.003							.071
266RL-22RD01A080E	8	.051	.059	.008	.007	.007	.007	.007	.006	.006	.006	.006	.005	.004	.003							.071
API Buttress																						
226RG-22BU01A050E	5	.074	.079	.008	.007	.007	.007	.007	.006	.006	.006	.005	.005	.003								.065
226RL-22BU01A050E	5	.066	.079	.008	.007	.007	.007	.007	.006	.006	.006	.005	.005	.003								.065
226RG-22BU01A0501E	5	.066	.079	.008	.007	.007	.007	.007	.006	.006	.006	.005	.005	.003								.065
226RL-22BU01A0501E	5	.066	.079	.008	.007	.007	.007	.007	.006	.006	.006	.005	.005	.003								.065

Infeed recommendations

The type of infeed, number of passes and size of infeed can have a decisive impact on the threading operation. The infeed recommendations are intended as starting values. Suitable number of passes must be determined by trial and error. The harder the workpiece the more number of passes.

- The workpiece diameter should not be more than 0.14 mm (.006 inch) larger than the max diameter of the thread to achieve optimum tool life.
- Infeeds of less than 0.05 mm (.002 inch) should be avoided, for austenitic stainless steels not less than 0.08 mm (.003 inch).

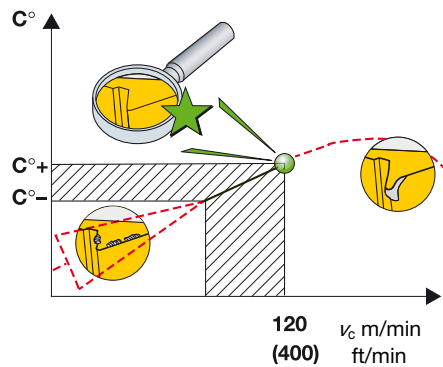
- When using a Cubic Boron Nitride (CBN) grade the max infeed value should be 0.07 mm (.003 inch).
- For C-geometry inserts, spring pass (a pass without infeed) should not be used.
- For Multi-point inserts it is essential that the recommendations on page C80 are used.
- For V-profile inserts the recommended number of passes that is used for full form inserts can be used.



Cutting speed

Starting cutting speed recommendations are given on page C68. Careful observation on the cutting edge can help you to achieve the best possible threading results.

- A cutting speed that is too low can result in built-up edge
- A cutting speed that is too high can result in plastic deformation of the edge



Formula

Formula to calculate infeed for each pass in a reduced series.

$$\Delta_{apx} = \frac{a_p}{\sqrt{nap-1}} \times \sqrt{\phi}$$

- Δ_{ap} Radial infeed
- x Actual pass (in a series from 1 to nap)
- a_p Total depth of thread
- nap Number of infeeds. See page C74
- ϕ 1st pass = 0.3
- 2nd pass = 1
- 3rd and higher passes = $x-1$

Grades for threading



Steel, cast steel, martensitic stainless steel, long chipping malleable iron



GC1125 (HC) - P20 (P05-P35)

PVD-coated grade with very good wear resistance for various steel threadings. To be used at high cutting speeds and long cutting times.



GC1020 (HC) - P20 (P10-P40)

Good, all-round PVD-coated grade for steel turning. Combines good wear resistance with sharpness also in low carbon.



GC1135 (HC) - P25 (P10-P45)

Good allround PVD-coated grade with good wear resistance and edge line toughness for various steel threadings. To be used at medium cutting speeds.



Cast iron, chilled cast iron, short chipping malleable iron.



GC1125 (HC) - K15 (K05-K20)

PVD-coated grade. Combines the superior wear resistance of a coated grade with the edge sharpness and toughness of an uncoated grade. Optimized for steel threading and for medium to high speeds.



GC1020 (HC) - K10 (K01-K20)

Competitive, all-around threading grade. Works best at medium to low cutting speeds, with a thin coating ideal for sharp cutting edges.



GC1135 (HC) - K20 (K10-K30)

Good allround PVD-coated grade with good wear resistance and edge line toughness for various steel threadings. To be used at medium cutting speeds.



Austenitic/ferritic/martensitic stainless steel, cast steel, manganese steel, alloy cast iron, malleable iron, free cutting steel.



GC1125 (HC) - M20 (M10-M30)

PVD-coated grade for stainless steels and other smearing materials at higher cutting speed.



GC1020 (HC) - N25 (N10-N30)

Good all-round PVD-coated grade with good wear resistance and edge sharpness in non-ferrous materials.



GC1135 (HC) - M25 (M10-M35)

Good allround PVD-coated grade with good wear resistance and very good edge line toughness for stainless steels and other smearing materials. To be used at medium cutting speeds. First choice in M-area and toughness demanding threading operations.



Non ferrous metals



GC1125 (HC) - N25 (N15-N35)

PVD-coated grade. Combines the superior wear resistance of a coated grade with the edge sharpness and toughness of an uncoated grade. Optimized for steel threading and for medium to high speeds.



GC1020 (HC) - N25 (N10-N30)

Competitive, all-around threading grade. Works best at medium to low cutting speeds, with a thin coating ideal for sharp cutting edges.



GC1135 (HC) - N25 (N10-N30)

PVD grade optimized for stainless steel and heat resistant super alloys. The best choice for sharp profiles in all materials and for low to medium speeds.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).

CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾


Boron nitride:


BN Polycrystalline boron nitride¹⁾


¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for threading


S Heat resistant and super alloys


 **GC1020 (HC)** – S20 (S05-S30)
A PVD-coated carbide grade for toughness demanding super alloy operations. To be used at low cutting speeds.

 **GC1125 (HC)** – S20 (S10-S25)
PVD-coated carbide grade for toughness demanding super alloy operations. To be used at lower cutting speeds.


 **GC1135 (HC)** - S25 (S10-S35)
Good allround PVD-coated carbide grade for toughness demanding super alloy threading. To be used at low cutting speeds. First choice in S-area.

P M K N S O

 **GC1105 (HC)** - S15 (S10-S20)
A PVD-coated carbide grade with high hot hardness and good resistance against plastic deformation giving even flank wear and outstanding performance.

 **GC1025 (HC)** - S25 (S15-S35)
A PVD-coated grade for toughness demanding operations, recommended for interrupted cuts. To be used at low cutting speeds.

H Hardened materials

 **CB7015 (BN)** – H15 (H01-H25)
This grade has a low content of cubic boron nitride which makes it suitable for threading applications in hardened steels.

Letter symbols specifying the designation of hard cutting materials:

- Hardmetals:**
- HW Uncoated hardmetal containing primarily tungsten carbide (WC)
 - HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TIC) or titanium nitrides (TIN) or both
 - HC Hardmetals as above, but coated

- Ceramics:**
- CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).
 - CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.
 - CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)
 - CC Ceramics as above, but coated.

- Diamond:**
- DP Polycrystalline diamond¹⁾
- Boron nitride:**
- BN Polycrystalline boron nitride¹⁾
- ¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.



Grades for threading

	ISO	ANSI		
P Steel	01	C8		▲
	10			
	20	C7	GC 1020 GC 1125 GC 1135 GC 1105 GC 1025	
	30	C6		
	40			
	50	C5		▼
M Stainless steel	10	-		▲
	20	-	GC 1020 GC 1125 GC 1135 GC 1105 GC 1025 H13A	
	30	-		
	40	-		▼
K Cast iron	01	C4		▲
	10	C3	GC 1020 GC 1125 GC 1135 GC 1025 H13A	
	20	C2		
	30	C1		
	40			▼
N Non-ferrous materials	10	C4		▲
	20	C3	GC 1020 GC 1135 GC 1105 GC 1025 H13A	
	30	C2		
	40	C1		▼
S Heat resistant and super alloys	10	-		▲
	20	-	GC 1020 GC 1125 GC 1105 GC 1025 GC 1135 H13A	
	30	-		
	40	-		▼
H Hardened materials	10	C4		▲
	20	C3	GC 1020 GC 1125 CB 7015	
	30	C2		
	40	C1		▼

The position and form of the grade symbols indicate the suitable field of application.

Centre of the field of application.

Recommended field of application.

▲ Wear resistance

▼ Toughness



Additional coverage due to the F-geometry

Turning tool adaptors

Rectangular shank

Rectangular shank to CoroTurn® XS adaptor D3-D4

Rectangular shank to CoroCut® MB adaptor D5

Cylindrical shank

Cylindrical shank to CoroCut® MB adaptor D8

Cylindrical shank with flat

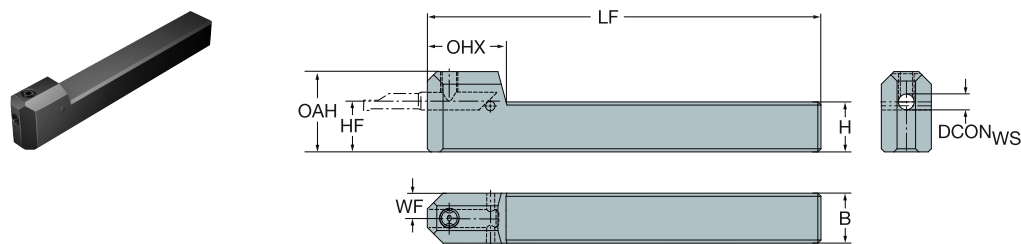
Cylindrical shank with flat to CoroTurn® SL adaptor D10

Cylindrical shank with flat to CoroTurn® XS adaptor D11-D16

Cylindrical shank with flat to CoroTurn® XS double-ended adaptor D17

Cylindrical shank with flat to CoroCut® MB adaptor D18-D19

Rectangular shank to CoroTurn® XS adaptor



Metric version

		Dimensions, mm										
CZC _{MS}	CZC _{WS}	OHX	Ordering code	DCON _{WS}	B	H	LF	WF	HF	OAH	(NM)	(KG)
12 x 12	4	19.0	CXS-1212-04FN	4.0	12.0	12.0	100.0	6.0	12.0	21.0	7	0.1
	5	25.0	CXS-1212-05FN	5.0	12.0	12.0	100.0	6.0	12.0	21.5	7	0.1
	6	26.0	CXS-1212-06FN	6.0	12.0	12.0	100.0	6.0	12.0	22.0	7	0.1
16 x 16	4	19.0	CXS-1616-04FN	4.0	16.0	16.0	125.0	8.0	16.0	25.0	7	0.2
	5	25.0	CXS-1616-05FN	5.0	16.0	16.0	125.0	8.0	16.0	25.5	7	0.2
	6	26.0	CXS-1616-06FN	6.0	16.0	16.0	125.0	8.0	16.0	26.0	7	0.2
	7	26.5	CXS-1616-07FN	7.0	16.0	16.0	125.0	8.0	16.0	26.5	7	0.2

Inch version

		Dimensions, inch										
CZC _{MS}	CZC _{WS}	OHX	Ordering code	DCON _{WS}	B	H	LF	WF	HF	OAH	(FT/LBS)	(LBS)
1/2 x 1/2	4	.748	CXS-08-04FN	.157	.500	.500	3.937	.250	.500	.827	5	0.4
	5	.984	CXS-08-05FN	.197	.500	.500	3.937	.250	.500	.846	5	0.4
	6	1.004	CXS-08-06FN	.236	.500	.500	3.937	.250	.500	.866	5	0.4
5/8 x 5/8	4	.748	CXS-10-04FN	.157	.625	.625	4.921	.313	.625	.984	5	0.6
	5	.984	CXS-10-05FN	.197	.625	.625	4.921	.313	.625	1.004	5	0.6
	6	1.004	CXS-10-06FN	.236	.625	.625	4.921	.313	.625	1.024	5	0.6
	7	1.043	CXS-10-07FN	.276	.625	.625	4.921	.313	.625	1.378	5	0.6

For spare parts, visit www.sandvik.coromant.com



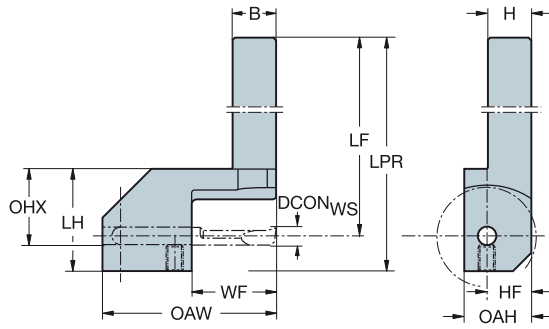
J19



A95

Rectangular shank to CoroTurn® XS adaptor

For internal machining in sliding head machines



Metric version

					Dimensions, mm														
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{WS}	B	H	LPR	LF	WF	HF	OAW	OAH	CNT	BAR	NM	KG	
10 x 10	4	29.0	1	2	CXS-1010-04R/L	4.0	10.0	10.0	99.0	89.0	18.0	10.0	36.5	16.0	M 5	10	7	0.1	
	5	29.0	1	2	CXS-1010-05R/L	5.0	10.0	10.0	99.0	89.0	23.0	10.0	48.0	16.0	M 5	10	7	0.1	
	6	29.0	1	2	CXS-1010-06R/L	6.0	10.0	10.0	99.0	89.0	28.0	10.0	53.0	16.0	M 5	10	7	0.1	
12 x 12	4	29.0	1	2	CXS-1212-04R/L	4.0	12.0	12.0	99.0	89.0	18.0	12.0	36.5	18.0	M 5	10	7	0.1	
	5	29.0	1	2	CXS-1212-05R/L	5.0	12.0	12.0	99.0	89.0	23.0	12.0	48.0	18.0	M 5	10	7	0.2	
	6	29.0	1	2	CXS-1212-06R/L	6.0	12.0	12.0	99.0	89.0	28.0	12.0	53.0	18.0	M 5	10	7	0.2	
16 x 16	5	34.0	1	2	CXS-1616-05R/L	5.0	16.0	16.0	104.0	94.0	23.0	16.0	48.0	22.0	M 5	10	7	0.3	
	6	34.0	1	2	CXS-1616-06R/L	6.0	16.0	16.0	104.0	94.0	28.0	16.0	53.0	22.0	M 5	10	7	0.3	

To correspond with seat size on insert.
Insert tightening torque Nm.

Inch version

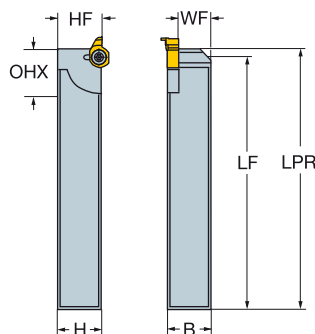
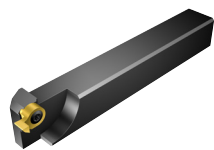
					Dimensions, inch														
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{WS}	B	H	LPR	LF	WF	HF	OAW	OAH	CNT	PSI	FT/LBS	LBS	
1/2 x 1/2	4	1.142	1	2	CXS-08-04R	.157	.500	.500	3.898	3.504	.709	.500	1.890	.748	M 5	145	5	0.3	
	5	1.142	1	2	CXS-08-05R	.197	.500	.500	3.898	3.504	.906	.500	1.890	.748	M 5	145	5	0.5	
	6	1.142	1	2	CXS-08-06R	.236	.500	.500	3.898	3.504	1.102	.500	1.890	.748	M 5	145	5	0.5	
3/8 x 3/8	4	1.142	1	2	CXS-06-04R	.157	.375	.375	3.898	3.504	.709	.375	1.437	.630	M 5	145	5	0.3	
5/8 x 5/8	5	1.339	1	2	CXS-10-05R	.197	.625	.625	4.094	3.701	.906	.625	2.087	.866	M 5	145	5	0.6	
	6	1.339	1	2	CXS-10-06R	.236	.625	.625	4.094	3.701	1.102	.625	2.087	.866	M 5	145	5	0.7	

To correspond with seat size on insert.
Insert tightening torque ft-lbs.

R = Right hand, L = Left hand



Rectangular shank to CoroCut® MB adaptor



Metric version

			Dimensions, mm									
CZC _{MS}	CZC _{WS}	OHX	Ordering code	DCON _{MS}	B	H	LPR	LF	WF	HF	NM KG	
12 x 12	09	20.0	MBG-1212-09R/L	9.0	12.0	12.0	100.0	95.5	15.1	12.0	3	0.1
16 x 16	09	20.0	MBG-1616-09R/L	9.0	16.0	16.0	120.0	115.5	19.1	16.0	3	0.2

Inch version

			Dimensions, inch									
CZC _{MS}	CZC _{WS}	OHX	Ordering code	DCON _{MS}	B	H	LPR	LF	WF	HF	FT/LBS LBS	
1/2 x 1/2	09	.787	MBG-08A-09R/L	.354	.500	.500	3.937	3.760	.622	.500	2	0.3
5/8 x 5/8	09	.787	MBG-10C-09R/L	.354	.625	.625	4.724	4.547	.747	.625	2	0.6

For spare parts, visit www.sandvik.coromant.com

R = Right hand, L = Left hand



J19



A95

Machine side interface Cylindrical shank

B

C

D

E

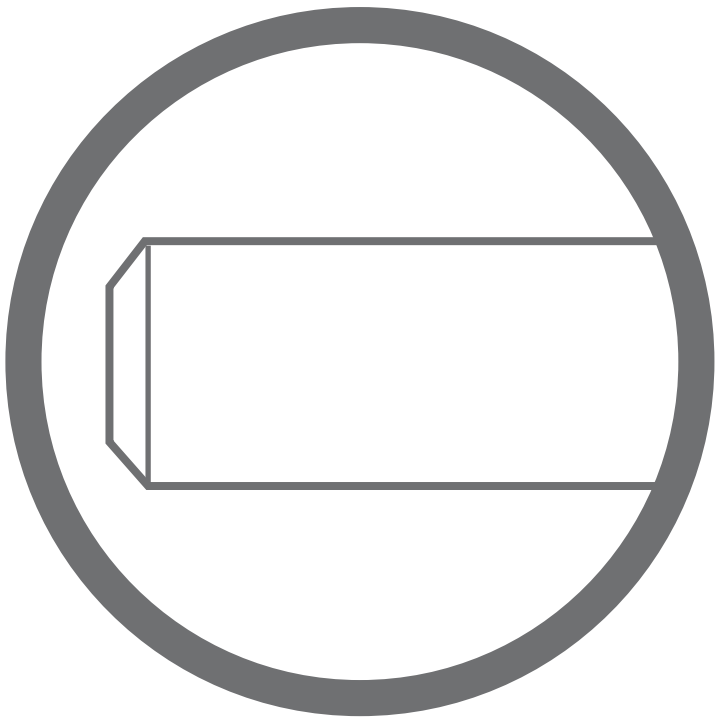
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G

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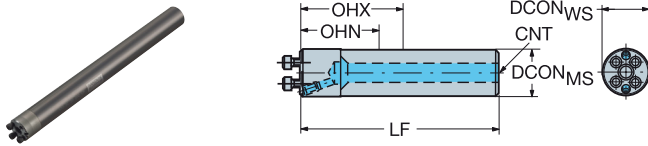
I

J



Cylindrical shank to CoroTurn® SL solid carbide adaptor

With groove for EasyFix sleeve



Metric version

							Dimensions, mm				
CZC _{MS}	CZC _{WS}	OHN	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LF	BAR	KG
16	16	16.0	76.0	1	1	570-2C 16 170 CR	16.0	16.0	170.0	150	0.4
20	20	20.0	100.0	1	1	570-2C 20 200 CR	20.0	20.0	200.0	150	0.8
25	25	25.0	130.0	1	1	570-2C 25 250 CR	25.0	25.0	250.0	150	1.5

Inch version

							Dimensions, inch					
CZC _{MS}	CZC _{WS}	OHN	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	BD ₁	LF	PSI	LBS
1	25	.984	5.213	1	1	A570-2C D16 10-25 CR	1.000	.984	1.000	10.039	2175	3.6
3/4	20	.787	3.713	1	1	A570-2C D12 08-20 CR	.750	.787	.787	8.071	2175	1.7
5/8	16	.630	2.963	1	1	A570-2C D10 07-16 CR	.625	.630	.630	7.087	2175	0.7

For spare parts, visit www.sandvik.coromant.com

N = Neutral



J19



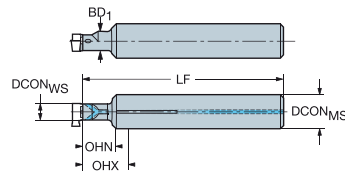
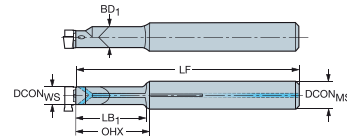
J16



A95

Cylindrical shank to CoroCut® MB adaptor

With groove for EasyFix sleeve

MB..Axx..R
Steel shankMB..Exx..R
Carbide shank

Metric version

							Dimensions, mm							
CZC _{MS}	CZC _{WS}	OHN	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	BD ₁	LB ₁	LF	BAR	KG	
12	07	24.0	1	1		MB-E12-24-07R	12.0	7.0	7.4	20.1	88.1	10	0.1	
		32.0	1	1		MB-E12-32-07R	12.0	7.0	7.4	28.1	96.1	10	0.1	
		48.0	1	1		MB-E12-48-07R	12.0	7.0	7.4	44.1	111.1	10	0.1	
		64.0	1	3		MB-E12-64-07R	12.0	7.0	9.0	60.1	126.1	80	0.1	
09		34.0	1	1		MB-E12-34-09R	12.0	9.0	9.5	28.7	94.7	10	0.1	
		45.0	1	1		MB-E12-45-09R	12.0	9.0	9.5	39.7	104.7	10	0.1	
		64.0	1	1		MB-E12-64-09R	12.0	9.0	9.5	59.7	124.7	10	0.0	
16	07	16.0	1	1		MB-A16-16-07R	16.0	7.0	7.4	12.1	93.1	10	0.1	
		20.0	1	1		MB-A16-20-09R	16.0	9.0	9.5	14.7	94.8	10	0.1	
		34.0	1	1		MB-E16-34-09R	16.0	9.0	9.5	28.7	94.7	10	0.2	
		45.0	1	1		MB-E16-45-09R	16.0	9.0	9.5	39.7	104.7	10	0.2	
	11		64.0	1	1		MB-E16-64-09R	16.0	9.0	9.5	58.7	124.7	10	0.2
			75.0	1	3		MB-E16-75-09R	16.0	9.0	11.0	69.8	134.8	80	0.2
			42.0	1	1		MB-E16-42-11R	16.0	11.0	11.0	42.0	94.4	10	0.2
			60.0	1	1		MB-E16-60-11R	16.0	11.0	11.0	60.0	124.4	10	0.3
20	11	85.0	1	1		MB-E16-85-11R	16.0	11.0	11.0	85.0	154.4	10	0.4	
		25.0	1	1		MB-A20-25-11R	20.0	11.0	11.0	25.0	89.4	10	0.1	
		40.0	1	1		MB-A20-40-11R	20.0	11.0	11.0	40.0	99.4	10	0.2	
		85.0	1	1		MB-E20-85-11R	20.0	11.0	11.0	85.0	154.4	10	0.5	

Inch version

							Dimensions, inch						
CZC _{MS}	CZC _{WS}	OHN	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	BD ₁	LB ₁	LF	PSI	LBS
1/2	07	1.260	1	1		MB-E0500-12-07R	.500	.276	.291	1.106	3.783	145	0.3
		1.890	1	1		MB-E0500-19-07R	.500	.276	.291	1.736	4.374	145	0.4
		2.520	1	3		MB-E0500-25-07R	.500	.276	.354	2.366	4.965	1160	0.4
		1.213	1	1		MB-E0500-13-09R	.500	.354	.374	1.130	3.728	145	0.4
09		1.606	1	1		MB-E0500-17-09R	.500	.354	.374	1.563	4.122	145	0.4
		2.394	1	1		MB-E0500-25-09R	.500	.354	.374	2.350	4.909	145	0.4
		1.000	1	1		MB-A0750-10-11R	.750	.433	.433	1.000	3.520	145	0.6
3/4	11	1.500	1	1		MB-A0750-15-11R	.750	.433	.433	1.500	3.913	145	0.6
		3.346	1	1		MB-E0750-33-11R	.750	.433	.433	3.346	6.079	145	1.1
		.630	1	1		MB-A0625-06-07R	.625	.276	.291	.476	3.665	145	0.3
5/8	09	.787	1	1		MB-A0625-08-09R	.625	.354	.374	.579	3.728	145	0.3
		1.213	1	1		MB-E0625-13-09R	.625	.354	.374	1.130	3.728	145	0.5
	1.610	1	1		MB-E0625-17-09R	.625	.354	.374	1.563	4.122	145	0.5	
	2.976	1	3		MB-E0625-29-09R	.625	.354	.433	2.748	5.307	1160	0.6	
	1.654	1	1		MB-E0625-16-11R	.625	.433	.433	1.654	3.717	145	0.6	
11	3.346	1	1		MB-E0625-33-11R	.625	.433	.433	3.346	6.079	145	0.9	

General minimum hole depends on insert; see respective insert ordering page.



J19

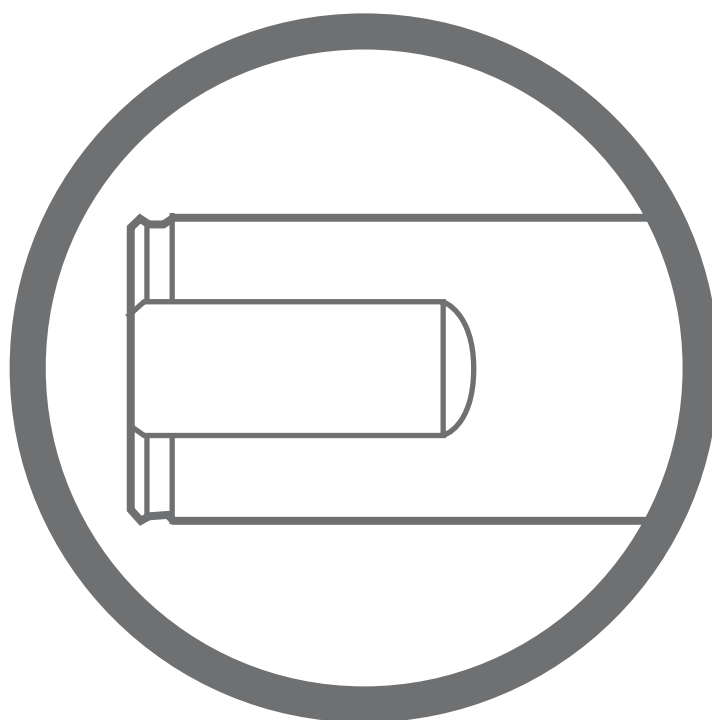


J16



A95

Machine side interface Cylindrical shank with flat



A

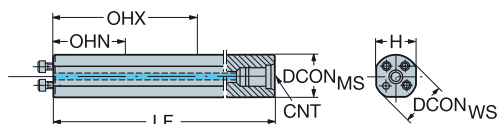
Cylindrical shank with flat to CoroTurn® SL adaptor

ENG

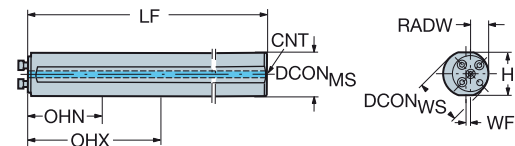
B



570-2C



570-2C..-40



C

Metric version

							Dimensions, mm							
CZC _{MS}	CZC _{WS}	OHN	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	WF	CNT	BAR	KG
16	16	0.0	44.0	1	1	570-2C 16 105	16.0	16.0	15.0	105.0	0.0	G 1/8-28	150	0.1
20	20	0.0	60.0	1	1	570-2C 20 140	20.0	20.0	18.0	140.0	0.0	G 1/4-19	150	0.3
25	25	0.0	80.0	1	1	570-2C 25 200	25.0	25.0	23.0	200.0	0.0	G 1/4-19	150	0.7

EasyFix for 16-25 mm (5/8 - 1")

E

Inch version

							Dimensions, inch								
CZC _{MS}	CZC _{WS}	OHN	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	BD ₁	LF	WF	CNT	PSI	LBS
5/8	16	.000	1.713	1	1	A570-2C D10 04-16	.625	.630	.560	.630	4.210	.000	G 1/8-28	2175	0.3
3/4	20	.000	2.213	1	1	A570-2C D12 05-20	.750	.787	.710	.787	5.200	.000	G 1/4-19	2175	0.6
1	25	.000	3.213	1	1	A570-2C D16 07-25	1.000	.984	.910	.984	7.200	.000	G 1/4-19	2175	1.5

EasyFix for 16-25 mm (5/8 - 1")

For spare parts, visit www.sandvik.coromant.com

G

H

I

J



J19



J16



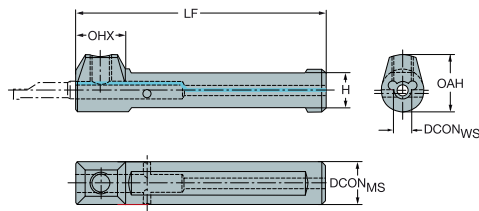
A95

Cylindrical shank with flat to CoroTurn® XS adaptor

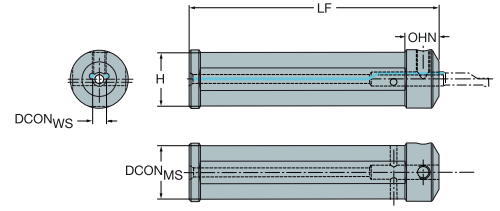
With internal coolant supply

Cylindrical with two flats

DSGN 1



2



For Star machines

							Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	DSGN	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	BAR PSI	NM	KG
22	4	14.0	1	1	2	CXS-A22-04	22.0	4	20	110	10	7	0.320
		.551					.866	.157	.787	4.331	145		
	5	14.0	1	1	2	CXS-A22-05	22.0	5	20	110	10	7	0.320
		.551					.866	.197	.787	4.331	145		
	6	14.0	1	1	2	CXS-A22-06	22.0	6	20	110	10	7	0.280
		.551					.866	.236	.787	4.331	145		
	7	14.0	1	1	2	CXS-A22-07	22.0	7	20	110	10	7	0.280
		.551					.866	.276	.787	4.331	145		

For Tsugami/Miyano machines

							Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	DSGN	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	BAR PSI	NM	KG
25	4	14.0	1	1	1	CXS-A25-04	25.0	4	23	110	10	7	0.427
		.551					.984	.157	.906	4.331	145		
	5	14.0	1	1	1	CXS-A25-05	25.0	5	23	110	10	7	0.419
		.551					.984	.197	.906	4.331	145		
	6	14.0	1	1	1	CXS-A25-06	25.0	6	23	110	10	7	0.400
		.551					.984	.236	.906	4.331	145		
	7	14.0	1	1	1	CXS-A25-07	25.0	7	23	110	10	7	0.410
		.551					.984	.276	.906	4.331	145		

For Nomura machines

							Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	DSGN	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	BAR PSI	NM	KG
23	4	14.0	1	1	1	CXS-A23-04	23.0	4	21	110	10	7	0.320
		.551					.906	.157	.827	4.331	145		
	5	14.0	1	1	1	CXS-A23-05	23.0	5	21	110	10	7	0.321
		.551					.906	.197	.827	4.331	145		
	6	14.0	1	1	1	CXS-A23-06	23.0	6	21	110	10	7	0.355
		.551					.906	.236	.827	4.331	145		
	7	14.0	1	1	1	CXS-A23-07	23.0	7	21	110	10	7	0.352
		.551					.906	.276	.827	4.331	145		

CZC_{WS} to correspond with CZC_{MS} on tool



J19



J16



A95

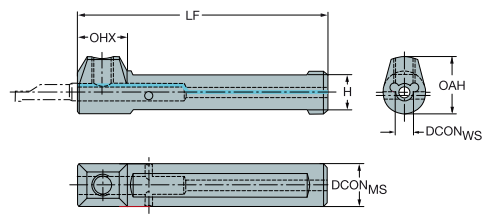
Cylindrical shank with flat to CoroTurn® XS adaptor

With internal coolant supply

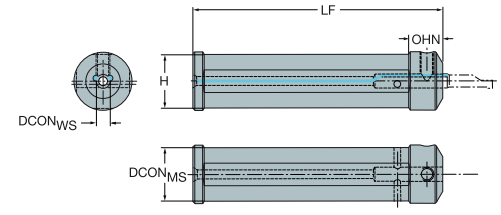
Cylindrical with two flats

B

DSGN 1



2



C

For Traub machines

D

							Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	DSGN	Ordering code	DCON _{MS}	DCON _{WS}	H	LF			
28	4	17.0	1	1	1	CXS-A28-04	28.0	4	26	120	10	7	0.496
		.669					1.102	.157	1.024	4.724	145		
	5	17.0	1	1	1	CXS-A28-05	28.0	5	26	120	10	7	0.508
		.669					1.102	.197	1.024	4.724	145		
	6	17.0	1	1	1	CXS-A28-06	28.0	6	26	120	10	7	0.511
		.669					1.102	.236	1.024	4.724	145		
	7	17.0	1	1	1	CXS-A28-07	28.0	7	26	120	10	7	0.509
		.669					1.102	.276	1.024	4.724	145		

E

For Citizen machines

F

							Dimensions, mm, inch								
CZC _{MS}	CZC _{WS}	OHN	OHX	CNSC	CXSC	DSGN	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	OAH			
3/4	4		14.0	1	1	1	CXS-A0750-04	19.1	4	18	110	20	10	7	0.252
			.551					.750	.157	.709	4.331	.787	145		
	5		14.0	1	1	1	CXS-A0750-05	19.1	5	18	110	20	10	7	0.247
			.551					.750	.197	.709	4.331	.787	145		
	6		14.0	1	1	1	CXS-A0750-06	19.1	6	18	110	22	10	7	0.250
			.551					.750	.236	.709	4.331	.866	145		
	7		14.0	1	1	1	CXS-A0750-07	19.1	7	18	110	22	10	7	0.247
			.551					.750	.276	.709	4.331	.866	145		
	8		14.0	1	1	1	CXS-A0750-08	19.1	8	18	75	24	10	7	0.251
			.551					.750	.315	.709	2.953	.945	145		
	10		14.0	1	1	1	CXS-A0750-10	19.1	10	18	110	24	10	7	0.243
			.551					.750	.394	.709	4.331	.945	145		
	1	4	15.0		1	2	CXS-A1000-04M	25.4	4	23	110	25	10	7	0.431
			.591					1.000	.157	.921	4.331	1.000	145		
	5	15.0		1	1	2	CXS-A1000-05M	25.4	5	23	110	25	10	7	0.400
			.591					1.000	.197	.921	4.331	1.000	145		
	6	15.0		1	1	2	CXS-A1000-06M	25.4	6	23	110	25	10	7	0.420
			.591					1.000	.236	.921	4.331	1.000	145		
	7	15.0		1	1	2	CXS-A1000-07M	25.4	7	23	110	25	10	7	0.380
			.591					1.000	.276	.921	4.331	1.000	145		
	8	15.0		1	1	2	CXS-A1000-08	25.4	8	23	110	25	10	7	0.412
			.591					1.000	.315	.921	4.331	1.000	145		
	10	15.0		1	1	2	CXS-A1000-10	25.4	10	23	110	25	10	7	0.410
			.591					1.000	.394	.921	4.331	1.000	145		

H

CZC_{WS} to correspond with CZC_{MS} on tool

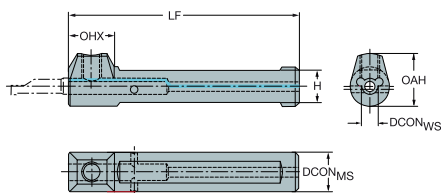
I

J



Cylindrical shank with flat to CoroTurn® XS adaptor

Cylindrical with two flats



Steel shank

						Dimensions, mm, inch							
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	OAH	BAR PSI	NM	KG
10	4	14.0	1	1	CXS-A10-04	10.0	4	8	65	14	10	7	0.062
		.551				.394	.157	.315	2.559	.571	145		
	5	14.0	1	1	CXS-A10-05	10.0	5	8	65	15	10	7	0.060
		.551				.394	.197	.315	2.559	.591	145		
12	4	14.0	1	1	CXS-A12-04	12.0	4	10	70	15	10	7	0.084
		.551				.472	.157	.394	2.756	.610	145		
	5	14.0	1	1	CXS-A12-05	12.0	5	10	70	16	10	7	0.080
		.551				.472	.197	.394	2.756	.630	145		
	6	14.0	1	1	CXS-A12-06	12.0	6	10	70	16	10	7	0.060
		.551				.472	.236	.394	2.756	.650	145		
16	4	14.0	1	1	CXS-A16-04	16.0	4	14	75	17	10	7	0.120
		.551				.630	.157	.551	2.953	.689	145		
	5	14.0	1	1	CXS-A16-05	16.0	5	14	75	18	10	7	0.131
		.551				.630	.197	.551	2.953	.709	145		
	6	14.0	1	1	CXS-A16-06	16.0	6	14	75	18	10	7	0.120
		.551				.630	.236	.551	2.953	.728	145		
	7	14.0	1	1	CXS-A16-07	16.0	7	14	75	19	10	7	0.129
		.551				.630	.276	.551	2.953	.748	145		
	8	14.0	1	1	CXS-A16-08	16.0	8	14	75	19	10	7	0.080
		.551				.630	.315	.551	2.953	.768	145		
20	4	14.0	1	1	CXS-A20-04	20.0	4	18	90	20	10	7	0.231
		.551				.787	.157	.709	3.543	.787	145		
	5	14.0	1	1	CXS-A20-05	20.0	5	18	90	20	10	7	0.213
		.551				.787	.197	.709	3.543	.787	145		
	6	14.0	1	1	CXS-A20-06	20.0	6	18	90	22	10	7	0.229
		.551				.787	.236	.709	3.543	.866	145		
	7	14.0	1	1	CXS-A20-07	20.0	7	18	90	22	10	7	0.227
		.551				.787	.276	.709	3.543	.866	145		
	8	14.0	1	1	CXS-A20-08	20.0	8	18	90	25	10	7	0.010
		.551				.787	.315	.709	3.543	.984	145		
	10	14.0	1	1	CXS-A20-10	20.0	10	18	90	25	10	7	0.230
		.551				.787	.394	.709	3.543	.984	145		
25	8	14.0	1	1	CXS-A25-08	25.0	8	23	110	25	10	7	0.413
		.551				.984	.315	.906	4.331	.984	145		
	10	14.0	1	1	CXS-A25-10	25.0	10	23	110	25	10	7	0.410
		.551				.984	.394	.906	4.331	.984	145		

For spare parts, visit www.sandvik.coromant.com



J19



J16

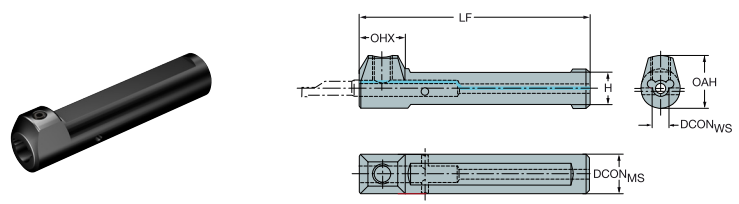


A95

Cylindrical shank with flat to CoroTurn® XS adaptor

Cylindrical with two flats

B



C

Steel shank

						Dimensions, mm, inch							
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	OAH	BAR PSI	NM	KG
1/2	4	14.0	1	1	CXS-A0500-04	12.7	4	10	70	15	10	7	0.320
		.551				.500	.157	.394	2.756	.610	145		
	5	14.0	1	1	CXS-A0500-05	12.7	5	10	70	16	10	7	0.080
		.551				.500	.197	.394	2.756	.630	145		
	6	14.0	1	1	CXS-A0500-06	12.7	6	10	70	16	10	7	0.087
		.551				.500	.236	.394	2.756	.650	145		
	5/8	14.0	1	1	CXS-A0625-04	15.9	4	14	75	17	10	7	0.120
		.551				.625	.157	.551	2.953	.689	145		
	5	14.0	1	1	CXS-A0625-05	15.9	5	14	75	18	10	7	0.080
		.551				.625	.197	.551	2.953	.709	145		
	6	14.0	1	1	CXS-A0625-06	15.9	6	14	75	18	10	7	0.128
		.551				.625	.236	.551	2.953	.728	145		
	7	14.0	1	1	CXS-A0625-07	15.9	7	14	75	19	10	7	0.130
		.551				.625	.276	.551	2.953	.748	145		
	8	14.0	1	1	CXS-A0625-08	15.9	8	14	75	19	10	7	0.130
		.551				.625	.315	.551	2.953	.765	145		

For spare parts, visit www.sandvik.coromant.com

F

G

H

I

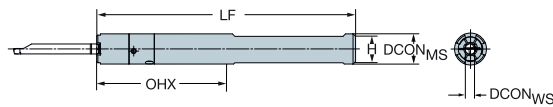
J



Cylindrical shank with flat to CoroTurn® XS adaptor

Metric design

Internal coolant supply



Steel shank

						Dimensions, mm, inch									
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	BD ₁	LB ₁	LB ₂	LF	BAR PSI	NM	KG
12 (x 10)	4	22.0	1	3	CXS-A12-04-X	12.0	4	11	14	70		70	80	20	0.078
		.866				.472	.157	.433	.571	2.756		2.756	1160		
	5	23.0	1	3	CXS-A12-05-X	12.0	5	11	14	70		70	80	20	0.073
		.906				.472	.197	.433	.571	2.756		2.756	1160		
16 (x 14)	4	22.0	1	3	CXS-A16-04-X	16.0	4	15	14	13	75	75	80	20	0.122
		.866				.630	.157	.591	.571	.512	2.952	2.953	1160		
	5	23.0	1	3	CXS-A16-05-X	16.0	5	15	14	14	75	75	80	20	0.116
		.906				.630	.197	.591	.571	.551	2.952	2.953	1160		
	6	26.5	1	3	CXS-A16-06-X	16.0	6	15	16	75		75	80	20	0.119
		1.043				.630	.236	.591	.650	2.953		2.953	1160		
	7	26.5	1	3	CXS-A16-07-X	16.0	7	15	16	75		75	80	20	0.117
		1.043				.630	.276	.591	.650	2.953		2.953	1160		
20 (x 18)	4	22.0	1	3	CXS-A20-04-X	20.0	4	19	14	13	90	90	80	20	0.207
		.866				.787	.157	.748	.571	.512	3.543	3.543	1160		
	5	26.0	1	3	CXS-A20-05-X	20.0	5	19	14	14	90	90	80	20	0.200
		1.024				.787	.197	.748	.571	.551	3.543	3.543	1160		
	6	26.5	1	3	CXS-A20-06-X	20.0	6	19	16	17	90	90	80	20	0.201
		1.043				.787	.236	.748	.650	.689	3.543	3.543	1160		
	7	26.5	1	3	CXS-A20-07-X	20.0	7	19	16	17	90	90	80	20	0.200
		1.043				.787	.276	.748	.650	.689	3.543	3.543	1160		
25	4	24.0	1	3	CXS-A25-04-X	25.0	4	24	14	13	22	110	80	20	0.374
		.945				.984	.157	.945	.571	.512	.866	4.331	1160		
	5	25.0	1	3	CXS-A25-05-X	25.0	5	24	14	14	23	110	80	20	0.368
		.984				.984	.197	.945	.571	.551	.925	4.331	1160		
	6	26.5	1	3	CXS-A25-06-X	25.0	6	24	16	17	25	110	80	20	0.350
		1.043				.984	.236	.945	.650	.689	1.003	4.331	1160		
	7	26.0	1	3	CXS-A25-07-X	25.0	7	24	16	17	25	110	80	20	0.365
		1.024				.984	.276	.945	.650	.689	.984	4.331	1160		

Cemented carbide shank

						Dimensions, mm, inch									
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	LF	BAR PSI	NM	KG			
1/2 (x .394)	4	53.0	1	3	CXS-E0500-04-X	12.7	4	11	103	80	8	0.165			
		2.087				.500	.157	.461	4.055	1160					
	5	58.0	1	3	CXS-E0500-05-X	12.7	5	11	108	80	8	0.168			
		2.283				.500	.197	.461	4.252	1160					
12 (x 10)	4	53.0	1	3	CXS-E12-04-X	12.0	4	11	103	80	8	0.152			
		2.087				.472	.157	.433	4.055	1160					
	5	58.0	1	3	CXS-E12-05-X	12.0	5	24	108	80	8	0.274			
		2.283				.472	.197	.945	4.252	1160					



J19



J16



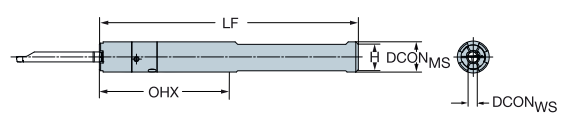
A95

Cylindrical shank with flat to CoroTurn® XS adaptor

Inch design

Internal coolant supply

B



C

Steel shank

D

						Dimensions, mm, inch									
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	BD ₁	LB ₁	LB ₂	LF	BAR PSI	NM	KG
1/2 (x .394)	4	22.0	1	3	CXS-A0500-04-X	12.7	4	11	14	70		70	80	20	0.083
		.866				.500	.157	.461	.571	2.756		2.756	1160		
	5	23.0	1	3	CXS-A0500-05-X	12.7	5	11	14	70		70	80	20	0.080
5/8 (x .551)	4	22.0	1	3	CXS-A0625-04-X	15.9	4	14	14	13	75	75	80	20	0.119
		.866				.625	.157	.586	.571	.512	2.952	2.953	1160		
	5	23.0	1	3	CXS-A0625-05-X	15.9	5	14	14	14	75	75	80	20	0.115
3/4	6	26.5	1	3	CXS-A0625-06-X	15.9	6	14	16	75		75	80	20	0.119
		1.043				.625	.236	.586	.650	2.953		2.953	1160		
	7	26.5	1	3	CXS-A0625-07-X	15.9	7	14	16	75		75	80	20	0.115
1	4	22.0	1	3	CXS-A0750-04-X	19.1	4	1	14	13	90	90	80	20	0.000
		.866				.750	.157	.041	.571	.512	3.543	3.543	1160		
	5	26.0	1	3	CXS-A0750-05-X	19.1	5	18	14	14	90	90	80	20	0.226
1	6	26.5	1	3	CXS-A0750-06-X	19.1	6	18	16	17	90	90	80	20	0.226
		1.043				.750	.236	.711	.650	.689	3.543	3.543	1160		
	7	26.5	1	3	CXS-A0750-07-X	19.1	7	18	16	17	90	90	80	20	0.225
1	4	24.0	1	3	CXS-A1000-04-X	25.4	4	24	14	13	22	110	80	20	0.380
		.945				1.000	.157	.961	.571	.512	.866	4.331	1160		
	5	25.0	1	3	CXS-A1000-05-X	25.4	5	24	14	14	23	110	80	20	0.379
1	6	26.5	1	3	CXS-A1000-06-X	25.4	6	24	16	17	25	110	80	20	0.227
		1.043				1.000	.236	.961	.650	.689	1.003	4.331	1160		
	7	26.0	1	3	CXS-A1000-07-X	25.4	7	24	16	17	25	110	80	20	0.375
	1.024				1.000	.276	.961	.650	.689	.984	4.331	1160			

G

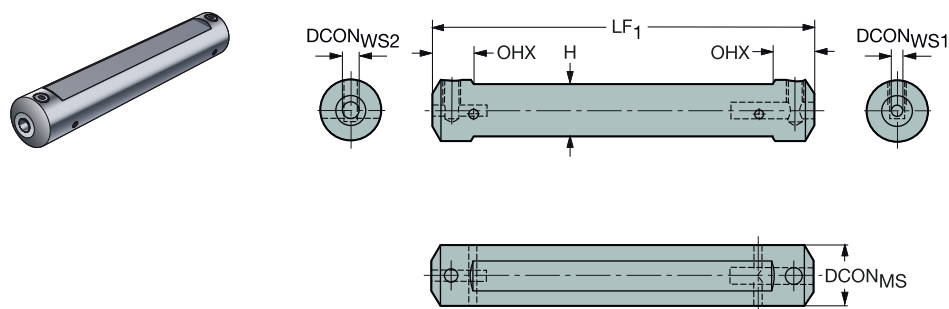
H

I

J



Cylindrical shank with flat to CoroTurn® XS double-ended adaptor



For Citizen machines

						Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	LF ₁	BAR PSI	NM	KG
3/4	6	15.0	1	1	CXS-A075-04-06	19.1	6	18	140	10	7	0.280
		.591				.750	.236	.709	5.512	145		

For Star machines

						Dimensions, mm, inch					
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LF ₁	BAR PSI	NM	KG
22	4	15.0	1	1	CXS-A22-04-04	22.0	4	140	10	7	0.379
		.591				.866	.157	5.512	145		
	6	15.0	1	1	CXS-A22-04-06	22.0	6	140	10	7	0.379
		.591				.866	.236	5.512	145		
		15.0	1	1	CXS-A22-06-06	22.0	6	140	10	7	0.370
		.591				.866	.236	5.512	145		

For Traub machines

						Dimensions, mm, inch					
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LF ₁	BAR PSI	NM	KG
28	6	15.0	1	1	CXS-A28-04-06	28.0	6	140	10	7	0.655
		.591				1.102	.236	5.512	145		

For Tsugami machines

						Dimensions, mm, inch					
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LF ₁	BAR PSI	NM	KG
25	6	15.0	1	1	CXS-A25-04-06	25.0	6	140	10	7	0.520
		.591				.984	.236	5.512	145		

For Other machines

						Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	LF ₁	BAR PSI	NM	KG
20	6	15.0	1	1	CXS-A20-04-06	20.0	6	18	140	10	7	0.336
		.591				.787	.236	.709	5.512	145		

CZC_{WS} to correspond with CZC_{MS} on tool

J19



J16



A95

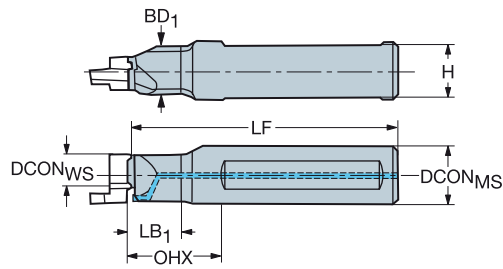
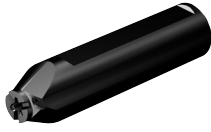
A

Cylindrical shank with flat to CoroCut® MB adaptor

Cylindrical with flat

Precision coolant supply

B



C

Metric version

						Dimensions, mm							
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	BD ₁	LB ₁	LF	BAR	KG
16	09	15.7	1	1	MB-A16-05-09R/L-HP	16.0	9.0	14.0	16.0	5.3	64.7	80	0.1
		20.0	1	1	MB-A16-20-09R/L-HP	16.0	9.0	14.0	9.0	20.0	74.7	80	0.1
		5.6	1	1	MB-A20-05-11R/L-HP	20.0	11.0	18.0	11.0	5.6	79.4	80	0.2

Inch version

						Dimensions, inch						
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	LB ₁	LF	PSI	LBS
3/4	11	.232	1	1	MB-A075-02-11R/L-HP	.750	.433	.709	.232	3.126	1160	0.6
5/8	09	.209	1	1	MB-A0625-02-09R/L-HP	.625	.354	.551	.209	2.547	1160	0.3
		.787	1	1	MB-A0625-08-09R/L-HP	.625	.354	.551	.787	2.941	1160	0.3

CZC_{WS} to correspond with CZC_{MS} on tool

R = Right hand, L = Left hand

General minimum hole depends on insert; see respective insert ordering page.

G

H

I

J



J19



J16



A95

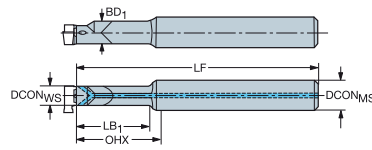
Cylindrical shank with flat to CoroCut® MB adaptor

Carbide shank boring bars

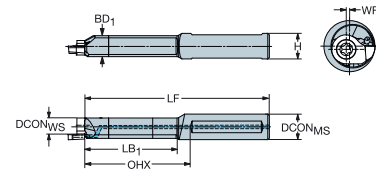
Internal coolant supply



MB..Axx



MB..Exx



Metric version

						Dimensions, mm									
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	BD ₁	LB ₁	LF	WF	(BAR)	(KG)	
12	07	27.0	1	3	MB-E12-24-07	12.0	7.0	10.0	7.4	20.1	87.9	0.0	10	0.0	
		35.0	1	3	MB-E12-32-07	12.0	7.0	10.0	7.4	28.1	96.1	0.0	10	0.1	
	09	50.0	1	3	MB-E12-48-07	12.0	7.0	10.0	7.4	44.1	111.1	0.0	10	0.2	
		34.0	1	3	MB-E12-34-09	12.0	9.0	10.0	9.5	28.7	94.7	0.0	10	0.1	
		45.0	1	3	MB-E12-45-09	12.0	9.0	10.0	9.5	39.7	104.7	0.0	10	0.1	
16	07	64.0	1	3	MB-E12-64-09	12.0	9.0	10.0	9.5	59.7	124.7	0.0	10	0.1	
		16.0	1	3	MB-A16-16-07	16.0	7.0	14.0	7.4	12.1	88.1	0.0	10	0.1	
	09	27.8	1	3	MB-A16-24-07	16.0	7.0	15.0	9.0	20.1	93.1	0.0	80	0.1	
		20.0	1	3	MB-A16-20-09	16.0	9.0	14.0	9.5	14.7	94.8	0.0	10	0.1	
		30.7	1	3	MB-A16-30-09	16.0	9.0	15.0	11.0	24.8	94.8	0.0	80	0.1	
		34.0	1	3	MB-E16-34-09	16.0	9.0	14.0	9.5	28.7	94.7	0.0	10	0.2	
		45.0	1	3	MB-E16-45-09	16.0	9.0	14.0	9.5	39.7	104.7	0.0	10	0.2	
		64.0	1	3	MB-E16-64-09	16.0	9.0	14.0	9.5	58.7	124.7	0.0	10	0.2	
		42.0	1	3	MB-E16R/L-42-09	16.0	9.0	15.0	13.0	36.7	94.8	1.0	80	0.2	
		60.0	1	3	MB-E16R/L-60-09	16.0	9.0	15.0	13.0	56.7	114.8	1.0	80	0.1	

Inch version

						Dimensions, inch										
CZC _{MS}	CZC _{WS}	OHX	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	H	BD ₁	LB ₁	LF	WF	(PSI)	(FT/LBS)	(LBS)	
1/2	07	.902	1	3	MB-E0500-09-07	.500	.276	.461	.354	.713	3.390	.000	1160	0.3		
		1.378	1	3	MB-E0500-12-07	.500	.276	.461	.291	1.102	3.787	.291	145	1	0.3	
	09	1.811	1	3	MB-E0500-19-07	.500	.276	.461	.291	1.732	4.378	.291	145	1	0.3	
		1.209	1	3	MB-E0500-13-09	.500	.354	.461	.394	1.130	3.728	.394	145	2	0.4	
		1.642	1	3	MB-E0500-17-09	.500	.354	.461	.394	1.563	4.122	.394	145	2	0.4	
5/8	07	2.390	1	3	MB-E0500-25-09	.500	.354	.461	.394	2.311	4.909	.394	145	2	0.4	
		.630	1	3	MB-A0625-06-07	.625	.276	.587	.291	.472	3.669	.291	145	1	0.3	
	09	1.091	1	3	MB-A0625-09-07	.625	.276	.586	.354	.791	3.984	.000	1160	0.3		
		.709	1	3	MB-A0625-08-09	.625	.354	.587	.394	.579	3.728	.394	145	2	0.5	
		1.205	1	3	MB-A0625-11-09	.625	.354	.586	.433	.976	3.732	.000	1160	0.3		
		2.390	1	3	MB-E0625-25-09	.625	.354	.587	.394	2.311	4.909	.394	145	2	0.6	
		1.583	1	3	MB-E0625R/L-16-09	.625	.354	.586	.512	1.445	3.728	.039	1160	0.4		
		1.185	1	3	MB-E0625R/L-23-09	.625	.354	.586	.512	2.232	4.516	.039	1160	0.4		

To correspond with insert size on holder.

R = Right hand, L = Left hand



J19



J16



A95

Milling

B

Face milling tools E4

CoroMill® 415 E8-E11

Shoulder milling tools E4

CoroMill® 490 E12-E15

CoroMill® 390 E16-E26

C

Profile milling tools E3

CoroMill® 300 E27-E32

Thread milling tools E6

CoroMill® 325 E33-E38

D

Chamfer milling tools E7

CoroMill® 495 E39-E43

For complete assortment, see www.sandvik.coromant.com

E

F

Thread milling

Face and shoulder milling

Tapping

Chamfering

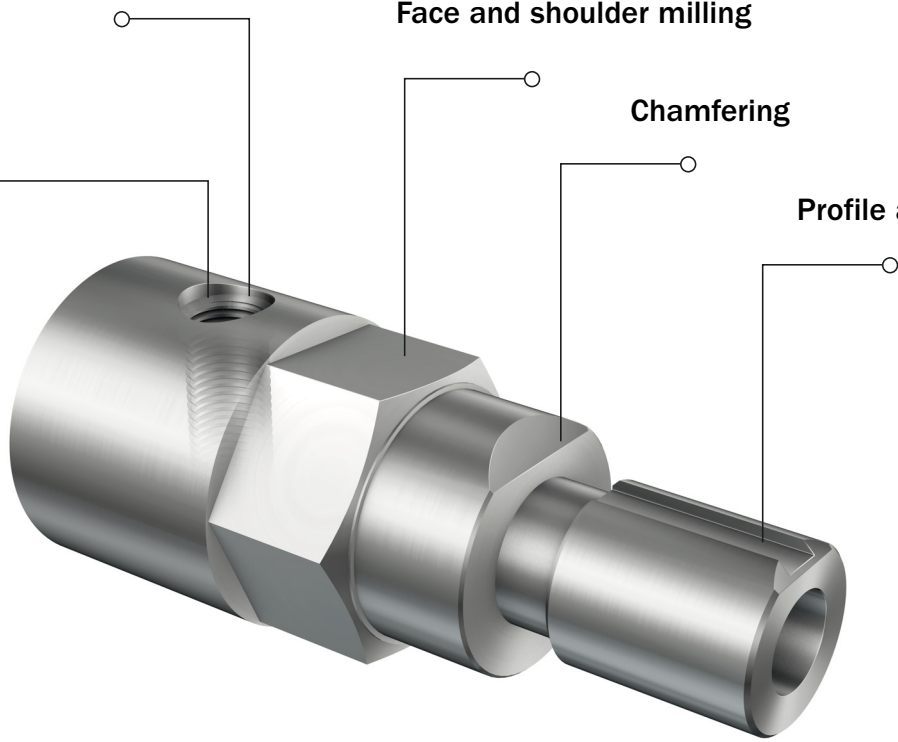
Profile and slot milling

G

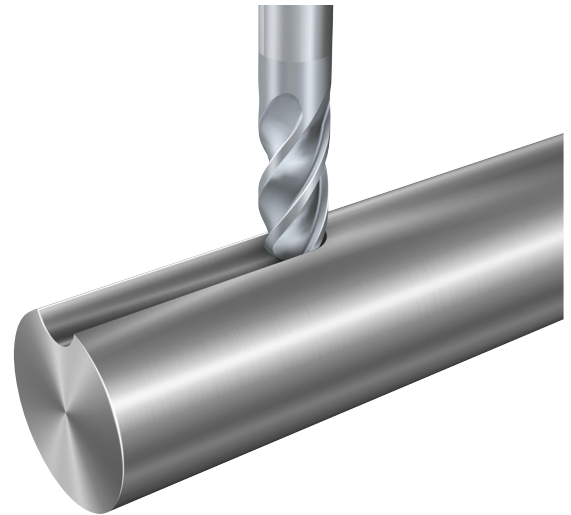
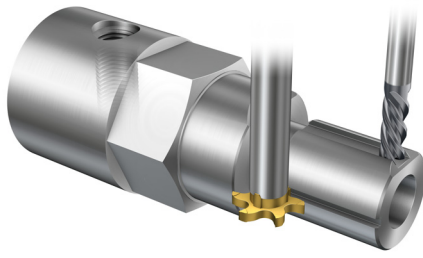
H









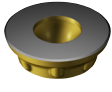
I

J

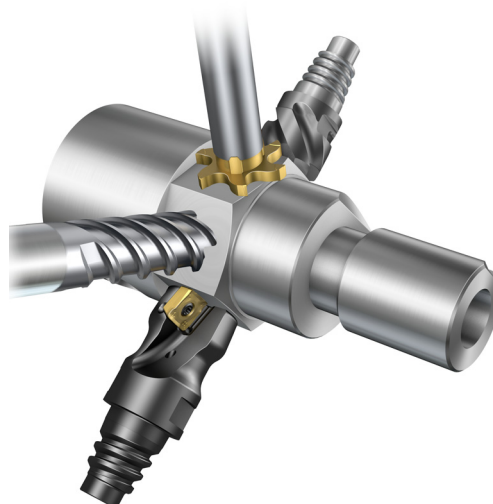







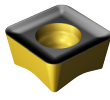
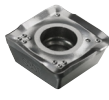
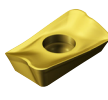
Profile and slot milling








	CoroMill® 300	CoroMill® Plura	CoroMill® 316	CoroMill® 327
				
Page	Profile milling E27	See solid round tools catalogue	See solid round tools catalogue	See Rotating tools catalogue
Material	P M N S H	P M N S H	P M N S H	P M N S H
Main operations				
KAPR	0°	0 - 90°	0 - 90°	90°
DC mm	5 - 17	0.2 - 20	9.5 - 25	9.7 - 34
DC inch	.178 - .435	.008 - .787	.375 - 1	.382 - 1.366
DCX mm	10 - 25	0.2 - 20	9.5 - 25	
DCX inch	.500 - 1.000	.008 - .787	.375 - 1	
APMX mm	2.5 - 6.0	0.15 - 38	5.3 - 14	4.5 - 10
APMX inch	.098 - .197	.005 - 1.5	.209 - .551	.177 - .394
Insert				
Insert sizes	05, 08, 09, 10, 12, 07, 20, 07, 24			
Couplings	Cylindrical shank Coromant EH	Cylindrical shank	Coromant EH	Cylindrical shank ER
Internal coolant	✓	✓	✓	✓

Face and shoulder milling

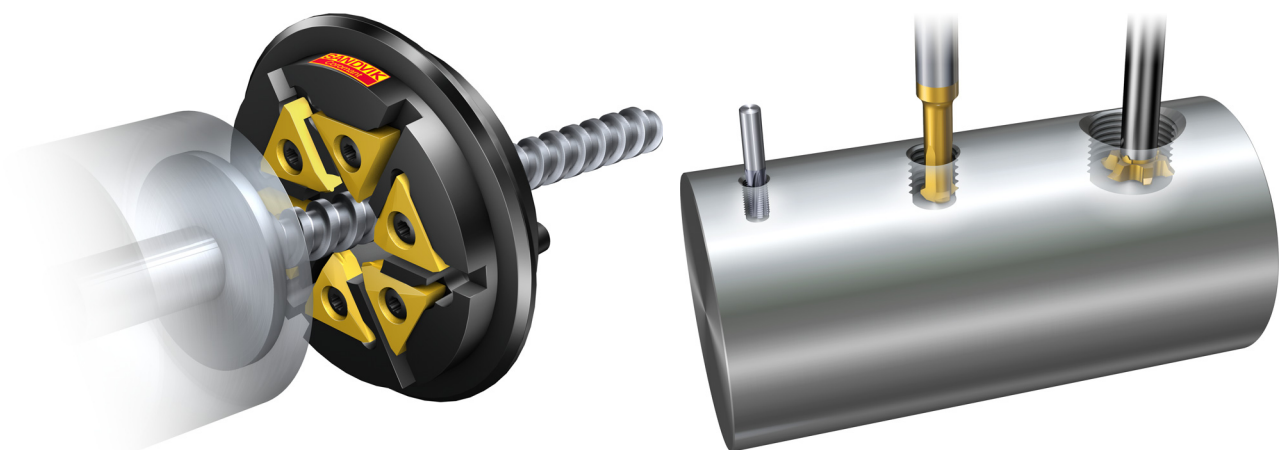



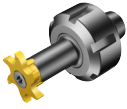


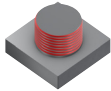
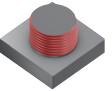


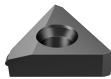
	CoroMill® 415	CoroMill® 490	CoroMill® 390	CoroMill® 300
				
Page	Face milling E8	Shoulder milling E12	Shoulder milling E16	Profile milling E27
Material	P M N S	P M N S H	P M N S H	P M N S H
Main operations				
KAPR	15°	90°	90°	0°
DC mm	4.6 - 16.6	20 - 25	9.7 - 25	5 - 17
DC inch	.169 - .669	.750 - 1.000	.375 - 1.000	.178 - .435
DCX mm	13 - 25			10 - 25
DCX inch	.500 - 1.000			.375 - .750
APMX mm	0.85 - 1.2	5.5	5.8 - 15.70	2.5 - 6.0
APMX inch	.033 - .047	.217	.228 - .618	.098 - .197
Insert				
Insert sizes	05, 07	8	07, 11, 17	05, 08, 09, 10, 12, 07, 20, 07, 24
Couplings	Cylindrical shank Coromant EH	Cylindrical shank Weldon Coromant EH	Coromant EH	Cylindrical shank Coromant EH
Internal coolant	✓	✓	✓	✓

Face and shoulder milling

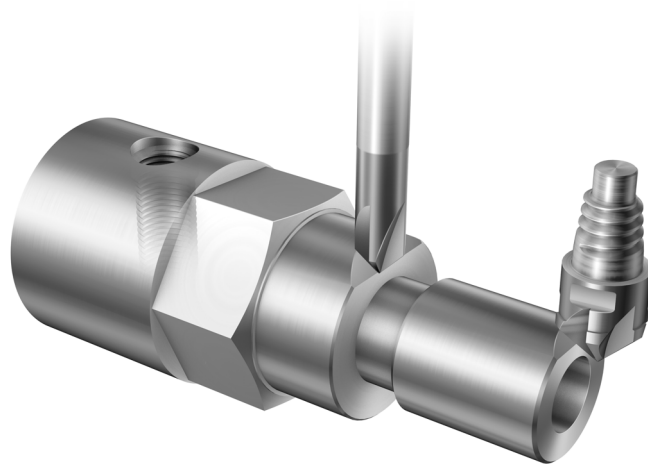
	CoroMill® Plura	CoroMill® 316
		
Page	See solid round tools catalogue	See solid round tools catalogue
Material	P M N S H	P M N S H
Main operations		
KAPR	15°	90°
DC mm	4.6 - 16.6	20 - 25
DC inch	.169 - .669	.750 - 1.000
DCX mm	13 - 25	
DCX inch	.500 - 1.000	
APMX mm	0.85 - 1.2	5.5
APMX inch	.033 - .047	.217
Insert		
Insert sizes		
Couplings	Cylindrical shank	Coromant EH
Internal coolant		











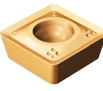


Thread milling



	CoroMill® 325	CoroMill® 327	CoroMill® Plura	CoroMill® 326
				
Page	Thread milling E33	See Rotating tools catalogue	See solid round tools catalogue	See solid round tools catalogue
Material	P M N S	P M N S	P M N S	P M N S
Main operations				
DC mm	6 - 20	9.7 - 34	1.2 - 25	5.8 - 7.8
DC inch		.382 - 1.366	.047 - .984	.228 - .307
DMIN mm		11.8	3.3	8.3
DMIN, inch		.465	.130	.326
TP	1.5 - 2.75	1.5 - 4.5	1.5 - 4.5	0.5 - 1
TPI		8 - 24	8 - 24	12 - 50
Profiles	HA & HB, other as special.	M, UN, WH, V-profile 60°	M, MJ, UN, NPT, NPTF	V-Profile 60°
Insert				
Insert sizes	16			
Couplings	Citizen, DMG, Eppinger, Jarvis, Madula, PCM, Tornos, Tsugami, WTO	Cylindrical shank ER	Cylindrical shank Weldon	Weldon
Internal coolant	✓	✓		

Chamfer milling



	CoroMill® 495	CoroMill® 327	CoroMill® Plura	CoroMill® 326	CoroMill® 316
					
Page	Chamfer milling E39	See Rotating tools catalogue	See solid round tools catalogue	See solid round tools catalogue	See solid round tools catalogue
Material	P M N S	P M N S	P M N S	P M N S	P M N S
Main operations					
DC mm	12 - 25	10.1 - 18.3	1 - 3	4.6 - 5.5	1.5 - 7
DC inch	.520 - 1.020	.398 - .720	.039 - .118	.181 - .217	.059 - .276
APMX mm	3.8 - 7.7	0.8 - 1.7	4.5 - 7.35	0.6 - 1.2	1.33 - 7.7
APMX inch	.150 - 268	.031 - .067	.177 - .289	.024 - .047	.052 - .303
Insert					
Insert sizes	09				
Couplings	Cylindrical shank Coromant EH Weldon	Cylindrical shank ER	Cylindrical shank	Weldon	Coromant EH
Internal coolant					
Options	Angles available: 15°, 30°, 45°, 60°	Angles available: 30°, 45°	Angles available: 45°, 60°	Angles available: 30°, 45°	Angles available: 15°, 30°, 45°, 60°

CoroMill® 415

Small diameter, high feed face milling cutter

CoroMill® 415 offers reduced cost per component and increased productivity thanks to the high metal removal rate and the four-edged inserts. iLock™ insert seat interface gives security, resulting in less scrapped components and also makes the small inserts easier to handle.

ISO application area:



Application

- High feed face milling
- Plunge milling
- Ramping
- Roughing to semi-finishing
- Helical interpolation
- Profiling

Benefits and features

- Versatile tool suitable for a wide range of applications
- Coolant channels for optimized chip evacuation
- Can be combined with the Coromant EH coupling
- Unique iLock™ insert seat interface resulting in less scrap workpieces. The iLock™ insert seat also makes the small inserts easier to handle.
- Tailor made options available



www.sandvik.coromant.com/coromill415

Couplings

- Cylindrical shank
- Coromant EH

Inserts

- Four cutting edges
- The unique iLock™ solution provides easy and accurate insert indexing, increased reliability and considerably improved tool life



E9

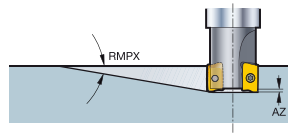


E11

E 8

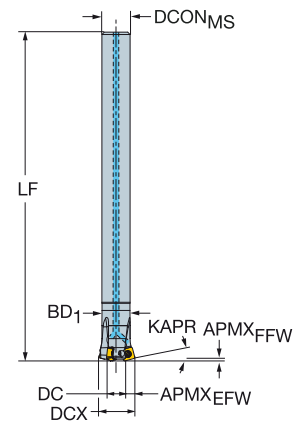
CoroMill® 415 face milling cutter

Cylindrical shank



KAPR

15°



Metric version

										Dimensions, mm									
DC	CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	CNSC	Ordering code	DCON _{MS}	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID			
4.6	05	12	3.0	0.85	0°	1 2	415-013A12-05H	12.0	13.0	11.0	15.0	140.0	0.6	0.16	23600	2	415N-050206M		
7.6	05	12	3.0	0.85	0°	1 3	415-016A12-05H	12.0	16.0	12.0	15.0	140.0	0.6	0.16	21300	3	415N-050206M		
11.6	05	16	3.0	0.85	0°	1 3	415-020A16-05L	16.0	20.0	16.0	15.0	200.0	0.6	0.37	19000	3	415N-050206M		
	05	16	3.0	0.85	0°	1 4	415-020A16-05M	16.0	20.0	16.0	15.0	200.0	0.6	0.33	19000	4	415N-050206M		
	05	16	3.0	0.85	0°	1 5	415-020A16-05H	16.0	20.0	16.0	15.0	200.0	0.6	0.27	19000	5	415N-050206M		
13.5	07	20	4.5	1.20	0°	1 4	415-025A20-07H	20.0	25.0	19.0	15.0	200.0	1.2	0.50	15700	4	415N-070310M		
16.6	05	20	3.0	0.85	0°	1 5	415-025A20-05M	20.0	25.0	21.0	15.0	200.0	0.6	0.50	17000	5	415N-050206M		

Inch version

										Dimensions, inch									
DC	CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	CNSC	Ordering code	DCON _{MS}	DCX	BD	LB	LF	FT/LBS	LBS	RPMX	CICT	MIID			
.169	05	1/2	.118	.033	0°	1 2	A415-013O13-05H	.500	.500	.433	.591	6.000	.4	0.48	23600	2	415N-050206M		
.295	05	1/2	.118	.033	0°	1 3	A415-016O13-05H	.500	.625	.468	.591	6.000	.4	0.49	21300	3	415N-050206M		
.417	05	5/8	.118	.033	0°	1 4	A415-019O16-05H	.625	.750	.593	.591	8.000	.4	0.79	19000	4	415N-050206M		
.551	07	3/4	.177	.047	0°	1 4	A415-025O19-07H	.750	1.000	.764	.591	9.000	.8	1.50	15700	4	415N-070310M		
.669	05	3/4	.118	.033	0°	1 5	A415-025O19-05M	.750	1.000	.843	.591	9.000	.4	1.46	17000	5	415N-050206M		

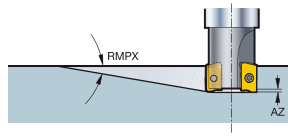
Spare parts	
	Insert screw
05	5513 020-28
07	5513 020-56

For complete list of spare parts, see www.sandvik.coromant.com



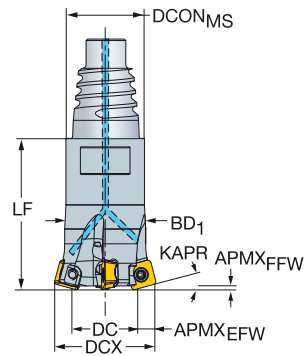
CoroMill® 415 face milling cutter

Coromant EH



KAPR

15°



Metric version

										Dimensions, mm									
DC	CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	CNSC	Ordering code	DCON _{MS}	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID			
4.6	05	E12	3.0	0.85	0°	1 2	415-13EH12-05H	11.7	13.0	11.0	10.0	25.0	0.6	0.14	23600	2	415N-050206M		
7.6	05	E16	3.0	0.85	0°	1 3	415-16EH16-05H	15.5	16.0	12.0	12.0	30.0	0.6	0.18	21300	3	415N-050206M		
8.6	07	E16	4.5	1.20	0°	1 2	415-20EH16-07H	15.5	20.0	14.0	12.0	35.0	1.2	0.17	17500	2	415N-070310M		
	07	E20	4.5	1.20	0°	1 2	415-20EH20-07H	19.3	20.0	14.0	15.0	35.0	1.2	0.13	17500	2	415N-070310M		
11.6	05	E16	3.0	0.85	0°	1 4	415-20EH16-05M	15.5	20.0	16.0	12.0	30.0	0.6	0.05	19000	4	415N-050206M		
	05	E20	3.0	0.85	0°	1 4	415-20EH20-05M	19.3	20.0	16.0	13.0	32.0	0.6	0.07	19000	4	415N-050206M		
	05	E16	3.0	0.85	0°	1 5	415-20EH16-05H	15.5	20.0	16.0	12.0	30.0	0.6	0.16	19000	5	415N-050206M		
	05	E20	3.0	0.85	0°	1 5	415-20EH20-05H	19.3	20.0	16.0	13.0	32.0	0.6	0.19	19000	5	415N-050206M		
13.5	07	E20	4.5	1.20	0°	1 3	415-25EH20-07M	19.3	25.0	19.0	15.0	35.0	1.2	0.08	15700	3	415N-070310M		
	07	E25	4.5	1.20	0°	1 3	415-25EH25-07M	24.2	25.0	19.0	18.0	40.0	1.2	0.12	15700	3	415N-070310M		
	07	E20	4.5	1.20	0°	1 4	415-25EH20-07H	19.3	25.0	19.0	15.0	35.0	1.2	0.20	15700	4	415N-070310M		
16.6	07	E25	4.5	1.20	0°	1 4	415-25EH25-07H	24.2	25.0	19.0	18.0	40.0	1.2	0.18	15700	4	415N-070310M		
	05	E20	3.0	0.85	0°	1 5	415-25EH20-05M	19.3	25.0	21.0	13.0	32.0	0.6	0.08	17000	5	415N-050206M		
	05	E25	3.0	0.85	0°	1 5	415-25EH25-05M	24.2	25.0	21.0	15.0	35.0	0.6	0.12	17000	5	415N-050206M		
	05	E20	3.0	0.85	0°	1 6	415-25EH20-05H	19.3	25.0	21.0	13.0	32.0	0.6	0.20	17000	6	415N-050206M		
05	E25	3.0	0.85	0°	1 6	415-25EH25-05H	24.2	25.0	21.0	15.0	35.0	0.6	0.24	17000	6	415N-050206M			

Inch version

										Dimensions, inch									
DC	CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	CNSC	Ordering code	DCON _{MS}	DCX	BD	LB	LF	FT/LBS	LBS	RPMX	CICT	MIID			
.169	05	E12	.118	.033	0°	1 2	A415-13EH12-05H	.484	.500	.433	.394	.984	.4	0.30	23600	2	415N-050206M		
.295	05	E16	.118	.033	0°	1 3	A415-16EH16-05H	.610	.625	.468	.472	1.181	.4	0.34	21300	3	415N-050206M		
.299	07	E20	.177	.047	0°	1 2	A415-19EH20-07H	.728	.750	.514	.591	1.378	.8	0.13	17500	2	415N-070310M		
.417	05	E20	.118	.033	0°	1 3	A415-19EH20-05M	.728	.750	.593	.512	1.260	.4	0.13	19000	3	415N-050206M		
	05	E20	.118	.033	0°	1 4	A415-19EH20-05H	.728	.750	.593	.512	1.260	.4	0.40	19000	4	415N-050206M		
.551	07	E25	.177	.047	0°	1 3	A415-25EH25-07M	.965	1.000	.764	.709	1.575	.8	0.57	15700	3	415N-070310M		
	07	E25	.177	.047	0°	1 4	A415-25EH25-07H	.965	1.000	.764	.709	1.575	.8	0.54	15700	4	415N-070310M		
.669	05	E25	.118	.033	0°	1 5	A415-25EH25-05M	.965	1.000	.843	.591	1.378	.4	0.29	17000	5	415N-050206M		
	05	E25	.118	.033	0°	1 6	A415-25EH25-05H	.965	1.000	.843	.591	1.378	.4	0.53	17000	6	415N-050206M		

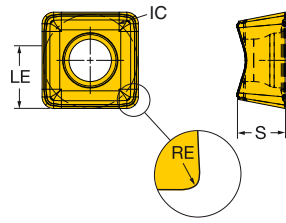
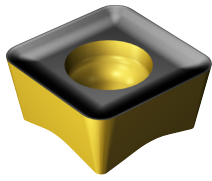
Spare parts	
	Insert screw
05	5513 020-28
07	5513 020-56

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 415 insert for milling

KRINS 15°

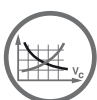


	RE	Ordering code	P		M				S			H		Dimensions, mm, inch				
			1040	1130	4340	1040	1130	4340	S30T	1130	H13A	S30T	S40T	1010	1130	IC	LE	S
Medium	M30	05 0.60 .024	415N-05 02 06M-M30	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	5.0	3.8	2.21
		07 1.00 .039	415N-07 03 10M-M30	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	7.0	5.0	3.07
																.276	.197	.121

For cutting data recommendations see Rotating tools catalogue



E9



E44



E67



J19

CoroMill® 490

Face and shoulder mill for precise profiles

Productive solution with easy handling

CoroMill 490 is an indexable milling cutter for economical shoulder milling with high precision. The Coromant EH coupling gives rigidity, enabling high cutting data and high metal removal rates. In small part machining it is recommended to use the cutter body with an integrated ER collet or cylindrical holder.

ISO application area:



Application

- Square shoulder milling
- Repeated shoulder milling
- Circular interpolation
- Face milling
- Slot milling



Benefits and features

- Great flexibility, high precision and good tolerances
- Light and quiet cutting with low cutting forces
- High productivity with outstanding insert geometry and grades
- Sharp edge lines and burr-free, smooth profiles
- Component feature finished in one pass
- True 90-degree cut without sharp steps
- Light cutting performance provides an optimal utilization of low-powered machine tools. This also facilitates use of the cutter on extended tool assemblies
- Undersized shanks for larger diameter cutters, using 8 mm (.315 inch) inserts, enable these cutters to fit into smaller tool holders
- Oversized versions enhance the accessibility and provide natural clearance to tight fixtures

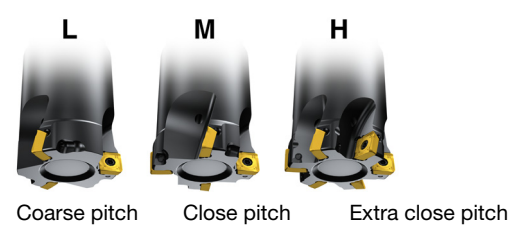
www.sandvik.coromant.com/coromill490

Couplings

- Cylindrical shank
- Weldon
- Coromant EH
- Undersized shanks for cylindrical cutters
- Oversized versions available on Coromant EH

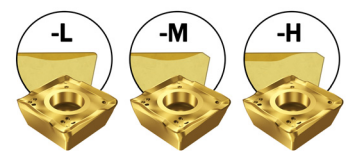
Inserts

- Four cutting edges
- Cemented carbide
- CBN



Precision

The insert edges are slightly crowned to compensate for deflection. Due to this geometry, angular distortion during shoulder milling is minimized, and discernable steps between repeatable passes are avoided.

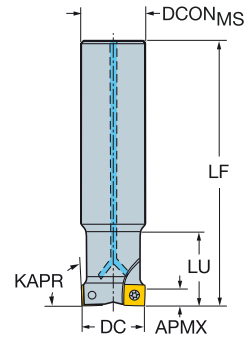


CoroMill® 490 square shoulder milling cutter

Cylindrical shank

KAPR

90°




Metric version

							Dimensions, mm						
DC	CZC _{MS}	APMX _{FFW}	CNSC	Ordering code	DCON _{MS}	LF	LU	NM	KG	RPMX	CICT	MIID	
20.0	08	16	5.50	1 2	490-020A16-08L	16.0	100.0		1.2	0.24	48500	2	490R-08T308
	08	20	5.50	1 2	490-020A20-08L	20.0	110.0	25.0	1.2	0.33	48500	2	490R-08T308
22.0	08	20	5.50	1 2	490-022A20L-08L	20.0	170.0		1.2	0.47	20300	2	490R-08T308
25.0	08	20	5.50	1 2	490-025A20-08L	20.0	110.0		1.2	0.34	40400	2	490R-08T308
	08	25	5.50	1 2	490-025A25-08L	25.0	120.0	32.0	1.2	0.49	40400	2	490R-08T308
	08	20	5.50	1 3	490-025A20-08M	20.0	110.0		1.2	0.32	40400	3	490R-08T308
	08	25	5.50	1 3	490-025A25-08M	25.0	120.0	32.0	1.2	0.46	40400	3	490R-08T308

Inch version

							Dimensions, inch						
DC	CZC _{MS}	APMX _{FFW}	CNSC	Ordering code	DCON _{MS}	LF	LU	FT/LBS	LBS	RPMX	CICT	MIID	
.750	08	3/4	.217	1 2	A490-019O19L-08L	.750	6.500	1.625	.8	0.89	22100	2	490R-08T308
1.000	08	1	.217	1 2	A490-025O25L-08L	1.000	8.000	2.125	.8	1.74	12100	2	490R-08T308
	08	1	.217	1 3	A490-025O25L-08M	1.000	8.000	2.125	.8	1.71	12100	3	490R-08T308

Spare parts	
	Insert screw
08	5513 020-35

For complete list of spare parts, see www.sandvik.coromant.com

E15



J19



J9

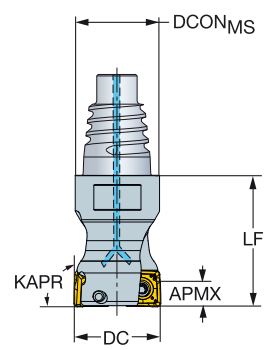


J16

CoroMill® 490 square shoulder milling cutter

Coromant EH

KAPR 90°



Metric version

						Dimensions, mm							
DC		CZC _{MS}	APMX _{FFW}	CNSC		Ordering code	DCON _{MS}	LF			RPMX	CICT	MIID
20.0	08	E20	5.50	1	2	490-020EH20-08L	19.3	30.0	1.2	0.14	48500	2	490R-08T308
25.0	08	E25	5.50	1	2	490-025EH25-08L	24.2	35.0	1.2	0.18	40400	2	490R-08T308
	08	E25	5.50	1	3	490-025EH25-08M	24.2	35.0	1.2	0.19	40400	3	490R-08T308

Inch version

						Dimensions, inch							
DC		CZC _{MS}	APMX _{FFW}	CNSC		Ordering code	DCON _{MS}	LF			RPMX	CICT	MIID
.750	08	E20	.216	1	2	A490-019EH20-08L	.728	1.181	.8	0.12	50600	2	490R-08T308
1.000	08	E25	.216	1	3	A490-025EH25-08M	.965	1.378	.8	0.43	40000	3	490R-08T308

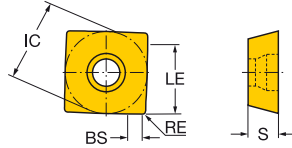
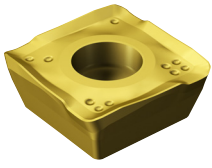
Spare parts	
	Insert screw
08	5513 020-35

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 490 insert for milling

KRINS 90°



	RE	Ordering code	P						M						K			N		S					H			Dimensions, mm, inch																									
			1040	1130	2030	2040	4220	4330	4940	530	1040	1130	2030	2040	4220	4330	4940	530	S30T	S40T	1010	4220	4330	4940	1130	H13A	1130	2030	2040	H13A	S30T	S40T	1010	1130	4220	530	IC	LE	S	BS													
Light	08	0.40	490R-08T304M-PL	★					★	★																													8.5	5.6	3.30	1.5											
		.016																																						.335	.220	.130	.069										
		0.80	490R-08T308M-PL	★					★	★																																	8.5	5.6	3.30	1.2							
		.031																																									.335	.220	.130	.047							
		0.40	490R-08T304E-ML	☆		☆	☆			★	☆	☆												★		★	☆	☆																8.5	5.6	3.30	1.5						
		.016																																										.335	.220	.130	.069						
Medium	0.80	490R-08T308E-ML	☆	★	☆	☆			★	☆	☆												☆	★	☆	☆	☆	★	☆																8.5	5.6	3.30	1.2					
		.031																																												.335	.220	.130	.047				
	0.80	490R-08T308M-PM	★				☆	★	☆															☆																							8.5	5.6	3.30	1.2			
		.031																																													.335	.220	.130	.047			
	1.20	490R-08T312M-PM	★				☆	★	☆															☆																							8.5	5.6	3.30	0.9			
		.047																																													.335	.220	.130	.033			
	1.60	490R-08T316M-PM	★				☆	★	☆															☆																								8.5	5.6	3.30	0.6		
		.063																																													.335	.220	.130	.024			
	0.80	490R-08T308E-MM	☆	★	☆	☆				★	☆	☆												☆	☆	☆	☆	★	☆																			8.5	5.6	3.30	1.2		
	.031																																													.335	.220	.130	.047				
Heavy	08	0.80	490R-08T308M-PH	☆				☆	★														☆																								8.5	5.6	3.30	1.2			
		.031																																															.335	.220	.130	.047	
	1.60	490R-08T316M-PH	☆				☆	★															☆																											8.5	5.6	3.30	0.6
		.063																																															.335	.220	.130	.024	



E13



E44



E67



J19

CoroMill® 390

Versatile shoulder milling cutters with ramping capability for mixed production

CoroMill® 390 covers many applications with shoulder and face milling already from diameter 10 mm (3/8 inch). The cutters generate a good quality 90 ° shoulder and are ideal for ramping and helical interpolation.

ISO application area:



Application

- Shoulder milling
- Repeated shoulder milling
- Turn milling
- Deep shoulder milling
- Edging
- Pocketing
- Linear and helical ramping

Benefits and features

- Close tolerances giving excellent surface finish and minimal mismatch
- Large depth of cut and steep ramping capability
- Oversized diameter for clearance is available
- Integrated damping technology Silent Tools™ for increased metal removal and improved surface finish
- Available in a shorter version for turning centres
- Internal coolant on most cutters



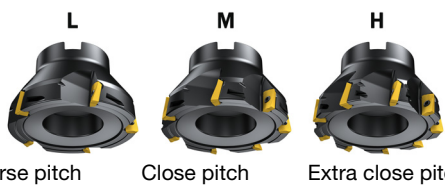
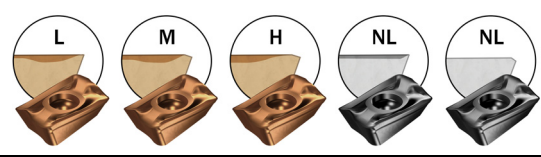
www.sandvik.coromant.com/coromil390

Cutter bodies

- Cylindrical shank
- Weldon
- Coromant EH
- Threaded coupling
- Oversized versions available on Coromant EH
- Undersized shanks on cylindrical cutters

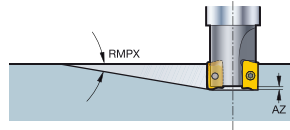
Inserts

- Two cutting edges
- Cemented carbide and PCD grades
- The light-cutting insert geometries and high-performance grades of are designed for low cutting forces and vibration-free machining for secure milling in all materials.



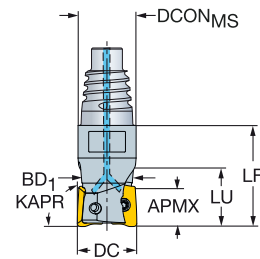
CoroMill® 390 square shoulder milling cutter

Coromant EH - Internal coolant supply



KAPR

90°



Metric version

									Dimensions, mm											
DC		CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	AZ	CNSC		Ordering code	DCON _{MS}	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID	
9.7	07	E10	2.0	5.80	7°	0.5	1	2	R390-0097EH10-07L	9.7	9.2	12.5	20.0	12.5	0.5	0.12	55600	2	390R-07..	
10.0	07	E10	2.0	5.80	7°	0.5	1	2	R390-010EH10-07L	9.7	9.3	12.5	20.0	12.5	0.5	0.07	54100	2	390R-07..	
11.7	07	E12	2.0	5.80	5°	0.5	1	2	R390-0117EH12-07L	11.7	11.0	11.9	20.0	11.9	0.5	0.08	47400	2	390R-07..	
12.0	07	E12	2.0	5.80	5°	0.5	1	2	R390-012EH12-07L	11.7	11.3	11.9	20.0	11.9	0.5	0.12	46500	2	390R-07..	
	07	E12	2.0	5.80	5°	0.5	1	3	R390-012EH12-07M	11.7	11.3	11.9	20.0	11.9	0.5	0.07	46500	3	390R-07..	
13.7	07	E12	2.0	5.80	3°	0.5	1	2	R390-0137EH12-07L	11.7	12.9	20.0	20.0		0.5	0.13	42000	2	390R-07..	
	07	E12	2.0	5.80	3°	0.5	1	3	R390-0137EH12-07M	11.7	12.9	20.0	20.0		0.5	0.12	42000	3	390R-07..	
14.0	07	E12	2.0	5.80	3°	0.5	1	3	R390-014EH12-07M	11.7	13.2	20.0	20.0		0.5	0.07	41400	3	390R-07..	
15.7	07	E16	2.0	5.80	3°	0.5	1	3	R390-0157EH16-07M	15.5	14.7	15.7	25.0	15.7	0.5	0.10	38100	3	390R-07..	
16.0	07	E16	2.0	5.80	3°	0.5	1	3	R390-016EH16-07M	15.5	15.0	15.7	25.0	15.7	0.5	0.09	37600	3	390R-07..	
	07	E16	2.0	5.80	3°	0.5	1	4	R390-016EH16-07H	15.5	15.0	15.7	25.0	15.7	0.5	0.14	37600	4	390R-07..	
	11	E16	5.5	10.00	10°	1.0	1	2	R390-016EH16-11L	15.5			27.0		1.2	0.08	41500	2	R390-11..	
18.0	07	E16	2.0	5.80	2°	0.5	1	3	R390-018EH16-07M	15.5	17.0	25.0	25.0		0.5	0.10	34800	3	390R-07..	
	11	E16	5.5	10.00	5°	1.0	1	2	R390-018EH16-11L	15.5			27.0		1.2	0.11	31000	2	R390-11..	
20.0	07	E20	2.0	5.80	2°	0.5	1	4	R390-020EH20-07M	19.3	19.0	14.4	25.0	14.4	0.5	0.10	32500	4	390R-07..	
	07	E20	2.0	5.80	2°	0.5	1	5	R390-020EH20-07H	19.3	19.0	14.4	25.0	14.4	0.5	0.16	32500	5	390R-07..	
	11	E20	5.5	10.00	5°	1.0	1	2	R390-020EH20-11L	19.3			30.0		1.2	0.13	34600	2	R390-11..	
	11	E20	5.5	10.00	5°	1.0	1	3	R390-020EH20-11M	19.3			30.0		1.2	0.13	34600	3	R390-11..	
22.0	11	E20	5.5	10.00	5°	1.0	1	2	R390-022EH20-11L	19.3			30.0		1.2	0.14	36500	2	R390-11..	
	11	E20	5.5	10.00	5°	1.0	1	3	R390-022EH20-11M	19.3			30.0		1.2	0.14	36500	3	R390-11..	
25.0	07	E25	2.0	5.80	1°	0.5	1	5	R390-025EH25-07M	24.2	24.0	13.9	25.0	13.9	0.5	0.20	28200	5	390R-07..	
	07	E25	2.0	5.80	1°	0.5	1	7	R390-025EH25-07H	24.2	24.0	13.9	25.0	13.9	0.5	0.20	28200	7	390R-07..	
	11	E25	5.5	10.00	5°	1.0	1	2	R390-025EH25-11L	24.2			35.0		1.2	0.19	36400	2	R390-11..	
	11	E25	5.5	10.00	5°	1.0	1	3	R390-025EH25-11M	24.2			35.0		1.2	0.18	36400	3	R390-11..	
	11	E25	5.5	10.00	5°	1.0	1	4	R390-025EH25-11H	24.2			35.0		1.2	0.19	36400	4	R390-11..	
17	E25	8.5	15.70	15°	1.5	1	2	R390-025EH25-17L	24.2			40.0		3.0	0.20	30800	2	R390-17..		

		Spare parts
DC		Insert screw
10.00-25.00	07	5513 020-82
16.00-22.00	11	5513 020-36
25.00-32.00	11	5513 020-35
25.00	17	5513 020-37

For complete list of spare parts, see www.sandvik.coromant.com



E21



J19



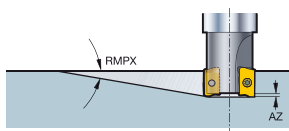
J9



J16

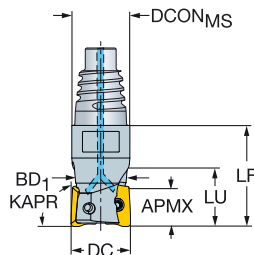
CoroMill® 390 square shoulder milling cutter

Coromant EH - Internal coolant supply



KAPR

90°



Inch version

									Dimensions, inch									
DC	CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	AZ	CNSC	Ordering code	DCON _{MS}	BD	LB	LF	LU	FT/LBS	LBS	RPMX	CICT	MIID	
.375	07	E10	.079	.228	7°	.020	1 2	RA390-010EH10-07L	.364	.355	.492	.787	.492	.3	0.17	56600	2	390R-07..
.500	07	E12	.079	.228	4°	.020	1 2	RA390-013EH12-07L	.484	.472	.469	.787	.469	.3	0.27	44500	2	390R-07..
							3	RA390-013EH12-07M	.484	.472	.469	.787	.469	.3	0.27	44500	3	390R-07..
.625	07	E16	.079	.228	3°	.020	1 3	RA390-016EH16-07M	.610	.586	.618	.984	.618	.3	0.30	37800	3	390R-07..
							4	RA390-016EH16-07H	.610	.586	.618	.984	.618	.3	0.30	37800	4	390R-07..
.750	11	E16	.217	.394	10°	.039	1 2	RA390-016EH16-11L	.610			1.063	.8	0.25	41800	2	R390-11..	
							4	RA390-019EH20-07M	.728	.711	.567	.984	.567	.3	0.27	33500	4	390R-07..
							5	RA390-019EH20-07H	.728	.711	.567	.984	.567	.3	0.27	33500	5	390R-07..
							2	RA390-019EH20-11L	.728			1.181	.8	0.31	35900	2	R390-11..	
1.000	07	E25	.079	.228	1°	.020	1 5	RA390-025EH25-07M	.965	.961	.547	.984	.547	.3	0.45	28000	5	390R-07..
							7	RA390-025EH25-07H	.965	.961	.547	.984	.547	.3	0.45	28000	7	390R-07..
							2	RA390-025EH25-11L	.965			1.378	.8	0.46	36100	2	R390-11..	
1.000	11	E25	.217	.394	4°	.039	1 3	RA390-025EH25-11M	.965			1.378	.8	0.44	36100	3	R390-11..	
							4	RA390-025EH25-11H	.965			1.378	.8	0.26	36100	4	R390-11..	
1.000	17	E25	.335	.618	14°	.059	1 2	RA390-025EH25-17L	.965			1.575	2.2	0.26	30500	2	R390-17..	

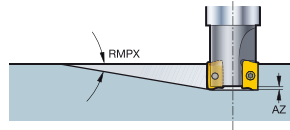
		Spare parts
DC"		Insert screw
.375-1.000	07	5513 020-82
.625-.750	11	5513 020-36
1.000-1.250	11	5513 020-35
1.000	17	5513 020-37

For complete list of spare parts, see www.sandvik.coromant.com



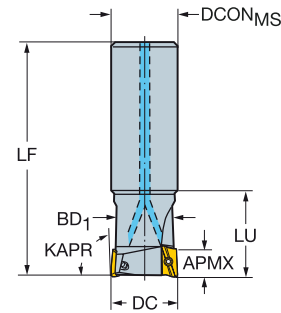
CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply



KAPR

90°



Metric version

DC	CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	AZ	CNSC	Ordering code	Dimensions, mm								CICT	MIID		
								DCON _{MS}	BD	LB	LF	LU	NM	KG	RPM				
9.7	07	10	2.0	5.80	7°	0.5	1	2	R390-0097A10-07L	10.0	9.2	15.0	60.0	15.0	0.5	0.07	55600	2	390R-07..
10.0	07	9	2.0	5.80	7°	0.5	1	2	R390-010A09L-07L	9.0	9.3	100.0	100.0		0.5	0.08	54100	2	390R-07..
	07	10	2.0	5.80	7°	0.5	1	2	R390-010A10-07L	10.0	9.3	15.0	60.0	15.0	0.5	0.07	54100	2	390R-07..
11.7	07	12	2.0	5.80	5°	0.5	1	2	R390-0117A12-07L	12.0	11.0	15.0	70.0	15.0	0.5	0.09	47400	2	390R-07..
	07	12	2.0	5.80	5°	0.5	1	3	R390-0117A12-07M	12.0	11.0	15.0	70.0	15.0	0.5	0.09	47400	3	390R-07..
12.0	07	10	2.0	5.80	5°	0.5	1	2	R390-012A10L-07L	10.0	11.3	120.0	120.0		0.5	0.11	46500	2	390R-07..
	07	12	2.0	5.80	5°	0.5	1	2	R390-012A12-07L	12.0	11.3	18.0	70.0	18.0	0.5	0.09	46500	2	390R-07..
	07	12	2.0	5.80	5°	0.5	1	3	R390-012A12-07M	12.0	11.3	18.0	70.0	18.0	0.5	0.09	46500	3	390R-07..
	11	16	5.5	10.00	6°	1.0	1	1	R390-012A16-11L	16.0			95.0	17.2	1.2	0.24	68600	1	R390-11..
13.7	07	14	2.0	5.80	3°	0.5	1	2	R390-0137A14-07L	14.0	12.9	15.0	80.0	15.0	0.5	0.12	42000	2	390R-07..
	07	14	2.0	5.80	3°	0.5	1	3	R390-0137A14-07M	14.0	12.9	15.0	80.0	15.0	0.5	0.12	42000	3	390R-07..
14.0	07	12	2.0	5.80	3°	0.5	1	3	R390-014A12L-07M	12.0	13.2	140.0	140.0		0.5	0.16	33800	3	390R-07..
	07	14	2.0	5.80	3°	0.5	1	3	R390-014A14-07M	14.0	13.2	20.0	80.0	20.0	0.5	0.12	41400	3	390R-07..
15.7	07	16	2.0	5.80	3°	0.5	1	3	R390-0157A16-07M	16.0	14.7	18.0	90.0	18.0	0.5	0.16	38100	3	390R-07..
16.0	07	14	2.0	5.80	3°	0.5	1	3	R390-016A14L-07M	14.0	15.0	160.0	160.0		0.5	0.23	24100	3	390R-07..
	07	16	2.0	5.80	3°	0.5	1	3	R390-016A16-07M	16.0	15.0	25.0	90.0	25.0	0.5	0.16	37600	3	390R-07..
	07	16	2.0	5.80	3°	0.5	1	4	R390-016A16-07H	16.0	15.0	25.0	90.0	25.0	0.5	0.16	37600	4	390R-07..
	11	16	5.5	10.00	10°	1.0	1	2	R390-016A16-11L	16.0			100.0	25.0	1.2	0.21	41500	2	R390-11..
	11	16	5.5	10.00	10°	1.0	1	2	R390-016A16L-11L	16.0			145.0	25.0	1.2	0.28	31000	2	R390-11..
18.0	11	16	5.5	10.00	7°	1.0	1	2	R390-018A16L-11L	16.0			145.0		1.2	0.31	31000	2	R390-11..
20.0	07	20	2.0	5.80	2°	0.5	1	4	R390-020A20-07M	20.0	19.0	25.0	110.0	25.0	0.5	0.29	32500	4	390R-07..
	07	20	2.0	5.80	2°	0.5	1	5	R390-020A20-07H	20.0	19.0	25.0	110.0	25.0	0.5	0.27	32500	5	390R-07..
	11	20	5.5	10.00	5°	1.0	1	2	R390-020A20-11L	20.0			110.0	25.0	1.2	0.34	34600	2	R390-11..
	11	20	5.5	10.00	5°	1.0	1	2	R390-020A20L-11L	20.0			170.0	40.0	1.2	0.50	20300	2	R390-11..
	11	20	5.5	10.00	5°	1.0	1	3	R390-020A20-11M	20.0			110.0	25.0	1.2	0.34	34600	3	R390-11..
22.0	11	20	5.5	10.00	5°	1.0	1	2	R390-022A20L-11L	20.0			170.0		1.2	0.50	20300	2	R390-11..
25.0	07	25	2.0	5.80	1°	0.5	1	5	R390-025A25-07M	25.0	24.0	32.0	120.0	32.0	0.5	0.46	28200	5	390R-07..
	07	25	2.0	5.80	1°	0.5	1	7	R390-025A25-07H	25.0	24.0	32.0	120.0	32.0	0.5	0.47	28200	7	390R-07..
	11	25	5.5	10.00	5°	1.0	1	2	R390-025A25-11L	25.0			120.0	32.0	1.2	0.54	36500	2	R390-11..
	11	25	5.5	10.00	5°	1.0	1	2	R390-025A25L-11L	25.0			210.0	50.0	1.2	0.83	11000	2	R390-11..
	11	25	5.5	10.00	5°	1.0	1	3	R390-025A25-11M	25.0			120.0	32.0	1.2	0.54	36500	3	R390-11..
	11	25	5.5	10.00	5°	1.0	1	4	R390-025A25-11H	25.0			120.0	32.0	1.2	0.54	36500	4	R390-11..
	17	25	8.5	15.70	15°	1.5	1	2	R390-025A25-17L	25.0			120.0	32.0	3.0	0.50	30800	2	R390-17..
	17	25	8.5	15.70	15°	1.5	1	2	R390-025A25L-17L	25.0			210.0	50.0	3.0	0.84	11000	2	R390-17..

Spare parts		
DC		Insert screw
10.00-25.00	07	5513 020-82
12.00-25.00	11	5513 020-36
25.00	11	5513 020-35
25.00	17	5513 020-37

For complete list of spare parts, see www.sandvik.coromant.com



E21



J19



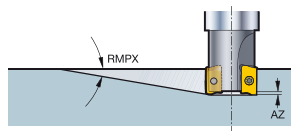
J9



J16

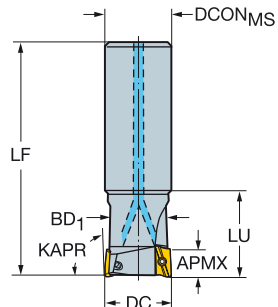
CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply



KAPR

90°



Inch version

										Dimensions, inch									
DC	CZC _{MS}	APMX _{FW}	APMX _{FW}	RMPX	AZ	CNSC	Ordering code	DCON _{MS}	BD	LB	LF	LU	FT/LBS	LBS	RPMX	CICT	MIID		
.375	07	5/16	.079	.228	7°	.020	1	2	RA390-010008L-07L	.313	.355	3.937	3.937	.3	0.16	56600	2	390R-07..	
07	3/8	.079	.228	7°	.020	1	2	RA390-010010-07L	.375	.355	.591	2.362	.591	.3	0.15	56600	2	390R-07..	
.500	07	3/8	.079	.228	4°	.020	1	2	RA390-013010L-07L	.375	.472	4.724	4.724	.3	0.23	44500	2	390R-07..	
07	1/2	.079	.228	4°	.020	1	2	RA390-013013-07L	.500	.472	.709	2.756	.709	.3	0.22	44500	2	390R-07..	
07	1/2	.079	.228	4°	.020	1	3	RA390-013013-07M	.500	.472	.709	2.756	.709	.3	0.21	44500	3	390R-07..	
.625	07	9/16	.079	.228	3°	.020	1	3	RA390-016014L-07M	.563	.586	6.299	6.299	.3	0.50	24100	3	390R-07..	
07	5/8	.079	.228	3°	.020	1	3	RA390-016016-07M	.625	.586	.984	3.543	.984	.3	0.35	37800	3	390R-07..	
07	5/8	.079	.228	3°	.020	1	4	RA390-016016-07H	.625	.586	.984	3.543	.984	.3	0.35	37800	4	390R-07..	
11	5/8	.217	.394	10°	.039	1	2	RA390-016016L-11L	.625			5.700	1.375	.8	0.71	31000	2	R390-11..	
.750	07	3/4	.079	.228	2°	.020	1	4	RA390-019019-07M	.750	.711	.984	4.331	.984	.3	0.57	33500	4	390R-07..
07	3/4	.079	.228	2°	.020	1	5	RA390-019019-07H	.750	.711	.984	4.331	.984	.3	0.55	33500	5	390R-07..	
11	3/4	.217	.394	5°	.039	1	2	RA390-019019L-11L	.750			6.500	1.625	.8	1.46	22100	2	R390-11..	
1.000	07	1	.079	.228	1°	.020	1	5	RA390-025025-07M	1.000	.961	1.260	4.724	1.260	.3	1.04	28000	5	390R-07..
07	1	.079	.228	1°	.020	1	7	RA390-025025-07H	1.000	.961	1.260	4.724	1.260	.3	1.05	28000	7	390R-07..	
11	1	.217	.394	4°	.039	1	2	RA390-025025L-11L	1.000			8.000	2.125	.8	1.77	12100	2	R390-11..	
11	1	.217	.394	4°	.039	1	3	RA390-025025L-11M	1.000			8.000	2.125	.8	1.78	12100	3	R390-11..	
17	1	.335	.618	15°	.059	1	2	RA390-025025L-17L	1.000			8.000	2.125	2.2	2.03	12100	2	R390-17..	

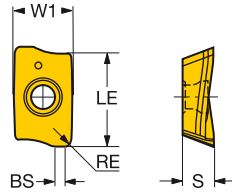
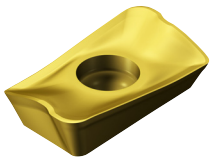
		Spare parts
DC"		Insert screw
.375-1.000	07	5513 020-82
.625-.750	11	5513 020-36
1.000	11	5513 020-35
1.000	17	5513 020-37

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 390 insert for milling

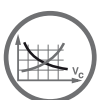
KRINS 90°



	RE	Ordering code	P										M					K				N			S				H			Dimensions, mm, inch																		
			1025	1040	1130	2030	2040	4220	4300	4340	530	1025	1040	2030	2040	4340	530	S30T	S40T	1010	1025	4220	4300	4340	1025	1130	530	HT3A	1025	1130	2030	2040	S30T	S40T	1010	1025	1130	4220	530	W1	LE	S	BS							
			☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆											
Light	ML	11 0.80 R390-11 T3 08E-ML	☆																																						6.8	10.0	3.59	1.5						
		.031 R390-11 T3 16E-ML	☆																																						268	.394	.141	.059						
		1.60 R390-11 T3 24E-ML	☆																																							6.8	10.0	3.59	0.8					
		.063 R390-11 T3 31E-ML	☆																																								268	.394	.141	.031				
		2.40 R390-11 T3 31E-ML	☆																																								6.8	10.0	3.59					
		.094 R390-11 T3 31E-ML	☆																																								268	.394	.141					
		3.10 R390-11 T3 31E-ML	☆																																								6.8	10.0	3.59					
	.122 R390-17 04 08E-ML	☆																																									268	.394	.141					
	17 0.80 R390-17 04 08E-ML	☆																																									9.6	15.7	4.76	1.5				
	.031 R390-11 T3 04E-NL																																												6.8	10.0	3.59	0.9		
	.016 R390-11 T3 08E-NL																																												268	.394	.141	.035		
	0.80 R390-11 T3 20E-NL																																												6.8	10.0	3.59	1.5		
	.031 R390-11 T3 31E-NL																																												268	.394	.141	.059		
	2.00 R390-11 T3 31E-NL																																												6.8	10.0	3.59			
	.079 R390-17 04 08E-NL																																													268	.394	.141		
	3.10 R390-17 04 31E-NL																																												6.8	10.0	3.59			
	.122 R390-17 04 20E-NL																																													268	.394	.141		
	4.00 R390-17 04 40E-NL																																													9.6	15.7	4.76	0.3	
	.157 R390-17 04 50E-NL																																														378	.618	.188	.012
	5.00 R390-17 04 50E-NL																																													9.6	15.7	4.76		
.197 R390-11 T3 04E-PL	☆	★																																													6.8	10.0	3.59	0.9
.016 R390-11 T3 08E-PL	☆	★																																													268	.394	.141	.035
0.80 R390-11 T3 08M-PL	☆	★																																													6.8	10.0	3.59	1.2
.031 R390-17 04 08E-PL	☆	★																																													268	.394	.141	.047
17 0.80 R390-17 04 08E-PL	☆	★																																													9.6	15.7	4.76	1.5
.031 R390-17 04 08M-PL	☆	★																																													378	.618	.188	.059
0.80 R390-17 04 08M-PL	☆	★																																													9.6	15.7	4.76	1.5
.031																																															378	.618	.188	.059



E17



E44



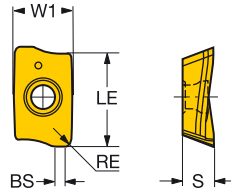
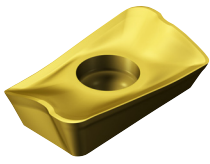
E67



J19

CoroMill® 390 insert for milling

KRINS 90°



RE	Ordering code	P																				M					K				N			S			H			Dimensions, mm, inch				
		1025	1040	1130	2030	2040	4220	4330	4340	530	1025	1040	1130	2030	2040	4340	530	S30T	S40T	1010	1025	4220	4330	4340	1025	1130	HT3A	1130	2030	2040	S30T	S40T	1010	1025	1130	4220	530	W1	LE	S	BS			
		☆	★				☆	★	☆	☆	★				☆	★	☆	☆	★	☆	★				☆	★		☆	★	☆	★	☆	★											
11	0.20	R390-11 T3 02E-PM	☆	★					☆	★										☆	★																		6.8	10.0	3.59	0.7		
	.008																																						.268	.394	.141	.028		
	0.40	R390-11 T3 04M-PM	☆	★																																				6.8	10.0	3.59	0.9	
	.016																																							.268	.394	.141	.035	
	0.80	R390-11 T3 08M-PM	☆	★																																				6.8	10.0	3.59	1.2	
	.031																																							.268	.394	.141	.047	
	1.20	R390-11 T3 12E-PM	☆	★																																				6.8	10.0	3.59	0.8	
	.047																																							.268	.394	.141	.031	
	1.60	R390-11 T3 16E-PM	☆	★																																				6.8	10.0	3.59	0.4	
	.063																																							.268	.394	.141	.016	
	1.60	R390-11 T3 16M-PM	☆	★																																				6.8	10.0	3.59	0.4	
	.063																																							.268	.394	.141	.016	
	2.00	R390-11 T3 20E-PM	☆	★																																				6.8	10.0	3.59		
	.079																																							.268	.394	.141		
	2.40	R390-11 T3 24E-PM	☆	★																																				6.8	10.0	3.59		
	.094																																							.268	.394	.141		
	3.10	R390-11 T3 31E-PM	☆	★																																				6.8	10.0	3.59		
	.122																																							.268	.394	.141		
	3.10	R390-11 T3 31M-PM	☆	★																																				6.8	10.0	3.59		
	.122																																							.268	.394	.141		
17	0.40	R390-17 04 04E-PM	☆	★																																				9.6	15.7	4.76	1.0	
	.016																																								.378	.618	.188	.039
	0.40	R390-17 04 04M-PM	☆	★																																					9.6	15.7	4.76	1.0
	.016																																								.378	.618	.188	.039
	0.80	R390-17 04 08M-PM	☆	★																																				9.6	15.7	4.76	1.5	
	.031																																								.378	.618	.188	.059
	1.20	R390-17 04 12E-PM	☆	★																																				9.6	15.7	4.76	1.1	
	.047																																								.378	.618	.188	.043
	1.60	R390-17 04 16E-PM	☆	★																																				9.6	15.7	4.76	0.7	
	.063																																								.378	.618	.188	.028
	1.60	R390-17 04 16M-PM	☆	★																																				9.6	15.7	4.76	0.7	
	.063																																								.378	.618	.188	.028
	2.00	R390-17 04 20E-PM	☆	★																																				9.6	15.7	4.76	0.3	
	.079																																								.378	.618	.188	.012
	2.40	R390-17 04 24E-PM	☆	★																																				9.6	15.7	4.76		
	.094																																								.378	.618	.188	
	3.10	R390-17 04 31E-PM	☆	★																																				9.6	15.7	4.76		
	.122																																								.378	.618	.188	
	3.10	R390-17 04 31M-PM	☆	★																																				9.6	15.7	4.76		
	.122																																								.378	.618	.188	
	4.00	R390-17 04 40E-PM	☆	★																																				9.6	15.7	4.76		
	.157																																								.378	.618	.188	
	4.80	R390-17 04 48E-PM	☆	★																																					9.6	15.7	4.76	
	.189																																								.378	.618	.188	
	5.00	R390-17 04 50E-PM	☆	★																																				9.6	15.7	4.76		
	.197																																								.378	.618	.188	
	6.00	R390-17 04 60E-PM	☆	★																																				9.6	15.7	4.76		
	.236																																								.378	.618	.188	
	6.35	R390-17 04 64E-PM	☆	★																																				9.6	15.7	4.76		
	.250																																								.378	.618	.188	



E17



E44



E67

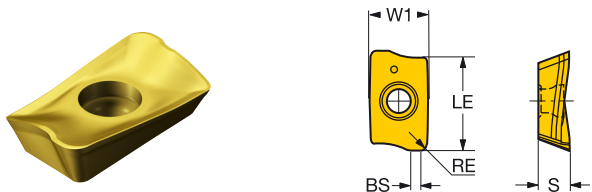


J19



CoroMill® 390 insert for milling

KRINS 90°



		P										M					K			N		S			H		Dimensions, mm, inch																	
		1025	1040	1130	2030	2040	4220	4330	4940	530	530	1025	1040	1130	2030	2040	4940	530	S30T	S40T	1010	1025	4220	4330	4940	1025	1130	530	HT3A	1025	1130	2030	2040	S30T	S40T	1010	1025	1130	4220	530	W1	LE	S	BS
Heavy	MH	11 1.00	R390-11 T3 10M-MH	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	6.8	10.0	3.59	1.0			
		.039																																				.268	.394	.141	.040			
	PH	11 1.00	R390-11 T3 10M-PH	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	6.8	10.0	3.59	1.0			
		.039																																				.268	.394	.141	.040			
		17 0.80	R390-17 04 08M-PH				☆	☆	☆	☆	☆					☆									☆	☆												9.6	15.7	4.76	1.5			
.031																																				.378	.618	.188	.059					
		1.60	R390-17 04 16M-PH				☆	☆	☆	☆					☆									☆	☆												9.6	15.7	4.76	1.5				
		.063																																			.378	.618	.188	.059				

E

F

G

H

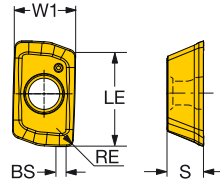
I

J



CoroMill® 390 insert for milling

KRINS 90°



		RE	Ordering code	Dimensions, mm, inch															
				P			M			K	N	S	H	W1	LE	S	BS		
				1040	1130	4300	1040	1130	4300	4300	4300	4300	4300	4300	4300	4300	4300	4300	4300
Light	ML	07 0.20	390R-070202E-ML	☆			★							4.0	5.9	2.40	0.7		
		.008													.160	.232	.094	.028	
		0.40	390R-070204E-ML	☆			★		☆						4.0	5.9	2.40	0.7	
		.016													.160	.232	.094	.028	
		0.80	390R-070208E-ML	☆			★		☆						4.0	5.9	2.40	0.7	
		.031													.160	.232	.094	.028	
		1.20	390R-070212E-ML	☆			★								4.0	5.9	2.40	0.7	
		.047													.160	.232	.094	.028	
	1.60	390R-070216E-ML	☆			★								4.0	5.9	2.40	0.2		
	.063													.160	.232	.094	.008		
	NL	07 0.20	390R-070202E-NL									★			4.0	5.9	2.40	0.7	
		.008													.160	.232	.094	.028	
		0.40	390R-070204E-NL									★			4.0	5.9	2.40	0.7	
		.016													.160	.232	.094	.028	
		0.80	390R-070208E-NL									★			4.0	5.9	2.40	0.7	
		.031													.160	.232	.094	.028	
		1.20	390R-070212E-PL	★			☆				☆	☆	☆		4.0	5.9	2.40	0.7	
		.047													.160	.232	.094	.028	
	1.60	390R-070216E-PL	★			☆				☆	☆	☆		4.0	5.9	2.40	0.2		
	.063													.160	.232	.094	.008		
	Medium	MM	07 0.20	390R-070202M-MM	☆			★							4.0	5.9	2.40	0.7	
			.008												.160	.232	.094	.028	
			0.40	390R-070204E-MM	☆			★		☆						4.0	5.9	2.40	0.7
			.016													.160	.232	.094	.028
0.80			390R-070208E-MM	☆			★		☆						4.0	5.9	2.40	0.7	
.031															.160	.232	.094	.028	
1.20			390R-070212M-MM	☆			★		☆						4.0	5.9	2.40	0.7	
.047															.160	.232	.094	.028	
1.60		390R-070216M-MM	☆			★		☆						4.0	5.9	2.40	0.2		
.063														.160	.232	.094	.008		
PM		07 0.20	390R-070202M-PM	★	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.0	5.9	2.40	0.7	
		.008													.160	.232	.094	.028	
		0.40	390R-070204M-PM	★	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.0	5.9	2.40	0.7	
		.016													.160	.232	.094	.028	
		0.80	390R-070208M-PM	★	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.0	5.9	2.40	0.7	
		.031													.160	.232	.094	.028	
		1.20	390R-070212M-PM	★	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.0	5.9	2.40	0.7	
		.047													.160	.232	.094	.028	
1.60		390R-070216M-PM	★	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.0	5.9	2.40	0.2		
.063														.160	.232	.094	.008		



E17



E44



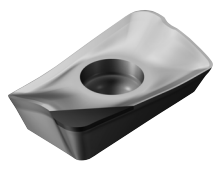
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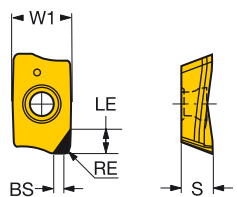
J19

CoroMill® 390 insert for milling

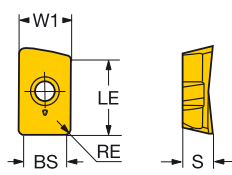
B



KRINS 90°



90°



C

Wiper inserts

D

			P	M	K	N	S	H	Dimensions, mm					
Light	PLW	RE	1025	1130	1025	1130	1025	1130	1025	1130	W1	LE	S	BS
		Ordering code	★	★	★	★	★	★	★	★	6.8	10.0	3.59	5.0

E

Advanced cutting materials

F

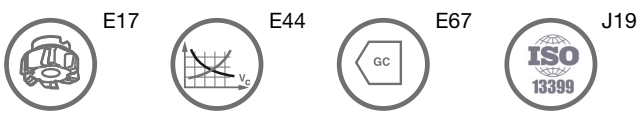
			N	Dimensions, mm, inch			
Light	NL	RE	CD10	W1	LE	S	BS
		Ordering code	★	6.8	4.0	3.59	2.2
		.016	★	.268	.157	.141	.087
		17	★	9.6	6.0	4.76	1.8
		.031	★	.378	.236	.188	.071

G

H

I

J



CoroMill® 300

Light cutting face and profile milling cutters

CoroMill® 300 is a round insert cutter for face milling and profiling. Its light cutting action allows for smooth entries and exits, generating low cutting force and little heat at small depths of cut. This allows the table feed to be increased five to ten times compared to general machining.

ISO application area:



Application

- Full slot milling
- Face milling
- Ramping
- Profiling
- Pocket milling



Benefits and features

- Universal product with a wide application window
- Large assortment covering many applications
- Cutters with positive design have light cutting action and generates low cutting forces, which allows for extra close pitched face mill versions with small inserts for high productivity at high speeds combined with high table feeds
- End mills with great accessibility and cutting action in all feed directions for multi-axis machining of complicated forms

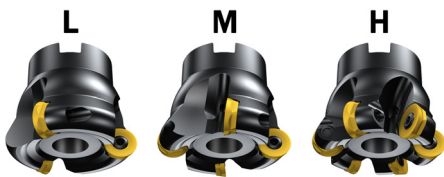
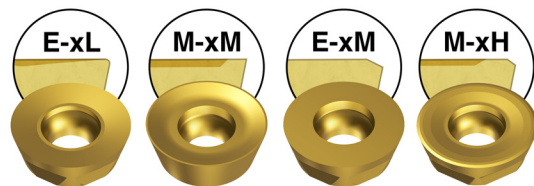
www.sandvik.coromant.com/coromill300

Couplings

- Cylindrical shank
- Weldon
- Coromant EH

Inserts

- Insert geometries and grades for all materials



Coarse pitch

Close pitch

Extra close pitch



E28



E31

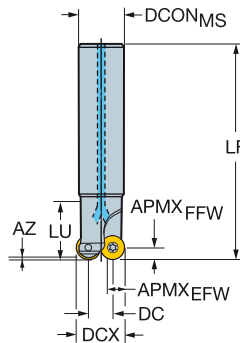
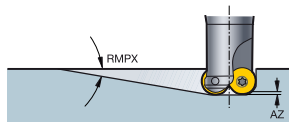


J9

CoroMill® 300 face milling cutter

Cylindrical shank - Internal coolant supply

Positive design



Metric version

										Dimensions, mm									
DC		CZC _{MS}	APM _{XEFW}	APM _{XFFW}	RMPX	AZ	CNSC		Ordering code	DCON _{MS}	DCX	BD	LB	LF			RPMX	CICT	MIID
15.0	10	20	7.5	5.00	13°	2.3	1	2	R300-025A20-10M	20.0	25.0	19.1	33.0	150.0	3.0	0.50	2850	2	R300-1032..
17.0	08	20	6.0	4.00	8°	1.9	1	3	R300-025A20-08M	20.0	25.0	20.3	25.0	150.0	1.2	0.44	7200	3	R300-0828..

Spare parts		
DC		Insert screw
17.00	08	5513 020-56
15.00	10	5513 020-43

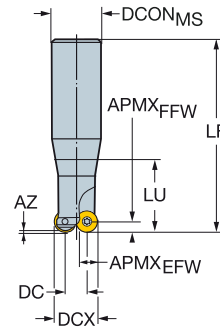
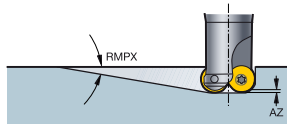
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 300 face milling cutter

Cylindrical shank

Neutral design



Metric version

								Dimensions, mm											
DC		CZC _{MS}	APM _{EFW}	APM _{FFW}	RMPX	AZ		Ordering code	DCON _{MS}	DCX	BD	LB	LF	LU			RPMX	CICT	MIID
5.0	05	16	3.8	2.50	20°	1.8	2	R300-010A16L-05L	16.0	10.0	9.1	18.0	160.0	25.4	0.6	0.32	15900	2	R300-0517..
	07 20	16	5.3	3.50	20°	1.0	2	R300-012A16L-07L	16.0	12.0	10.4	21.0	200.0	37.8	0.9	0.38	8900	2	R300-0720..
8.0	08	20	6.0	4.00	20°	1.8	2	R300-016A20L-08L	20.0	16.0	14.1	25.0	200.0	51.9	1.2	0.54	12700	2	R300-0828..
10.0	10	25	7.5	5.00	20°	3.4	2	R300-020A25L-10L	25.0	20.0	18.1	30.0	250.0	48.8	3.0	1.16	8100	2	R300-1032..
12.0	12	25	9.0	6.00	20°	2.7	2	R300-024A25L-12L	25.0	24.0	22.1	30.0	250.0	76.0	3.0	1.20	8900	2	R300-1240..

		Spare parts
DC		Insert screw
5.00	05	5513 020-40
5.00	07 20	5513 020-41
8.00	08	5513 020-36
10.00	10	5513 020-43
12.00	12	5513 020-39

For complete list of spare parts, see www.sandvik.coromant.com



E31



J19

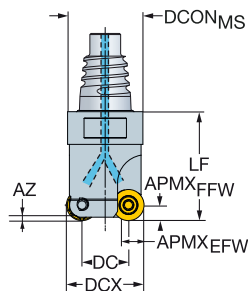
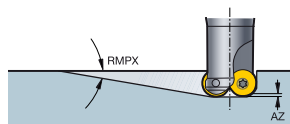


J9

CoroMill® 300 face milling cutter

Coromant EH - Internal coolant supply

Neutral design



D Metric version

										Dimensions, mm									
DC		CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	AZ	CNSC		Ordering code	DCON _{MS}	DCX	BD	LB	LF			RPMX	CICT	MIID
5.0	05	E10	3.8	2.50	20°	1.8	1	2	R300-10EH10-05L	9.7	10.0	9.0	13.1	20.0	0.6	0.06	20000	2	R300-0517..
	07 20	E12	5.3	3.50	20°	1.0	1	2	R300-12EH12-07L	11.7	12.0	10.3	17.5	25.0	0.9	0.07	20000	2	R300-0720..
7.0	05	E12	3.8	2.50	10°	1.0	1	3	R300-12EH12-05M	11.7	12.0	11.0	12.5	20.0	0.6	0.10	20000	3	R300-0517..
8.0	07 20	E12	5.3	3.50	20°	1.1	1	3	R300-15EH12-07M	11.7	15.0	13.3	17.5	25.0	0.9	0.10	20000	3	R300-0720..
	07 24	E12	5.3	3.50	20°	0.9	1	2	R300-15EH12-07L	11.7	15.0	13.3	17.5	25.0	0.9	0.10	20000	2	R300-0724..
	08	E16	6.0	4.00	20°	1.8	1	2	R300-16EH16-08L	15.5	16.0	14.0	21.3	30.0	1.2	0.09	20000	2	R300-0828..
9.0	07 20	E16	5.3	3.50	15°	0.9	1	3	R300-16EH16-07M	15.5	16.0	14.3	16.3	25.0	0.9	0.11	20000	3	R300-0720..
10.0	10	E20	7.5	5.00	20°	3.4	1	2	R300-20EH20-10L	19.3	20.0	18.0	25.0	35.0	3.0	0.12	20000	2	R300-1032..
12.0	08	E20	6.0	4.00	12°	1.5	1	3	R300-20EH20-08M	19.3	20.0	18.0	20.0	30.0	1.2	0.13	20000	3	R300-0828..

F Inch version

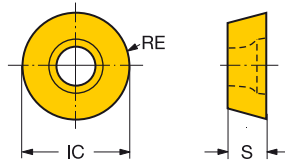
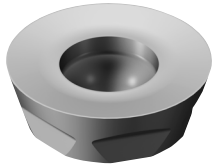
										Dimensions, inch									
DC		CZC _{MS}	APMX _{EFW}	APMX _{FFW}	RMPX	AZ	CNSC		Ordering code	DCON _{MS}	DCX	BD	LB	LF			RPMX	CICT	MIID
.178	05	E10	.148	.098	20°	.054	1	2	RA300-10EH10-05L	.364	.375	.335	.516	.787	.4	0.02	20000	2	R300-0517..
.224	07 20	E12	.207	.138	20°	.056	1	2	RA300-13EH12-07L	.484	.500	.435	.689	.984	.6	0.04	20000	2	R300-0720..
.303	05	E12	.148	.098	10°	.035	1	3	RA300-13EH12-05M	.484	.500	.460	.492	.787	.4	0.21	20000	3	R300-0517..
.310	08	E16	.236	.157	20°	.038	1	2	RA300-16EH16-08L	.610	.625	.548	.839	1.181	.8	0.24	20000	2	R300-0828..
.349	07 20	E16	.207	.138	20°	.035	1	3	RA300-16EH16-07M	.610	.625	.560	.642	.984	.6	0.24	20000	3	R300-0720..
.356	10	E20	.295	.197	20°	.111	1	2	RA300-19EH20-10L	.728	.750	.673	.984	1.378	2.2	0.13	20000	2	R300-1032..
.435	08	E20	.236	.157	20°	.069	1	3	RA300-19EH20-08M	.728	.750	.673	.787	1.181	.8	0.11	20000	3	R300-0828..

Spare parts	
	Insert screw
05	5513 020-40
07 20	5513 020-41
07 24	5513 020-42
08	5513 020-35
10	5513 020-43

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 300 insert for milling



Metric version

	RE	Ordering code	P					M					K			N		S				H		Dimensions, mm, inch									
			1025	1040	1130	2030	4220	4330	4340	1025	1040	1130	2030	4220	4330	4340	H13A	1025	1130	H13A	1025	2030	4220	H13A	S30T	S40T	1010	1025	1130	4220	IC	S	
Light	08	4.00	R300-0828E-PL		★																										8.0	2.78	
		.157																													.315	.109	
		4.00	R300-0828E-KL																												8.0	2.78	
		.157																													.315	.109	
	10	5.00	R300-1032E-PL		★																										10.0	3.18	
		.197																													.394	.125	
	5.00	R300-1032E-KL																												10.0	3.18		
	.197																													.394	.125		
	12	6.00	R300-1240E-PL					★																							12.0	3.97	
	.236																													.472	.156		
	6.00	R300-1240E-ML							★																						12.0	3.97	
	.236																													.472	.156		
Medium	08	4.00	R300-0828E-PM					★																							8.0	2.78	
		.157																													.315	.109	
		4.00	R300-0828M-PM						★																						8.0	2.78	
		.157																													.315	.109	
		4.00	R300-0828E-MM							★																					8.0	2.78	
		.157																													.315	.109	
		4.00	R300-0828M-MM								★																				8.0	2.78	
		.157																													.315	.109	
	10	5.00	R300-1032E-PM						★																							10.0	3.18
		.197																													.394	.125	
		5.00	R300-1032M-PM							★																						10.0	3.18
		.197																													.394	.125	
	5.00	R300-1032E-MM								★																					10.0	3.18	
	.197																													.394	.125		
	5.00	R300-1032M-MM									★																				10.0	3.18	
	.197																													.394	.125		
	12	6.00	R300-1240E-PM						★																						12.0	3.97	
	.236																													.472	.156		
	6.00	R300-1240M-PM									★																				12.0	3.97	
	.236																													.472	.156		
	6.00	R300-1240E-MM										★																			12.0	3.97	
	.236																													.472	.156		
	6.00	R300-1240M-MM											★																		12.0	3.97	
	.236																													.472	.156		
Heavy	08	4.00	R300-0828M-PH																												8.0	2.78	
		.157																													.315	.109	
		4.00	R300-0828M-MH																												8.0	2.78	
		.157																													.315	.109	
	10	5.00	R300-1032M-PH																													10.0	3.18
		.197																													.394	.125	
	5.00	R300-1032M-MH																													10.0	3.18	
	.197																													.394	.125		
	12	6.00	R300-1240M-PH																													12.0	3.97
	.236																														.472	.156	
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	.236																														.472	.156	



E28



E44



E67

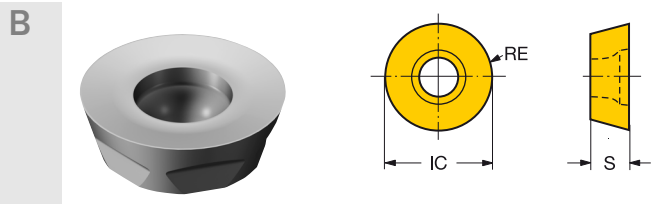


J19



CoroMill® 300 insert for milling

ENG



C

Inch version

D

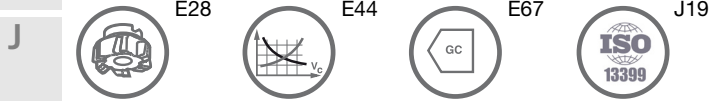
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		P			M			N		S		H		IC	S		
		1010	1025	1030	2040	4340	1025	1030	2040	4340	1025	1030	1025	1030	2040	1010	1025
		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
Medium	07 20 3.50 .138	R300-0720E-PM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7.0	1.99
	07 24 3.50 .138	R300-0724E-PM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	7.0	2.38
	07 20 3.50 .138	R300-0720E-MM		☆		☆						☆				7.0	1.99
	07 24 3.50 .138	R300-0724E-MM		☆		☆						☆				7.0	2.38
	05 2.50 .098	R300-0517E-PM		☆	☆		☆	☆	☆	☆	☆		☆			5.0	1.70
	09 4.76 .187	R300-0932E-PM	☆	☆		☆		☆	☆	☆	☆	☆	☆	☆		9.5	3.18
	4.76 .187	R300-0932M-PM		☆		☆		☆	☆	☆	☆		☆			9.5	3.18
	4.76 .187	R300-0932E-MM		☆		☆						☆				9.5	3.18
	09 4.76 .187	R300-0932M-PH		☆		☆										9.5	3.18

F

G

H

I



CoroMill® 325

Thread whirling cutter

High quality threads

The whirling process allows high thread quality when machining external threads on slender components. The thread whirling rings are available for different drive units in most sliding head machines. A small stocked insert assortment for HA and HB thread forms and engineered solutions to fit specific components are available.

Application

Thread whirling of threads on long and slender components, like screws. Diameter 3 - 10 mm (.118 - .394 inch).

Typical components

- Bone screws
- Spinal screws
- Dental implants
- Other long, slender components

ISO application area:



Benefits and features

- Increased productivity
- Chip control
- Increased tool life
- Cost saving
- High quality threads
- One grade for all materials
- Compatible with many sliding head machines and spindles
- Deep threads are easily made
- Optimized for titanium and stainless steel

www.sandvik.coromant.com/coromill325

Standard threads

Other thread forms can be offered as special.

Chip control

- Chip control is superior to single-point threading, enabling more continuous and productive machining.



E36



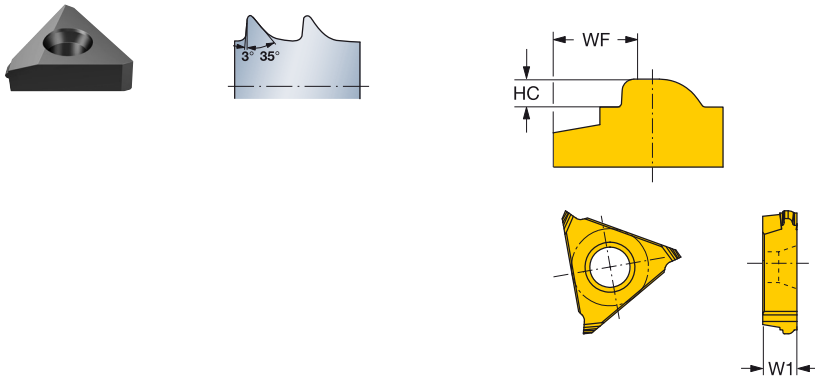
E34

CoroMill® 325 Thread whirling inserts

External threads

HA threads

THFTSR ISO 5835-1991



C

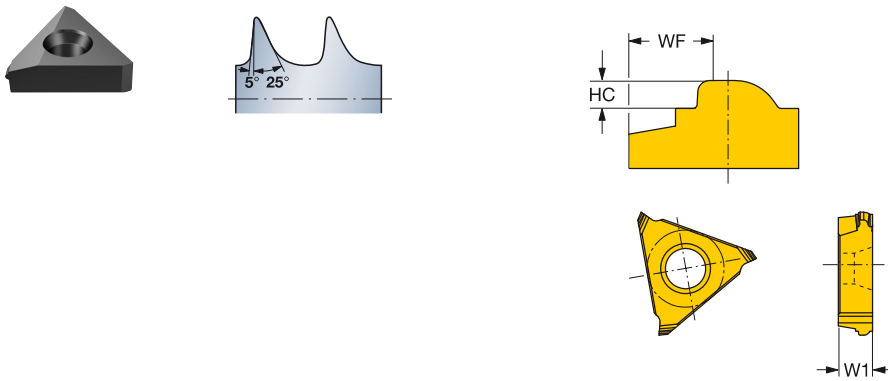
D

				Dimensions, mm, inch										
				HC	HC"	WF	WF"	W1	W1"	FTDZ	P	M	N	S
		TP	Ordering code	0.480	.0189	2.680	.1055	4.100	.1614	HA 4	1105	1105	1105	1105
16	3/8	1.50	325R16-150HAF01	0.750	.0295	2.620	.1031	4.100	.1614	HA 4.5/HA 5	☆	☆	☆	☆
		1.75	325R16-175HAF01								☆	☆	☆	☆

E

HB threads

THFTSR ISO 5835-1991



F

G

				Dimensions, mm, inch										
				HC	HC"	WF	WF"	W1	W1"	FTDZ	M	N	S	
		TP	Ordering code	1.025	.0404	2.660	.1047	4.100	.1614	HB 4	1105	1105	1105	
16	3/8	1.75	325R16-175HBF01	1.750	.0689	2.080	.0819	4.100	.1614	HB 6.5	☆	☆	☆	
		2.75	325R16-275HBF01								☆	☆	☆	

H

Tolerances:

	HCTOLL	HCTOLL"	HCTOLU	HCTOLU"	WFTOLL	WFTOLL"	WFTOLU	WFTOLU"
325R..HA	-0.01	-.0002	0.01	.0002	-0.02	-.0004	0.02	.0004
325R..HB	-0.01	-.0002	0.01	.0002	-0.02	-.0004	0.02	.0004

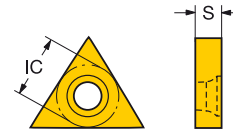
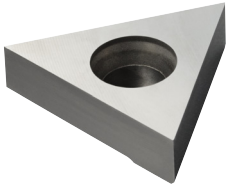
Specially-formed inserts can also be ordered. See your local Sandvik Coromant representative for more information.

I

J



CoroMill® 325 carbide blank



		P	M	N	S	Dimensions, mm, inch
	Ordering code	H _T OF	H _T OF	H _T OF	H _T OF	S
16	3/4	☆	☆	☆	☆	4.0
						.157
	325R16-0500-BG	☆	☆	☆	☆	5.5
						.217



E36



E44

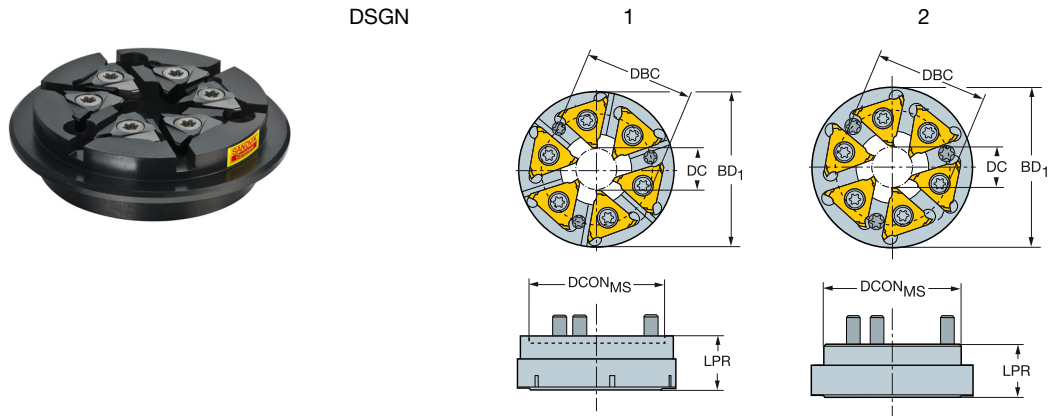


E67



J19

CoroMill® 325 Thread whirling cutter



Citizen-PCM

							Dimensions, mm, inch						
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR	KG	NM	MIID
16	3/8	6	2	0	6	325-06AP20-16M	20	26	35	15	0.06	6.5	325R16-150HAF01
16	3/8	12	1	0	6	325-12AP40-16M	40	32.5	46	15.5	0.12	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12AP45-16M	45	30	46	18	0.13	6.5	325R16-150HAF01

Citizen - Jarvis

							Dimensions, mm, inch						
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR	KG	NM	MIID
16	3/8	12	1	0	6	325-12AQ40-16M	40	32	46	13.5	0.12	6.5	325R16-150HAF01

Citizen - Citizen

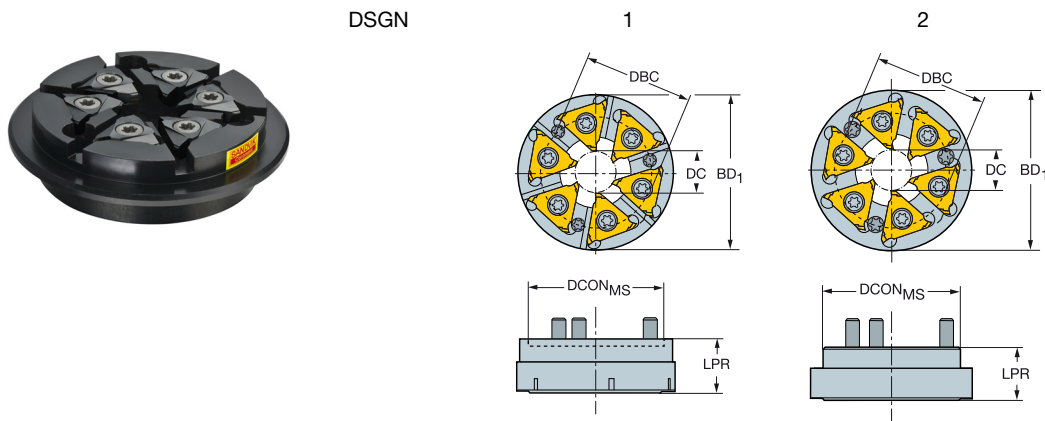
							Dimensions, mm, inch						
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR	KG	NM	MIID
16	3/8	12	2	0	6	325-12AA33-16M	33	40	46.9	18.5	0.10	6.5	325R16-150HAF01

Spare parts	
Insert screw	Mounting screw
5513 020-02	5513 039-02

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 325 Thread whirling cutter



Tsugami-Tsugami

							Dimensions, mm, inch						
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR	KG	NM	MIID
16	3/8	12	2	0	6	325-12CC52-16M	52	42	65	17	0.21	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12CC52-16M-B	52	44	52	10	0.10	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12CC52-16M-C	52	38	54	19	0.23	6.5	325R16-150HAF01
16	3/8	16	2	0	6	325-16CC50-16M	50	40	62	20	0.21	6.5	325R16-150HAF01
16	3/8	20	2	0	6	325-20CC52-16M	52	42	65	17	0.12	6.5	325R16-150HAF01

Tornos-Tornos

							Dimensions, mm, inch						
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR	KG	NM	MIID
16	3/8	12	2	0	6	325-12DD50-16M	50	40	67	15.4	0.25	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12DD40-16M	40	31	57	15	0.12	6.5	325R16-150HAF01

Spare parts		
Ordering code	Insert screw	Mounting screw
325-12CC52-16M	5513 020-02	5513 039-04
325-12CC52-16M-B	5513 020-02	
325-12CC52-16M-C	5513 020-02	
325-12DD50-16M	5513 020-02	5513 039-02
325-16CC50-16M	5513 020-02	5513 039-04

For complete list of spare parts, see www.sandvik.coromant.com



E34

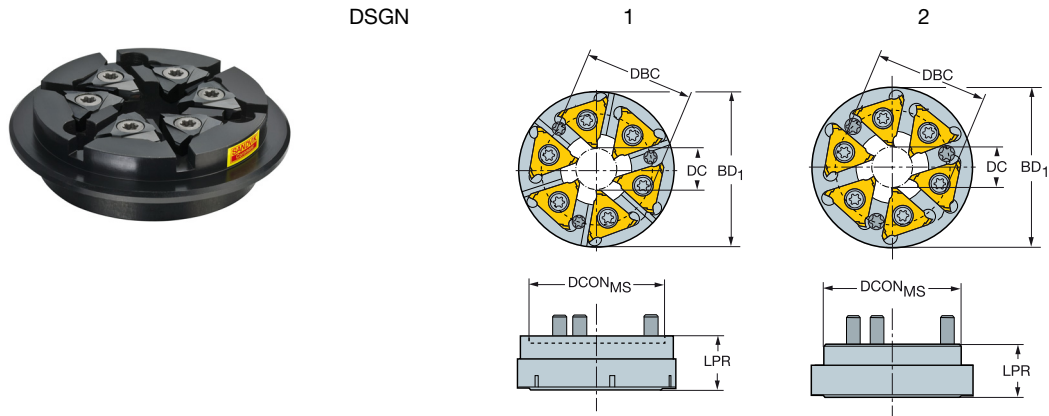


J19



J16

CoroMill® 325 Thread whirling cutter



Citizen, Hanwha - Madula

						Dimensions, mm, inch							
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR			MIID
16	3/8	12	2	0	6	325-12RR45-16M	45	27	56	15	0.14	6.5	325R16-150HAF01

DMG - DMG

						Dimensions, mm, inch							
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR			MIID
16	3/8	13.5	1	0	6	325-14GG42-16M	42	33	49	14.75	0.11	6.5	325R16-150HAF01

Star - Star

						Dimensions, mm, inch							
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	DBC	BD ₁	LPR			MIID
16	3/8	12	2	0	6	325-12BB40-16M	40	32	47	15	0.12	6.5	325R16-150HAF01

Star, Goodway, Doosan, Hanwha, Nexturn, Tsugami - WTO

						Dimensions, mm, inch						
		DC	DSGN	CNSC		Ordering code	DCON _{MS}	BD ₁	LPR			MIID
16	3/8	20	2	0	6	325-20EE54-16M	54	56.5	13.8	0.10	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12EE32-16M	32	43.8	18.2	0.12	6.5	325R16-150HAF01

Spare parts	
Insert screw	Mounting screw
5513 020-02	5513 039-02

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 495

Versatile chamfer cutter

CoroMill® 495 is a dedicated chamfering family for 15°, 30°, 45°, 60° chamfers. Capable of machining over and under.

ISO application area:

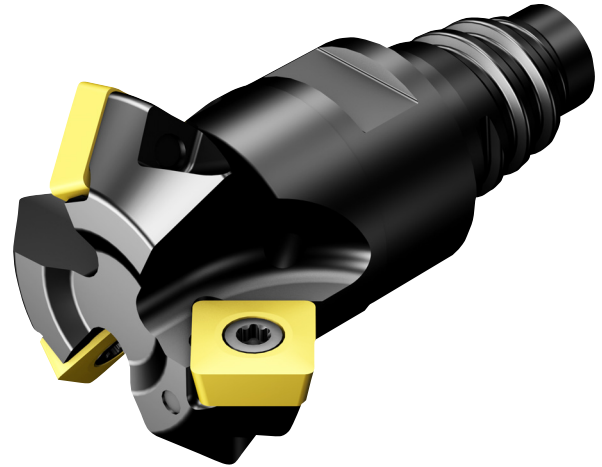


Application

- Chamfering of holes and along edges
- Typical operations are chamfers, back chamfers and deburring

Benefits and features

- Versatile tool for many different chamfer operations
- Flexible inserts capable to perform in several workpiece materials
- High machine utilization thanks to few tool changes
- Indexable inserts with four cutting edges
- Cutter bodies with high number of inserts in relation to body size



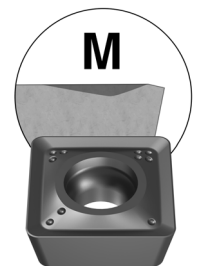
www.sandvik.coromant.com/coromill495

Couplings

- Cylindrical shank
- Coromant EH

Inserts

- Insert geometries and grades for all materials
- Four cutting edges



L



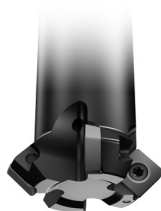
Coarse pitch

M



Close pitch

H



Extra close pitch



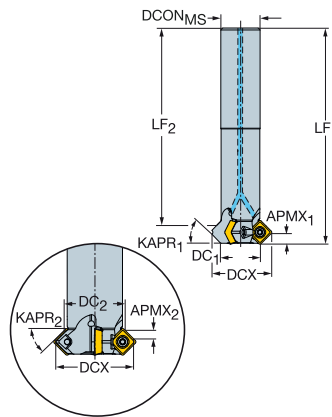
E40



E43

CoroMill® 495 chamfer milling cutter

Cylindrical shank



Metric version

										Dimensions, mm											
KAPR ₁	KAPR ₂	CZC _{MS}	APMX ₁	APMX ₂	CNSC	Ordering code	DCON _{MS}	DC ₁	DC ₂	DCX	BD	LF ₁	LF ₂	LU	BAR	NM	KG	RPMX	CICT	MIID	
30°	60°	09	16	3.8	6.5	1 1	495-012A16-3009L	16.0	12.0	18.3	26.0	17.2	100.0	88.7	20	1.4	0.23	14400	1	495-09T3M-XL	
45°	45°	09	16	5.4	5.4	1 1	495-012A16-4509L	16.0	12.0	17.7	23.4	11.2	100.0	90.8	51.0	20	1.4	0.23	14400	1	495-09T3M-XL
60°	30°	09	16	6.8	3.9	1 1	495-012A16-6009L	16.0	12.0	13.5	20.1	13.5	100.0	90.3	49.0	20	1.4	0.20	14400	1	495-09T3M-XL
75°	09	16	7.7			1 1	495-012A16-7509L	16.0	12.0		16.2	13.0			20	1.4	0.20	14400	1	495-09T3M-XL	
45°	45°	09	20	5.4	5.4	1 3	495-020A20-4509M	20.0	20.5	20.9	31.9	19.7	110.0	98.2	58.0	20	1.4	0.33	9500	3	495-09T3M-XL
75°	09	25	7.7			1 3	495-025A25-7509H	25.0	25.5		29.7	25.2			20	1.4	0.50	8100	3	495-09T3M-XL	
30°	60°	09	25	3.8	6.5	1 4	495-025A25-3009H	25.0	25.5	31.8	39.5	30.7	120.0	108.7	59.0	20	1.4	0.54	8100	4	495-09T3M-XL
45°	45°	09	25	5.4	5.4	1 4	495-025A25-4509H	25.0	25.5	25.9	36.9	24.7	120.0	108.2		20	1.4	0.48	8100	4	495-09T3M-XL
60°	30°	09	25	6.8	3.9	1 4	495-025A25-6009H	25.0	25.5	19.9	33.6	18.7	120.0	108.4	59.0	20	1.4	0.42	8100	4	495-09T3M-XL

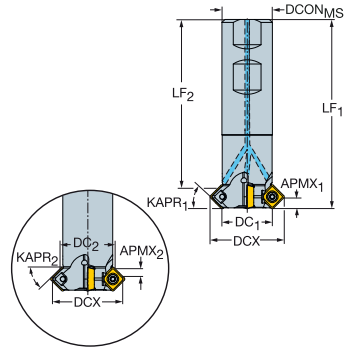
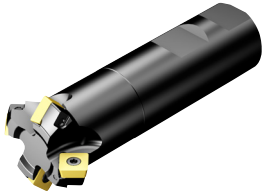
Spare parts
Insert screw
5513 020-04

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 495 chamfer milling cutter

Weldon



Inch version

											Dimensions, inch										
KAPR ₁	KAPR ₂	CZC _{MS}	APMX ₁	APMX ₂	CNSC	Ordering code	DCON _{MS}	DC ₁	DC ₂	DCX	BD	LF ₁	LF ₂	LU	PSI	FT/LBS	LBS	RPMX	CICT	MIID	
30°	60°	09	.150	.260	1	A495-013M16-3009L	.625	.520	.771	1.071	.723	2.882	2.437		290	1.0	0.43	13600	1	495-09T3M-XL	
45°	45°	09	.215	.215	1	A495-013M16-4509L	.625	.520	.745	0.969	.489	2.882	2.520		290	1.0	0.41	13600	1	495-09T3M-XL	
60°	30°	09	.268	.155	1	A495-013M16-6009L	.625	.520	.560	0.838	.577	2.882	2.500	.768	290	1.0	0.19	13600	1	495-09T3M-XL	
75°	09	5/8	.304		1	A495-013M16-7509L	.625	.520		0.686	.562				290	1.0	0.18	13600	1	495-09T3M-XL	
45°	45°	09	.215	.215	1	A495-020M19-4509M	.750	.770	.788	1.219	.739	3.350	2.879		290	1.0	0.50	9500	3	495-09T3M-XL	
75°	09	1	.304		1	A495-026M25-7509H	1.000	1.020		1.185	1.009				290	1.0	0.87	8000	3	495-09T3M-XL	
30°	60°	09	.150	.260	1	A495-026M25-3009H	1.000	1.020	.560	1.571	1.223	3.750	3.306		290	1.0	0.95	8000	4	495-09T3M-XL	
45°	45°	09	.215	.215	1	A495-026M25-4509H	1.000	1.020	1.038	1.469	.989	3.750	3.285		290	1.0	0.93	8000	4	495-09T3M-XL	
60°	30°	09	.268	.155	1	A495-026M25-6009H	1.000	1.020	.804	1.338	.754	3.751	3.283	1.319	290	1.0	0.84	8000	4	495-09T3M-XL	

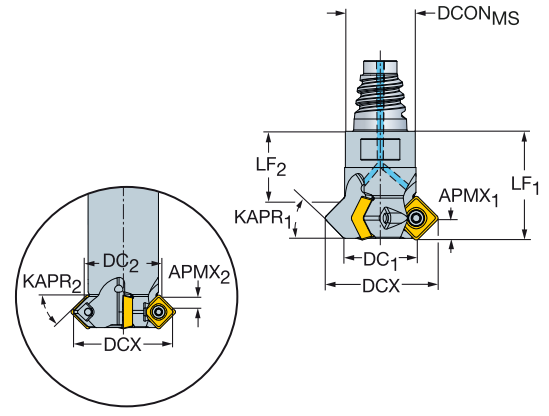
Spare parts
Insert screw
5513 020-04

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 495 chamfer milling cutter

Coromant EH



Metric version

										Dimensions, mm										
KAPR ₁	KAPR ₂	CZC _{MS}	APMX ₁	APMX ₂	CNSC	Ordering code	DCON _{MS}	DC ₁	DC ₂	DCX	BD	LF ₁	LF ₂	BAR	NM	KG	RPMX	CICT	MIID	
45°	45°	09	E16	5.4	5.4	1 1	495-012EH16-4509L	15.5	12.0	17.7	23.4	11.2	30.0	20.8	20	1.4	0.09	14400	1	495-09T3M-XL
45°	45°	09	E20	5.4	5.4	1 3	495-020EH20-4509M	19.3	20.5	20.9	31.9	19.7	30.0	18.2	20	1.4	0.15	9500	3	495-09T3M-XL
45°	45°	09	E25	5.4	5.4	1 4	495-025EH25-4509H	24.2	25.5	25.5	36.9	24.7	35.0	23.2	20	1.4	0.18	8100	4	495-09T3M-XL

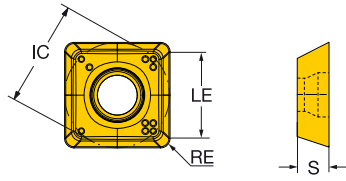
Spare parts
Insert screw
5513 020-04

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 495 insert for milling

KRINS 90°



		Dimensions, mm, inch										
		RE		P	M	N	S	H	IC	LE	S	
		09	0.80	1040	1130	1040	1130	1130	1130	9.0	7.4	3.51
Medium	PL	09	0.80	495-09T3M-PM	★	☆	☆	☆	☆	9.0	7.4	3.51
			.031							.354	.291	.138
	ML	09	0.80	495-09T3M-MM	☆	★				9.0	7.4	3.51
			.031							.354	.291	.138



E40



E44



E67



J19

Milling with large engagement, metric values

ISO P			Specific cutting force k_{c1}	Hardness Brinell		CT530			GC1010		GC1025	
MC No.	CMC No.	Material		N/mm ²	HB	mc	Max chip thickness, h_{ex} mm					
							0.1 - 0.15 - 0.2		0.05 - 0.1 - 0.2		0.05 - 0.1 - 0.2	
Cutting speed v_c , m/min												
Steel												
Unalloyed												
P1.1.Z.AN	01.1	C = 0.1-0.25%	1500	125	0.25	430-390-350	-	-	-	-	-	340-310-255
P1.2.Z.AN	01.2	C = 0.25-0.55%	1600	150	0.25	385-350-315	-	-	-	-	-	305-280-230
P1.3.Z.AN	01.3	C = 0.55-0.80%	1700	170	0.25	365-330-300	-	-	-	-	-	290-260-215
P1.3.Z.AN	01.4		1800	210	0.25	315-290-260	-	-	-	-	-	250-230-185
P1.3.Z.HT	01.5		2000	300	0.25	235-210-195	-	-	-	-	-	185-170-140
Low alloyed (alloying elements ≤ 5%)												
P2.1.Z.AN	02.1	Non-hardened	1700	175	0.25	300-275-245	-	-	-	-	-	280-255-210
P2.5.Z.HT	02.2	Hardened and tempered	1900	300	0.25	195-180-160	-	-	-	-	-	155-140-115
High alloyed (alloying elements > 5%)												
P3.0.Z.AN	03.11	Annealed	1950	200	0.25	230-205-185	180-165-135	-	-	-	-	180-165-135
P3.1.Z.AN	03.13	Hardened tool steel	2150	200	0.25	190-170-155	150-135-110	-	-	-	-	150-135-110
P3.0.Z.HT	03.21		2900	300	0.25	165-150-135	130-120-100	-	-	-	-	130-120-100
P3.0.Z.HT	03.22		3100	380	0.25	105-95-85	80-75-60	-	-	-	-	80-75-60
Castings												
P1.5.C.UT	06.1	Unalloyed	1400	150	0.25	305-280-250	245-220-180	-	-	-	-	245-220-180
P2.6.C.UT	06.2	Low alloyed (alloying elements ≤ 5%)	1600	200	0.25	245-220-200	195-175-145	-	-	-	-	195-175-145
P3.0.C.UT	06.3	High alloyed (alloying elements > 5%)	1950	200	0.25	180-160-145	140-130-105	-	-	-	-	140-130-105
ISO M			Specific cutting force k_{c1}	Hardness Brinell		CT530		M30B		GC1130		
MC No.	CMC No.	Material		N/mm ²	HB	mc	Max chip thickness, h_{ex} mm					
							0.1 - 0.15 - 0.2		0.1 - 0.2 - 0.4		0.05 - 0.1 - 0.2	
Cutting speed v_c , m/min												
Stainless steel												
Ferritic/martensitic												
P5.0.Z.AN	05.11	Non-hardened	1800	200	0.21	285-255-230	265-210-135	-	-	-	-	255-225-180
P5.0.Z.PH	05.12	PH-hardened	2850	330	0.21	205-185-165	175-140-90	-	-	-	-	180-160-130
P5.0.Z.HT	05.13	Hardened	2350	330	0.21	215-190-170	200-160-100	-	-	-	-	185-165-135
Austenitic												
M1.0.Z.AQ	05.21	Non-hardened	1950	200	0.21	265-240-215	-	-	-	-	-	250-225-180
M1.0.Z.PH	05.22	PH-hardened	2850	330	0.21	200-175-160	-	-	-	-	-	170-155-125
M2.0.Z.AQ	05.23	Super austenitic	2250	200		-	-	-	-	-	-	-
Austenitic-ferritic (Duplex)												
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	0.21	260-235-210	-	-	-	-	-	205-185-145
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	0.21	230-205-185	-	-	-	-	-	175-155-125
Stainless steel - Cast												
Ferritic/martensitic												
P5.0.C.UT	15.11	Non-hardened	1700	200	0.25	255-230-205	230-185-120	-	-	-	-	225-200-160
P5.0.C.PH	15.12	PH-hardened	2450	330	0.25	180-160-145	150-120-80	-	-	-	-	155-140-115
P5.0.C.HT	15.13	Hardened	2150	330	0.25	195-175-155	180-145-90	-	-	-	-	170-155-120
M1.0.C.UT	15.21	Non hardened	1800	200	0.25	255-225-205	-	-	-	-	-	235-210-170
M1.0C.PH	15.22	PH-hardened	2450	330	0.25	180-160-145	-	-	-	-	-	160-140-115
M2.0.C.AQ	15.23	Super austenitic	2150	200		-	-	-	-	-	-	-
Austenitic-ferritic (Duplex)												
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	0.25	245-220-195	-	-	-	-	-	195-175-140
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	0.25	215-190-170	-	-	-	-	-	160-145-115
ISO K			Specific cutting force k_{c1}	Hardness Brinell		CB50		CC6190		GC1010		
MC No.	CMC No.	Material		N/mm ²	HB	mc	Max chip thickness, h_{ex} mm					
							0.1 - 0.15 - 0.2		0.1 - 0.2 - 0.3		0.1 - 0.2 - 0.3	
Cutting speed v_c , m/min												
Malleable cast iron												
K1.1.C.NS	07.1	Ferritic (short chipping)	790	130	0.28	-	1300-1050-880	-	-	-	-	225-185-150
K1.1.C.NS	07.2	Pearlitic (long chipping)	900	230	0.28	-	1100-890-730	-	-	-	-	185-155-125
Grey cast iron												
K2.1.C.UT	08.1	Low tensile strength	890	180	0.28	910-780-670	1600-1300-1050	-	-	-	-	245-200-165
K2.2.C.UT	08.2	High tensile strength	1100	245	0.28	850-720-620	1200-990-810	-	-	-	-	195-160-130
Nodular cast iron												
K3.1.C.UT	09.1	Ferritic	900	160	0.28	-	1000-830-680	-	-	-	-	155-125-105
K3.3.C.UT	09.2	Pearlitic	1350	250	0.28	495-420-360	840-690-570	-	-	-	-	145-120-95



Conditions:

Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

GC1130	GC4220	GC4230	GC4240	GC2030	GC2040	GC3040				
Max chip thickness, h_{ex} mm										
0.05-0.1-0.2	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.4	0.1-0.2-0.4				
Cutting speed v_c m/min										
375-340-280 335-305-250 320-290-235 275-250-205 205-185-155	490-405-330 440-360-295 415-340-280 365-300-245 270-220-180	400-330-270 360-295-245 340-280-230 295-245-200 220-180-150	340-280-230 305-250-205 290-235-195 250-205-170 185-155-125	295-240-165 265-215-145 250-205-135 220-180-120 160-130-90	295-240-165 265-215-145 250-205-135 220-180-120 160-130-90	390-320-260 350-285-235 330-270-220 290-235-195 215-175-145				
265-240-195 170-155-130	345-285-230 225-185-150	280-230-190 185-150-125	240-195-160 155-130-105	205-170-115 135-110-75	205-170-115 135-110-75	275-225-185 180-145-120				
180-165-135 150-135-110 130-120-100 80-75-60	300-245-200 215-180-145 190-155-125 120-95-80	195-160-130 160-130-110 140-115-95 85-70-60	165-135-110 135-110-90 120-100-80 75-60-50	155-130-85 125-105-70 110-90-60 70-55-38	155-130-85 125-105-70 110-90-60 70-55-38	205-170-140 170-140-115 150-125-100 95-75-65				
245-220-180 195-175-145 140-130-105	350-290-235 280-230-190 205-170-140	260-215-175 205-170-140 150-125-100	220-180-150 175-145-120 130-105-85	210-170-115 170-140-95 120-100-70	210-170-115 170-140-95 120-100-70	280-230-190 220-180-150 160-135-110				
1040	S30T	S40T	GC2030	GC2040	GC4230	GC4240	GC1010	GC1025		
Max chip thickness, h_{ex} mm										
0.05-0.15-0.25	0.05-0.15-0.25	0.1-0.2-0.3	0.05-0.15-0.25	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.3	0.05-0.1-0.2		
Cutting speed v_c m/min										
185-140-105 130-100-70 135-100-75	255-190-140 180-135-100 185-140-105	250-200-160 170-135-110 180-145-115	240-190-155 170-135-110 175-140-115	240-190-155 165-130-105 175-140-110	275-220-175 190-150-120 200-160-125	210-170-110 140-110-70 160-125-80	285-255-230 205-185-165 215-190-170	255-225-180 180-160-130 185-165-135		
180-135-100 125-95-70 125-90-70	250-185-140 170-130-95 170-125-95	210-165-135 165-130-105 145-115-95	235-190-150 165-130-105 -	200-160-130 160-125-100 -	- - -	185-150-95 135-105-70 -	265-240-215 200-175-160 170-125-95	250-225-180 170-155-125 -		
150-115-85 125-95-70	205-155-115 175-130-95	175-140-110 140-115-90	195-155-125 165-130-105	170-135-105 135-110-85	- -	170-135-85 135-110-70	260-240-215 230-205-185	205-185-145 170-155-125		
165-125-90 115-85-65 125-90-70	225-165-125 155-115-85 170-125-95	220-175-140 150-120-95 165-135-105	215-170-135 150-120-95 160-130-105	210-170-135 145-115-90 160-130-100	245-195-155 165-130-105 180-145-115	185-150-95 120-100-65 145-115-75	255-230-205 180-160-145 195-175-155	225-200-160 155-140-115 170-155-120		
175-130-95 115-85-65 110-85-60	235-175-130 160-115-85 155-115-85	200-160-130 150-120-95 130-105-85	225-180-145 150-120-95 -	190-155-125 145-115-90 -	- - -	180-140-90 125-100-65 -	255-225-205 180-160-145 -	235-210-170 160-140-115 -		
145-105-80 115-85-65	195-15-110 160-120-90	165-130-105 135-105-85	185-150-120 150-120-95	160-125-100 130-100-80	- -	160-125-80 125-100-65	245-220-195 215-190-170	195-175-140 160-145-115		
GC3220	GC3330	GC3040	K20W	GC4230	GC4240	GC1020	H13A	K20D	K20M	K15W
Max chip thickness, h_{ex} mm										
0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.4	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
Cutting speed v_c m/min										
265-220-180 220-180-150	260-215-145 215-175-120	240-195-135 200-165-110	225-185-150 185-150-125	215-175-145 175-145-120	195-160-130 160-130-110	205-170-140 170-140-115	120-105-75 100-85-65	265-220-180 220-180-150	255-210-170 210-170-140	- -
290-240-195 235-190-155	285-235-155 225-185-125	260-215-145 210-170-115	245-200-165 195-160-130	230-190-155 185-155-125	215-175-145 170-140-115	225-185-150 180-145-120	130-110-85 105-90-65	290-240-195 235-190-155	275-225-185 220-180-150	245-200-165 195-160-130
180-150-125 170-140-115	280-230-155 225-185-125	165-135-90 150-125-85	155-125-105 140-115-95	145-120-100 135-110-90	135-110-90 125-100-85	140-115-95 130-105-90	80-70-50 75-65-50	180-150-125 170-140-115	175-140-115 160-130-110	- -

Milling with large engagement, metric values

ISO N	MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	mc	CD10	H10	CT530
							Max chip thickness, h_{ex} mm		
							0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2
							Cutting speed v_c , m/min		
N1.2.Z.UT	30.11		Aluminium alloys Wrought or wrought and coldworked, non-aging	400	60		1900-1750-1600	940-870-810	1050-960-890
N1.2.Z.AG	30.12		Aluminium alloys Wrought or wrought and aged	650	100		1700-1550-1450	850-780-730	930-860-800
N1.3.C.UT	30.21		Aluminium alloys Cast, non-aging	600	75	0.25	1900-1750-1600	940-870-810	1050-960-890
N1.3.C.AG	30.22		Aluminium alloys Cast or cast and aged	700	90	0.25	1700-1550-1450	850-790-730	930-860-800
N1.1.Z.UT	30.3		Aluminium alloys Al >99%	350	30		1900-1750-1600	950-880-810	1050-960-890
N1.4.C.NS	30.41		Aluminium alloys Cast, 13-15% Si	700	130		760-700-650	380-350-325	415-385-355
	30.42		Aluminium alloys Cast, 16-22% Si	700	130		570-530-485	285-265-245	310-290-270
N3.3.U.UT	33.1		Copper and copper alloys Free cutting alloys, ≥1% Pb	550	110	0.25	940-870-810	470-435-405	520-480-445
N3.2.C.UT	33.2		Copper and copper alloys Brass, leaded bronzes, ≤1% Pb	550	90		940-870-810	470-435-405	520-480-445
N3.1.U.UT	33.3		Copper and copper alloys Bronze and non-leaded copper incl. electrolytic copper	1350	100	0.25	660-610-570	330-305-285	365-335-310

ISO S	MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	mc	GC1025	GC1130	H13A
							Max chip thickness, h_{ex} mm		
							0.05 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2
							Cutting speed v_c , m/min		
S1.0.U.AN	20.11		Heat resistant super alloys Iron base Annealed or solution treated	2400	200	0.25	60-55-50	60-55-50	60-55-50
S1.0.U.AG	20.12		Heat resistant super alloys Iron base Aged or solution treated and aged	2500	280	0.25	45-40-37	45-40-37	45-40-38
S2.0.Z.AN	20.21		Nickel base Annealed or solution treated	2650	250	0.25	60-55-50	60-55-50	55-55-50
S2.0.Z.AG	20.22		Nickel base Aged or solution treated and aged	2900	350	0.25	36-33-30	36-33-30	35-33-30
S2.0.C.NS	20.24		Nickel base Cast or cast and aged	3000	320	0.25	45-40-36	45-40-36	45-40-38
S3.0.Z.AN	20.31		Cobalt alloys Annealed or solution treated	2700	200	0.25	25-22-20	25-22-20	23-21-18
S3.0.Z.AG	20.32		Cobalt alloys Solution treated and aged	3000	300	0.25	18-16-14	18-16-14	17-15-13
S3.0.C.NS	20.33		Cobalt alloys Cast or cast and aged	3100	320	0.25	16-14-13	16-14-13	16-14-13
S4.1.Z.UT	23.1		Titanium alloys ¹⁾ Commercial pure (99.5% Ti)	1300	Rm ²⁾ 400	0.23	125-115-105	125-115-105	125-115-110
S4.2.Z.AN	23.21		Titanium alloys ¹⁾ α , near α and $\alpha + \beta$ alloys, annealed	1400	950	0.23	55-50-45	55-50-45	50-45-45
S4.3.Z.AG	23.22		Titanium alloys ¹⁾ $\alpha + \beta$ alloys in aged cond., β alloys, annealed or aged	1400	1050	0.23	45-40-36	45-40-36	38-36-33

ISO H	MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	mc	CB50	CT530	GC4220
							Max chip thickness, h_{ex} mm		
							0.07 - 0.12 - 0.2	0.07 - 0.12 - 0.2	0.1 - 0.15 - 0.25
							Cutting speed v_c , m/min		
H1.3.Z.HA	04.1		Extra hard steel Hardened and tempered	4200	59 HRC	0.25	160-140-115	80-75-55	55-45-36
H2.0.C.UT	10.1		Chilled cast iron Cast or cast and aged	2250	400	0.28	310-270-215	155-140-110	100-90-70

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.
 2) Rm = ultimate tensile strength measured in MPa.



Conditions:
 Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

GC1130	H10F	H13A	GC1025					
Max chip thickness, h_{ex} mm								
0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1-0.15-0.2					
Cutting speed v_c, m/min								
990-910-850	940-870-810	750-700-650	990-910-850					
890-820-760	850-780-730	680-630-580	890-820-760					
990-910-850	940-870-810	750-700-650	990-910-850					
990-920-850	850-790-730	680-630-580	990-920-850					
990-920-850	950-880-810	760-700-650	990-920-850					
395-370-340	380-350-325	300-280-260	395-370-340					
300-275-255	285-265-245	225-210-195	300-275-255					
495-460-425	470-435-405	375-350-325	495-460-425					
495-460-425	470-435-405	375-350-325	495-460-425					
345-320-295	330-305-285	265-245-225	345-320-295					
H10F								
S30T								
S40T								
GC2030								
GC2040								
GC1010								
Max chip thickness, h_{ex} mm								
0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.05 - 0.15 - 0.2	0.1 - 0.15 - 0.25	0.1-0.15-0.2			
Cutting speed v_c, m/min								
55-50-45	-	-	55-50-45	60-55-45	-			
40-37-35	-	-	40-38-34	45-39-32	-			
50-50-45	-	-	55-50-45	55-50-40	-			
32-30-27	-	-	34-31-28	35-31-26	-			
40-37-34	-	-	40-37-34	40-38-31	-			
22-19-17	-	-	23-21-18	23-21-17	-			
15-14-12	-	-	17-15-13	17-15-12	-			
14-13-12	-	-	15-14-12	15-14-11	-			
115-105-100	150-135-125	125-115-110	120-105-95	120-110-100	150-135-125			
45-40-38	65-60-55	45-40-39	50-45-39	45-39-36	65-60-55			
34-31-29	50-50-45	38-36-33	40-37-34	37-33-30	55-50-45			
GC3040								
GC1010								
GC1130								
GC1025								
Max chip thickness, h_{ex} mm								
0.1 - 0.2 - 0.25	0.07 - 0.12 - 0.2	0.07-0.12-0.2	0.07-0.12-0.2					
Cutting speed v_c, m/min								
45-33-29	110-95-80	40-36-29	40-36-29					
85-65-55	215-185-150	75-70-55	75-70-55					

Milling with small engagement, metric values

ISO P			Specific cutting force k_{c1}	Hardness Brinell	mc	CT530	GC1010	GC3040
MC No.	CMC No.	Material				Max chip thickness, h_{ex} mm		
						0.1 - 0.15 - 0.2	0.05 - 0.1 - 0.2	0.1-0.15-0.3
						Cutting speed v_c , m/min		
Steel								
Unalloyed								
P1.1.Z.AN	01.1	C = 0.1-0.25%	1500	125	0.25	500-490-475	-	455-445-415
P1.2.Z.AN	01.2	C = 0.25-0.55%	1600	150	0.25	450-440-430	-	410-400-375
P1.3.Z.AN	01.3	C = 0.55-0.80%	1700	170	0.25	425-415-405	-	385-375-350
P1.3.Z.AN	01.4		1800	210	0.25	370-360-355	-	335-330-305
P1.3.Z.HT	01.5		2000	300	0.25	275-265-260	-	250-245-225
Low-alloy (alloying elements ≤5%)								
P2.1.Z.AN	02.1	Non-hardened	1700	175	0.25	350-345-335	-	320-310-290
P2.5.Z.HT	02.2	Hardened and tempered	1900	300	0.25	230-225-220	-	205-205-190
High-alloy (alloying elements >5%)								
P3.0.Z.AN	03.11	Annealed	1950	200	0.25	265-260-255	195-190-185	240-235-220
P3.1.Z.AN	03.13	Hardened tool steel	2150	200	0.25	220-215-210	160-160-150	200-195-185
P3.0.Z.HT	03.21		2900	300	0.25	190-190-185	140-140-135	175-170-160
P3.0.Z.HT	03.22		3100	380	0.25	120-120-115	90-85-85	110-105-100
Castings								
P1.5.C.UT	06.1	Unalloyed	1400	150	0.25	355-350-340	265-255-245	325-315-295
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	0.25	285-280-275	210-205-195	260-255-235
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	1950	200	0.25	210-205-200	155-150-145	190-185-175
ISO M			Specific cutting force k_{c1}	Hardness Brinell	mc	CT530	GC1130	GC1025
MC No.	CMC No.	Material				Max chip thickness, h_{ex} mm		
						0.1 - 0.15 - 0.2	0.05 - 0.1 - 0.2	0.05-0.1-0.2
						Cutting speed v_c , m/min		
Stainless steel								
Ferritic/martensitic								
P5.0.Z.AN	05.11	Non-hardened	1800	200	0.21	340-335-325	275-270-255	275-270-255
P5.0.Z.PH	05.12	PH-hardened	2850	330	0.21	245-240-235	195-190-180	195-190-180
P5.0.Z.HT	05.13	Hardened	2350	330	0.21	255-250-240	200-195-190	200-195-190
Austenitic								
M1.0.Z.AQ	05.21	Non-hardened	1950	200	0.21	320-310-300	270-265-255	270-265-255
M1.0.Z.PH	05.22	PH-hardened	2850	330	0.21	235-230-225	190-185-175	190-185-175
M2.0.Z.AQ	05.23	Super austenitic	2250	200		-	-	-
Austenitic-ferritic (Duplex)								
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	0.21	310-300-295	225-220-210	225-220-210
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	0.21	275-270-260	190-185-175	190-185-175
Stainless steel - Cast								
Ferritic/martensitic								
P5.0.C.UT	15.11	Non-hardened	1700	200	0.25	305-295-290	245-240-230	245-240-230
P5.0C.PH	15.12	PH-hardened	2450	330	0.25	215-210-205	170-170-160	170-170-160
P5.0.C.HT	15.13	Hardened	2150	330	0.25	235-225-220	185-180-175	185-180-175
Austenitic								
M1.0.C.UT	15.21	Austenitic	1800	200	0.25	300-295-285	260-250-240	260-250-240
M1.0C.PH	15.22	PH-hardened	2450	330	0.25	215-210-205	170-170-160	170-170-160
M2.0.C.AQ	15.23	Super austenitic	2150	200		-	-	-
Austenitic-ferritic (Duplex)								
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	0.25	295-285-280	215-205-195	215-205-195
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	0.25	255-250-245	175-170-165	175-170-165
ISO K			Specific cutting force k_{c1}	Hardness Brinell	mc	CB50	CC6190	K20D
MC No.	CMC No.	Material				Max chip thickness, h_{ex} mm		
						0.1 - 0.15 - 0.2	0.1 - 0.2 - 0.3	0.1-0.2-0.3
						Cutting speed v_c , m/min		
Malleable cast iron								
K1.1.C.NS	07.1	Ferritic (short chipping)	790	130	0.28	-	1500-1450-1400	305-290-280
	07.2	Pearlitic (long chipping)	900	230	0.28	-	1250-1200-1150	250-240-230
Grey cast iron								
K2.1.C.UT	08.1	Low tensile strength	890	180	0.28	1150-1100-1100	1850-1750-1700	285-270-260
K2.2.C.UT	08.2	High tensile strength	1100	245	0.28	1100-1050-1000	1400-1350-1300	225-215-210
Nodular cast iron								
K3.1.C.UT	09.1	Ferritic	900	160	0.28	-	1200-1150-1100	210-205-200
K3.3.C.UT	09.2	Pearlitic	1350	250	0.28	630-610-590	980-930-890	195-195-185

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.



Conditions:
Side milling, cutter dia. 25 mm.
Working engagement 10 mm.

GC1025	GC1130	GC4220	GC4230	GC4240	GC2030	GC2040				
Max chip thickness, h_{ex} mm										
0.05-0.1-0.2	0.05-0.1-0.2	0.1-0.15-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.05-0.15-0.25	0.1-0.2-0.3				
Cutting speed v_c, m/min										
365-360-345 330-325-310 310-305-290 270-265-255 200-195-190	405-395-380 365-355-340 345-335-320 300-295-280 220-220-210	570-560-520 510-500-470 485-475-445 425-415-390 310-305-285	465-445-425 420-400-385 395-380-360 345-330-315 255-245-235	395-380-360 355-340-325 335-320-310 295-280-270 220-210-200	340-335-320 305-300-290 290-280-270 255-250-240 185-185-175	340-325-315 305-295-280 290-275-265 255-245-235 185-180-170				
300-295-285 170-165-160	285-280-265 185-180-175	400-390-365 260-255-240	325-315-300 215-205-195	280-265-255 180-175-165	240-235-225 155-155-145	240-230-220 155-150-145				
195-190-185 160-160-150 140-140-135 90-85-85	195-190-185 160-160-150 140-140-135 90-85-85	350-340-320 250-245-230 220-215-200 135-135-125	225-215-205 185-180-170 165-155-150 100-95-95	190-185-175 160-150-145 140-135-125 85-85-80	180-175-170 150-145-140 130-125-120 80-80-75	180-175-165 150-140-135 130-125-120 80-75-75				
265-255-245 210-205-195 155-150-145	265-255-245 210-205-195 155-150-145	410-400-375 325-320-295 240-235-220	305-290-280 240-230-220 175-170-160	255-245-235 205-195-190 150-145-140	240-235-225 195-190-185 145-140-135	240-230-220 195-185-180 145-135-130				
GC1040										
S30T										
S40T										
GC2030										
GC2040										
GC4230										
GC4240										
M30B										
GC1010										
Max chip thickness, h_{ex} mm										
0.05-0.15-0.25										
0.05-0.15-0.25										
0.1-0.2-0.25										
0.05-0.15-0.25										
0.1-0.2-0.25										
0.1-0.2-0.25										
0.1-0.2-0.25										
0.1-0.2-0.3										
0.1-0.2-0.4										
0.05-0.1-0.2										
Cutting speed v_c, m/min										
210-195-185 145-140-130 155-145-135	285-265-250 200-185-175 210-195-180	295-280-275 205-195-275 215-205-200	260-250-235 185-175-170 195-185-175	285-270-265 195-185-180 205-195-190	325-310-305 225-215-210 235-225-220	250-240-225 165-160-150 190-180-170	275-270-255 195-190-180 200-195-190	340-335-325 245-240-235 255-250-240		
205-190-175 140-135-125 140-130-120	280-260-245 190-180-170 190-180-170	250-235-230 195-185-180 175-165-160	255-245-230 180-170-160 -	240-225-220 190-180-175 -	- - -	220-210-200 160-150-145 -	- - -	320-310-300 235-230-225 190-180-170		
170-160-150 140-130-125	230-215-200 195-180-170	205-195-190 165-160-155	215-205-195 180-170-160	200-190-185 160-155-150	- -	200-190-180 160-155-145	- -	310-300-295 275-270-260		
185-175-165 130-120-110 185-175-170	250-235-220 175-165-155 190-180-165	2-250-235 180-170-165 200-190-185	235-225-210 160-155-145 175-165-160	250-240-235 170-165-160 190-180-175	290-275-270 195-185-185 215-205-200	225-210-200 145-140-130 175-165-155	245-240-230 170-170-160 185-180-175	305-295-290 215-210-205 235-225-220		
195-180-170 130-120-110 125-120-110	265-250-235 175-165-155 175-160-150	240-225-220 180-170-165 155-145-145	245-230-220 160-155-145 -	230-215-210 170-165-160 -	- - -	210-200-190 145-140-130 -	- - -	300-295-285 215-210-205 -		
160-150-140 130-125-115	220-205-190 180-170-160	195-185-180 160-150-145	205-195-185 165-160-150	190-180-175 150-145-140	- -	190-180-170 150-140-135	- -	295-285-280 255-250-245		
GC3220										
GC3330										
GC3040										
K20W										
GC4230										
GC4240										
GC1020										
H13A										
GC1010										
K20M										
K15W										
Max chip thickness, h_{ex} mm										
0.1-0.15-0.25										
0.1-0.2-0.3										
0.1-0.2-0.3										
0.1-0.2-0.3										
0.1-0.15-0.25										
0.1-0.15-0.25										
0.1-0.2-0.3										
0.1-0.2-0.3										
Cutting speed v_c, m/min										
310-305-290 255-250-240	305-290-280 250-240-230	280-270-255 230-220-210	260-250-240 215-205-195	250-245-235 205-200-190	225-220-210 185-185-175	240-230-220 195-190-180	135-130-125 110-110-105	250-245-235 205-200-190	295-290-275 245-240-225	- -
340-330-315 270-265-255	330-315-300 265-255-240	305-290-280 245-235-225	285-270-260 225-215-210	270-265-255 215-210-205	250-240-230 200-195-185	260-250-240 205-200-190	145-140-140 120-115-110	270-265-255 215-210-205	320-315-300 260-250-240	285-270-260 225-215-210
210-205-200 195-195-185	330-315-300 265-255-240	190-185-175 175-170-160	180-170-165 165-160-150	170-165-160 155-155-145	155-150-145 145-140-135	160-155-150 150-145-140	95-90-85 85-85-80	170-165-160 155-155-145	200-195-190 185-185-175	- -

Milling with small engagement, metric values

ISO N	MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	mc	CD10	CT530	H10
							Max chip thickness, h_{ex} mm		
							Cutting speed v_c , m/min		
			Aluminium alloys						
N1.2.Z.UT	30.11		Wrought or wrought and coldworked, non-aging	400	60		2100-2100-2050	1150-1150-1100	1050-1050-1000
N1.2.Z.AG	30.12		Wrought or wrought and aged	650	100		1900-1850-1850	1050-1050-1000	950-940-920
			Aluminium alloys						
N1.3.C.UT	30.21		Cast, non-aging	600	75	0.25	2100-2100-2050	1150-1150-1000	1050-1050-1000
N1.3.C.AG	30.22		Cast or cast and aged	700	90	0.25	1900-1900-1850	1050-1050-1100	950-940-920
			Aluminium alloys						
N1.1.Z.UT	30.3		Al >99%	350	30		2150-2100-2050	1150-1150-1150	1050-1050-1050
			Aluminium alloys						
N1.4.C.NS	30.41	30.42	Cast, 13-15% Si Cast, 16-22% Si	700 700	130 130		850-840-820 640-630-620	470-460-450 350-345-340	425-420-410 320-315-310
			Copper and copper alloys						
N3.3.U.UT	33.1		Free cutting alloys, ≥1% Pb	550	110	0.25	1050-1050-1050	580-570-560	530-520-510
N3.2.C.UT	33.2		Brass, leaded bronzes, ≤1% Pb	550	90		1050-1050-1000	580-570-560	530-520-510
N3.1.U.UT	33.3		Bronze and non-leaded copper incl. electrolytic copper	1350	100	0.25	740-730-720	410-400-395	370-365-360
ISO S	MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	mc	GC1025	GC1130	GC1010
			Heat resistant super alloys						
			Iron base						
S1.0.U.AN	20.11		Annealed or solution treated	2400	200	0.25	70-70-70	70-70-70	-
S1.0.U.AG	20.12		Aged or solution treated and aged	2500	280	0.25	55-50-50	55-50-50	-
			Nickel base						
S2.0.Z.AN	20.21		Annealed or solution treated	2650	250	0.25	70-65-65	70-65-65	-
S2.0.Z.AG	20.22		Aged or solution treated and aged	2900	350	0.25	45-40-40	45-40-40	-
S2.0.C.NS	20.24		Cast or cast and aged	3000	320	0.25	55-50-50	55-50-50	-
			Cobalt alloys						
S3.0.Z.AN	20.31		Annealed or solution treated	2700	200	0.25	30-29-28	30-29-28	-
S3.0.Z.AG	20.32		Solution treated and aged	3000	300	0.25	21-20-20	21-20-20	-
S3.0.C.NS	20.33		Cast or cast and aged	3100	320	0.25	20-19-18	20-19-18	-
			Titanium alloys¹⁾		Rm¹⁾				
S4.1.Z.UT	23.1		Commercial pure (99,5% Ti)	1300	400	0.23	150-145-140	150-145-140	170-165-160
S4.2.Z.AN	23.21		α, near α and α + β alloys, annealed	1400	950	0.23	65-65-65	65-65-65	75-75-70
S4.3.Z.AG	23.22		α + β alloys in aged cond., β alloys, annealed or aged	1400	1050	0.23	55-50-50	55-50-50	65-60-66
ISO H	MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	mc	CB50	CT530	GC1025
			Extra hard steel						
H1.3.Z.HA	04.1		Hardened and tempered	4200	59 HRC	0.25	190-180-175	95-90-85	45-45-45
			Chilled cast iron						
H2.0.C.UT	10.1		Cast or cast and aged	2250	400	0.28	355-345-330	180-175-165	90-85-85

- 1) 45-60° entering angle. Positive cutting geometry and coolant should be used.
- 2) Rm = ultimate tensile strength measured in MPa.



Conditions:
Side milling, cutter dia. 25 mm.
Working engagement 10 mm.

GC1025	GC1130	H10F	H13A						
Max chip thickness, h_{ex} mm									
0.1-0.15-0.2	0.1-0.15-0.2	0.1-0.15-0.2	0.1-0.15-0.2						
Cutting speed v_c m/min									
1100-1100-1050	1100-1100-1050	1050-1050-1000	850-830-820						
1000-980-970	1000-980-970	950-940-920	760-750-740						
1100-1100-1050	1100-1100-1050	1050-1050-1000	850-830-820						
110-1100-1100	1100-1100-1100	950-940-920	760-750-740						
1100-1100-1100	1100-1100-1100	1050-1050-1050	850-840-825						
445-440-430	445-440-430	425-420-410	340-335-330						
335-330-325	335-330-325	320-315-310	255-250-245						
560-550-540	560-550-540	530-520-510	425-415-410						
560-550-540	560-550-540	530-520-510	425-415-410						
390-380-375	390-380-375	370-365-360	295-290-285						
H13A H10F S30T S40T GC2030 GC2040									
Max chip thickness, h_{ex} mm									
0.1-0.15-0.2	0.1-0.2-0.3	0.1-0.15-0.2	0.1-0.15-0.2	0.05-0.15-0.2	0.05-0.15-0.25				
Cutting speed v_c m/min									
65-65-65	60-60-60	-	-	65-65-65	70-65-65				
50-50-50	45-45-40	-	-	50-50-45	50-50-45				
65-65-60	60-55-55	-	-	65-60-60	65-65-60				
40-39-38	36-35-33	-	-	40-38-38	40-39-38				
50-50-50	45-45-40	-	-	50-45-45	50-50-45				
28-27-26	26-24-23	-	-	28-27-26	28-27-26				
20-19-19	18-17-16	-	-	20-19-19	20-19-19				
19-19-18	17-16-16	-	-	19-18-17	19-18-17				
140-140-135	130-125-120	170-165-160	145-145-140	140-135-130	145-140-135				
55-55-55	50-50-45	75-75-70	55-50-50	55-55-55	50-50-50				
45-40-40	38-37-36	65-60-66	45-45-45	50-45-45	45-40-40				
GC4220 GC3040 GC1010 GC1130									
Max chip thickness, h_{ex} mm									
0.1-0.12-0.25	0.1-0.2-0.25	0.07-0.12-0.2	0.07-0.12-0.2						
Cutting speed v_c m/min									
65-65-60	55-50-50	130-125-120	45-45-45						
125-125-115	100-95-95	250-240-230	90-85-85						

Milling with large engagement, inch values

ISO P	MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	mc	Cutting speed v_c , ft/min		
							CT530	GC1010	GC2040
							Max chip thickness, h_{ex} inch .004 - .006 - .008 .002 - .004 - .008 .004 - .008 - .016		
							Cutting speed v_c , ft/min		
P1.1.Z.AN	01.1		Steel Unalloyed C = 0.10 - 0.25%	216,500	125	0.25	1400-1250-1150	-	960-780-520
P1.2.Z.AN	01.2		C = 0.25 - 0.55%	233,000	150	0.25	1250-1150-1050	-	860-700-470
P1.3.Z.AN	01.3		C = 0.55 - 0.80%	247,000	170	0.25	1200-1050-970	-	810-660-440
P1.3.Z.AN	01.4			260,500	210	0.25	1050-940-850	-	710-580-390
P1.3.Z.HT	01.5			291,500	300	0.25	770-690-630	-	520-430-285
P2.1.Z.AN	02.1		Low alloyed (alloying elements ≤ 5%) Non-hardened	246,500	175	0.25	980-890-800	-	670-550-370
P2.5.Z.HT	02.2		Hardened and tempered	278,500	300	0.25	640-580-520	-	440-360-240
P3.0.Z.AN	03.11		High alloyed (alloying elements > 5%) Annealed	282,000	200	0.25	740-670-610	590-540-440	510-415-275
P3.1.Z.AN	03.13		Hardened tool steel	311,000	200	0.25	620-560-500	490-445-360	415-340-225
P3.0.Z.HT	03.21			420,000	300	0.25	540-485-440	430-390-315	365-300-200
P3.0.Z.HT	03.22			448,500	380	0.25	340-305-275	270-245-200	225-185-125
P1.5.C.UT	06.1		Castings Unalloyed	204,000	150	0.25	1000-910-820	800-720-590	680-560-370
P2.6.C.UT	06.2		Low alloyed (alloying elements ≤ 5%)	230,500	200	0.25	800-720-650	630-570-470	550-445-300
P3.0.C.UT	06.3		High alloyed (alloying elements > 5%)	283,500	200	0.25	580-530-475	465-420-345	400-325-220
ISO M	MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	mc	Cutting speed v_c , ft/min		
							CT530	GC1025	M30B
							Max chip thickness, h_{ex} inch .004 - .006 - .008 .002 - .004 - .008 .004 - .006 - .008		
							Cutting speed v_c , ft/min		
P5.0.Z.AN	05.11		Stainless steel Ferritic/martensitic Non-hardened	262,000	200	0.21	940-830-740	830-740-590	860-680-430
P5.0.Z.PH	05.12		PH-hardened	411,500	330	0.21	670-600-530	590-520-415	560-450-285
P5.0.Z.HT	05.13		Hardened	340,000	330	0.21	700-620-550	610-540-430	640-510-325
M1.0.Z.AQ	05.21		Austenitic Non-hardened	285,000	200	0.21	870-780-690	820-730-580	-
M1.0.Z.PH	05.22		PH-hardened	414,000	330	0.21	640-580-510	560-500-400	-
M2.0.Z.AQ	05.23		Super austenitic	328,000	200		-	-	-
M3.1.Z.AQ	05.51		Austenitic-ferritic (Duplex) Non-weldable ≥ 0.05%C	286,500	230	0.21	850-760-680	670-600-475	-
M3.2.Z.AQ	05.52		Weldable < 0.05%C	356,500	260	0.21	750-670-600	570-510-405	-
P5.0.C.UT	15.11		Stainless steel - Cast Ferritic/martensitic Non-hardened	246,500	200	0.25	830-740-660	740-660-520	760-600-380
P5.0C.PH	15.12		PH-hardened	354,500	330	0.25	590-520-465	520-460-365	495-395-250
P5.0.C.HT	15.13		Hardened	311,000	330	0.25	640-570-510	560-500-395	590-465-295
M1.0.C.UT	15.21		Non hardened	261,000	200	0.25	830-740-660	780-690-550	-
M1.0C.PH	15.22		PH-hardened	356,000	330	0.25	590-530-470	520-460-365	-
M2.0.C.AQ	15.23		Super austenitic	310,500	200		-	-	-
M3.1.C.AQ	15.51		Austenitic-ferritic (Duplex) Non-weldable ≥ 0.05%C	258,000	230	0.25	810-720-640	640-570-450	-
M3.2.C.AQ	15.52		Weldable < 0.05%C	326,500	260	0.25	700-630-560	530-475-375	-
ISO K	MC No.	CMC No.	Material	Specific cutting force k_{c1} lbs/in ²	Hardness Brinell HB	mc	Cutting speed v_c , ft/min		
							CB50	CC6190	GC1010
							Max chip thickness, h_{ex} inch .004 - .006 - .008 .004 - .008 - .012 .004 - .008 - .012		
							Cutting speed v_c , ft/min		
K1.1.C.NS	07.1		Malleable cast iron Ferritic (short chipping)	115,000	130	0.28	-	4250-3500-2850	740-605-490
	07.2		Pearlitic (long chipping)	131,000	230	0.28	-	3550-2900-2350	605-510-410
K2.1.C.UT	08.1		Grey cast iron Low tensile strength	130,000	180	0.28	2950-2550-2150	5150-4200-3450	800-655-540
K2.2.C.UT	08.2		High tensile strength	159,500	245	0.28	2750-2350-2000	3900-3200-2600	640-525-425
K3.1.C.UT	09.1		Nodular cast iron Ferritic	130,000	160	0.28	-	3300-2700-2200	510-410-345
K3.3.C.UT	09.2		Pearlitic	194,500	250	0.28	1600-1350-1150	2750-2250-1850	475-390-310

4.000 inch
(100mm)



5.000 inch
(125mm)

Conditions:

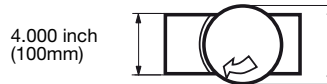
Cutter, dia. 5.000 inch (125 mm)
Working engagement
4.000 inch (100 mm)

GC1025	GC1130	GC4220	GC4230	GC4240	GC3040	GC2030				
Max chip thickness, h_{ex} inch										
.002-.004-.008	.002-.004-.008	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.008-.016				
Cutting speed v_c ft/min										
1100-1000-820 1000-910-740 950-860-700 820-750-610 610-550-450	1250-1100-910 1100-1000-820 1050-940-770 910-820-670 670-610-500	1600-1300-1050 1450-1200-960 1350-1100-910 1200-970-790 880-720-590	1300-1050-870 1150-960-780 1100-900-740 970-790-650 710-580-475	1100-910-740 1000-820-670 940-770-630 820-670-550 610-500-405	1250-1050-850 1150-930-760 1100-880-720 940-770-630 700-570-465	960-780-520 860-700-470 810-660-440 710-580-390 520-430-285				
920-830-680 510-460-375	860-780-640 560-510-415	1100-920-750 730-600-490	920-750-610 600-490-400	780-640-520 510-415-340	890-730-600 580-475-390	670-550-370 440-360-240				
590-540-440 490-445-360 430-390-315 270-245-200	590-540-440 490-445-360 430-390-315 270-245-200	970-800-650 710-580-475 610-500-410 385-315-255	630-510-420 520-430-350 455-370-305 285-235-190	540-440-360 445-360-295 390-315-260 245-200-160	680-550-450 560-460-375 490-400-325 305-250-205	510-415-275 415-340-225 365-300-200 225-185-125				
800-720-590 630-570-470 465-420-345	800-720-590 630-570-470 465-420-345	1150-940-770 910-740-610 670-550-445	850-690-570 680-550-450 495-405-330	720-590-480 570-470-385 420-345-280	910-740-610 720-590-485 530-435-355	680-560-370 550-445-300 400-325-220				
GC1130 1040 S30T S40T GC2030 GC2040 GC4230 GC4240 GC1010										
Max chip thickness, h_{ex} inch										
.002-.004-.008	.002-.006-.010	.002-.006-.010	.004-.008-.012	.002-.006-.010	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.008-.016	.004-.006-.008	
Cutting speed v_c ft/min										
830-740-590 590-520-415 610-540-430	610-450-330 430-315-235 445-330-245	830-610-450 580-430-320 610-445-330	810-650-510 560-445-355 590-470-375	790-630-500 560-445-350 580-460-365	780-620-495 540-425-340 570-450-360	900-710-570 620-490-390 640-510-410	690-550-345 455-365-230 520-410-260	940-830-740 670-600-530 700-620-550		
820-730-580 560-500-400 -	590-435-325 415-305-225 405-300-220	810-600-445 560-415-305 560-415-305	680-540-430 540-425-340 475-375-300	770-610-485 540-425-340 -	660-520-415 520-410-325 -	- -	610-485-305 440-350-220 -	870-780-690 640-580-510 560-415-305		
670-600-475 570-510-405	495-365-270 410-305-225	670-495-365 570-420-310	570-450-360 460-365-290	640-510-405 540-425-340	550-435-345 440-350-280	- -	550-435-275 440-350-220	850-760-680 750-670-600		
740-660-520 520-460-365 560-500-395	540-400-295 375-275-200 405-300-220	730-540-400 510-380-280 560-410-305	720-570-455 490-390-310 540-430-345	700-560-445 485-385-305 530-420-335	690-550-440 470-375-295 520-415-330	800-630-500 540-430-340 590-470-375	610-485-305 400-320-200 475-375-240	830-740-660 590-520-465 640-570-510		
780-690-550 520-460-365 -	560-415-310 365-270-200 365-270-200	770-570-425 520-380-280 500-370-275	650-520-415 490-390-310 425-340-270	730-580-465 485-385-305 -	630-500-395 470-375-300 -	- -	580-460-290 400-320-200 -	830-740-660 590-530-470 -		
640-570-450 530-475-375	470-350-255 385-285-210	640-470-345 530-390-290	540-430-340 430-345-275	610-485-385 495-395-315	520-410-325 415-330-265	- -	520-415-260 410-325-205	810-720-640 700-630-560		
GC3220 GC3330 GC3040 K20W GC4230 GC4240 GC1020 H13A K20D K20M K15W										
Max chip thickness, h_{ex} inch										
.004-.008-.012	.004-.008-.016	.004-.008-.016	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.008-.016	.004-.008-.016	.004-.008-.012	.004-.008-.012	.004-.008-.012
Cutting speed v_c ft/min										
870-710-580 720-590-480	850-700-465 700-570-380	790-640-430 650-530-355	730-600-490 600-495-405	700-570-465 570-470-385	630-520-425 520-430-350	670-550-445 550-450-370	395-335-245 325-280-205	870-710-580 720-590-480	835-690-560 690-560-460	- -
950-780-630 760-620-510	930-760-510 740-610-405	850-700-465 680-560-375	800-650-530 640-520-425	760-620-510 610-495-405	690-570-465 550-455-370	730-600-485 580-475-390	430-365-270 340-290-215	950-780-630 760-620-510	900-740-605 720-590-490	800-650-530 640-520-425
590-485-395 550-450-370	920-750-500 740-610-405	530-435-290 495-405-270	500-410-335 465-380-310	475-390-320 440-360-295	435-355-290 405-330-270	455-370-305 425-350-285	270-230-170 250-215-155	590-485-395 550-450-370	575-460-380 525-424-360	- -

Milling with large engagement, inch values

ISO N			Specific cutting force k_{c1}	Hardness Brinell		CD10			H10	H13A
MC No.	CMC No.	Material		lbs/in ²	HB	mc	Max chip thickness, h_{ex} inch			
							.004-.006-.008	.004-.006-.008	.004-.006-.008	
						Cutting speed v_c , ft/min				
Aluminium alloys										
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	58,000	60		6150-5700-5250	3050-2850-2650	2450-2250-2100		
N1.2.Z.AG	30.12	Wrought or wrought and aged	94,500	100		5550-5100-4750	2750-2550-2350	2200-2050-1900		
Aluminium alloys										
N1.3.C.UT	30.21	Cast, non-aging	87,000	75	0.25	6150-5700-5250	3050-2850-2650	2450-2250-2100		
N1.3.C.AG	30.22	Cast or cast and aged	101,500	90	0.25	5550-5150-4750	2750-2550-2350	2200-2050-1900		
Aluminium alloys										
N1.1.Z.UT	30.3	Al >99%	50,500	30		6200-5700-5300	3100-2850-2650	2450-2300-2100		
Aluminium alloys										
N1.4.C.NS	30.41	Cast, 13-15% Si	101,500	130		2450-2300-2100	1250-1150-1050	990-910-850		
	30.42	Cast, 16-22% Si	101,500	130		1850-1700-1600	930-860-790	740-690-630		
Copper and copper alloys										
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	79,500	110	0.25	3100-2850-2650	1550-1450-1300	1250-1150-1050		
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	80,000	90		3100-2850-2650	1550-1400-1300	1250-1150-1050		
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	196,000	100	0.25	2150-2000-1850	1100-1000-920	860-800-740		
ISO S			Specific cutting force k_{c1}	Hardness Brinell		GC1025			GC1130	GC1010
MC No.	CMC No.	Material		lbs/in ²	HB	mc	Max chip thickness, h_{ex} inch			
							.004-.006-.008	.004-.006-.008	.004-.006-.008	
						Cutting speed v_c , ft/min				
Heat resistant super alloys										
Iron base										
S1.0.U.AN	20.11	Annealed or solution treated	348,000	200	0.25	200-180-160	200-180-160	-		
S1.0.U.AG	20.12	Aged or solution treated and aged	359,000	280	0.25	150-135-120	150-135-120	-		
Nickel base										
S2.0.Z.AN	20.21	Annealed or solution treated	383,000	250	0.25	190-170-155	190-170-155	-		
S2.0.Z.AG	20.22	Aged or solution treated and aged	420,500	350	0.25	120-105-95	120-105-95	-		
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	0.25	145-130-120	150-140-120	-		
Cobalt alloys										
S3.0.Z.AN	20.31	Annealed or solution treated	391,500	200	0.25	80-70-65	80-70-65	-		
S3.0.Z.AG	20.32	Solution treated and aged	432,000	300	0.25	55-50-45	55-50-45	-		
S3.0.C.NS	20.33	Cast or cast and aged	450,500	320	0.25	50-45-40	50-45-40	-		
Titanium alloys¹⁾				Rm²⁾						
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	188,500	400	0.23	415-375-340	415-375-340	445-380-330		
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	203,000	950	0.23	185-165-150	185-165-150	200-170-145		
S4.3.Z.AG	23.22	α + β alloys in aged cond., β alloys, annealed or aged	203,000	1050	0.23	145-130-120	145-130-120	155-135-115		
ISO H			Specific cutting force k_{c1}	Hardness Brinell		CB50			CT530	GC1130
MC No.	CMC No.	Material		lbs/in ²	HB	mc	Max chip thickness, h_{ex} inch			
							.003-.005-.008	.003-.004-.008	.003-.005-.008	
						Cutting speed v_c , ft/min				
Extra hard steel										
H1.3.Z.HA	04.1	Hardened and tempered	606,500	59 HRC	0.25	520-455-370	260-245-185	130-115-95		
Chilled cast iron										
H2.0.C.UT	10.1	Cast or cast and aged	326,500	400	0.28	990-870-700	495-465-350	250-215-175		

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.
 2) Rm = ultimate tensile strength measured in MPa.

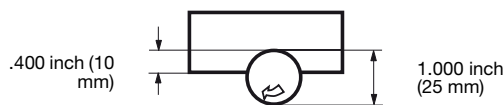


Conditions:
 Cutter, dia. 5.000 inch (125 mm) Working engagement 4.000 inch (100 mm)

CT530	GC1025	GC1130	H10F					
Max chip thickness, h_{ex} inch								
.004-.006-.008	.004-.006-.008	.004-.006-.008	.004-.006-.008					
Cutting speed v_c ft/min								
3400-3100-2900	3200-3000-2750	3200-3000-2750	3050-2850-2650					
3050-2800-2600	2900-2700-2500	2900-2700-2500	2750-2550-2350					
3400-3150-2900	3250-3000-2750	3250-3000-2750	3050-2850-2650					
3050-2800-2600	3250-3000-2750	3250-3000-2750	2750-2550-2350					
3400-3150-2900	3250-3000-2800	3250-3000-2800	3100-2850-2650					
1350-1250-1150	1300-1200-1100	1300-1200-1100	1250-1150-1050					
1000-940-870	970-900-830	970-900-830	930-860-790					
1700-1550-1450	1600-1500-1400	1600-1500-1400	1550-1450-1300					
1700-1550-1450	1600-1500-1400	1600-1500-1400	1550-1400-1300					
1200-1100-1000	1150-1050-970	1150-1050-970	1100-1000-920					
H13A								
H10F								
S30T								
S40T								
GC2030								
GC2040								
Max chip thickness, h_{ex} inch								
.004-.006-.008	.004-.006-.008	.004-.006-.008	.004-.006-.008	.004-.006-.008	.004-.006-.010			
Cutting speed v_c ft/min								
195-180-170	180-165-155	-	-	185-165-150	190-170-140			
145-130-120	130-120-115	-	-	135-125-110	140-125-105			
185-175-160	170-160-145	-	-	175-160-145	180-165-135			
115-105-100	105-95-90	-	-	110-100-90	115-100-85			
145-135-125	130-120-110	-	-	135-120-110	135-125-100			
75-65-60	70-65-55	-	-	75-65-60	75-65-55			
55-50-45	50-45-39	-	-	55-50-45	55-50-39			
50-45-40	45-40-37	-	-	50-45-39	50-45-35			
410-380-350	375-345-320	445-380-330	415-375-340	385-350-315	400-360-325			
165-150-140	145-135-125	200-170-145	150-135-125	155-140-125	140-130-115			
125-115-105	110-105-95	155-135-115	125-115-100	135-120-110	120-110-100			
GC4220								
GC3040								
GC1010								
GC1025								
Max chip thickness, h_{ex} inch								
.004-.006-.010	.004-.008-.010	.003-.005-.008	.003-.005-.008					
Cutting speed v_c ft/min								
175-150-115	140-110-95	360-310-255	130-115-95					
330-285-220	270-205-180	690-600-490	250-215-175					

Milling with small engagement, inch values

ISO P	MC No.	CMC No.	Material	Specific cutting force k_{c1}	Hardness Brinell	mc	Cutting speed v_c , ft/min		
							CT530	GC1010	GC2040
							Max chip thickness, h_{ex} inch		
			.004-.006-.008	.002-.004-.008	.004-.008-.012				
			Steel				Cutting speed v_c, ft/min		
			Unalloyed						
P1.1.Z.AN	01.1		C = 0.10 -0.25%	216,500	125	0.25	1650-1600-1550	-	1100-1050-1000
P1.2.Z.AN	01.2		C = 0.25-0.55%	233,000	150	0.25	1450-1450-1400	-	1000-960-920
P1.3.Z.AN	01.3		C = 0.55-0.80%	247,000	170	0.25	1400-1350-1350	-	950-900-860
P1.3.Z.AN	01.4			260,500	210	0.25	1200-1200-1150	-	830-800-760
P1.3.Z.HT	01.5			291,500	300	0.25	890-880-860	-	610-590-560
			Low-alloy (alloying elements ≤5%)						
P2.1.Z.AN	02.1		Non-hardened	246,500	175	0.25	1150-1100-1100	-	790-750-720
P2.5.Z.HT	02.2		Hardened and tempered	278,500	300	0.25	750-730-720	-	510-490-470
			High-alloy (alloying elements >5%)						
P3.0.Z.AN	03.11		Annealed	282,000	200	0.25	870-850-830	640-630-600	590-570-540
P3.1.Z.AN	03.13		Hardened tool steel	311,000	200	0.25	720-700-690	530-520-495	485-465-440
P3.0.Z.HT	03.21			420,000	300	0.25	630-620-600	465-455-435	425-405-390
P3.0.Z.HT	03.22			448,500	380	0.25	395-385-380	290-285-270	265-255-240
			Castings						
P1.5.C.UT	06.1		Unalloyed	204,000	150	0.25	1150-1150-1100	860-840-810	790-760-730
P2.6.C.UT	06.2		Low-alloy (alloying elements ≤5%)	230,500	200	0.25	930-910-890	690-670-640	640-610-580
P3.0.C.UT	06.3		High-alloy (alloying elements >5%)	283,500	200	0.25	680-670-650	500-490-470	465-445-425
ISO M	MC No.	CMC No.	Material	Specific cutting force k_{c1}	Hardness Brinell	mc	CT530	GC1025	M30B
							Max chip thickness, h_{ex} inch		
							.004-.006-.008	.004-.006-.008	.004-.008-.012
							Cutting speed v_c , ft/min		
			Stainless steel						
			Ferritic/martensitic						
P5.0.Z.AN	05.11		Non-hardened	262,000	200	0.21	1100-1100-1050	910-890-840	910-890-840
P5.0.Z.PH	05.12		PH-hardened	411,500	330	0.21	800-780-760	640-630-590	640-630-590
P5.0.Z.HT	05.13		Hardened	340,000	330	0.21	830-810-790	660-650-610	660-650-610
			Austenitic						
M1.0.Z.AQ	05.21		Non-hardened	285,000	200	0.21	1050-1000-990	890-870-830	-
M1.0.Z.PH	05.22		PH-hardened	414,000	330	0.21	770-750-730	620-600-570	-
M2.0.Z.AQ	05.23		Super austenitic	328,000	200		-	-	-
			Austenitic-ferritic (Duplex)						
M3.1.Z.AQ	05.51		Non-weldable ≥ 0.05%C	286,500	230	0.21	1000-990-970	740-720-680	-
M3.2.Z.AQ	05.52		Weldable < 0.05%C	356,500	260	0.21	900-880-860	620-610-580	-
			Stainless steel - Cast						
			Ferritic/martensitic						
P5.0.C.UT	15.11		Non-hardened	246,500	200	0.25	990-970-940	810-790-750	810-790-750
P5.0c.PH	15.12		PH-hardened	354,500	330	0.25	700-680-670	560-550-520	560-550-520
P5.0.C.HT	15.13		Hardened	311,000	330	0.25	760-740-720	610-590-570	610-590-570
			Austenitic						
M1.0.C.UT	15.21		Austenitic	261,000	200	0.25	990-960-940	850-830-790	-
M1.0c.PH	15.22		PH-hardened	356,000	330	0.25	700-690-670	570-550-520	-
M2.0.C.AQ	15.23		Super austenitic	310,500	200		-	-	-
			Austenitic-ferritic (Duplex)						
M3.1.C.AQ	15.51		Non-weldable ≥ 0.05%C	258,000	230	0.25	960-940-910	700-680-650	-
M3.2.C.AQ	15.52		Weldable < 0.05%C	326,500	260	0.25	840-820-800	580-560-540	-
ISO K	MC No.	CMC No.	Material	Specific cutting force k_{c1}	Hardness Brinell	mc	CB50	CC6190	GC1010
							Max chip thickness, h_{ex} inch		
							.004-.006-.008	.004-.006-.012	.004-.008-.012
							Cutting speed v_c , ft/min		
			Malleable cast iron						
			Ferritic (short chipping)	115,000	130	0.28	-	5000-4800-4550	810-800-760
K1.1.C.NS	07.1		Pearlitic (long chipping)	131,000	230	0.28	-	4100-3950-3750	670-660-630
			Grey cast iron						
K2.1.C.UT	08.1		Low tensile strength	130,000	180	0.28	3800-3650-3550	6050-5750-5500	890-870-830
K2.2.C.UT	08.2		High tensile strength	159,500	245	0.28	3550-3400-3300	4600-4400-4200	710-690-660
			Nodular cast iron						
K3.1.C.UT	09.1		Ferritic	130,000	160	0.28	-	3850-3700-3550	560-540-520
K3.3.C.UT	09.2		Pearlitic	194,500	250	0.28	2050-2000-1900	3200-3050-2900	520-500-480



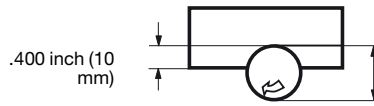
Conditions:
Side milling, cutter dia. 1.000 inch (25 mm). Working engagement .400 inch (10 mm).

GC1025	GC1130	GC4220	GC4230	GC4240	GC3040	GC2030	GC2040			
Max chip thickness, h_{ex} inch										
.002-.004-.008	.002-.004-.008	.004-.006-.012	.004-.006-.012	.004-.008-.012	.004-.006-.012	.004-.006-.010	.004-.008-.012			
Cutting speed v_c ft/min										
1200-1200-1150 1100-1050-1000 1000-1000-960 890-870-830 660-650-620	1350-1300-1250 1200-1150-1100 1150-1100-1050 980-960-920 730-710-680	1850-1850-1700 1700-1650-1550 1600-1550-1450 1400-1350-1250 1000-1000-940	1500-1450-1400 1350-1300-1250 1300-1250-1200 1150-1100-1050 840-800-760	1300-1250-1200 1150-1100-1050 1100-1050-1000 960-920-880 710-680-650	1500-1450-1350 1350-1300-1200 1250-1250-1150 1100-1050-1000 810-800-740	1100-1100-1050 1000-990-940 950-930-880 830-820-780 610-600-570	1100-1050-1000 1000-960-920 950-900-860 830-800-760 610-590-560			
990-970-930 550-540-520	930-910-870 610-590-570	1300-1300-1200 860-840-780	1050-1000-980 700-670-640	910-870-830 590-570-540	1050-1000-950 680-660-620	790-770-740 510-500-480	790-750-720 510-490-470			
640-630-600 530-520-495 465-455-435 290-285-270	640-630-600 530-520-495 465-455-435 290-285-270	1150-1100-1050 830-810-760 720-700-660 450-440-410	740-700-670 610-580-560 530-510-485 335-320-305	630-600-570 520-495-475 455-435-415 285-270-260	790-770-720 660-640-600 570-560-520 360-350-330	590-580-550 485-475-450 425-415-400 265-260-250	590-570-540 485-465-440 425-405-390 265-255-240			
860-840-810 690-670-640 500-490-470	860-840-810 690-670-640 500-490-470	1350-1300-1200 1050-1050-970 780-760-710	990-950-910 790-760-720 580-550-530	840-810-770 670-640-610 490-470-450	1050-1050-970 850-830-770 620-610-570	790-780-740 640-630-600 465-455-435	790-760-730 640-610-580 465-445-425			
GC1130 1040 S30T S40T GC2030 GC2040 GC4230 GC4240 GC1010										
Max chip thickness, h_{ex} inch										
.002-.004-.008	.002-.006-.010	.002-.006-.010	.004-.008-.010	.002-.006-.010	.004-.008-.010	.004-.008-.010	.004-.008-.010	.004-.008-.012	.002-.004-.008	
Cutting speed v_c ft/min										
910-890-840 640-630-590 660-650-610	680-640-600 485-450-420 500-470-440	930-870-810 660-610-570 680-540-590	970-920-900 670-630-620 710-670-650	860-820-780 610-580-550 630-600-570	930-890-860 640-610-590 680-640-630	1050-1000-990 740-700-680 770-730-710	820-780-740 540-520-490 620-590-560	1100-1100-1050 800-780-760 830-810-790		
890-870-830 620-600-570 -	660-640-580 465-435-405 455-425-395	910-850-800 630-590-550 630-590-550	810-770-750 640-610-590 570-540-520	840-800-760 580-560-530 -	780-740-730 620-590-570 -	- - -	730-690-660 520-500-475 -	1050-1000-990 770-750-730 630-590-550		
740-720-680 620-610-580	560-520-490 465-435-405	750-710-660 640-600-560	680-650-630 550-520-510	700-670-630 590-560-530	650-620-610 530-500-490	- -	650-620-590 530-500-475	1000-990-970 900-880-860		
810-790-750 560-550-520 610-590-570	610-570-530 420-390-365 455-425-400	830-770-720 580-540-500 620-580-550	860-820-800 580-550-540 650-620-600	770-730-690 530-500-475 580-550-520	830-790-770 560-530-520 620-590-580	950-900-880 650-610-600 710-670-650	730-690-660 475-455-430 570-540-510	990-970-940 700-680-670 760-740-720		
850-830-790 570-550-520 -	640-590-550 420-395-365 415-385-360	870-810-760 580-540-510 570-530-495	780-740-720 590-560-540 510-480-470	800-760-720 530-500-480 -	750-710-690 560-540-520 -	- - -	690-660-630 480-455-430 -	990-960-940 700-690-670 -		
700-680-650 580-560-540	530-495-460 430-405-375	710-670-620 590-560-520	640-610-600 520-490-480	670-630-600 540-520-490	620-590-570 495-470-460		620-590-560 490-465-440	960-940-910 840-820-800		
GC3220 GC3330 GC3040 K20W K20M GC4230 GC4240 GC1020 H13A K20D K15W										
Max chip thickness, h_{ex} inch										
.004-.006-.010	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.006-.010	.004-.006-.010	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.008-.012
Cutting speed v_c ft/min										
1000-1000-950 840-820-790	990-950-910 820-780-750	920-880-840 760-720-690	860-820-780 710-670-650	970-950-900 800-790-740	810-800-760 670-660-630	740-730-690 610-600-570	780-750-710 640-620-590	445-430-415 365-355-340	1000-970-930 840-800-770	- -
1100-1100-1050 890-870-830	1100-1050-990 870-830-790	1000-950-910 800-770-730	930-890-850 740-710-680	1050-1030-985 855-820-790	890-870-830 710-690-660	810-790-760 650-630-610	850-810-780 680-650-620	485-465-450 385-370-360	1100-1050-1000 890-850-810	930-890-850 740-710-680
690-680-650 650-630-600	1100-1050-980 870-830-790	630-600-570 580-560-530	580-560-530 540-520-495	655-640-625 605-605-575	560-540-520 520-500-480	510-495-475 470-460-440	530-510-485 495-475-455	305-295-285 280-270-260	690-660-630 650-620-590	- -

Milling with small engagement, inch values

ISO N			Specific cutting force k_{c1}	Hardness Brinell		CD10			CT530		H10	
MC No.	CMC No.	Material		lbs/in ²	HB	mc	Max chip thickness, h_{ex} inch					
							.004-.006-.008		.004-.006-.008		.004-.006-.008	
Cutting speed v_c , ft/min												
Aluminium alloys												
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	58,000	60		6950-6800-6700	3800-3750-3700	3450-3400-3350				
N1.2.Z.AG	30.12	Wrought or wrought and aged	94,500	100		6250-6150-6050	3450-3400-3300	3100-3050-3000				
Aluminium alloys												
N1.3.C.UT	30.21	Cast, non-aging	87,000	75	0.25	6950-6800-6700	3800-3750-3700	3450-3400-3350				
N1.3.C.AG	30.22	Cast or cast and aged	101,500	90	0.25	6250-6150-6050	3450-3400-3300	3150-3050-3000				
Aluminium alloys												
N1.1.Z.UT	30.3	Al >99%	50,500	30		7000-6850-6750	3850-3750-3700	3500-3450-3350				
Aluminium alloys												
N1.4.C.NS	30.41	Cast, 13-15% Si	101,500	130		2800-2750-2700	1550-1500-1500	1400-1350-1350				
N1.4.C.NS	30.42	Cast, 16-22% Si	101,500	130		2100-2050-2000	1150-1150-1100	1050-1050-1000				
Copper and copper alloys												
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	79,500	110	0.25	3500-3400-3350	1900-1900-1850	1750-1700-1700				
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	80,000	90		3450-3400-3350	1900-1900-1850	1750-1700-1700				
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	196,000	100	0.25	2450-2400-2350	1350-1300-1300	1200-1200-1150				
ISO S			Specific cutting force k_{c1}	Hardness Brinell		GC1025		GC1130		GC1010		
MC No.	CMC No.	Material		lbs/in ²	HB	mc	Max chip thickness, h_{ex} inch					
							.002-.006-.008		.002-.006-.008		.004-.006-.008	
Cutting speed v_c , ft/min												
Heat resistant super alloys												
Iron base												
S1.0.U.AN	20.11	Annealed or solution treated	348,000	200	0.25	235-225-220	235-225-220	-				
S1.0.U.AG	20.12	Aged or solution treated and aged	359,000	280	0.25	175-170-165	175-170-165	-				
Nickel base												
S2.0.Z.AN	20.21	Annealed or solution treated	383,000	250	0.25	225-215-210	225-215-210	-				
S2.0.Z.AG	20.22	Aged or solution treated and aged	420,500	350	0.25	140-135-130	140-135-130	-				
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	0.25	175-165-160	175-165-160	-				
Cobalt alloys												
S3.0.Z.AN	20.31	Annealed or solution treated	391,500	200	0.25	100-95-90	100-95-90	-				
S3.0.Z.AG	20.32	Solution treated and aged	432,000	300	0.25	70-65-65	70-65-65	-				
S3.0.C.NS	20.33	Cast or cast and aged	450,500	320	0.25	65-60-60	65-60-60	-				
Titanium alloys¹⁾				Rm²⁾								
S4.1.Z.UT	23.1	Commercial pure (99.5% Ti)	188,500	400	0.23	495-470-460	495-470-460	560-540-520				
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	203,000	950	0.23	220-210-205	220-210-205	250-245-235				
S4.3.Z.AG	23.22	α + β alloys in aged cond., β alloys, annealed or aged	203,000	1050	0.23	170-165-160	170-165-160	195-190-185				
ISO H			Specific cutting force k_{c1}	Hardness Brinell		CB50		CT530		GC1130		
MC No.	CMC No.	Material		lbs/in ²	HB	mc	Max chip thickness, h_{ex} inch					
							.003-.005-.008		.003-.004-.008		.003-.005-.008	
Cutting speed v_c , ft/min												
Extra hard steel												
H1.3.Z.HA	04.1	Hardened and tempered	606,500	59 HRC	0.25	610-600-570	305-300-285	155-150-140				
Chilled cast iron												
H2.0.C.UT	10.1	Cast or cast and aged	326,500	400	0.28	1150-1150-1100	580-570-540	295-285-270				

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.
 2) Rm = ultimate tensile strength measured in MPa.




Conditions:
 Side milling, cutter dia. 1.000 inch (25 mm). Working engagement .400 inch (10 mm).

GC1025	GC1130	H10F	H13A							
Max chip thickness, h_{ex} inch										
.004-.006-.008	.004-.006-.008	.004-.006-.008	.004-.006-.008							
Cutting speed v_c, ft/min										
3650-3600-3500	3650-3600-3500	3450-3400-3350	2750-2700-2700							
3300-3200-3150	3300-3200-3150	3100-3050-3000	2500-2450-2400							
3650-3600-3500	3650-3600-3500	3450-3400-3350	2750-2700-2700							
3650-3600-3500	3650-3600-3500	3150-3050-3000	2500-2450-2400							
3650-3600-3550	3650-3600-3550	3500-3450-3350	2800-2750-2700							
1450-1450-1400	1450-1450-1400	1400-1350-1350	1100-1100-1100							
1100-1100-1050	1100-1100-1050	1050-1050-1000	840-820-810							
1850-1800-1750	1850-1800-1750	1750-1700-1700	1400-1350-1350							
1850-1800-1750	1850-1800-1750	1750-1700-1700	1400-1350-1350							
1250-1250-1250	1250-1250-1250	1200-1200-1150	970-950-940							
H13A										
H10F										
S30T										
S40T										
GC2030										
GC2040										
Max chip thickness, h_{ex} inch										
.004-.006-.008	.004-.008-.012	.004-.006-.008	.004-.006-.008	.002-.006-.008	.002-.006-.010					
Cutting speed v_c, ft/min										
220-215-215	200-195-190	-	-	220-210-205	225-215-210					
160-160-155	150-145-140	-	-	165-155-155	165-160-150					
210-210-205	195-185-180	-	-	210-200-195	215-210-200					
130-130-125	115-115-110	-	-	130-125-125	135-130-125					
160-160-155	145-140-135	-	-	160-155-150	165-155-150					
90-90-85	85-80-75	-	-	90-90-85	90-90-85					
65-65-60	60-55-55	-	-	65-65-60	65-65-60					
60-60-60	55-55-50	-	-	60-60-55	60-60-55					
465-455-445	420-405-395	560-540-520	485-470-460	460-440-430	480-455-445					
185-180-175	165-160-155	250-245-235	175-170-170	185-180-175	170-160-160					
140-140-135	125-120-115	195-190-185	145-145-140	160-150-150	145-135-135					
GC4220										
GC3040										
GC1010										
GC1025										
Max chip thickness, h_{ex} inch										
.004-.005-.010	.004-.008-.010	.003-.005-.008	.003-.005-.008							
Cutting speed v_c, ft/min										
215-215-195	175-165-160	420-405-390	155-150-140							
410-400-370	335-315-305	810-790-750	295-285-270							


Face milling tools

CoroMill® 415

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
415N-050206M-M30	M	0.39	(0.3-0.5)	0.1	(0.078-0.129)	.015	(.012-.020)	.004	(.003-.005)
415N-070310M-M30	M	0.46	(0.35-0.55)	0.12	(0.091-0.142)	.018	(.014-.022)	.005	(.004-.006)


Shoulder milling tools

CoroMill® 490

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
490L-140408M-PM	P	0.17	(0.12-0.25)	0.17	(0.12-0.25)	.007	(.005-.010)	.007	(.005-.010)
490R-08T304E-ML	M	0.13	(0.08-0.18)	0.13	(0.08-0.18)	.005	(.003-.007)	.005	(.003-.007)
490R-08T304M-KL	K	0.12	(0.05-0.15)	0.12	(0.05-0.15)	.005	(.002-.006)	.005	(.002-.006)
490R-08T304M-PL	P	0.08	(0.05-0.12)	0.08	(0.05-0.12)	.003	(.002-.005)	.003	(.002-.005)
490R-08T308E-ML	M	0.14	(0.08-0.18)	0.14	(0.08-0.18)	.006	(.003-.007)	.006	(.003-.007)
490R-08T308E-MM	M	0.17	(0.12-0.22)	0.17	(0.12-0.22)	.007	(.005-.009)	.007	(.005-.009)
490R-08T308M-KH	K	0.24	(0.15-0.3)	0.24	(0.15-0.3)	.009	(.006-.012)	.009	(.006-.012)
490R-08T308M-KL	K	0.12	(0.05-0.15)	0.12	(0.05-0.15)	.005	(.002-.006)	.005	(.002-.006)
490R-08T308M-KM	K	0.17	(0.1-0.2)	0.17	(0.1-0.2)	.007	(.004-.008)	.007	(.004-.008)
490R-08T308M-MM	M	0.16	(0.1-0.2)	0.16	(0.1-0.2)	.006	(.004-.008)	.006	(.004-.008)
490R-08T308M-PH	P	0.2	(0.15-0.25)	0.2	(0.15-0.25)	.008	(.006-.010)	.008	(.006-.010)
490R-08T308M-PL	P	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
490R-08T308M-PM	P	0.15	(0.1-0.2)	0.15	(0.1-0.2)	.006	(.004-.008)	.006	(.004-.008)
490R-08T312E-MM	M	0.17	(0.12-0.22)	0.17	(0.12-0.22)	.007	(.005-.009)	.007	(.005-.009)
490R-08T312M-KM	K	0.17	(0.1-0.2)	0.17	(0.1-0.2)	.007	(.004-.008)	.007	(.004-.008)
490R-08T312M-PM	P	0.14	(0.08-0.18)	0.14	(0.08-0.18)	.006	(.003-.007)	.006	(.003-.007)
490R-08T316E-MM	M	0.17	(0.12-0.22)	0.17	(0.12-0.22)	.007	(.005-.009)	.007	(.005-.009)
490R-08T316M-KH	K	0.24	(0.15-0.3)	0.24	(0.15-0.3)	.009	(.006-.012)	.009	(.006-.012)
490R-08T316M-KM	K	0.17	(0.1-0.2)	0.17	(0.1-0.2)	.007	(.004-.008)	.007	(.004-.008)
490R-08T316M-PH	P	0.21	(0.15-0.25)	0.21	(0.15-0.25)	.008	(.006-.010)	.008	(.006-.010)
490R-08T316M-PM	P	0.14	(0.08-0.18)	0.14	(0.08-0.18)	.006	(.003-.007)	.006	(.003-.007)
490R-140408E	KH	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
490R-140408E-ML	M	0.14	(0.08-0.18)	0.14	(0.08-0.18)	.006	(.003-.007)	.006	(.003-.007)
490R-140408E-MM	M	0.17	(0.12-0.22)	0.17	(0.12-0.22)	.007	(.005-.009)	.007	(.005-.009)
490R-140408M-MM	M	0.16	(0.12-0.2)	0.16	(0.12-0.2)	.006	(.005-.008)	.006	(.005-.008)
490R-140408M-PH	P	0.28	(0.2-0.35)	0.28	(0.2-0.35)	.011	(.008-.014)	.011	(.008-.014)
490R-140408M-PL	P	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
490R-140408M-PM	P	0.17	(0.12-0.25)	0.17	(0.12-0.25)	.007	(.005-.010)	.007	(.005-.010)
490R-140412E-MM	M	0.17	(0.12-0.22)	0.17	(0.12-0.22)	.007	(.005-.009)	.007	(.005-.009)
490R-140412M-PM	P	0.17	(0.12-0.25)	0.17	(0.12-0.25)	.007	(.005-.010)	.007	(.005-.010)
490R-140416E-MM	M	0.17	(0.12-0.22)	0.17	(0.12-0.22)	.007	(.005-.009)	.007	(.005-.009)
490R-140416M-PM	P	0.17	(0.12-0.25)	0.17	(0.12-0.25)	.007	(.005-.010)	.007	(.005-.010)
490R-140420E	K	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
490R-140420E-MM	M	0.16	(0.12-0.2)	0.17	(0.12-0.22)	.006	(.005-.008)	.007	(.005-.009)
490R-140420M-MM	M	0.16	(0.12-0.2)	0.16	(0.12-0.2)	.006	(.005-.008)	.006	(.005-.008)
490R-140420M-PH	P	0.28	(0.2-0.35)	0.28	(0.2-0.35)	.011	(.008-.014)	.011	(.008-.014)
490R-140420M-PM	P	0.17	(0.12-0.25)	0.17	(0.12-0.25)	.007	(.005-.010)	.007	(.005-.010)


Shoulder milling tools

CoroMill® 390

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
390R-070202E-ML	M	0.05	(0.02-0.07)	0.05	(0.02-0.07)	.002	(.001-.003)	.002	(.001-.003)
390R-070202E-NL	N	0.1	(0.02-0.2)	0.1	(0.02-0.2)	.004	(.001-.008)	.004	(.001-.008)
390R-070202E-PL	P	0.05	(0.02-0.07)	0.05	(0.02-0.07)	.002	(.001-.003)	.002	(.001-.003)
390R-070202M-MM	M	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070202M-PM	P	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070204E-KL	K	0.07	(0.03-0.1)	0.05	(0.02-0.07)	.003	(.001-.004)	.002	(.001-.003)
390R-070204E-ML	M	0.05	(0.02-0.07)	0.05	(0.02-0.07)	.002	(.001-.003)	.002	(.001-.003)
390R-070204E-MM	M	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070204E-NL	N	0.05	(0.02-0.07)	0.1	(0.02-0.2)	.002	(.001-.003)	.004	(.001-.008)
390R-070204E-PL	P	0.05	(0.02-0.07)	0.05	(0.02-0.07)	.002	(.001-.003)	.002	(.001-.003)
390R-070204M-KM	K	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070204M-MM	M	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070204M-PM	P	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070208E-KL	K	0.07	(0.03-0.1)	0.05	(0.02-0.07)	.003	(.001-.004)	.002	(.001-.003)
390R-070208E-ML	M	0.05	(0.02-0.07)	0.05	(0.02-0.07)	.002	(.001-.003)	.002	(.001-.003)
390R-070208E-MM	M	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070208E-NL	N	0.05	(0.02-0.07)	0.1	(0.02-0.2)	.002	(.001-.003)	.004	(.001-.008)
390R-070208E-PL	P	0.05	(0.02-0.07)	0.05	(0.02-0.07)	.002	(.001-.003)	.002	(.001-.003)
390R-070208M-KM	K	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070208M-MM	M	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070208M-PM	P	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070212E-ML	M	0.07	(0.03-0.1)	0.05	(0.02-0.07)	.003	(.001-.004)	.002	(.001-.003)
390R-070212E-PL	P	0.05	(0.02-0.07)	0.05	(0.02-0.07)	.002	(.001-.003)	.002	(.001-.003)
390R-070212M-MM	M	0.1	(0.02-0.2)	0.07	(0.03-0.1)	.004	(.001-.008)	.003	(.001-.004)
390R-070212M-PM	P	0.07	(0.03-0.1)	0.07	(0.03-0.1)	.003	(.001-.004)	.003	(.001-.004)
390R-070216E-ML	M	0.07	(0.03-0.1)	0.05	(0.02-0.07)	.003	(.001-.004)	.002	(.001-.003)
390R-070216E-PL	P	0.07	(0.03-0.1)	0.05	(0.02-0.07)	.003	(.001-.004)	.002	(.001-.003)
390R-070216M-KM	K	0.05	(0.02-0.07)	0.07	(0.03-0.1)	.002	(.001-.003)	.003	(.001-.004)
390R-070216M-MM	M	0.1	(0.02-0.2)	0.07	(0.03-0.1)	.004	(.001-.008)	.003	(.001-.004)
390R-070216M-PM	P	0.12	(0.08-0.2)	0.07	(0.03-0.1)	.005	(.003-.008)	.003	(.001-.004)
R390-11T302E-KM	K	0.1	(0.08-0.15)	0.1	(0.08-0.18)	.004	(.003-.006)	.004	(.003-.007)
R390-11T302E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T302E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T304E-PL	P	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-11T304M-KM	K	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
R390-11T304M-PM	P	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
R390-11T308E-KL	K	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-11T308E-ML	M	0.08	(0.04-0.15)	0.08	(0.04-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-11T308E-NL	N	0.18	(0.06-0.35)	0.15	(0.05-0.25)	.007	(.002-.014)	.006	(.002-.010)
R390-11T308E-PL	P	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-11T308E-PLW	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T308M-KL	K	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-11T308M-KM	K	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T308M-MM	M	0.13	(0.08-0.2)	0.13	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T308M-PL	P	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-11T308M-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T310M-KH	K	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T310M-MH	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T310M-PH	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T312E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-11T312E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T312E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T316E-KM	K	0.15	(0.1-0.25)	0.1	(0.08-0.18)	.006	(.004-.010)	.004	(.003-.007)
R390-11T316E-ML	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T316E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T316E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T316M-KM	K	0.12	(0.08-0.2)	0.15	(0.1-0.25)	.005	(.003-.008)	.006	(.004-.010)
R390-11T316M-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T320E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-11T320E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T320E-NL	N	0.18	(0.06-0.4)	0.18	(0.06-0.35)	.007	(.002-.016)	.007	(.002-.014)
R390-11T320E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T324E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-11T324E-ML	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T324E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T324E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T331E-KM	K	0.15	(0.1-0.25)	0.1	(0.08-0.18)	.006	(.004-.010)	.004	(.003-.007)
R390-11T331E-ML	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T331E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T331E-NL	N	0.18	(0.06-0.4)	0.18	(0.06-0.4)	.007	(.002-.016)	.007	(.002-.016)
R390-11T331E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T331M-KM	K	0.12	(0.08-0.2)	0.15	(0.1-0.25)	.005	(.003-.008)	.006	(.004-.010)
R390-11T331M-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-11T304E-P4-NL	N	0.17	(0.1-0.2)	0.17	(0.1-0.2)	.007	(.004-.008)	.007	(.004-.008)
R390-170404E-KM	K	0.1	(0.08-0.15)	0.1	(0.08-0.18)	.004	(.003-.006)	.004	(.003-.007)
R390-170404E-MM	M	0.15	(0.08-0.2)	0.12	(0.08-0.2)	.006	(.003-.008)	.005	(.003-.008)


Shoulder milling tools

CoroMill® 390

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
R390-170404E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170404M-KM	K	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
R390-170404M-PM	P	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
R390-170408E-KL	K	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-170408E-ML	M	0.08	(0.04-0.15)	0.08	(0.04-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-170408E-NL	N	0.17	(0.1-0.2)	0.15	(0.08-0.25)	.007	(.004-.008)	.006	(.003-.010)
R390-170408E-PL	P	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-170408M-KH	K	0.2	(0.15-0.35)	0.2	(0.15-0.35)	.008	(.006-.014)	.008	(.006-.014)
R390-170408M-KL	K	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-170408M-KM	K	0.15	(0.1-0.25)	0.15	(0.1-0.25)	.006	(.004-.010)	.006	(.004-.010)
R390-170408M-MM	M	0.15	(0.08-0.2)	0.15	(0.08-0.2)	.006	(.003-.008)	.006	(.003-.008)
R390-170408M-PH	P	0.2	(0.15-0.35)	0.2	(0.15-0.35)	.008	(.006-.014)	.008	(.006-.014)
R390-170408M-PL	P	0.08	(0.05-0.15)	0.08	(0.05-0.15)	.003	(.002-.006)	.003	(.002-.006)
R390-170408M-PM	P	0.15	(0.1-0.25)	0.15	(0.1-0.25)	.006	(.004-.010)	.006	(.004-.010)
R390-170412E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-170412E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170412E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170416E-KM	K	0.15	(0.1-0.25)	0.1	(0.08-0.18)	.006	(.004-.010)	.004	(.003-.007)
R390-170416E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170416E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170416M-KM	K	0.12	(0.08-0.2)	0.15	(0.1-0.25)	.005	(.003-.008)	.006	(.004-.010)
R390-170416M-PH	P	0.2	(0.15-0.35)	0.2	(0.15-0.35)	.008	(.006-.014)	.008	(.006-.014)
R390-170416M-PM	P	0.15	(0.1-0.25)	0.15	(0.1-0.25)	.006	(.004-.010)	.006	(.004-.010)
R390-170420E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-170420E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170420E-NL	N	0.2	(0.12-0.32)	0.2	(0.1-0.3)	.008	(.005-.013)	.008	(.004-.012)
R390-170420E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170424E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-170424E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170424E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170431E-KM	K	0.15	(0.1-0.25)	0.1	(0.08-0.18)	.006	(.004-.010)	.004	(.003-.007)
R390-170431E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170431E-NL	N	0.2	(0.12-0.32)	0.2	(0.12-0.32)	.008	(.005-.013)	.008	(.005-.013)
R390-170431E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170431M-KM	K	0.12	(0.08-0.2)	0.15	(0.1-0.25)	.005	(.003-.008)	.006	(.004-.010)
R390-170431M-PM	P	0.15	(0.1-0.25)	0.15	(0.1-0.25)	.006	(.004-.010)	.006	(.004-.010)
R390-170440E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-170440E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170440E-NL	N	0.2	(0.12-0.4)	0.2	(0.12-0.32)	.008	(.005-.016)	.008	(.005-.013)
R390-170440E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170448E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-170448E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170448E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170450E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-170450E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170450E-NL	N	0.2	(0.12-0.4)	0.2	(0.12-0.4)	.008	(.005-.016)	.008	(.005-.016)
R390-170450E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170460E-KM	K	0.1	(0.08-0.18)	0.1	(0.08-0.18)	.004	(.003-.007)	.004	(.003-.007)
R390-170460E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170460E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170464E-KM	K	0.08	(0.04-0.15)	0.1	(0.08-0.18)	.003	(.002-.006)	.004	(.003-.007)
R390-170464E-MM	M	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170464E-PM	P	0.12	(0.08-0.2)	0.12	(0.08-0.2)	.005	(.003-.008)	.005	(.003-.008)
R390-170408E-P6-NL	N	0.17	(0.1-0.2)	0.17	(0.1-0.2)	.007	(.004-.008)	.007	(.004-.008)
R390-180608H-KL	K	0.11	(0.05-0.22)	0.11	(0.05-0.22)	.004	(.002-.009)	.004	(.002-.009)
R390-180608H-ML	M	0.11	(0.05-0.22)	0.11	(0.05-0.22)	.004	(.002-.009)	.004	(.002-.009)
R390-180608H-PL	P	0.11	(0.05-0.22)	0.11	(0.05-0.22)	.004	(.002-.009)	.004	(.002-.009)
R390-180608M-KM	K	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180608M-MM	M	0.18	(0.1-0.3)	0.18	(0.1-0.3)	.007	(.004-.012)	.007	(.004-.012)
R390-180608M-PM	P	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180612H-KL	K	0.11	(0.05-0.22)	0.11	(0.05-0.22)	.004	(.002-.009)	.004	(.002-.009)
R390-180612H-ML	M	0.11	(0.05-0.22)	0.11	(0.05-0.22)	.004	(.002-.009)	.004	(.002-.009)
R390-180612H-PL	P	0.11	(0.05-0.22)	0.11	(0.05-0.22)	.004	(.002-.009)	.004	(.002-.009)
R390-180612M-KM	K	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180612M-KMR	K	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180612M-MM	M	0.18	(0.1-0.3)	0.18	(0.1-0.3)	.007	(.004-.012)	.007	(.004-.012)
R390-180612M-MMR	M	0.18	(0.1-0.3)	0.18	(0.1-0.3)	.007	(.004-.012)	.007	(.004-.012)
R390-180612M-PM	P	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180612M-PMR	P	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180616H-ML	M	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180616H-PL	P	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180616M-KM	K	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180616M-MM	M	0.18	(0.1-0.3)	0.18	(0.1-0.3)	.007	(.004-.012)	.007	(.004-.012)
R390-180616M-PM	P	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180620H-ML	M	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180620H-PL	P	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)

Shoulder milling tools

CoroMill® 390

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
R390-180620M-KM	K	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180620M-MM	M	0.18	(0.1-0.3)	0.18	(0.1-0.3)	.007	(.004-.012)	.007	(.004-.012)
R390-180620M-PM	P	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180624H-ML	M	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180624H-PL	P	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180631H-KL	K	0.11	(0.05-0.22)	0.11	(0.05-0.22)	.004	(.002-.009)	.004	(.002-.009)
R390-180631H-ML	M	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180631H-PL	P	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180631M-KM	K	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180631M-MM	M	0.18	(0.1-0.3)	0.18	(0.1-0.3)	.007	(.004-.012)	.007	(.004-.012)
R390-180631M-PM	P	0.2	(0.08-0.3)	0.2	(0.08-0.3)	.008	(.003-.012)	.008	(.003-.012)
R390-180640H-ML	M	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180640H-PL	P	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180650H-ML	M	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180650H-PL	P	0.12	(0.05-0.22)	0.12	(0.05-0.22)	.005	(.002-.009)	.005	(.002-.009)
R390-180660H-ML	M	0.14	(0.05-0.22)	0.14	(0.05-0.22)	.006	(.002-.009)	.006	(.002-.009)
R390-180660H-PL	P	0.14	(0.05-0.22)	0.14	(0.05-0.22)	.006	(.002-.009)	.006	(.002-.009)
R390-180664H-ML	M	0.14	(0.05-0.22)	0.14	(0.05-0.22)	.006	(.002-.009)	.006	(.002-.009)
R390-180664H-PL	P	0.14	(0.05-0.22)	0.14	(0.05-0.22)	.006	(.002-.009)	.006	(.002-.009)

Profile milling tools


CoroMill® 300




Ordering code	Material	Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
R300-0517E-PM	P	0.08	(0.05-0.12)	0.08	(0.05-0.12)	.003	(.002-.005)	.003	(.002-.005)
R300-0720E-MM	M	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0720E-PM	P	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0724E-MM	M	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0724E-PM	P	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0828E-KL	K	0.13	(0.05-0.2)	0.11	(0.05-0.15)	.005	(.002-.008)	.004	(.002-.006)
R300-0828E-KM	K	0.15	(0.07-0.25)	0.13	(0.05-0.2)	.006	(.003-.010)	.005	(.002-.008)
R300-0828E-MM	M	0.13	(0.07-0.2)	0.13	(0.05-0.2)	.005	(.003-.008)	.005	(.002-.008)
R300-0828E-PL	P	0.11	(0.05-0.15)	0.11	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0828E-PM	P	0.13	(0.05-0.2)	0.13	(0.05-0.2)	.005	(.002-.008)	.005	(.002-.008)
R300-0828M-KH	K	0.15	(0.07-0.25)	0.15	(0.07-0.25)	.006	(.003-.010)	.006	(.003-.010)
R300-0828M-MH	M	0.13	(0.05-0.2)	0.15	(0.07-0.25)	.005	(.002-.008)	.006	(.003-.010)
R300-0828M-MM	M	0.13	(0.07-0.2)	0.13	(0.07-0.2)	.005	(.003-.008)	.005	(.003-.008)
R300-0828M-PH	P	0.15	(0.07-0.25)	0.15	(0.07-0.25)	.006	(.003-.010)	.006	(.003-.010)
R300-0828M-PM	P	0.13	(0.07-0.2)	0.13	(0.07-0.2)	.005	(.003-.008)	.005	(.003-.008)
R300-0932E-MM	M	0.15	(0.07-0.23)	0.13	(0.04-0.2)	.006	(.003-.009)	.005	(.002-.008)
R300-0932E-PM	P	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-0932M-PH	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-0932M-PM	P	0.15	(0.07-0.23)	0.13	(0.06-0.2)	.006	(.003-.009)	.005	(.002-.008)
R300-1032E-KL	K	0.21	(0.05-0.29)	0.13	(0.04-0.15)	.008	(.002-.011)	.005	(.002-.006)
R300-1032E-MM	M	0.17	(0.07-0.29)	0.18	(0.04-0.25)	.007	(.003-.011)	.007	(.002-.010)
R300-1032E-PL	P	0.15	(0.05-0.17)	0.13	(0.04-0.15)	.006	(.002-.007)	.005	(.002-.006)
R300-1032E-PM	P	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1032M-KH	K	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1032M-MH	M	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1032M-MM	M	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1032M-PH	P	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1032M-PM	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1240E-KM	K	0.23	(0.07-0.35)	0.18	(0.04-0.25)	.009	(.003-.014)	.007	(.002-.010)
R300-1240E-ML	M	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-1240E-MM	M	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1240E-PL	P	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-1240E-PM	P	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1240M-KH	K	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1240M-MH	M	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1240M-MM	M	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1240M-PH	P	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1240M-PM	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1340E-ML	M	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-1340E-MM	M	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1340E-PL	P	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-1340E-PM	P	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1340M-KH	K	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1340M-MH	M	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1340M-MM	M	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)

Profile milling tools


CoroMill® 300

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
R300-1340M-PH	P	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1340M-PM	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1648E-KM	K	0.29	(0.07-0.46)	0.2	(0.04-0.3)	.011	(.003-.018)	.008	(.002-.012)
R300-1648E-ML	M	0.17	(0.05-0.23)	0.15	(0.04-0.2)	.007	(.002-.009)	.006	(.002-.008)
R300-1648E-MM	M	0.21	(0.07-0.29)	0.2	(0.04-0.3)	.008	(.003-.011)	.008	(.002-.012)
R300-1648E-PL	P	0.17	(0.05-0.23)	0.15	(0.04-0.2)	.007	(.002-.009)	.006	(.002-.008)
R300-1648E-PM	P	0.23	(0.05-0.35)	0.2	(0.04-0.3)	.009	(.002-.014)	.008	(.002-.012)
R300-1648M-KH	K	0.29	(0.07-0.46)	0.25	(0.06-0.4)	.011	(.003-.018)	.010	(.002-.016)
R300-1648M-MH	M	0.29	(0.07-0.46)	0.25	(0.06-0.4)	.011	(.003-.018)	.010	(.002-.016)
R300-1648M-MM	M	0.21	(0.07-0.29)	0.18	(0.06-0.25)	.008	(.003-.011)	.007	(.002-.010)
R300-1648M-PH	P	0.29	(0.07-0.46)	0.25	(0.06-0.4)	.011	(.003-.018)	.010	(.002-.016)
R300-1648M-PM	P	0.21	(0.07-0.29)	0.18	(0.06-0.25)	.008	(.003-.011)	.007	(.002-.010)
R300-2060E-ML	M	0.28	(0.06-0.35)	0.2	(0.04-0.25)	.011	(.002-.014)	.008	(.002-.010)
R300-2060E-MM	M	0.35	(0.06-0.57)	0.25	(0.04-0.4)	.014	(.002-.022)	.010	(.002-.016)
R300-2060E-PL	P	0.28	(0.06-0.35)	0.2	(0.04-0.25)	.011	(.002-.014)	.008	(.002-.010)
R300-2060E-PM	P	0.35	(0.06-0.57)	0.25	(0.04-0.4)	.014	(.002-.022)	.010	(.002-.016)
R300-2060M-KH	K	0.49	(0.07-0.78)	0.35	(0.05-0.55)	.019	(.003-.031)	.014	(.002-.022)
R300-2060M-MH	M	0.49	(0.07-0.78)	0.35	(0.05-0.55)	.019	(.003-.031)	.014	(.002-.022)
R300-2060M-MM	M	0.28	(0.07-0.42)	0.2	(0.05-0.3)	.011	(.003-.017)	.008	(.002-.012)
R300-2060M-PH	P	0.49	(0.07-0.78)	0.35	(0.05-0.55)	.019	(.003-.031)	.014	(.002-.022)
R300-2060M-PM	P	0.28	(0.07-0.42)	0.2	(0.05-0.3)	.011	(.003-.017)	.008	(.002-.012)
R300-2570E-ML	M	0.31	(0.06-0.4)	0.22	(0.04-0.28)	.012	(.002-.016)	.009	(.002-.011)
R300-2570E-PL	P	0.31	(0.06-0.4)	0.22	(0.04-0.28)	.012	(.002-.016)	.009	(.002-.011)
R300-2570M-KH	K	0.57	(0.07-0.85)	0.4	(0.05-0.6)	.022	(.003-.033)	.016	(.002-.024)
R300-2570M-MM	M	0.31	(0.07-0.47)	0.22	(0.05-0.33)	.012	(.003-.019)	.009	(.002-.013)
R300-2570M-PH	P	0.57	(0.07-0.85)	0.4	(0.05-0.6)	.022	(.003-.033)	.016	(.002-.024)
R300-2570M-PM	P	0.31	(0.07-0.47)	0.22	(0.05-0.33)	.012	(.003-.019)	.009	(.002-.013)

CoroMill® 216

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
APMT160408-M	K	0.35	(0.14-0.7)	0.25	(0.1-0.5)	.014	(.006-.028)	.010	(.004-.020)
R216-1002E-M	PMSH	0.14	(0.06-0.21)	0.1	(0.04-0.15)	.006	(.002-.008)	.004	(.002-.006)
R216-1202E-M	PMSH	0.14	(0.06-0.21)	0.1	(0.04-0.15)	.006	(.002-.008)	.004	(.002-.006)
R216-1202M-M	PMKSH	0.14	(0.08-0.21)	0.1	(0.04-0.15)	.006	(.003-.008)	.004	(.002-.006)
R216-1603E-M	PMS	0.14	(0.06-0.21)	0.1	(0.04-0.15)	.006	(.002-.008)	.004	(.002-.006)
R216-1603M-M	PMKNSh	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
R216-20T3E-M	PMS	0.21	(0.06-0.25)	0.15	(0.04-0.18)	.008	(.002-.010)	.006	(.002-.007)
R216-20T3M-M	PMKNSh	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
R216-2504E-M	PMS	0.21	(0.06-0.25)	0.15	(0.04-0.18)	.008	(.002-.010)	.006	(.002-.007)
R216-2504M-M	PMKSH	0.17	(0.08-0.21)	0.12	(0.06-0.15)	.007	(.003-.008)	.005	(.002-.006)
R216-3006E-M	PMS	0.24	(0.06-0.28)	0.17	(0.04-0.2)	.009	(.002-.011)	.007	(.002-.008)
R216-3006M-M	PMKSH	0.21	(0.08-0.28)	0.15	(0.06-0.2)	.008	(.003-.011)	.006	(.002-.008)
R216-3206E-M	PMS	0.24	(0.06-0.28)	0.17	(0.04-0.2)	.009	(.002-.011)	.007	(.002-.008)
R216-3206M-M	PMKSH	0.21	(0.08-0.28)	0.15	(0.06-0.2)	.008	(.003-.011)	.006	(.002-.008)
R216-4007E-M	PMS	0.28	(0.06-0.35)	0.2	(0.04-0.25)	.011	(.002-.014)	.008	(.002-.010)
R216-4007M-M	PMKS	0.28	(0.1-0.42)	0.2	(0.07-0.3)	.011	(.004-.017)	.008	(.003-.012)
R216-5007E-M	PMS	0.28	(0.06-0.35)	0.2	(0.04-0.25)	.011	(.002-.014)	.008	(.002-.010)
R216-5007M-M	PMKS	0.35	(0.1-0.7)	0.25	(0.07-0.5)	.014	(.004-.028)	.010	(.003-.020)


CoroMill® 216

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
RA216-1002E-M	PMSH	0.14	(0.06-0.21)	0.1	(0.04-0.15)	.006	(.002-.008)	.004	(.002-.006)
RA216-1302E-M	PMS	0.14	(0.06-0.21)	0.1	(0.04-0.15)	.006	(.002-.008)	.004	(.002-.006)
RA216-1302M-M	PMKNSh	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RA216-1603M-M	PMKSH	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RA216-19T3E-M	PMS	0.21	(0.06-0.25)	0.15	(0.04-0.18)	.008	(.002-.010)	.006	(.002-.007)
RA216-19T3M-M	PMKNSh	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RA216-2504E-M	PMS	0.21	(0.06-0.25)	0.15	(0.04-0.18)	.008	(.002-.010)	.006	(.002-.007)
RA216-2504M-M	PMKNSh	0.17	(0.08-0.21)	0.12	(0.06-0.15)	.007	(.003-.008)	.005	(.002-.006)
RA216-3206M-M	PMKSH	0.21	(0.08-0.28)	0.15	(0.06-0.2)	.008	(.003-.011)	.006	(.002-.008)
RA216-3807M-M	PMKS	0.28	(0.1-0.42)	0.2	(0.07-0.3)	.011	(.004-.017)	.008	(.003-.012)
RA216-5107M-M	PMKNS	0.35	(0.1-0.7)	0.25	(0.07-0.5)	.014	(.004-.028)	.010	(.003-.020)

Chamfer milling tools

CoroMill® 495

B

Ordering code		Feed per tooth, f_z mm/tooth		Max chip thickness, h_{ex} mm		Feed per tooth, f_z inch/tooth		Max chip thickness, h_{ex} inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
495-09T3M-MM	M	0.17	(0.12-0.25)	0.16	(0.12-0.2)	.007	(.005-.010)	.006	(.005-.008)
495-09T3M-PM	P	0.17	(0.12-0.25)	0.17	(0.12-0.25)	.007	(.005-.010)	.007	(.005-.010)

C

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J

Grades for milling

P Steel

Basic grades



GC1130 (HC) - P30 (P15-P40)

Hard, thin coated PVD-grade with Zertivo™ technology for various applications. Suitable from light roughing to finishing in average stability for wet and dry machining. Good choice for complex tool paths and sticky materials.

Where GC1130 is not available, please use GC1030.



GC4240 (HC) - P40 (P35-P50)

Tough CVD-coated grade (medium thick coating) suited for tough and demanding medium to rough milling applications for wet and dry machining.



GC4230 (HC) - P30 (P10-P40)

Medium hard CVD-coated grade (medium thick coating) designed for medium to rough milling applications in average cutting conditions for wet and dry machining.



GC4220 (HC) - P20 (P10-P25)

Hard CVD-coated (thick coating) grade suitable for high cutting speeds in medium to rough milling application with good stability for dry machining.

Complementary grades



GC1010 (HC) - P10 (P05-P15)

Very hard PVD-coated (thin coating) grade for finishing in very stable conditions and hardened materials for wet and dry machining.



CT530 (HT) - P15 (P10-P15)

Medium hard uncoated cermet grade for finishing applications at high cutting speeds for dry machining.



GC2030 (HC) - P30 (P20-P40)

Medium hard PVD-coated (thin coating) grade for sticky materials for wet and dry machining.



GC2040 (HC) - P45 (P30-P50)

Tough CVD-coated grade (medium thick coating) for roughing in tough and demanding applications for wet and dry machining and good for mixed material production.



GC3040 (HC) - P20 (P10-P40)

Medium hard CVD-coated (thick coating) grade which complements GC4230 in abrasive materials.



GC1025 (HC) - P30 (P15-P30)

Hard PVD-coated (thin coating) grade for light roughing to finishing in sticky materials for wet and dry machining.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Grades for milling

M Austenitic/ferritic/martensitic stainless steel

Basic grades



GC1040 (HC) - M30 (M15-M35)

Tough, thin-coated PVD grade for finishing to roughing in unstable to stable wet or dry conditions. Good choice for complex tool paths and sticky materials.



GC2040 (HC) - M40 (M25-M40)

Tough, medium-thick coated CVD grade designed for tough and demanding, medium to rough milling applications with poor stability in dry conditions. High feed rates, large diameters and radial engagements.



S30T (HC) - M25 (M15-M35)

Medium hard, thin-coated PVD grade to be used as a complement to GC1040 when stability is good and for demands on high cutting speed in wet and dry conditions.



GC2030 (HC) - M25 (M15-M30)

Medium-hard, thin coated PVD grade for light roughing to finishing. Complement to GC1040 in good stability, for high cutting speeds in dry conditions.

Complementary grades



S40T (HC) - M40 (M30-M40)

Very tough, medium-thick-coated CVD grade designed for toughness-demanding medium to rough milling applications with poor stability. Can be used in both dry and wet conditions.



GC1130 (HC) - M15 (M10-M20)

Hard, thin-coated PVD grade with Zertivo™ technology for use as a complement to GC1040 with good stability and demands for high cutting speed. Can be used in both dry and wet conditions. Good choice for mixed ISO M/ISO P material production.

Where GC1130 does not exist, please use GC1030.



CT530 (HT) - M10 (M10-M15)

Medium hard uncoated cermet grade for finishing applications at high cutting speeds for dry machining.



GC4240 (HC) - M40 (M30-M40)

Tough, medium-thick-coated CVD grade for tough and demanding, medium to rough milling applications of martensitic stainless steels in dry conditions.

Complementary grades



GC1025 (HC) – M15 (M10 – M20)

PVD coated carbide grade for light milling of stainless steel. In combination with periphery ground inserts, the first choice for sticky and workhardening materials.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Grades for milling

K Cast iron

Basic grades



GC3330 (HC) - K20 (K15-K35)

Hard CVD-coated grade with thick coating, designed for medium to rough milling of all cast irons in average to stable conditions, both dry and wet. First choice in grey cast iron and mixed ISO K applications.



GC1020 (HC) - K20 (K10-K25)

Hard PVD-coated grade with thin coating for light roughing to finishing of nodular cast iron in dry and wet conditions, and grey cast iron in wet and average to stable conditions. First choice for nodular cast iron and/or small diameter cutters.



GC3220 (HC) - K15 (K10-K25)

Hard CVD-coated grade with very thick coating, designed for high cutting speeds in medium to rough grey cast milling applications with good stability in dry conditions.



GC3040 (HC) - K30 (K20-K40)

Medium-hard CVD grade with thick coating for tough and demanding medium to rough milling applications of grey cast iron in dry conditions.

Complementary grades



GC4220 (HC) - K25 (K20 - K30)

Coated carbide grade for light to heavy milling of cast iron at medium speeds. To complement GC3000 grades in operations.



GC1010 (HC) - K05 (K01-K10)

Very hard PVD-coated grade with thin coating for finishing in very stable conditions. A harder complement to GC1020 in wet conditions.



H13A (HW) - K20 (K10-K25)

Hard uncoated carbide grade for rough to finish milling with sharp cutting edges, at low speeds and in average to stable, dry and wet conditions.



GC4240 (HC) - K40 (K30-K40)

Tough CVD-coated grade with medium-thick coating, for use as a tougher complement to GC3040 when stability is poor, in dry and wet conditions.



GC4230 (HC) - K30 (K20-K35)

Medium-hard CVD-coated grade with medium-thick coating, for toughness-demanding, medium to rough milling applications of nodular cast iron in dry and wet conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HC Hardmetals as above, but coated

Ceramics:

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for milling

N Non ferrous metals, plastics, wood

Basic grades



H13A (HW) - N15 (N10-N25)
 Hard uncoated grade for roughing to semi-finishing with sharp edges in average to stable conditions. Excellent surface finish in wet and dry machining.



GC1025 (HC) – N15 (N10 – N25)
 PVD-coated carbide grade for rough milling of aluminium alloys in combination with ground cutting edges.



CD10 (DP) - N05 (N01-N10)
 Polycrystalline diamond-tipped grade (PCD) with sharp edges for light roughing to finishing in stable conditions for wet or dry machining with a high demand on the quality of the surface finish and process stability. Good choice for abrasive materials.

Complementary grades



CT530 (HT) - N15 (N10-N20)
 Medium-hard, uncoated cermet grade for finishing in rather stable conditions and elevated cutting speeds in wet and dry conditions.



GC1130 (HC) - N15 (N10-N25)
 Hard, thin-coated PVD Zertivo™ grade for roughing to semi-finishing in average conditions with less demands on surface finish in wet and dry conditions.

*Where GC1130 does not exist, please use GC1030.



H10F (HW) - N15 (N10-N25)
 Hard uncoated grade for light roughing to finishing with sharp edges in average conditions for good surface in wet and dry conditions.

E

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I

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TIC) or titanium nitrides (TIN) or both

HC Hardmetals as above, but coated

Diamond:

DP Polycrystalline diamond¹⁾

J

Grades for milling

S

Heat resistant alloys Titanium alloys

Basic grades



S30T (HC) - S25 (S15-S30)

Medium-hard PVD-coated grade with thin coating, for finishing to light roughing applications in rather stable conditions. Excellent edge line durability and surface finish. Can be used in both wet and dry conditions.



S40T (HC) - S35 (S25-S45)

A very tough, medium-thick-coated CVD grade for roughing in toughness-demanding applications. Can be used in both wet and dry conditions.



GC1130 (HC) - S15 (S10-S25)

A hard PVD-coated Zertivo™ grade with thin coating, to be used as a complement to S30T for long time in cut. Can be used in both wet and dry conditions.

*Where GC1130 does not exist, please use GC1030.



GC1010 (HC) - S10 (S05-S10)

A very hard and thin-coated PVD grade for finishing in very stable, wet or dry conditions.



GC2030 (HC) - S20 (S15-S25)

Medium-hard, thin-coated PVD grade to be used as a complement to S30T for long time in cut. Can be used in both wet and dry conditions.



GC2040 (HC) - S30 (S25-S40)

Tough, medium thick coated CVD grade for roughing in toughness-demanding applications. Use as a complement to S40T for large diameters or large radial engagements in wet and dry conditions.



H10F (HW) - S25 (S20-S30)

Hard uncoated grade for light roughing to finishing in stable conditions with high demands on sharp edges and surface finish for both wet and dry conditions.



H13A (HW) - S20 (S15-S25)

Hard uncoated grade, for use as backup for H10F in more stable applications. Can be used in both wet and dry conditions.



GC1025 (HC) - S15 (S10-S20)

Hard, thin-coated PVD grade to be used as a complement to S30T for long time in cut and/or machining sticky materials. Can be used in both wet and dry conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:


HW Uncoated hardmetal containing primarily tungsten carbide (WC)


HC Hardmetals as above, but coated

Grades for milling


H Hardened steel


Basic grades


 **GC1010 (HC)** - H10 (H05-H15)
 Hard PVD grade with a thin coating for light roughing to finishing of hardened steel with 36 HRC or higher and should be used in stable conditions for both wet and dry machining.


 **GC4220 (HC)** - H25 (H15-H30)
 Hard CVD grade with a thick coating for light roughing to finishing at low feeds, moderate speeds and large radial engagements in the lower ISO H hardness range for both wet and dry machining.

Complementary grades

 **GC1130 (HC)** - H10 (H10-H20)
 Hard, thin coated PVD grade with Zertivo™ technology for light roughing to finishing at low feeds, moderate speeds and small radial engagements in the lower ISO H hardness range for both wet and dry machining.
 *Where GC1130 does not exist, please use GC1030.

 **CT530 (HT)** - H25(H10-H25)
 Medium-hard uncoated cermet grade, for light finishing in stable and dry conditions.

 **GC1025 (HC)** – H15 (H10 – H20)
 PVD-coated carbide grade for milling of hardened components at low feeds and moderate speeds.

 **GC3040 (HC)** - H25 (H20-H30)
 Medium-hard, thick coated CVD grade that can be used as a backup to GC4220 in unstable and dry conditions.

E

F

G

H

I

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

J

	ISO	ANSI			
P	01	C8			
	10				
	20	C7			
	30	C6			
	40				
	50	C5			
M	10	-			
	20				
	30				
	40				
K	01	C4			
	10	C3			
	20	C2			
	30	C1			
	40				
N	01	C4			
	10	C3			
	20	C2			
	30	C1			
S	10	-			
	20				
	30				
	40				
H	01	C4			
	10	C3			
	20	C2			
	30	C1			

The position and form of the grade symbols indicate the suitable field of application.

Centre of the field of application.

Recommended field of application.

▲ Wear resistance

▼ Toughness



= Basic grades



= Complementary grades



Drilling



B

C

D

E

F

G

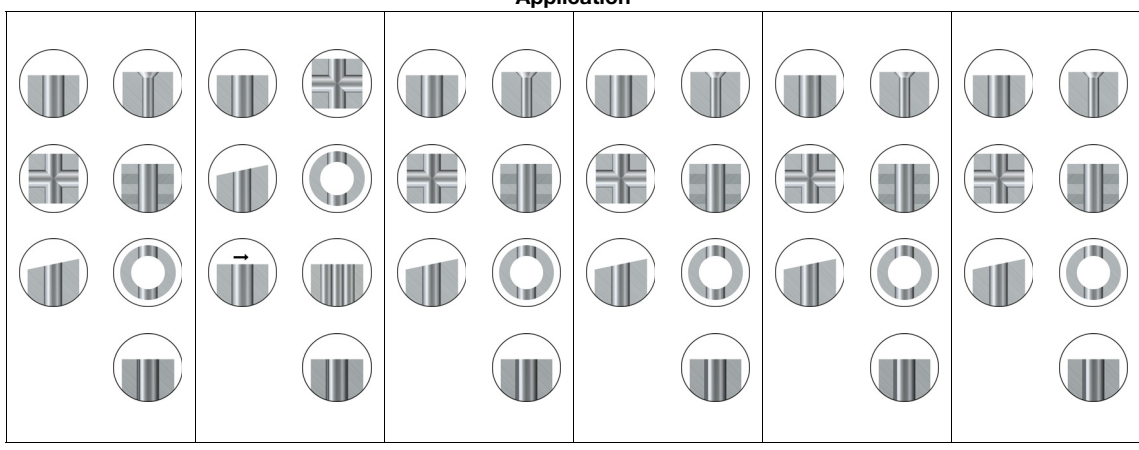
H

I

J

Drill type	Exchangeable tip drill	Indexable insert drill	Solid carbide drill	Solid carbide drill	Solid carbide drill	Solid carbide gun drill
Page	F4	See Rotating tools catalogue	See solid round tools catalogue	See solid round tools catalogue	See solid round tools catalogue	Web
DC mm	10.00 - 33.00	12.00 - 63.50	0.30 - 20.00	3.00 - 20.00	3.00 - 20.00	0.8 - 12.00
DC inch	.393-.472	.500	.012 - .787	.118 - .787	.118 - .787	.031- .472
ISO application area						
ULDR	3-10 x DC	2-5 x DC	2-7 x DC	7-8 x DC	3-7 x DC	≤300
TCHA	H9-H10	H12-H13	IT8-IT10	IT8-IT9	H6-H9	IT8
Coolant	Internal	Internal	Internal and external	Internal and external	Internal and external	Internal

Application



Exchangeable tip drills

CoroDrill® 870



F4

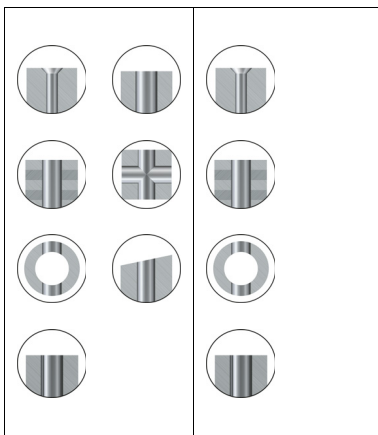
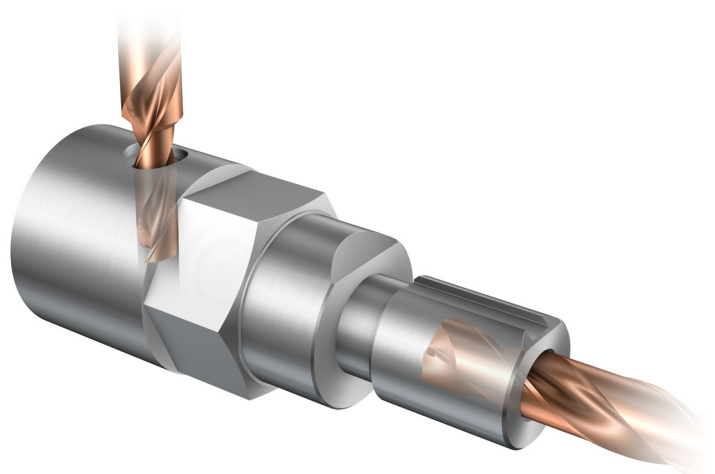
Indexable drills

CoroDrill® 880

Web

www.sandvik.coromant.com/corodril880

861	862
	
Solid carbide drill	Solid carbide drill
See solid round tools catalogue	See solid round tools catalogue
3.00 - 20.00	1.85-2.95
.118 - .787	.073 - .116
<div style="display: flex; flex-direction: column; gap: 5px;"> <div style="border: 1px solid black; background-color: #0056b3; color: white; padding: 2px; text-align: center;">P</div> <div style="border: 1px solid black; background-color: #ffcc00; color: black; padding: 2px; text-align: center;">M</div> <div style="border: 1px solid black; background-color: #808080; color: white; padding: 2px; text-align: center;">N</div> </div>	<div style="display: flex; flex-direction: column; gap: 5px;"> <div style="border: 1px solid black; background-color: #0056b3; color: white; padding: 2px; text-align: center;">P</div> <div style="border: 1px solid black; background-color: #ffcc00; color: black; padding: 2px; text-align: center;">M</div> <div style="border: 1px solid black; background-color: #808080; color: white; padding: 2px; text-align: center;">N</div> <div style="border: 1px solid black; background-color: #e67e22; color: white; padding: 2px; text-align: center;">S</div> </div>
12-30 x DC	8-12 x DC
H8-H9	H8-H9
Internal and external	Internal



CoroDrill® 870

Secure and predictable holemaking process

ISO application area:



Benefits and features

The interface between tip and drill is simple, accurate, and stable. Optimised drill flutes facilitate chip evacuation. The tip is changed while still in the holder saving you valuable cutting time. New cutting edge geometries and grades provide a safe cutting process with optimised chip control, high penetration rates, and a long, dependable tool life.

- Reliable and secure process
- Easy handling and secure tip changing
- Optimised chip control and evacuation
- Long, predictable tool life and high productivity
- Low cost per hole and excellent hole quality



www.sandvik.coromant.com/corodril870

Drill bodies

- Drilling depths: up to 10 x drill diameter
- Couplings: Cylindrical shank
- Hole tolerances: H9-H10

Drill tips

- New grades to provide increased tool life and predictable wear
- Easy handling and secure tip changing
- Tip changing possible while tool is in the machine to reduce downtime

Drill tip geometries

- PM optimized for ISO-P
- MM optimized for ISO-M
- GP pilot tip for all materials

Gently press the tip down and toward the support surface while tightening the screw to the recommended torque shown on the drill body. Preferably use a torque screw driver to ensure the tip is securely seated. Untighten the screw approximately 1.5 revolutions to release the tip.



Tailor Made step and chamfer drills for producing step or chamfer holes in one operation are available.

Hole tolerance (not applicable for GP geometry)

H9 - H10

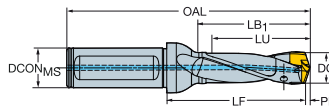
Diameter range, mm (inch)		10.00-18.00 (.394 - .708)
Hole tolerance, mm (inch)	3×DC-8×DC	0/+0.043 (.0017)
	10×DC	0/+0.070 (.0028)



CoroDrill® 870 exchangeable tip drill

Drill bodies

Cylindrical shank with flat according to ISO 9766



Metric design

							Dimensions, mm									
DCN	DCX		LU	CZC _{MS}	TCHA	Ordering code	DCON _{MS}	LF	OAL	LB ₁	PL			RPMX	MID _P	
10.00	10.49	6	33.09	16	H9	870-1000-6L16-3	16.00	46.40	96.00	35.00	1.60	10	0.141	33000	870-1040-6-PM	
10.00	10.49	6	54.07	16	H9	870-1000-6L16-5	16.00	67.40	117.00	56.00	1.60	10	0.148	15000		
10.00	10.49	6	85.54	16	H9	870-1000-6L16-8	16.00	99.40	149.00	88.00	1.60	15	0.157	12000		
10.00	10.49	6	106.52	16	H10	870-1000-6L16-10	16.00	120.40	170.00	109.00	1.60	30	0.161	9000		
10.50	10.99	7	34.67	16	H9	870-1050-7L16-3	16.00	47.31	97.00	36.00	1.69	10	0.143	33000	870-1090-7-PM	
10.50	10.99	7	56.65	16	H9	870-1050-7L16-5	16.00	69.31	119.00	58.00	1.69	10	0.150	15000		
10.50	10.99	7	89.62	16	H9	870-1050-7L16-8	16.00	102.31	152.00	91.00	1.69	15	0.161	12000		
10.50	10.99	7	111.60	16	H10	870-1050-7L16-10	16.00	124.31	174.00	113.00	1.69	30	0.168	9000		
11.00	11.49	8	36.23	16	H9	870-1100-8L16-3	16.00	49.25	99.00	38.00	1.75	10	0.145	33000	870-1140-8-PM	
11.00	11.49	8	59.21	16	H9	870-1100-8L16-5	16.00	72.25	122.00	61.00	1.75	10	0.154	15000		
11.00	11.49	8	93.68	16	H9	870-1100-8L16-8	16.00	107.25	157.00	96.00	1.75	15	0.165	12000		
11.00	11.49	8	116.66	16	H10	870-1100-8L16-10	16.00	130.25	180.00	119.00	1.75	30	0.172	9000		
11.50	11.99	9	37.82	16	H9	870-1150-9L16-3	16.00	51.17	101.00	40.00	1.83	10	0.146	33000	870-1190-9-PM	
11.50	11.99	9	61.80	16	H9	870-1150-9L16-5	16.00	75.17	125.00	64.00	1.83	10	0.157	15000		
11.50	11.99	9	97.77	16	H9	870-1150-9L16-8	16.00	111.17	161.00	100.00	1.83	15	0.170	12000		
11.50	11.99	9	121.75	16	H10	870-1150-9L16-10	16.00	135.17	185.00	124.00	1.83	30	0.178	9000		
12.00	12.49	10	39.38	16	H9	870-1200-10L16-3	16.00	53.10	103.00	42.00	1.90	10	0.151	33000	870-1240-10-PM	
12.00	12.49	10	64.36	16	H9	870-1200-10L16-5	16.00	77.10	127.00	66.00	1.90	10	0.164	15000		
12.00	12.49	10	101.83	16	H9	870-1200-10L16-8	16.00	116.10	166.00	105.00	1.90	15	0.180	12000		
12.00	12.49	10	126.81	16	H10	870-1200-10L16-10	16.00	141.10	191.00	130.00	1.90	30	0.187	7000		

Inch design

							Dimensions, inch									
DCN	DCX		LU	CZC _{MS}	TCHA	Ordering code	DCON _{MS}	LF	OAL	LB ₁	PL			RPMX	MID _P	
.393	.413	6	1.302	5/8	H9	870-1000-6LX063-3	.625	1.827	3.780	1.378	.063	145	0.308	33000	870-1040-6-PM	
.393	.413	6	2.128	5/8	H9	870-1000-6LX063-5	.625	2.654	4.606	2.205	.063	145	0.324	15000		
.393	.413	6	3.367	5/8	H9	870-1000-6LX063-8	.625	3.913	5.866	3.465	.063	217	0.344	12000		
.393	.413	6	4.193	5/8	H10	870-1000-6LX063-10	.625	4.740	6.693	4.291	.063	435	0.352	9000		
.413	.433	7	1.364	5/8	H9	870-1050-7LX063-3	.625	1.863	3.819	1.417	.067	145	0.312	33000	870-1090-7-PM	
.413	.433	7	2.230	5/8	H9	870-1050-7LX063-5	.625	2.729	4.685	2.283	.067	145	0.329	15000		
.413	.433	7	3.528	5/8	H9	870-1050-7LX063-8	.625	4.028	5.984	3.583	.067	217	0.354	12000		
.413	.433	7	4.393	5/8	H10	870-1050-7LX063-10	.625	4.894	6.850	4.449	.067	435	0.363	9000		
.433	.452	8	1.426	5/8	H9	870-1100-8LX063-3	.625	1.939	3.898	1.496	.069	145	0.317	33000	870-1140-8-PM	
.433	.452	8	2.331	5/8	H9	870-1100-8LX063-5	.625	2.844	4.803	2.402	.069	145	0.352	15000		
.433	.452	8	3.688	5/8	H9	870-1100-8LX063-8	.625	4.222	6.181	3.780	.069	217	0.363	12000		
.433	.452	8	4.592	5/8	H10	870-1100-8LX063-10	.625	5.128	7.087	4.685	.069	435	0.374	9000		
.452	.472	9	1.488	5/8	H9	870-1150-9LX063-3	.625	2.015	3.976	1.575	.072	145	0.320	33000	870-1190-9-PM	
.452	.472	9	2.433	5/8	H9	870-1150-9LX063-5	.625	2.959	4.921	2.520	.072	145	0.342	15000		
.452	.472	9	3.849	5/8	H9	870-1150-9LX063-8	.625	4.377	6.339	3.937	.072	217	0.374	12000		
.452	.472	9	4.793	5/8	H10	870-1150-9LX063-10	.625	5.322	7.283	4.882	.072	435	0.385	9000		
.472	.492	10	1.550	5/8	H9	870-1200-10LX063-3	.625	2.091	4.055	1.654	.075	145	0.332	33000	870-1240-10-PM	
.472	.492	10	2.533	5/8	H9	870-1200-10LX063-5	.625	3.035	5.000	2.598	.075	145	0.357	15000		
.472	.492	10	4.009	5/8	H9	870-1200-10LX063-8	.625	4.571	6.535	4.134	.075	217	0.391	10000		
.472	.492	10	4.992	5/8	H10	870-1200-10LX063-10	.625	5.555	7.520	5.118	.075	435	0.410	7000		



F6



J19



J9

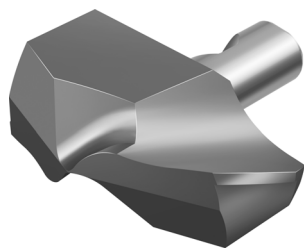


J16

CoroDrill® 870 drill tip

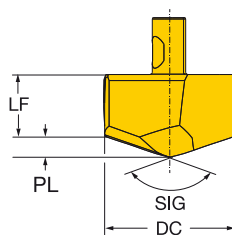
ENG

B



TCHA
SIG

H9
142°



C

D

		P	M	K	N	S	Dimensions, mm, inch							
DC	DC*	↑	Ordering code	4334	4334	4334	4334	4334	LF	LF"	PL	PL"	SIG	TCHA
10.00	.393	6	870-1000-6-PM	★	☆	☆	☆	☆	4.7	.183	1.5	.061	142°	H9
10.10	.397		870-1010-6-PM	★	☆	☆	☆	☆	4.7	.183	1.6	.061	142°	H9
10.20	.401		870-1020-6-PM	★	☆	☆	☆	☆	4.6	.182	1.6	.062	142°	H9
10.30	.405		870-1030-6-PM	★	☆	☆	☆	☆	4.6	.181	1.6	.063	142°	H9
10.40	.409		870-1040-6-PM	★	☆	☆	☆	☆	4.6	.181	1.6	.063	142°	H9
10.50	.413	7	870-1050-7-PM	★	☆	☆	☆	☆	4.6	.180	1.6	.064	142°	H9
10.60	.417		870-1060-7-PM	★	☆	☆	☆	☆	4.6	.180	1.6	.065	142°	H9
10.70	.421		870-1070-7-PM	★	☆	☆	☆	☆	4.6	.179	1.7	.065	142°	H9
10.80	.425		870-1080-7-PM	★	☆	☆	☆	☆	4.5	.178	1.7	.066	142°	H9
10.90	.429		870-1090-7-PM	★	☆	☆	☆	☆	4.5	.178	1.7	.067	142°	H9
11.00	.433	8	870-1100-8-PM	★	☆	☆	☆	☆	5.2	.206	1.7	.066	142°	H9
11.10	.437		870-1110-8-PM	★	☆	☆	☆	☆	5.2	.205	1.7	.067	142°	H9
11.11	.437		870-1111-8-PM	★	☆	☆	☆	☆	5.2	.205	1.7	.067	142°	H9
11.20	.440		870-1120-8-PM	★	☆	☆	☆	☆	5.2	.204	1.7	.067	142°	H9
11.30	.444		870-1130-8-PM	★	☆	☆	☆	☆	5.2	.204	1.7	.068	142°	H9
11.40	.448		870-1140-8-PM	★	☆	☆	☆	☆	5.2	.203	1.8	.069	142°	H9
11.50	.452	9	870-1150-9-PM	★	☆	☆	☆	☆	5.1	.202	1.8	.069	142°	H9
11.60	.456		870-1160-9-PM	★	☆	☆	☆	☆	5.1	.202	1.8	.070	142°	H9
11.70	.460		870-1170-9-PM	★	☆	☆	☆	☆	5.1	.201	1.8	.071	142°	H9
11.80	.464		870-1180-9-PM	★	☆	☆	☆	☆	5.1	.200	1.8	.071	142°	H9
11.90	.468		870-1190-9-PM	★	☆	☆	☆	☆	5.1	.200	1.8	.072	142°	H9
12.00	.472	10	870-1200-10-PM	★	☆	☆	☆	☆	5.7	.223	1.8	.072	142°	H9

G

H

I

J



F5



F9



F17

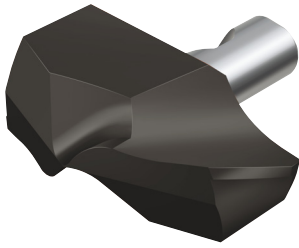
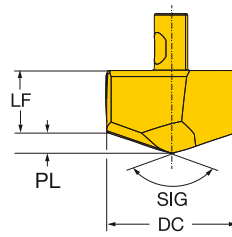


J19



J9

CoroDrill® 870 drill tip

TCHA
SIGH9
142°

		M	S	Dimensions, mm, inch						
DC	DC*	Ordering code	2334	2334	LF	LF*	PL	PL*	SIG	TCHA
10.00	.393	6 870-1000-6-MM	★	☆	4.7	.183	1.5	.061	142°	H9
10.10	.397	870-1010-6-MM	★	☆	4.7	.183	1.6	.061	142°	H9
10.20	.401	870-1020-6-MM	★	☆	4.6	.182	1.6	.062	142°	H9
10.30	.405	870-1030-6-MM	★	☆	4.6	.181	1.6	.063	142°	H9
10.40	.409	870-1040-6-MM	★	☆	4.6	.181	1.6	.063	142°	H9
10.50	.413	7 870-1050-7-MM	★	☆	4.6	.180	1.6	.064	142°	H9
10.60	.417	870-1060-7-MM	★	☆	4.6	.180	1.6	.065	142°	H9
10.70	.421	870-1070-7-MM	★	☆	4.6	.179	1.7	.065	142°	H9
10.80	.425	870-1080-7-MM	★	☆	4.5	.178	1.7	.066	142°	H9
10.90	.429	870-1090-7-MM	★	☆	4.5	.178	1.7	.067	142°	H9
11.00	.433	8 870-1100-8-MM	★	☆	5.2	.206	1.7	.066	142°	H9
11.10	.437	870-1110-8-MM	★	☆	5.2	.205	1.7	.067	142°	H9
11.11	.437	870-1111-8-MM	★	☆	5.2	.205	1.7	.067	142°	H9
11.20	.440	870-1120-8-MM	★	☆	5.2	.204	1.7	.067	142°	H9
11.30	.444	870-1130-8-MM	★	☆	5.2	.204	1.7	.068	142°	H9
11.40	.448	870-1140-8-MM	★	☆	5.2	.203	1.8	.069	142°	H9
11.50	.452	9 870-1150-9-MM	★	☆	5.1	.202	1.8	.069	142°	H9
11.60	.456	870-1160-9-MM	★	☆	5.1	.202	1.8	.070	142°	H9
11.70	.460	870-1170-9-MM	★	☆	5.1	.201	1.8	.071	142°	H9
11.80	.464	870-1180-9-MM	★	☆	5.1	.200	1.8	.071	142°	H9
11.90	.468	870-1190-9-MM	★	☆	5.1	.200	1.8	.072	142°	H9
12.00	.472	10 870-1200-10-MM	★	☆	5.7	.223	1.8	.072	142°	H9



F5



F9



F17



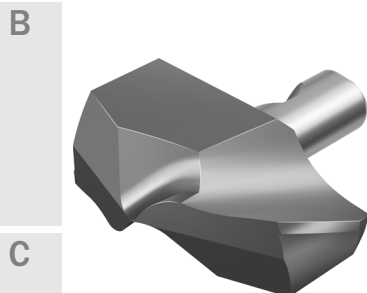
J19



J9

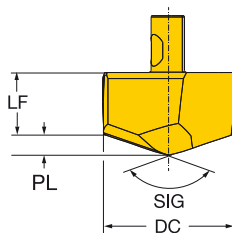
CoroDrill® 870 drill tip

For pilot holes



TCHA
SIG

F9
152°



C

		P	M	K	N	S	Dimensions, mm, inch					
DC	DC*	4334	4334	4334	4334	4334	LF	LF"	PL	PL"	SIG	TCHA

D

DC	DC*	Ordering code	P	M	K	N	S	LF	LF"	PL	PL"	SIG	TCHA
10.00	.393	870-1000-6-GP	*	*	*	*	*	4.6	.181	1.1	.043	152°	F9
10.10	.397	870-1010-6-GP	*	*	*	*	*	4.6	.181	1.1	.043	152°	F9
10.20	.401	870-1020-6-GP	*	*	*	*	*	4.6	.180	1.1	.044	152°	F9
10.30	.405	870-1030-6-GP	*	*	*	*	*	4.6	.180	1.1	.044	152°	F9
10.40	.409	870-1040-6-GP	*	*	*	*	*	4.6	.180	1.1	.045	152°	F9
10.50	.413	870-1050-7-GP	*	*	*	*	*	4.6	.179	1.2	.045	152°	F9
10.60	.417	870-1060-7-GP	*	*	*	*	*	4.6	.179	1.2	.045	152°	F9
10.70	.421	870-1070-7-GP	*	*	*	*	*	4.5	.179	1.2	.046	152°	F9
10.80	.425	870-1080-7-GP	*	*	*	*	*	4.5	.178	1.2	.046	152°	F9
10.90	.429	870-1090-7-GP	*	*	*	*	*	4.5	.178	1.2	.046	152°	F9
11.00	.433	870-1100-8-GP	*	*	*	*	*	5.2	.206	1.2	.046	152°	F9
11.10	.437	870-1110-8-GP	*	*	*	*	*	5.2	.205	1.2	.047	152°	F9
11.11	.437	870-1111-8-GP	*	*	*	*	*	5.2	.205	1.2	.047	152°	F9
11.20	.440	870-1120-8-GP	*	*	*	*	*	5.2	.204	1.2	.048	152°	F9
11.30	.444	870-1130-8-GP	*	*	*	*	*	5.2	.204	1.2	.048	152°	F9
11.40	.448	870-1140-8-GP	*	*	*	*	*	5.2	.204	1.2	.048	152°	F9
11.50	.452	870-1150-9-GP	*	*	*	*	*	5.2	.203	1.2	.049	152°	F9
11.60	.456	870-1160-9-GP	*	*	*	*	*	5.2	.203	1.3	.049	152°	F9
11.70	.460	870-1170-9-GP	*	*	*	*	*	5.1	.202	1.3	.050	152°	F9
11.80	.464	870-1180-9-GP	*	*	*	*	*	5.1	.202	1.3	.050	152°	F9
11.90	.468	870-1190-9-GP	*	*	*	*	*	5.1	.202	1.3	.050	152°	F9
12.00	.472	870-1200-10-GP	*	*	*	*	*	5.7	.225	1.3	.051	152°	F9

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CoroDrill® 870

< 6 x DC

Metric values

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V _c) m/min correlating with drill diameter		
					10.00-20.99 mm		
					Min.	Rec.	Max.
P	Unalloyed steel				Grade 4334		
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	80	120	160
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	80	120	160
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	70	100	130
	P1.5.C.UT	06.1	Cast - untreated	150	80	110	140
	Low alloy steel				Grade 4334 and 3334		
	P2.1.Z.AN	02.1	Annealed	175	80	110	140
	P2.2.Z.AN	02.1	Annealed	240	80	110	140
	P2.4.Z.AN	02.1	Annealed	225	80	110	140
	P2.5.Z.HT	02.2	Hardened and tempered	330	70	100	130
P2.6.C.UT	06.2	Cast - untreated	200	70	100	130	
High alloy steel							
P3.0.Z.AN	03.11	Annealed	200	60	80	100	
P3.0.Z.HT	03.21	Hardened and tempered	380	40	60	80	
M	Ferritic/martensitic stainless steel				Grade 4334 and 2334		
	P5.0.Z.AN	05.11	Annealed	200	30	40	50
	P5.0.Z.HT	05.13	Hardened and tempered	330	70	90	110
	Austenitic stainless steel				Grade 2334 and 4334		
	M1.0.Z.AQ	05.21	Annealed/quenched	200	40	50	60
	M1.0.C.UT	15.21	Cast+untreated	200	50	60	70
	M1.1.Z.AQ	05.21	Machinability improved	200	60	75	90
	Super-austenitic (Ni≥20%) stainless steel						
	M2.0.Z.AQ	05.23	Annealed/quenched	200	20	40	60
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	20	40	60
Duplex (austenitic/ferritic) stainless steel							
M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	40	55	70	
M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	20	40	60	
K	Malleable cast iron				Grade 3334 and 4334		
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	100	145	190
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	90	125	160
	Grey cast iron						
	K2.1.C.UT	08.1	Low tensile strength	180	100	150	200
	K2.2.C.UT	08.2	High tensile strength	245	90	130	170
Nodular cast iron							
K3.1.C.UT	09.1	Ferritic	155	100	145	190	
K3.3.C.UT	09.2	Pearlitic	265	90	125	160	
N	Aluminium based alloys				Grade 4334		
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	150	200	250
N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	150	200	250	
S	Heat resistant super alloys				Grade 2334 and 4334		
	S2.0.Z.AG	20.22	Ni based	350	18	20	30
S4.3.Z.AN	23.21	Titanium based	330	25	40	60	

CoroDrill® 870

< 6 x DC

Metric values

Feed (f _n) mm/r correlating with drill diameter					
10.00-11.99 mm			12.00-13.99 mm		
Min.	Rec.	Max.	Min.	Rec.	Max.
Geometry -PM and -GP					
0.12	0.18	0.28	0.14	0.20	0.35
0.12	0.18	0.28	0.14	0.20	0.35
0.12	0.18	0.28	0.14	0.20	0.35
0.12	0.18	0.28	0.14	0.20	0.35
Geometry -PM, -KM and -GP					
0.12	0.18	0.30	0.14	0.20	0.37
0.12	0.18	0.30	0.14	0.20	0.37
0.12	0.18	0.30	0.14	0.20	0.37
0.12	0.18	0.30	0.14	0.20	0.37
0.12	0.18	0.30	0.14	0.20	0.37
0.10	0.16	0.24	0.12	0.19	0.33
0.10	0.16	0.24	0.12	0.19	0.33
Geometry -PM, -MM and -GP					
0.12	0.14	0.19	0.14	0.16	0.22
0.10	0.12	0.16	0.10	0.12	0.16
Geometry -MM and -GP					
0.10	0.12	0.14	0.10	0.12	0.14
0.10	0.12	0.14	0.10	0.12	0.14
0.10	0.12	0.16	0.10	0.12	0.16
0.10	0.12	0.14	0.10	0.12	0.16
0.10	0.12	0.14	0.10	0.12	0.16
Geometry -MM and -GP					
0.10	0.12	0.16	0.10	0.12	0.16
0.10	0.12	0.14	0.10	0.12	0.14
Geometry -KM and -GP					
0.16	0.25	0.36	0.18	0.30	0.42
0.16	0.25	0.36	0.18	0.30	0.42
0.16	0.25	0.36	0.18	0.30	0.42
0.16	0.25	0.36	0.18	0.30	0.42
0.16	0.25	0.36	0.18	0.30	0.42
Geometry -PM and -GP					
0.20	0.25	0.30	0.22	0.32	0.40
0.20	0.25	0.30	0.22	0.32	0.40
Geometry -PM, -MM and -GP					
0.08	0.10	0.14	0.08	0.11	0.14
0.09	0.12	0.15	0.10	0.14	0.16

CoroDrill® 870

≥ 6 x DC

Metric values

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V _c) m/min correlating with drill diameter		
					10.00-20.99 mm		
					Min.	Rec.	Max.
P	Unalloyed steel				Grade 4334		
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	80	120	160
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	80	120	160
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	70	100	130
	P1.5.C.UT	06.1	Cast - untreated	150	80	110	140
	Low alloy steel				Grade 4334 and 3334		
	P2.1.Z.AN	02.1	Annealed	175	80	110	140
	P2.2.Z.AN	02.1	Annealed	240	80	110	140
	P2.4.Z.AN	02.1	Annealed	225	80	110	140
	P2.5.Z.HT	02.2	Hardened and tempered	330	70	100	130
P2.6.C.UT	06.2	Cast - untreated	200	70	100	130	
P	High alloy steel						
	P3.0.Z.AN	03.11	Annealed	200	60	80	100
P3.0.Z.HT	03.21	Hardened and tempered	380	40	60	80	
M	Ferritic/martensitic stainless steel				Grade 4334 and 2334		
	P5.0.Z.AN	05.11	Annealed	200	30	40	50
	P5.0.Z.HT	05.13	Hardened and tempered	330	70	90	110
	Austenitic stainless steel				Grade 2334 and 4334		
	M1.0.Z.AQ	05.21	Annealed/quenched	200	40	50	60
	M1.0.C.UT	15.21	Cast+untreated	200	50	60	70
	M1.1.Z.AQ	05.21	Machinability improved	200	60	75	90
	Super-austenitic (Ni≥20%) stainless steel						
	M2.0.Z.AQ	05.23	Annealed/quenched	200	20	40	60
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	20	40	60
Duplex (austenitic/ferritic) stainless steel				Grade 2334			
M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	40	55	70	
M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	20	40	60	
K	Malleable cast iron				Grade 3334 and 4334		
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	100	130	170
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	90	115	145
	Grey cast iron						
	K2.1.C.UT	08.1	Low tensile strength	180	100	135	180
	K2.2.C.UT	08.2	High tensile strength	245	90	120	155
K	Nodular cast iron						
	K3.1.C.UT	09.1	Ferritic	155	100	130	170
K3.3.C.UT	09.2	Pearlitic	265	90	115	145	
N	Aluminium based alloys				Grade 4334		
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	150	200	250
N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	150	200	250	
S	Heat resistant super alloys				Grade 2334 and 4334		
	S2.0.Z.AG	20.22	Ni based	350	18	20	30
S4.3.Z.AN	23.21	Titanium based	330	25	40	60	

CoroDrill® 870

≥ 6 x DC

Metric values

Feed (f _n) mm/r correlating with drill diameter					
10.00-11.99 mm			12.00-13.99 mm		
Min.	Rec.	Max.	Min.	Rec.	Max.
Geometry -PM					
0.12	0.14	0.22	0.14	0.16	0.28
0.12	0.14	0.22	0.14	0.16	0.28
0.12	0.14	0.22	0.14	0.16	0.28
0.12	0.14	0.22	0.14	0.16	0.28
Geometry -PM and -KM					
0.12	0.14	0.24	0.14	0.16	0.30
0.12	0.14	0.24	0.14	0.16	0.30
0.12	0.14	0.24	0.14	0.16	0.30
0.12	0.13	0.21	0.14	0.15	0.26
0.12	0.14	0.24	0.14	0.16	0.30
0.10	0.13	0.19	0.12	0.15	0.26
0.10	0.11	0.17	0.12	0.13	0.23
Geometry -PM and -MM					
0.12	0.13	0.15	0.14	0.15	0.18
0.10	0.11	0.12	0.10	0.11	0.12
Geometry -MM and -PM					
0.10	0.11	0.12	0.10	0.11	0.12
0.10	0.11	0.12	0.10	0.11	0.12
0.10	0.11	0.13	0.10	0.11	0.13
0.10	0.11	0.12	0.10	0.11	0.13
0.10	0.11	0.12	0.10	0.11	0.13
Geometry -MM					
0.10	0.11	0.13	0.10	0.11	0.13
0.10	0.11	0.12	0.10	0.11	0.13
Geometry -KM and -PM					
0.16	0.20	0.29	0.18	0.24	0.34
0.16	0.20	0.29	0.18	0.24	0.34
0.16	0.20	0.29	0.18	0.24	0.34
0.16	0.20	0.29	0.18	0.24	0.34
Geometry -PM					
0.20	0.22	0.28	0.22	0.24	0.35
0.20	0.22	0.28	0.22	0.24	0.35
Geometry -MM and -PM					
0.08	0.10	0.14	0.08	0.11	0.14
0.09	0.11	0.14	0.10	0.12	0.15

CoroDrill® 870

< 6 x DC

Inch values

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V _c) ft/min correlating with drill diameter .3937-.8264"		
					Min.	Rec.	Max.
P	Unalloyed steel				Grade 4334		
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	260	395	525
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	260	395	525
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	230	330	425
	P1.5.C.UT	06.1	Cast - untreated	150	260	360	460
	Low alloy steel				Grade 4334 and 3334		
	P2.1.Z.AN	02.1	Annealed	175	260	360	460
	P2.2.Z.AN	02.1	Annealed	240	260	360	460
	P2.4.Z.AN	02.1	Annealed	225	260	360	460
	P2.5.Z.HT	02.2	Hardened and tempered	330	230	330	425
P2.6.C.UT	06.2	Cast - untreated	200	230	330	425	
P	High alloy steel						
	P3.0.Z.AN	03.11	Annealed	200	195	260	330
P3.0.Z.HT	03.21	Hardened and tempered	380	130	195	260	
M	Ferritic/martensitic stainless steel				Grade 4334 and 2334		
	P5.0.Z.AN	05.11	Annealed	200	100	130	165
	P5.0.Z.HT	05.13	Hardened and tempered	330	230	295	360
	Austenitic stainless steel				Grade 2334 and 4334		
	M1.0.Z.AQ	05.21	Annealed/quenched	200	130	165	195
	M1.0.C.UT	15.21	Cast+untreated	200	165	195	230
	M1.1.Z.AQ	05.21	Machinability improved	200	195	245	295
	Super-austenitic (Ni≥20%) stainless steel						
	M2.0.Z.AQ	05.23	Annealed/quenched	200	65	130	195
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	65	130	195
Duplex (austenitic/ferritic) stainless steel							
M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	130	180	230	
M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	65	130	195	
K	Malleable cast iron				Grade 3334 and 4334		
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	330	475	620
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	295	410	525
	Grey cast iron						
	K2.1.C.UT	08.1	Low tensile strength	180	330	490	655
	K2.2.C.UT	08.2	High tensile strength	245	295	425	560
Nodular cast iron							
K3.1.C.UT	09.1	Ferritic	155	330	475	620	
K3.3.C.UT	09.2	Pearlitic	265	295	410	525	
N	Aluminium based alloys				Grade 4334		
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	490	650	820
N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	490	650	820	
S	Heat resistant super alloys				Grade 2334 and 4334		
	S2.0.Z.AG	20.22	Ni based	350	60	65	100
S4.3.Z.AN	23.21	Titanium based	330	80	130	195	

CoroDrill® 870

< 6 x DC

Inch values

Feed (f _n) inch/rev. correlating with drill diameter					
.3937-.4720"			.4724-.5508"		
Min.	Rec.	Max.	Min.	Rec.	Max.
Geometry -PM and -GP					
.0047	.0071	.0110	.0055	.0079	.0138
.0047	.0071	.0110	.0055	.0079	.0138
.0047	.0071	.0110	.0055	.0079	.0138
.0047	.0074	.0110	.0055	.0079	.0138
Geometry -PM, -KM and -GP					
.0047	.0071	.0118	.0055	.0079	.0146
.0047	.0071	.0118	.0055	.0079	.0146
.0047	.0071	.0118	.0055	.0079	.0146
.0047	.0071	.0118	.0055	.0079	.0146
.0047	.0074	.0118	.0055	.0079	.0146
.0039	.0063	.0094	.0047	.0075	.0130
.0039	.0063	.0094	.0047	.0075	.0130
Geometry -PM, -MM and -GP					
.0047	.0055	.0075	.0055	.0063	.0087
.0039	.0047	.0063	.0039	.0047	.0063
Geometry -MM, PM and -GP					
.0039	.0047	.0055	.0039	.0047	.0055
.0039	.0047	.0055	.0039	.0047	.0055
.0039	.0047	.0063	.0039	.0047	.0063
Geometry -MM and -GP					
.0039	.0047	.0063	.0039	.0047	.0063
.0039	.0047	.0055	.0039	.0047	.0055
Geometry -KM, PM and -GP					
.0063	.0098	.0142	.0071	.0118	.0165
.0063	.0098	.0142	.0071	.0118	.0165
Geometry -PM and -GP					
.0063	.0098	.0142	.0071	.0118	.0165
.0063	.0098	.0142	.0071	.0118	.0165
Geometry -PM and -GP					
.0079	.0098	.0118	.0087	.0126	.0157
.0079	.0098	.0118	.0087	.0126	.0157
Geometry -MM, -PM and -GP					
.0031	.0039	.0055	.0031	.0043	.0055
.0035	.0047	.0059	.0039	.0055	.0063

CoroDrill® 870

≥ 6 x DC

Inch values

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V _c) ft/min correlating with drill diameter		
					.3937-.8264"		
					Min.	Rec.	Max.
P	Unalloyed steel				Grade 4334		
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	260	395	525
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	260	395	525
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	230	330	425
	P1.5.C.UT	06.1	Cast - untreated	150	260	360	460
	Low alloy steel				Grade 4334 and 3334		
	P2.1.Z.AN	02.1	Annealed	175	260	360	460
	P2.2.Z.AN	02.1	Annealed	240	260	360	460
	P2.4.Z.AN	02.1	Annealed	225	260	360	460
	P2.5.Z.HT	02.2	Hardened and tempered	330	230	330	425
P2.6.C.UT	06.2	Cast - untreated	200	230	330	425	
High alloy steel							
P3.0.Z.AN	03.11	Annealed	200	195	260	330	
P3.0.Z.HT	03.21	Hardened and tempered	380	130	195	260	
M	Ferritic/martensitic stainless steel				Grade 4334 and 2334		
	P5.0.Z.AN	05.11	Annealed	200	100	130	165
	P5.0.Z.HT	05.13	Hardened and tempered	330	230	295	360
	Austenitic stainless steel				Grade 2334 and 4334		
	M1.0.Z.AQ	05.21	Annealed/quenched	200	130	165	195
	M1.0.C.UT	15.21	Cast+untreated	200	165	195	230
	M1.1.Z.AQ	05.21	Machinability improved	200	195	245	295
	Super-austenitic (Ni≥20%) stainless steel						
	M2.0.Z.AQ	05.23	Annealed/quenched	200	65	130	195
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	65	130	195
Duplex (austenitic/ferritic) stainless steel				Grade 2334			
M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	130	180	230	
M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	65	130	195	
K	Malleable cast iron				Grade 3334 and 4334		
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	330	425	560
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	295	380	475
	Grey cast iron						
	K2.1.C.UT	08.1	Low tensile strength	180	330	440	590
	K2.2.C.UT	08.2	High tensile strength	245	295	395	510
Nodular cast iron							
K3.1.C.UT	09.1	Ferritic	155	330	425	560	
K3.3.C.UT	09.2	Pearlitic	265	295	380	475	
N	Aluminium based alloys				Grade 4334		
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	490	650	820
N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	490	650	820	
S	Heat resistant super alloys				Grade 2334 and 4334		
	S2.0.Z.AG	20.22	Ni based	350	60	65	100
S4.3.Z.AN	23.21	Titanium based	330	80	130	195	

CoroDrill® 870

≥ 6 x DC

Inch values

Feed (f _n) inch/rev. correlating with drill diameter					
.3937-.4720"			.4724-.5508"		
Min.	Rec.	Max.	Min.	Rec.	Max.
Geometry -PM					
.0047	.0057	.0088	.0055	.0063	.0110
.0047	.0057	.0088	.0055	.0063	.0110
.0047	.0057	.0088	.0055	.0063	.0110
.0047	.0057	.0088	.0055	.0063	.0110
Geometry -PM and -KM					
.0047	.0057	.0094	.0055	.0063	.0117
.0047	.0057	.0094	.0055	.0063	.0117
.0047	.0057	.0094	.0055	.0063	.0117
.0047	.0050	.0083	.0055	.0059	.0102
.0047	.0057	.0094	.0055	.0063	.0117
Geometry -PM and -MM					
.0039	.0050	.0076	.0047	.0060	.0104
.0039	.0044	.0066	.0047	.0052	.0091
Geometry -MM and -PM					
.0047	.0051	.0060	.0055	.0059	.0069
.0039	.0043	.0047	.0039	.0043	.0047
Geometry -MM and -PM					
.0039	.0043	.0047	.0039	.0043	.0047
.0039	.0043	.0047	.0039	.0043	.0047
.0039	.0043	.0050	.0039	.0043	.0050
Geometry -MM					
.0039	.0043	.0050	.0039	.0043	.0050
.0039	.0043	.0047	.0039	.0043	.0050
Geometry -KM and -PM					
.0063	.0079	.0113	.0071	.0094	.0132
.0063	.0079	.0113	.0071	.0094	.0132
Geometry -KM and -PM					
.0063	.0079	.0113	.0071	.0094	.0132
.0063	.0079	.0113	.0071	.0094	.0132
Geometry -PM					
.0079	.0087	.0110	.0087	.0094	.0138
.0079	.0087	.0110	.0087	.0094	.0138
Geometry -MM and -PM					
.0031	.0039	.0055	.0031	.0043	.0055
.0035	.0043	.0055	.0039	.0047	.0059

Grades for drills with indexable inserts

P

Steel, cast steel, martensitic stainless steel, long chipping malleable iron



GC4324 (HC) – P20 (P10-P35)

Grade for peripheral insert. Grade GC4324 is the productivity choice in stable conditions. Inveio technology enables high wear resistance and long tool life. GC4324 withstands high cutting temperatures, making it suitable for high cutting speed, high feed, or long time in cut. MT-CVD coated grade.



GC4234(HC) – P30 (P15-P35)

Fine grained cemented carbide substrate with excellent combination of both hardness and toughness. A thick multilayered TiAlN coating with optimized residual stress and hardness level.



GC1044(HC) – P40 (P25-P50)

The basic choice as central insert for ISO P application area. PVD-coated grade with excellent wear resistance and toughness at low to high cutting speeds.



GC4344 (HC) - P40 (P25-P45)

Grade for peripheral insert. Suitable for toughness demanding operations. When machining in average to difficult conditions, select grade GC4344 for good edge-line properties and reliable tool life. PVD coated grade using Zertivo technology.



GC4334(HC) - P30 (P20-P40)

Grade for peripheral insert. Grade GC4334 is the first choice in applications with good to average conditions. Inveio technology provides a high level of wear resistance. Long tool life and reliable wear that is easy to follow. MT-CVD coated grade.

B

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H

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW	Uncoated hardmetal containing primarily tungsten carbide (WC)
HT	Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
HC	Hardmetals as above, but coated

Ceramics:

CA	Oxide ceramics containing primarily aluminium oxide (Al_2O_3).
CM	Mixed ceramics containing primarily aluminium oxide (Al_2O_3) but containing components other than oxides.
CN	Nitride ceramics containing primarily silicon nitride (Si_3N_4)
CC	Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

I

J

Grades for drills with indexable inserts

M Austenitic/ferritic/martensitic stainless steel, cast steel, manganese steel, alloy cast iron, malleable iron, free cutting steel.



GC1144 (HC) – M35 (M20-M40)
 First choice centre ISO M grade. Suitable for all types of stainless steels. PVD coated grade.



GC2234 (HC) - M25 (M15-M35)
 A tough fine grained cemented carbide substrate together with a thin multilayered TiAlN coating, optimized for high edge line security and resistance to adhesive forces when drilling ISO M materials.



GC2044 (HC) – M35 (M20-M40)
 First choice periphery ISO M grade based on fine-grained cemented carbide coated with a PVD-oxide coating for excellent wear resistance and resistance against built up edge in all types of stainless steels.



GC4234 (HC) - M20 (M10-M30)
 Fine grained cemented carbide substrate with excellent combination of both hardness and toughness. A thick multilayered TiAlN coating with optimized residual stress and hardness level.



GC1044(HC) – M35 (M20-M40)
 Grade for central insert. PVD coated.



GC4344 (HC) - M35 (M20-M40)
 Complementary periphery ISO S grade. GC4344 is a PVD coated grade using Zertivo technology, with excellent edge toughness and resistance against built-up edge.



GC4334(HC) - M30 (M20-M35)
 Grade for peripheral insert. GC4334 is a complementary grade in applications with good to average conditions. Inveio technology provides a high level of wear resistance. MT-CVD coated grade.

Letter symbols specifying the designation of hard cutting materials:

- Hardmetals:**
- HW Uncoated hardmetal containing primarily tungsten carbide (WC)
 - HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
 - HC Hardmetals as above, but coated

Ceramics:

- CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).
- CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.
- CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)
- CC Ceramics as above, but coated.

Diamond:

- DP Polycrystalline diamond¹⁾

Boron nitride:

- BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.



Grades for drills with indexable inserts

N Non ferrous metals



GC1044 (HC) – N20 (N10-N30)

The basic choice as central grade for ISO N application area. PVD-coated grade.



GC4344(HC) - N20 (N10-N30)

Complementary periphery ISO S grade. GC4344 is a PVD coated grade using Zertivo technology, with excellent edge toughness and resistance against built-up edge.



GC4334 (HC) - N15 (N01-N25)

First peripheral grade choice in steel applications with good to average conditions. Inveio™ technology provides a high level of wear resistance.



GC4234(HC) - N15 (N05-N25)

Fine grained cemented carbide substrate with excellent combination of both hardness and toughness. A thick multilayered TiAlN coating with optimized residual stress and hardness level.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW	Uncoated hardmetal containing primarily tungsten carbide (WC)
HT	Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
HC	Hardmetals as above, but coated

Ceramics:

CA	Oxide ceramics containing primarily aluminium oxide (Al ₂ O ₃).
CM	Mixed ceramics containing primarily aluminium oxide (Al ₂ O ₃) but containing components other than oxides.
CN	Nitride ceramics containing primarily silicon nitride (Si ₃ N ₄)
CC	Ceramics as above, but coated.

Diamond:

DP	Polycrystalline diamond ¹⁾
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Boron nitride:


BN	Polycrystalline boron nitride ¹⁾
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¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

Grades for drills with indexable inserts

S Heat resistant and super alloys

 **GC1044 (HC)** – S30 (S20-S35)
Complementary central grade for ISO S materials. PVD-coated grade.

 **GC4344(HC)** - S30 (S20-S40)
Complementary periphery ISO S grade. GC4344 is a PVD coated grade using Zertivo technology, with excellent edge toughness and resistance against built-up edge.

 **GC4334(HC)** – H15 (H10-H25)
Peripheral insert
Inveio enables high wear resistance and long tool life.

Letter symbols specifying the designation of hard cutting materials:

- Hardmetals:**
- HW Uncoated hardmetal containing primarily tungsten carbide (WC)
 - HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both
 - HC Hardmetals as above, but coated

Ceramics:

- CA Oxide ceramics containing primarily aluminium oxide (Al₂O₃).
- CM Mixed ceramics containing primarily aluminium oxide (Al₂O₃) but containing components other than oxides.
- CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)
- CC Ceramics as above, but coated.

Diamond:

- DP Polycrystalline diamond¹⁾

Boron nitride:

- BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.



Grades for drills with indexable inserts

H Hardened materials



GC4334(HC) – H15 (H10-H25)

Peripheral insert

Inveio enables high wear resistance and long tool life.



GC4344 (HC) - H20 (H10-H30)

Complementary periphery ISO S grade. GC4344 is a PVD coated grade using Zertivo technology, with excellent edge toughness and resistance against built-up edge.



GC1044(HC) – H20 (H10-H30)

The basic choice as central grade for ISO H application area. PVD-coated grade.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

Ceramics:

CA Oxide ceramics containing primarily aluminium oxide (Al_2O_3).

CM Mixed ceramics containing primarily aluminium oxide (Al_2O_3) but containing components other than oxides.

CN Nitride ceramics containing primarily silicon nitride (Si_3N_4)

CC Ceramics as above, but coated.

Diamond:

DP Polycrystalline diamond¹⁾

Boron nitride:

BN Polycrystalline boron nitride¹⁾

¹⁾ Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

CoroDrill® 870

CoroDrill® 880

	ISO	ANSI	CoroDrill® 870			CoroDrill® 880			Stability
			Low	Heat	High	Low	Heat	High	
P Steel	01	C8							▲
	10	C7		GC 4334			GC 4334	GC 4324	
	20	C6		GC 4334			GC 4334	GC 4324	
	30	C6				GC 1044 4344			
	40	C5							▼
M Stainless steel	10	-					GC 1144	GC 4334	▲
	20	-		GC 2334	GC 4334		GC 1044 4344	GC 4334	
	30	-							
	40	-					GC 2044		▼
K Cast iron	01	C4							▲
	10	C3						GC 4324	
	20	C2		GC 3334			GC 4334		
	30	C1	GC 4334			GC 1044 4344			▼
N Non-ferrous metals	01	C4							▲
	10	C3		GC 4334				GC 4334	
	20	C2					GC 1044 4344	H13A	
	30	C1							▼
S Heat resistant and super alloys	10	-							▲
	20	-		GC 2334	GC 4334			GC 1144	H13A
	30	-					GC 1044 4344	GC 2044	
	40	-							▼
H Hardened materials	01	C4							▲
	10	C3						GC 4334	
	20	C2					GC 1044 4344		
	30	C1							▼

The position and form of the grade symbols indicate the suitable field of application.

Centre of the field of application.

Recommended field of application.

▲ Stable

▼ Unstable



= Basic grades



= Complementary grades

Reaming

CoroReamer™ 830 G3
Solid carbide head G4
Adaptor G5

B

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CoroReamer™ 830

High feed exchangeable-head tool for through holes

Application

- For all industry segments e.g. general machining, die and mould, automotive, energy and power generation
- Available in spiral flute for through holes and straight flute for blind holes
- Achievable hole tolerance: H7
- 20 Bar coolant pressure

ISO application area:

P

Benefits and features

- High surface finish and operation security
- High penetration rate
- Fast and easy head change with high accuracy < 3µm (120µinch)
- Effective chip evacuation by directing cutting fluid at each edge
- Achievable hole tolerance: H7
- Brazed cermet inserts in grade P10R
- Short and long shank options
- Head change



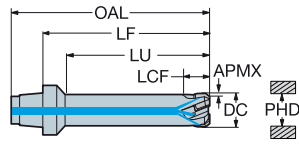
www.sandvik.coromant.com/cororeamer830

CoroReamer™ 830 solid carbide head for reaming

Internal coolant supply

TCHA
CN5C

H7
1



Dimensions, mm, inch

DC	DC"	LU	LU"	CZC _{MS}	Ordering code	DCON _{MS}	DCON _{MS} "	OAL	OAL"	LCF	LCF"	L	L"	LF	LF"	APMX	APMX"	PHD	PHD"	BSG
10.00	.394	45.00	1.772	S12	830B-E06D1000H7S12	12.00	.472	71.35	2.809	9.99	.393	6.00	.236	60.00	2.362	0.3	.012	9.80	.386	COROMANT
11.00	.433	45.00	1.772	S12	830B-E06D1100H7S12	12.00	.472	71.35	2.809	10.00	.394	6.00	.236	60.00	2.362	0.3	.012	10.80	.425	COROMANT
12.00	.472	45.00	1.772	S12	830B-E06D1200H7S12	12.00	.472	71.35	2.809	9.99	.393	6.00	.236	60.00	2.362	0.3	.012	11.80	.465	COROMANT

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G 4



ENG

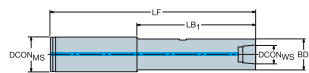
Cylindrical shank to CoroReamer™ 830 adaptor

Internal coolant supply



DSGN

2



		Dimensions, mm, inch												
CZC _{MS}	CZC _{WS}	CNSC	CXSC	DSGN	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BD ₁	BAR PSI	KG	RPMX
20.0	S12	1	1	2	830-S12A20035F	20.0	12.0	50	85.0	35.0	17.8	100	0.23	50000
	S12	1	1	2	830-S12A20069F	20.0	12.0	50	118.5	68.5	17.8	100	0.29	50000
	S12	1	1	2	830-S12A20130F	20.0	12.0	50	179.5	129.5	17.8	100	0.40	50000
						.787	.472	1.969	3.346	1.378	.701	1450		
						.787	.472	1.969	4.665	2.697	.701	1450		
						.787	.472	1.969	7.067	5.098	.701	1450		

Main spare parts

For reamer diameter	Key for head (mm)	Retention knob with cutting fluid through	Retention knob without cutting fluid through
10-18 mm (.394-.709 inch)	3021 010-040 (4.0)	5519 107-01	—
19-23 mm (.748-.906 inch)	3021 010-040 (4.0)	—	5519 106-01
24-31.75 mm (.945-1.250 inch)	3021 010-050 (5.0)	—	5519 106-02



J19



J16

Cutting data for Reamer 830

Metric values

ISO	CMC	Material	Hardness Brinell HB	Grade	Cutting speed	Feed	Radial depth of cut
					V_c m/min	f_z mm/insert	a_p mm
P	01.1 01.2 01.3 01.4	Unalloyed steel					
		Non-hardened 0.10-0.25% C	90-200	P10R	150-200	0.15-0.25	0.1-0.3
		Non-hardened 0.25-0.55% C	125-225		150-200	0.15-0.25	
		Non-hardened 0.55-0.80% C	150-225		140-180	0.15-0.25	
	High carbon & carbon tool steel	180-225	140-180		0.15-0.25		
	02.1 02.2	Low alloy steel					
Non-hardened		150-260	P10R	110-180	0.15-0.25	0.1-0.3	
Hardened and tempered	220-400	70-130		0.10-0.20			
06.1 06.2	Steel castings						
	Unalloyed	90-225	P10R	140-180	0.15-0.25	0.1-0.3	
Low alloyed	150-250	100-150		0.15-0.25			
K	07.2	Malleable cast iron					
		Perlitic	150-270	P10R	150-200	0.15-0.25	0.1-0.3
	Nodular cast iron						
09.2	Perlitic	200-300	P10R	110-190	0.15-0.25	0.1-0.3	

Inch values

ISO	CMC	Material	Hardness Brinell HB	Grade	Cutting speed	Feed	Radial depth of cut
					V_c ft/min	f_z inch/insert	a_p inch
P	01.1 01.2 01.3 01.4	Unalloyed steel					
		Non-hardened 0.10-0.25% C	90-200	P10R	490-650	.006-.010	.004-.012
		Non-hardened 0.25-0.55% C	125-225		490-650	.006-.010	
		Non-hardened 0.55-0.80% C	150-225		460-590	.006-.010	
	High carbon & carbon tool steel	180-225	460-590		.006-.010		
	02.1 02.2	Low alloy steel					
Non-hardened		150-260	P10R	360-590	.006-.010	.004-.012	
Hardened and tempered	220-400	230-425		.004-.008			
06.1 06.2	Steel castings						
	Unalloyed	90-225	P10R	460-590	.006-.010	.004-.012	
Low alloyed	150-250	330-490		.006-.010			
K	07.2	Malleable cast iron					
		Perlitic	150-270	P10R	490-650	.006-.010	.004-.012
	Nodular cast iron						
09.2	Perlitic	200-300	P10R	360-620	.006-.010	.004-.012	

Rotating tool adaptors

Cylindrical shank

Cylindrical shank to Coromant EH adaptor H3-H7

ER

ER to Coromant EH adaptor H9-H10

B

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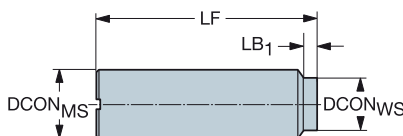
I

J

Cylindrical shank to Coromant EH adaptor

Straight design

Steel shank



Metric version

					Dimensions, mm, inch							
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BAR PSI	KG	RPMX
10.0	E10	1	1	E10-A10-SS-075	10.0	9.6	54	75.0	20.0	80	0.09	40000
					.394	.378	2.126	2.953	.787	1160		
12.0	E12	1	1	E12-A12-SS-100	12.0	11.6	77	100.0	22.0	80	0.14	31000
					.472	.457	3.032	3.937	.866	1160		
16.0	E10	1	1	E10-A16-SS-065	16.0	9.6	57	65.0	5.0	80	0.14	40000
					.630	.378	2.244	2.559	.197	1160		
	E12	1	1	E12-A16-SS-065	16.0	11.6	58	65.0	5.0	80	0.15	40000
					.630	.457	2.283	2.559	.197	1160		
20.0	E16	1	1	E16-A20-SS-070	20.0	15.4	63	70.0	5.0	80	0.26	40000
					.787	.606	2.480	2.756	.197	1160		
	E16	1	1	E16-A20-SS-110	20.0	15.4	83	110.0	25.0	80	0.33	40000
					.787	.606	3.268	4.331	.984	1160		
	E20	1	1	E20-A20-SS-120	20.0	19.2	89	120.0	30.0	80	0.38	34000
					.787	.756	3.504	4.724	1.181	1160		
25.0	E20	1	1	E20-A25-SS-080	25.0	19.2	73	80.0	5.0	80	0.39	40000
					.984	.756	2.874	3.150	.197	1160		
	E25	1	1	E25-A25-SS-140	25.0	24.1	99	140.0	40.0	80	0.63	25000
					.984	.949	3.898	5.512	1.575	1160		
32.0	E25	1	1	E25-A32-SS-080	32.0	24.1	73	80.0	5.0	80	0.62	40000
					1.260	.949	2.874	3.150	.197	1160		

Inch version

					Dimensions, mm, inch							
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BAR PSI	KG	RPMX
3/8	E10	1	1	AE10-A10-SS-030	9.5	9.2	54	76.2	21.3	80	0.09	40000
					.375	.360	2.126	3.000	.839	1160		
1/2	E10	1	1	AE10-A12-SS-025	12.7	9.2	55	63.5	6.3	80	0.10	40000
					.500	.360	2.165	2.500	.250	1160		
	E10	1	1	AE10-A12-SS-030	12.7	9.2	48	76.2	25.4	80	0.11	40000
					.500	.360	1.890	3.000	1.000	1160		
	E12	1	1	AE12-A12-SS-030	12.7	12.2	68	76.2	6.3	80	0.12	40000
					.500	.480	2.677	3.000	.250	1160		
	E12	1	1	AE12-A12-SS-045	12.7	12.2	87	114.3	25.4	80	0.16	30000
					.500	.480	3.425	4.500	1.000	1160		
5/8	E16	1	1	AE16-A16-SS-030	15.9	15.4	68	76.2	6.3	80	0.21	40000
					.625	.606	2.677	3.000	.250	1160		
	E16	1	1	AE16-A16-SS-045	15.9	15.4	87	114.3	25.4	80	0.26	30000
					.625	.606	3.425	4.500	1.000	1160		
3/4	E20	1	1	AE20-A19-SS-030	19.1	18.4	68	76.2	6.3	80	0.27	40000
					.750	.724	2.677	3.000	.250	1160		
	E20	1	1	AE20-A19-SS-045	19.1	18.4	88	114.3	25.4	80	0.34	40000
					.750	.724	3.465	4.500	1.000	1160		
1.0	E25	1	1	AE25-A25-SS-035	25.4	24.4	81	88.9	6.3	80	0.46	40000
					1.000	.961	3.189	3.500	.250	1160		
	E25	1	1	AE25-A25-SS-045	25.4	24.4	75	114.3	38.1	80	0.55	40000
					1.000	.961	2.953	4.500	1.500	1160		
1 1/4	E25	1	1	AE25-A32-SS-065	31.8	24.4	99	165.1	63.5	80	0.90	23000
					1.250	.961	3.898	6.500	2.500	1160		

For spare parts, visit www.sandvik.coromant.com

J19



J9



J16

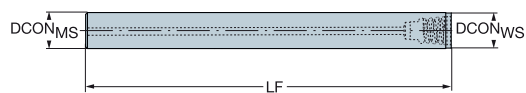
A

Cylindrical shank to Coromant EH adaptor

Straight design

G-undersized steel shank

B



C

Metric version

					Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	BAR PSI	KG	RPMX
9.7	E10	1	1	EH10-A09.7-SS-080	9.7	9.6	78	80.0	80	0.10	40000
					.382	.378	3.071	3.150	1160		
11.7	E12	1	1	EH12-A11.7-SS-085	11.7	11.6	83	85.0	80	0.12	40000
					.461	.457	3.268	3.346	1160		
15.7	E16	1	1	EH16-A15.7-SS-100	15.7	15.4	97	100.0	80	0.24	40000
					.618	.606	3.819	3.937	1160		
19.7	E20	1	1	EH20-A19.7-SS-120	19.7	19.2	117	120.0	80	0.38	40000
					.776	.756	4.606	4.724	1160		
24.7	E25	1	1	EH25-A24.7-SS-135	24.7	24.1	132	135.0	80	0.56	40000
					.972	.949	5.197	5.315	1160		

E

Inch version

					Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	BAR PSI	KG	RPMX
9.2	E10	1	1	AEH10-A09.2-SS-080	9.2	9.2	78	80.0	80	0.09	40000
					.362	.360	3.071	3.150	1160		
18.7	E20	1	1	AEH20-A18.7-SS-110	18.7	18.4	107	110.0	80	0.33	40000
					.736	.724	4.213	4.331	1160		

F

For spare parts, visit www.sandvik.coromant.com

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H

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J



J19



J9

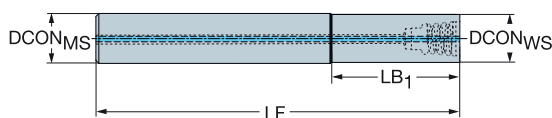


J16

Cylindrical shank to Coromant EH adaptor

Straight design

Heavy metal shank



Metric version

					Dimensions, mm, inch							
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BAR PSI	KG	RPMX
10.0	E10	1	1	EH10-A10-SH-100	10.0	9.6	79	100.0	20.0	80	0.18	26000
					.394	.378	3.110	3.937	.787	1160		
12.0	E12	1	1	EH12-A12-SH-110	12.0	11.6	84	110.0	25.0	80	0.26	25000
					.472	.457	3.307	4.331	.984	1160		
16.0	E16	1	1	EH16-A16-SH-130	16.0	15.4	94	130.0	35.0	80	0.52	22000
					.630	.606	3.701	5.118	1.378	1160		
20.0	E20	1	1	EH20-A20-SH-160	20.0	19.2	114	160.0	45.0	80	0.92	17000
					.787	.756	4.488	6.299	1.772	1160		
25.0	E25	1	1	EH25-A25-SH-185	25.0	24.1	119	185.0	65.0	80	1.58	16000
					.984	.949	4.685	7.283	2.559	1160		

Inch version

					Dimensions, mm, inch							
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BAR PSI	KG	RPMX
3/8	E10	1	1	AEH10-A10-SH-100	9.5	9.2	97	100.0	20.0	80	0.17	23000
					.375	.360	3.819	3.937	.787	1160		
1/2	E12	1	1	AEH12-A12-SH-120	12.7	12.2	84	120.0	25.0	80	0.31	25000
					.500	.480	3.307	4.724	.984	1160		
5/8	E16	1	1	AEH16-A16-SH-130	15.9	15.4	94	130.0	35.0	80	0.52	22000
					.625	.606	3.701	5.118	1.378	1160		
3/4	E20	1	1	AEH20-A19-SH-160	19.1	18.4	114	160.0	45.0	80	0.85	17000
					.750	.724	4.488	6.299	1.772	1160		
1.0	E25	1	1	AEH25-A25-SH-185	25.4	24.4	119	185.0	65.0	80	1.63	16000
					1.000	.961	4.685	7.283	2.559	1160		

For spare parts, visit www.sandvik.coromant.com



J19



J9

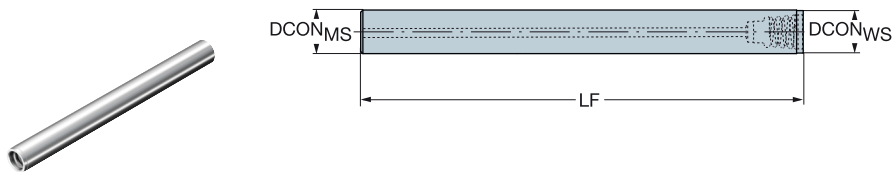


J16

Cylindrical shank to Coromant EH adaptor

Straight design

G-undersized heavy metal shank



Metric version

					Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	BAR PSI	KG	RPMX
9.7	E10	1	1	EH10-A09.7-SH-100	9.7	9.6	97	100.0	80	0.17	23000
					.382	.378	3.819	3.937	1160		
	E10	1	1	EH10-A09.7-SH-120	9.7	9.6	117	120.0	80	0.20	19000
					.382	.378	4.606	4.724	1160		
11.7	E12	1	1	EH12-A11.7-SH-110	11.7	11.6	107	110.0	80	0.25	23000
					.461	.457	4.213	4.331	1160		
	E12	1	1	EH12-A11.7-SH-135	11.7	11.6	132	135.0	80	0.29	17000
					.461	.457	5.197	5.315	1160		
15.7	E16	1	1	EH16-A15.7-SH-130	15.7	15.4	126	130.0	80	0.51	19000
					.618	.606	4.961	5.118	1160		
	E16	1	1	EH16-A15.7-SH-160	15.7	15.4	156	160.0	80	0.61	15000
					.618	.606	6.142	6.299	1160		
19.7	E20	1	1	EH20-A19.7-SH-160	19.7	19.2	156	160.0	80	0.91	19000
					.776	.756	6.142	6.299	1160		
	E20	1	1	EH20-A19.7-SH-200	19.7	19.2	196	200.0	80	1.15	12000
					.776	.756	7.717	7.874	1160		
24.7	E25	1	1	EH25-A24.7-SH-185	24.7	24.1	181	185.0	80	1.58	14000
					.972	.949	7.126	7.283	1160		
	E25	1	1	EH25-A24.7-SH-235	24.7	24.1	231	235.0	80	1.99	10500
					.972	.949	9.094	9.252	1160		

Inch version

					Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	BAR PSI	KG	RPMX
9.2	E10	1	1	AEH10-A09.2-SH-100	9.2	9.2	97	100.0	80	0.16	23000
					.362	.360	3.819	3.937	1160		
	E10	1	1	AEH10-A09.2-SH-120	9.2	9.2	117	120.0	80	0.19	19000
					.362	.360	4.606	4.724	1160		
18.7	E20	1	1	AEH20-A18.7-SH-150	18.7	18.4	147	150.0	80	0.78	19000
					.736	.724	5.787	5.906	1160		
	E20	1	1	AEH20-A18.7-SH-190	18.7	18.4	186	190.0	80	0.97	12000
					.736	.724	7.323	7.480	1160		

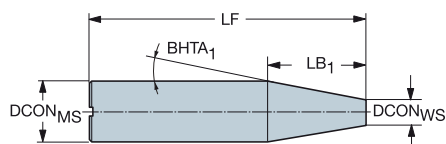
For spare parts, visit www.sandvik.coromant.com



Cylindrical shank to Coromant EH adaptor

Conical design

Metric version



Steel shank

					Dimensions, mm, inch									
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BHTA ₁	$\left(\frac{\text{BAR}}{\text{PSI}}\right)$	$\left(\frac{\text{KG}}{\text{KG}}\right)$	RPMX	
20.0	E16	1	1	EH16-A20-CS-165	20.0	15.4	138	165.0	26.3	5°	80	0.44	27000	
					.787	.606	5.461	6.496	1.035		1160			
25.0	E20	1	1	EH20-A25-CS-200	25.0	19.2	120	200.0	80.0	1°	80	0.70	19000	
					.984	.756	4.724	7.874	3.150		1160			

Cemented carbide shank

					Dimensions, mm, inch									
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BHTA ₁	$\left(\frac{\text{BAR}}{\text{PSI}}\right)$	$\left(\frac{\text{KG}}{\text{KG}}\right)$	RPMX	
16.0	E10	1	1	EH10-A16-CE-140	16.0	9.6	103	140.0	36.6	5°	80	0.41	36000	
					.630	.378	4.071	5.512	1.441		1160			
	E12	1	1	EH12-A16-CE-165	16.0	11.6	139	165.0	25.1	5°	80	0.50	23000	
					.630	.457	5.508	6.496	.988		1160			
20.0	E16	1	1	EH16-A20-CE-165	20.0	15.4	138	165.0	26.3	5°	80	0.78	27000	
					.787	.606	5.461	6.496	1.035		1160			
25.0	E20	1	1	EH20-A25-CE-150	25.0	19.2	116	150.0	33.1	5°	80	1.05	23000	
					.984	.756	4.567	5.906	1.303		1160			
	E20	1	1	EH20-A25-CE-200	25.0	19.2	117	200.0	83.0	2°	80	1.08	19000	
					.984	.756	4.606	7.874	3.268		1160			

Note!

Cemented carbide shank to be used for Finishing/Semi finishing only

For spare parts, visit www.sandvik.coromant.com

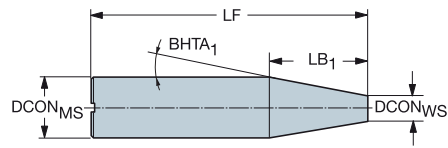
A

Cylindrical shank to Coromant EH adaptor

Conical design

Inch version

B



C

Steel shank

D

				Ordering code		Dimensions, mm, inch								
CZC _{MS}	CZC _{WS}	CNSC	CXSC			DCON _{MS}	DCON _{WS}	LSC	LF	LB ₁	BHTA ₁	BAR PSI	KG	RPMX
1.0	E16	1	1	AEH16-A25-CS-065		25.4	15.4	107	165.1	57.2	5°	80	0.66	31000
						1.000	.606	4.248	6.500	2.252		1160		

For spare parts, visit www.sandvik.coromant.com

E

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J19



J9

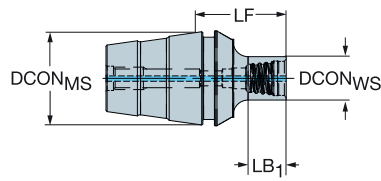


J16

H 8

ER to Coromant EH adaptor

Machine side interface DIN 6499-B



Metric version

				Dimensions, mm, inch						
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LF	LB ₁	BAR PSI	KG
ER16	E10	1	1	EH-ER16-10-008	17.0	9.6	14.9	7.2	80	0.09
					.669	.378	.587	.283	1160	
ER20	E10	1	1	EH-ER20-10-008	21.0	9.6	15.8	7.2	80	0.11
					.827	.378	.622	.283	1160	
	E12	1	1	EH-ER20-12-010	21.0	11.6	17.8	9.2	80	0.13
					.827	.457	.701	.362	1160	
ER25	E10	1	1	EH-ER25-10-012	26.0	9.6	20.3	7.2	80	0.16
					1.024	.378	.799	.283	1160	
	E12	1	1	EH-ER25-12-014	26.0	11.6	22.3	10.2	80	0.17
					1.024	.457	.878	.402	1160	
	E16	1	1	EH-ER25-16-016	26.0	15.4	24.3	14.2	80	0.24
					1.024	.606	.957	.559	1160	
ER32	E10	1	1	EH-ER32-10-012	33.0	9.6	21.5	7.4	80	0.25
					1.299	.378	.846	.291	1160	
	E12	1	1	EH-ER32-12-014	33.0	11.6	23.5	9.4	80	0.27
					1.299	.457	.925	.370	1160	
	E16	1	1	EH-ER32-16-018	33.0	15.4	27.5	13.4	80	0.35
					1.299	.606	1.083	.528	1160	
	E20	1	1	EH-ER32-20-022	33.0	19.2	31.5	18.9	80	0.34
					1.299	.756	1.240	.744	1160	
	E25	1	1	EH-ER32-25-025	33.0	24.1	34.5	25.0	80	0.41
					1.299	.949	1.358	.984	1160	
ER40	E16	1	1	EH-ER40-16-022	41.0	15.4	33.1	15.0	20	0.51
					1.614	.606	1.303	.591	290	
	E20	1	1	EH-ER40-20-025	41.0	19.2	36.1	19.0	20	0.53
					1.614	.756	1.421	.748	290	
	E25	1	1	EH-ER40-25-028	41.0	24.1	39.1	24.0	20	0.58
					1.614	.949	1.539	.945	290	

Inch version

				Dimensions, mm, inch								
CZC _{MS}	CZC _{WS}	CNSC	CXSC	Ordering code	DCON _{MS}	DCON _{WS}	LF	LB ₁	BD ₁	BAR PSI	KG	RPMX
ER16	E10	1	1	EH-ER16-A10-007	17.0	9.2	13.9	6.2	9.2	80	0.09	40000
					.669	.360	.547	.244	.362	1160		
ER20	E10	1	1	EH-ER20-A10-007	21.0	9.2	14.8	6.2	9.2	80	0.11	40000
					.827	.360	.583	.244	.362	1160		
ER25	E10	1	1	EH-ER25-A10-011	26.0	9.2	19.3	6.2	9.2	80	0.15	32000
					1.024	.360	.760	.244	.362	1160		

For spare parts, visit www.sandvik.coromant.com

J19



J9



J16

A

ER to Coromant EH adaptor

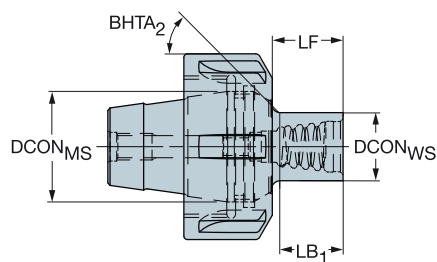
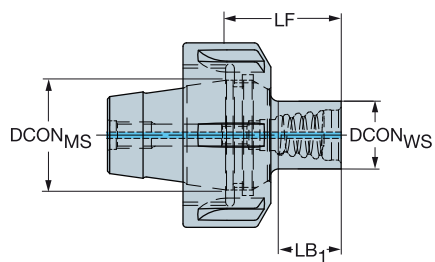
Machine side interface DIN 6499-B

B

DSGN

1



4



C

D

Dimensions, mm, inch

CZC _{MS}	CZC _{WS}	CNSC	CXSC	DSGN	Ordering code	DCON _{MS}	DCON _{WS}	LF	LB ₁	LB ₂	BD ₂	BHTA ₂			RPMX
ER11	E10	1	1	1	392.EREH-11 10 008	11.4	9.6	16.8	8.0				80	0.09	40000
						.449	.378	.661	.315				1160		
ER16	E10	1	1	1	392.EREH-16 10 008	17.0	9.6	8.0	8.0				80	0.17	40000
						.669	.378	.315	.315				1160		
	E12	1	1	1	392.EREH-16 12 010	17.0	11.6	20.5	10.0				80	0.16	40000
						.669	.457	.807	.394				1160		
ER20	E10	1	1	1	392.EREH-20 10 008	21.0	9.6	8.0	8.0				80	0.21	40000
						.827	.378	.315	.315				1160		
	E12	1	1	1	392.EREH-20 12 010	21.0	11.6	10.0	10.0				80	0.14	40000
						.827	.457	.394	.394				1160		
	E16	1	1	1	392.EREH-20 16 014	21.0	15.4	24.1	14.0				80	0.27	40000
						.827	.606	.949	.551				1160		
ER25	E10	1	1	4	392.EREH-25 10 012	26.0	9.6	7.2	7.2	12.0	9.6	45°	80	0.21	40000
						1.024	.378	.283	.283	.472	.378		1160		
	E12	1	1	4	392.EREH-25 12 014	26.0	11.6	10.2	10.2	14.0	11.6	45°	80	0.21	40000
						1.024	.457	.402	.402	.551	.457		1160		
	E16	1	1	4	392.EREH-25 16 016	26.0	15.4	14.2	14.2	16.0	15.4	45°	80	0.22	40000
						1.024	.606	.559	.559	.630	.606		1160		
	E20	1	1	1	392.EREH-25 20 019	26.0	19.2	29.1	19.0				80	0.36	40000
						1.024	.756	1.146	.748				1160		

For spare parts, visit www.sandvik.coromant.com

G

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J19



J9



J16

Accessories

QST™ holding system

Stop for high precision coolant QST™ holding system	13
Wedge for QST™ holding system	14-15
Assembly item	17-18
Coolant connection kit	19

Sleeves

Cylindrical sleeve with EasyFix™ positioning	110-115
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B

C

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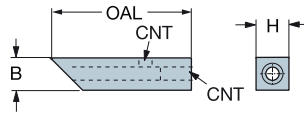
H

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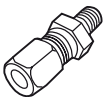
Stop for high precision coolant QS™ holding system

Citizen/Star/Nexturn

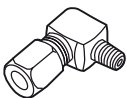


Ordering code	CZC _{MS}	Dimensions, mm, inch			
		B	H	OAL	CNT
Metric					
QS-1010HP-M	10 x 10, 10 x 12	10	10	51	M6
QS-1212HP-M	12 x 12	12	12	51	M6
QS-1616HP-M	16 x 16	16	16	51	M6
Inch					
QS-A06HP-M	3/8 x 1/2	.375	.375	2.000	M6
QS-A08HP-M	1/2 x 1/2	.500	.500	2.000	M6
QS-A10HP-M	5/8 x 5/8	.625	.625	2.000	M6

New tube connectors M6 intended for 6 mm tube diameters are introduced and to be ordered separately.

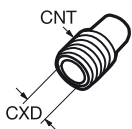


Code	Coupling
5696 001-01	Straight



5696 020-01	90°
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Optional nozzles (to be ordered separately)



Ordering code	CXD mm	CNT
5691 026-11	0.6	M6
5691 026-12	0.8	M6
5691 026-13	1.0	M6
5691 026-14	1.2	M6
5691 026-15	1.4	M6

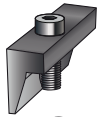


J19

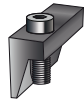
Wedge for QS™ holding system

Citizen/Star/Nexturn

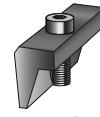
ENG



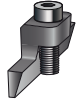
QS-10



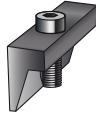
QS-351



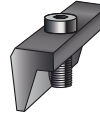
QS-230, QS230A



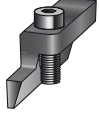
QS-20
QS-371
QS-372



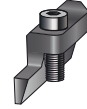
QS-352



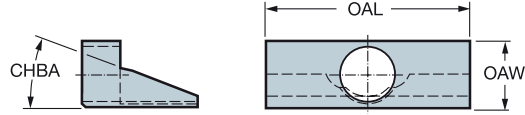
QS-240



QS-30, QS-31,
QS-30A, QS-31A
QS-361



QS-40, QS-40A



D

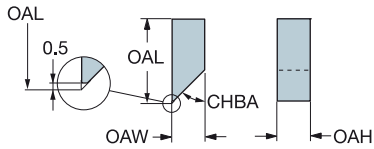
		Dimensions, mm, inch		
Machine type	Ordering code	OAL	OAW	CHBA
Citizen	Metric			
	QS-10	20	7	17°
	QS-20	37	9.9	22°
	QS-30	32	12	22°
	QS-31	32	11.3	22°
	QS-40	29	13.5	22°
Star	Inch			
	QS-30A	1.260	.472	22°
	QS-31A	1.260	.445	22°
	QS-40A	1.142	.531	22°
Nexturn	Metric			
	QS-351	30	13.5	24°20'
	QS-352	35	13.5	24°20'
	QS-361	28	12.5	24.7
	QS-371	32	9.9	24.7
Nexturn	QS-372	72	9.9	24.7
	Inch			
	QS-230 ¹⁾	28	12.5	14°40'
	QS-240	28	13.7	14°40'
	QS-230A	1.102	.465	14°40'

1) Will also work on 5/8" machines.

G

Stop for QS™ holding system

Citizen/Star/Nexturn



H

		Dimensions, mm, inch		
Ordering code	For shank size mm, inch	OAW	OAH	OAL
Metric				
QS-0808	0808	8	8	40
QS-1010	1010	10	10	51
QS-1212	1212	12	12	51
QS-1616	1616	16	16	51
Inch				
QS-A06	3/8	.375	.375	2.000
QS-A08	1/2	.500	.500	2.000
QS-A10	5/8	.625	.625	2.000

I

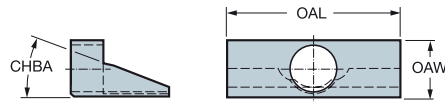
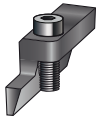


J19

J

Wedge for QS™ holding system

Tsugami/Hanwa



For Tsugami machines

Ordering code	Dimensions, mm, inch		
	OAL	OAW	α
QS-140HP	35	11.9	15°
QS-140	29	11.9	15°
QS-150	30	17.3	15°
QS-160	30	17.3	15°

For Hanwa machines

Ordering code	Dimensions, mm, inch		
	OAL	OAW	α
QS-410	32	11	20°
QS-450	32	15.8	20°

Wedge	MTM	Model	Shank	
			ISO metric	ANSI inch
QS-150	Tsugami	BH 38	1616	10 (5/8)
QS-160	Tsugami	BS 32/BS 20	1616	10 (5/8)
QS-140 For front position	Tsugami	S 205/S 206/SS207	1212	08 (1/2)
QS-140 HP For back position	Tsugami	S 205/S 206/SS07	1212	08 (1/2)
QS-410	Hanwa	XD 20H,J/XD 26H	1212	08 (1/2)
QS-450	Hanwa	XD 32H	1616	10 (5/8)

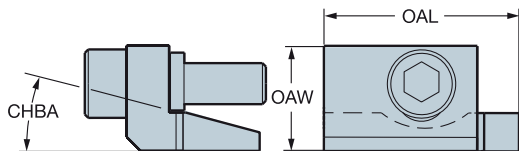
Note! The information above is a guide to choosing the correct tooling combinations. However, you should always perform a practical test to ensure the correct fit.



J19



Wedge for QS™ holding system



Dimensions

Ordering code	OAL	OAW	CHBA
QS-130B	28	15.1	15°
QS-140RB	29	14.7	15°
QS-140BB	29	14.7	15°
QS-351B	20	13.5	24°20'

Wedge	MTM	Model	Shank	
			ISO metric	ANSI inch
For back position for QS-HP				
QS-130B	Tsugami	BO, BS, BU, BM, BA, BW	1212, 1616	08, 10
	Tornos	Delta 12/20	1212, 1616	08, 10
Rear bottom shank, front position				
QS-140RB	Tsugami	S205, S206, SS207	1212	08
QS-140BB	Tsugami	S205, S206, SS207	1212	08
For back position				
QS-351B	Star	SB16, SC20, SE12/16	1010	06
		SE16B, SR16, SR20, SR20R	1212	08
		SR25/32J	1616	10

Note! The information above is a guide to choosing the correct tooling combinations. However, you should always perform a practical test to ensure the correct fit.



J19

Assembly item

Tsugami/Tornos

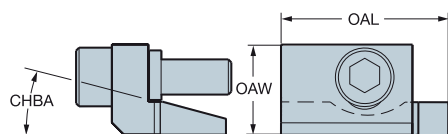
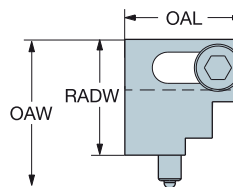
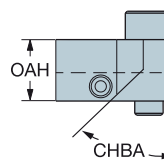
Wedge

QS-130



Stop

QS-130-12
QS-130-16



Ordering code	Dimensions, mm, inch				
	OAW	OAW"	OAL	OAL"	CHBA
Wedge					
Metric					
QS-130	15.1	.594	28.0	1.102	15°

Ordering code	For shank size	Dimensions, mm, inch					
		RADW	RADW"	OAW	OAW"	OAH	OAH"
Stop							
Metric							
QS-130-12	1212 (1/2")	24.5	.965	27.6	1.087	13.0	.512
QS-130-16	1616 (5/8")	24.5	.965	31.5	1.241	13.0	.512



J19

Assembly item

Wedge	MTM	Model	Shank	
			ISO metric	ANSI inch
QS-10	Citizen	R04/R07	0808	
QS-20	Citizen	A16,C12,K12,K16,L16,L20	1010	06
QS-30	Citizen	A20,B20,C16,C20,C32,K12,K16,L16,L20	1212	
QS-30A	Citizen	A20,B20,C16,C20,C32,K12,K16,L16,L20		08
QS-31	Citizen	L16 VIII, L720	1212	
QS-31A	Citizen	L16 VIII, L720		08
QS-40	Citizen	L32,M20,M32	1616	
QS-40A	Citizen	L32,M20,M32		10
QS-130	Tornos	Delta 12/20	1212,1616	08,10
	Tsugami	B0,BS,BU,BM,BN,BA and BW models	1212,1616	08,10
QS-230	Nexturn	SA20	1212	
QS-230A	Nexturn	SA20		08
QS-240	Nexturn	SA26	1616	10
QS-351 (For back position and front position for parting off tools)	Star	SB-16,SC20,SE12/16	1010	06
		SE16B,SR16,SR20,SR20R	1212	08
		S25/32J	1616	10
QS-352 (For front position for turning tools)	Star	SB-16,SC20,SE12/16	1010	06
		SE16B,SR16,SR20,SR20R	1212	08
		S25/32J	1616	10
QS-371 For front position	Star	SB16, SV30	1010	6 (3/8)
QS-372 For back position	Star	SB16, SV30	1010	6 (3/8)
QS-361	Star	SB20R	1212	08 (1/2)

Note! The information above is a guide to choosing the correct tooling combinations. However, you should always perform a practical test to ensure the correct fit.

Stop	MTM	Shank	
		ISO metric	ANSI inch
QS-0808	Citizen/Star/Nexturn	0808	
QS-1010	Citizen/Star/Nexturn	1010	
QS-1212	Citizen/Star/Nexturn	1212	
QS-1616	Citizen/Star/Nexturn	1616	
QS-A06	Citizen/Star/Nexturn		06
QS-A08	Citizen/Star/Nexturn		08
QS-A10	Citizen/Star/Nexturn		10
QS-130-12	Tsugami/Tornos	1212	08
QS-130-16	Tsugami/Tornos	1616	10

Coolant connection kit

QS-HP80-M6-xxxx-1



QS-HP80-PTFE



QS-HP100-M6-AN4-A



		Dimensions, mm, inch	
CZC _{MS}	CZC _{WS}	Ordering code	OAL
NPT 1/8"	M6	QS-HP80-M6-NPT18-1	500 <i>19.685</i>
G 1/8" (BSPP)	M6	QS-HP80-M6-G18-1	500 <i>19.685</i>
R 1/8" (BSPT)	M6	QS-HP80-M6-R18-1	500 <i>19.685</i>
AN-3	M6	QS-HP80-M6-AN3-1	500 <i>19.685</i>
AN-4	M6	QS-HP80-M6-AN4-1	500 <i>19.685</i>
M10 x 1.5	M6	QS-HP80-M6-M10-1	500 <i>19.685</i>
AN-4	M6	QS-HP100-M6-AN4-A	33 <i>1.299</i>
-	-	QS-HP80-PTFE	1000 <i>39.370</i>



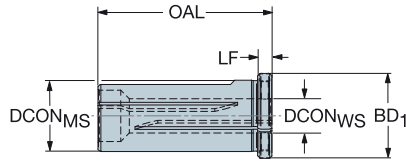
J19

Cylindrical sleeve with EasyFix™ positioning

ISO 9766

Metallic sealed for high pressure coolant through tool

B



C

Metric version

D

			Dimensions, mm					
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁	
16	5	EF-16-05	16	5	5	48	21	
	6	EF-16-06	16	6	5	48	21	
	8	EF-16-08	16	8	5	48	21	
	10	EF-16-10	16	10	5	48	21	
20	12	EF-16-12	16	12	5	48	21	
	5	EF-20-05	20	5	5	55	25	
	6	EF-20-06	20	6	5	55	25	
	8	EF-20-08	20	8	5	55	25	
25	10	EF-20-10	20	10	5	55	25	
	12	EF-20-12	20	12	5	55	25	
	5	EF-25-05	25	5	5	61	30	
	6	EF-25-06	25	6	5	61	30	
F	8	EF-25-08	25	8	5	61	30	
	10	EF-25-10	25	10	5	61	30	
	12	EF-25-12	25	12	5	61	30	
	16	EF-25-16	25	16	5	61	30	

To be used with ISO 9766 adaptors, see Rotating tool adaptors chapter in Rotating tools catalogue or sandvik.coromant.com

G

H

I

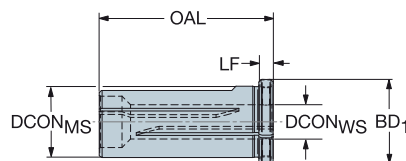
J



Cylindrical sleeve with EasyFix™ positioning

ISO 9766

Metallic sealed for high pressure coolant through tool



Inch version

			Dimensions, inch				
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁
1	1/4	EF-A16-A04	1.000	.250	.197	2.401	1.181
	5/16	EF-A16-A05	1.000	.312	.197	2.401	1.181
	3/8	EF-A16-A06	1.000	.375	.197	2.401	1.181
	1/2	EF-A16-A08	1.000	.500	.197	2.401	1.181
	5/8	EF-A16-A10	1.000	.625	.197	2.401	1.181
1 1/4	1/4	EF-A20-A04	1.250	.250	.197	2.559	1.417
	5/16	EF-A20-A05	1.250	.312	.197	2.559	1.417
	3/8	EF-A20-A06	1.250	.375	.197	2.559	1.417
	1/2	EF-A20-A08	1.250	.500	.197	2.559	1.417
	5/8	EF-A20-A10	1.250	.625	.197	2.559	1.417
1 1/2	3/4	EF-A20-A12	1.250	.750	.197	2.559	1.417
	1/4	EF-A24-A04	1.500	.250	.197	2.952	1.732
	5/16	EF-A24-A05	1.500	.312	.197	2.952	1.732
	3/8	EF-A24-A06	1.500	.375	.197	2.952	1.732
	1/2	EF-A24-A08	1.500	.500	.197	2.952	1.732
1	5/8	EF-A24-A10	1.500	.625	.197	2.952	1.732
	3/4	EF-A24-A12	1.500	.750	.197	2.952	1.732
	1	EF-A24-A16	1.500	1.000	.197	2.952	1.732

To be used with ISO 9766 adaptors, see Rotating tool adaptors chapter in Rotating tools catalogue or sandvik.coromant.com



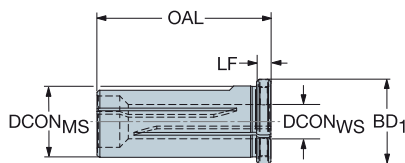
J19

Cylindrical sleeve with EasyFix™ positioning

Cylindrical sleeves for metric bars



132L..-B



CZC_{MS} metric - CZC_{WS} metric

			Dimensions, mm				
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁
12	5	132L-1205050-B	12	5	5	55	25
16	5	132L-1605050-B	16	5	5	55	31
20	5	132L-2005050-B	20	5	5	55	26
	6	132L-2006050-B	20	6	5	55	26
	8	132L-2008050-B	20	8	5	55	26
	10	132L-2010050-B	20	10	5	55	26
22	12	132L-2012050-B	20	12	5	55	26
	5	132L-2205050-B	22	5	5	55	28
	6	132L-2206050-B	22	6	5	55	28
	8	132L-2208050-B	22	8	5	55	28
25	10	132L-2210050-B	22	10	5	55	28
	12	132L-2212050-B	22	12	5	55	28
25	5	132L-2505085-B	25	5	5	85	31

CZC_{MS} metric - CZC_{WS} metric

ISO 9766

			Dimensions, mm				
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁
25	6	132L-2506-B	25	6	5	61	31
	8	132L-2508-B	25	8	5	61	31
	10	132L-2510-B	25	10	5	61	31
	12	132L-2512-B	25	12	5	61	31
40	16	132L-2516-B	25	16	5	61	31
	20	132L-4020-B	40	20	5	75	46
	25	132L-4025-B	40	25	5	75	46

Groove for EasyFix sleeve is available on all cylindrical boring bars in diameter.
5-25 mm (.197-1.000 inch)



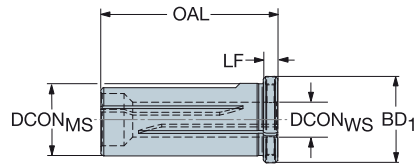
J19

Cylindrical sleeve with EasyFix™ positioning

Cylindrical sleeves for metric bars



132L..-B (INCH)



CZC_{MS} inch - CZC_{WS} metric

			Dimensions, inch				
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁
1	6	132L-1606050-B	1.000	.236	.197	2.165	1.236
	8	132L-1608050-B	1.000	.315	.197	2.165	1.236
	10	132L-1610050-B	1.000	.394	.197	2.165	1.236
	12	132L-1612050-B	1.000	.472	.197	2.165	1.236
3/4	6	132L-1206050-B	.750	.236	.197	2.165	.984
	8	132L-1208050-B	.750	.315	.197	2.165	.984
	10	132L-1210050-B	.750	.394	.197	2.165	.984
	12	132L-1212050-B	.750	.472	.197	2.165	.984

Groove for EasyFix sleeve is available on all cylindrical boring bars in diameter.
5-25 mm (.197-1.000 inch)



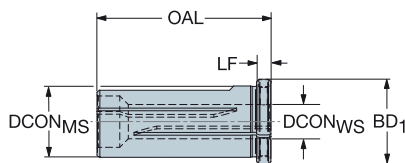
J19

Cylindrical sleeve with EasyFix™ positioning

Cylindrical sleeves for inch bars



132P.-B



CZC_{MS} inch - CZC_{WS} inch

			Dimensions, inch				
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁
1	3/16	132P-160333-B	1.000	.187	.197	3.346	1.236
	1/4	132P-160433-B	1.000	.250	.197	3.346	1.236
	5/16	132P-160533-B	1.000	.313	.197	3.346	1.236
	3/8	132P-160633-B	1.000	.375	.197	3.346	1.236
	1/2	132P-160833-B	1.000	.500	.197	3.346	1.236
1 1/2	5/8	132P-161033-B	1.000	.625	.197	3.346	1.236
	3/8	132P-240641-B	1.500	.375	.197	4.134	1.736
	1/2	132P-240841-B	1.500	.500	.197	4.134	1.736
E	5/8	132P-241041-B	1.500	.625	.197	4.134	1.736
	3/4	132P-241241-B	1.500	.750	.197	4.134	1.736
	1	132P-241641-B	1.500	1.000	.197	4.134	1.736
	1 1/4	132P-200533-B	1.250	.313	.197	3.346	1.488
F	3/8	132P-200633-B	1.250	.375	.197	3.346	1.488
	1/2	132P-200833-B	1.250	.500	.197	3.346	1.488
	5/8	132P-201033-B	1.250	.625	.197	3.346	1.488
	3/4	132P-201233-B	1.250	.750	.197	3.346	1.488
	2	132P-320849-B	2.000	.500	.197	4.921	2.236
F	5/8	132P-321049-B	2.000	.625	.197	4.921	2.236
	3/4	132P-321249-B	2.000	.750	.197	4.921	2.236
	1	132P-321649-B	2.000	1.000	.197	4.921	2.236

CZC_{MS} metric - CZC_{WS} inch

ISO 9766

			Dimensions, mm				
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁
G	25	132P-25A03-B	25	4	5	61	31
	1/4	132P-25A04-B	25	6	5	61	31
	5/16	132P-25A05-B	25	7	5	61	31
	3/8	132P-25A06-B	25	9	5	61	31
	1/2	132P-25A08-B	25	12	5	61	31
	5/8	132P-25A10-B	25	15	5	61	31
H	32	132P-32A05-B	32	7	5	65	38
	3/8	132P-32A06-B	32	9	5	65	38
	1/2	132P-32A08-B	32	12	5	65	38
	5/8	132P-32A10-B	32	15	5	65	38
	3/4	132P-32A12-B	32	19	5	65	38

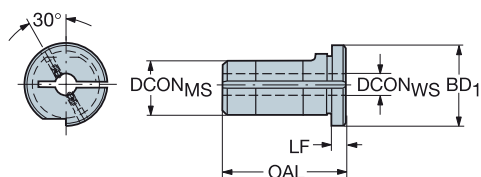
Groove for EasyFix sleeve is available on all cylindrical boring bars in diameter. 5-25 mm (.197-1.000 inch)



Cylindrical sleeve with EasyFix™ positioning

132W- (Whistle Notch) for metric bars

EasyFix™



Metric version

			Dimensions, mm				
CZC _{MS}	CZC _{WS}	Ordering code	DCON _{MS}	DCON _{WS}	LF	OAL	BD ₁
25	5	132W-2505-B	25	5	5	50	31
	6	132W-2506-B	25	6	5	50	31
	8	132W-2508-B	25	8	5	50	31
	10	132W-2510-B	25	10	5	50	31
	12	132W-2512-B	25	12	5	50	31
	16	132W-2516-B	25	16	5	50	31

Groove for EasyFix sleeve is available on all cylindrical boring bars in diameter.
5-25 mm (.197-1.000 inch)

Sleeves for boring bars, 132N, can be used for all cylindrical Sandvik Coromant
boring bars in diameter range 5-32 mm (.197-1.250 inch)



J19

General information

CoroTurn® SL

Modular system of adaptors with exchangeable cutting heads

Application

- For internal and external turning, grooving and threading
- Perfect in combination with Silent Tools™ dampening boring bars in operations with long overhangs or vibration tendencies

Benefits and features

Flexible tooling

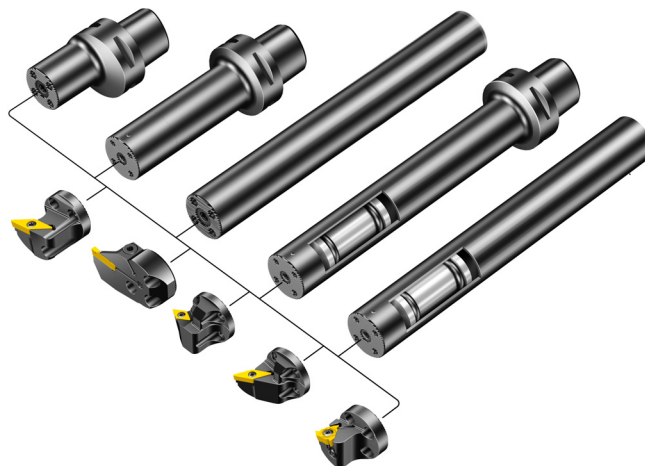
- The ingenious Serration Lock (SL) interface is extremely robust and lets you create a wide range of tool combinations from a small inventory of adaptors and cutting heads
- Adaptors available for both internal and external machining

Reliable chip evacuation and long tool life

- The high precision nozzles on the cutting heads put coolant exactly where you need it, for good chip breaking and long tool life
- Tool wear is mainly on the exchangeable cutting head, extending the life of the adaptor

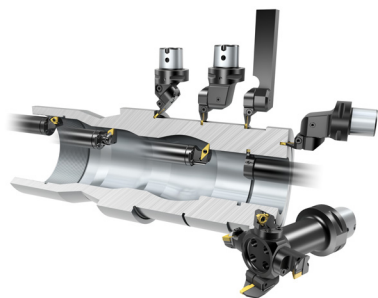
High machine utilization

- Adaptors with internal coolant for efficient coolant supply



CoroTurn® SL is divided into four different systems:

1. Cutting heads, shank tools and adaptors



2. CoroTurn® SL70 for profiling and pocketing



3. Quick change for large bores



4. Quick change for small bores



Advanced cutting materials

In negative and positive basic-shape inserts

Cubic boron nitride (CBN)

Unique CBN grade chain for hard part turning (HPT) with materials designed for high performance in target application area.

T-Max® P
CoroTurn® 107
CoroTurn® TR



Ceramics

The ceramic grade chain includes solutions for machining cast iron, heat resistant super alloys and hardened materials.

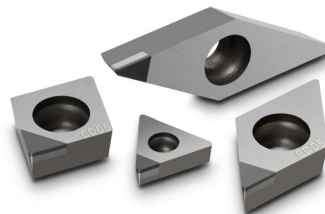
T-Max®



Polycrystalline Diamond (PCD)

Effective in the machining of non-ferrous materials.

CoroTurn® 107
T-Max®



Wiper

B Inserts for increased productivity

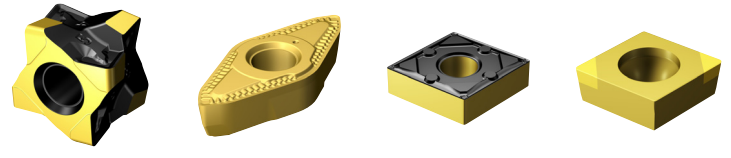
For increased feed rates without affecting surface finish

TECHNOLOGY
Wiper

C Wiper

The corner radius design of wiper inserts allows for machining at high feed rates without affecting surface finish or chip breaking ability.

- Two times the feed – same surface finish
- Same feed – twice as good surface finish



D

E

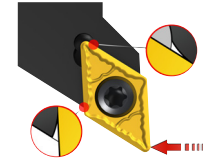
iLock™

F Preventing insert movement for improved machining performance

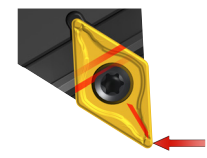
G Application

- High dimensional accuracy
- Long tool life
- Good chip control

Tools with iLock design have rails or serrations on the tool holder and corresponding slots on the insert for a tight locking. This prevents the cutting forces from affecting the tool position.



Forces cause micro movements of the insert in its seat.



With the T-railed interface on CoroTurn TR the insert stays fixed in its position.

H

I

J

General turning inserts

Inserts, metric

C	N	M	G	12	04	08	-			-	PF
1	2	3	4	5	6	7		8	9		12

Inserts, inch









C	N	M	G	4	3	2	-			-	PF
1	2	3	4	5	6	7		8	9		12






Inserts, advanced cutting materials, metric

C	N	G	A	12	04	08	-	T	010	20
1	2	3	4	5	6	7		8	10	11



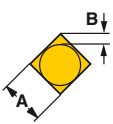
Inserts, advanced cutting materials, inch

C	N	G	A	4	3	2	-	T	03	20
1	2	3	4	5	6	7		8	10	11

1 Insert shape	
C 	D 
K 	R 
S 	T 
V 	W 

2 Insert clearance angle	
B 	C 
E 	N 
P 	O Specific description

3 Tolerances, metric		
Class S	IC / W1	
G	±0.13	±0.025
M	±0.13	±0.05 - ±0.15 ¹⁾
U	±0.13	±0.08 - ±0.25 ¹⁾
E	±0.025	±0.025
1)Varies depending on the size of IC. See below.		
Inscribed circle IC mm	Tolerance class	
	M	U
3.97		
5.0		
5.56		
6.0	±0.05	±0.08
6.35		
8.0		
9.525		
10.0		
12.0	±0.08	±0.13
12.7		
15.875		
16.0	±0.10	±0.18
19.05		
20.0		
25.0	±0.13	±0.25
25.4		
31.75	±0.15	±0.25
32.0		
For positive inserts iC is valid for a sharp corner. See cutting edge condition F. (Picture 8).		

3 Tolerances, inch		
		
A: Theoretical diameter of the insert inscribed circle. T: Thickness of the insert. B: See figures.		
Tolerances in inch		
Class B:	A:	T:
A ±.0002	±.001	±.001
B .0002	.001	.005
C .0005	.001	.001
D .0005	.001	.005
E .001	.001	.001
F .0002	.0005	.001
G .001	.001	.005
H .0005	.0005	.001
J .0002	.002-.005	.001
K .0005	.002-.005	.001
L .001	.002-.005	.001
M .002-.005	.002-.005	.005
U .005-.012	.005-.010	.005
N .002-.010	.002-.004	.001

General turning inserts

4 Insert type	
A	V
G	R
M	T
N	W
P	X Special design
Q	

5 Insert size		Cutting edge length, metric									
		IC mm	IC inch	C	D	R	S	T	V	W	K
<p>Inscribed circle is indicated in 1/8".</p> <p>*) For insert shape K (KNMX, KNUX) only the theoretical cutting edge length is indicated.</p>											
		3.18	1/8"					05			
		3.97	5/32"					06		02	
		5.0				05					
		5.56	7/32"			09					
		6.0			06	07			11	11	04
		6.35	1/4"								
		8.0				08					
		9.525	3/8"	09	11	09	09	16	16	06	16*)
		10.0	10.0			10					
		12.0				12					
		12.7	1/2"	12	15	12	12	22	22	08	
		13			13				13		
		15.875	5/8"	16		15	15	27			
		16.0				16					
		19.0	3/4"	19		19	19	33			
		20.0				20					
		25.0				25 ¹⁾					
		25.4	1"	25		25 ²⁾	25				
		31.75	1 1/4"			31					
		32				32					

6 Insert thickness, S mm, inch			
Metric:		Inch:	
01 S = 1.59	1	S = .0625	
T1 S = 1.98	(1.2)	S = .075	
02 S = 2.38	(1.5)	S = 3/32	
03 S = 3.18	2	S = 1/8	
T3 S = 3.97	(2.5)	S = 5/32	
04 S = 4.76	3	S = 3/16	
05 S = 5.56	4	S = 1/4	
06 S = 6.35	5	S = 5/16	
07 S = 7.94	6	S = 3/8	
09 S = 9.52	6.3	S = .394	
10 S = 10.00	7.6	S = .475	
12 S = 12.00			

7 Nose radius, RE mm, inch	
Metric:	Inch:
00* = 0	00 = 0
01 = 0.1	.30 = .004
02 = 0.2	.50 = .008
04 = 0.4	1 = .0156
05 = 0.5	
08 = 0.8	2 = .031
10 = 1.0	
12 = 1.2	3 = .047
15 = 1.5	
16 = 1.6	4 = .063
24 = 2.4	6 = .094
32 = 3.2	8 = .125

Note: See example for approximation of metric nose radius. 16 = 1.6 mm = .063 = .0625

8 Cutting edge condition	
F	Sharp cutting edge
A	ER treated cutting edge (ANSI)
E	ER treated cutting edge
T	Negative land
K	Double negative lands
S	Negative land and ER treated cutting edge

9 Hand of tool	
R	Feed
L	Feed
N	Feed

10 Chamfer width metric, inch	
Metric:	
010 BN = 0.10	
025 BN = 0.25	
070 BN = 0.70	
150 BN = 1.50	
200 BN = 2.00	
Inch:	
03 BN = .003	
08 BN = .008	
30 BN = .030	
60 BN = .060	
80 BN = .080	

For more information, see code key on page J7

11 Chamfer angle	
15 GB = 15°	
20 GB = 20°	

12 Manufacturer's option	
The ISO code consists of nine symbols including 8 and 9 which are used only when required. In addition the manufacturer may add further three symbols e. g.	<ul style="list-style-type: none"> - WF = Wiper – finishing - WMX = Wiper, medium machining - PF = ISO P – finishing - PR = ISO P – roughing

7 * Code on round inserts
 Code 00 or M0 in position 7 is used on round inserts in the metric code. M0 shows that the diameter of the insert has a metric even dimension. In the inch code for round inserts, position 7 isn't used at all. It's blank.









Advanced cutting material inserts

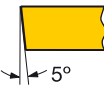
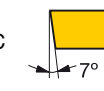

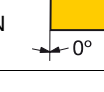

Metric












C	N	G	A	12	04	08	T	010	20	R	A	WG
1	2	3	4	5	6	7	8	9	10	11	12	13

Inch



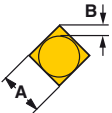
C	N	G	A	4	3	2	T	03	20	R	A	WG
1	2	3	4	5	6	7	8	9	10	11	12	13













1 Insert shape	
C 	D 
K 	R 
S 	T 
V 	W 

2 Insert clearance angle	
B 	C 
E 	N 
P 	O Specific description

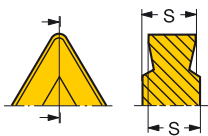
4 Insert type	
A 	V 
G 	R 
M 	T 
N 	W 
P 	X 
Q 	Special design

3 Tolerances, metric		
Class	S	IC / W1
G	±0.13	±0.025
M	±0.13	±0.05 – ±0.15 ¹⁾
U	±0.13	±0.08 – ±0.25 ¹⁾
E	±0.025	±0.025
¹⁾ Varies depending on the size of IC. See below.		
Inscribed circle	Tolerance class	
IC mm	M	U
3.97		
5.0		
5.56		
6.0	±0.05	±0.08
6.35		
8.0		
9.525		
10.0		
12.0	±0.08	±0.13
12.7		
15.875		
16.0	±0.10	±0.18
19.05		
20.0		
25.0	±0.13	±0.25
25.4		
31.75	±0.15	±0.25
32.0		
For positive inserts iC is valid for a sharp corner. See cutting edge condition F. (Picture 8).		

3 Tolerances, inch		
		
A: Theoretical diameter of the insert inscribed circle. T: Thickness of the insert. B: See figures.		
Tolerances in inch		
Class B:	A:	T:
A ±.0002	±.001	±.001
B .0002	.001	.005
C .0005	.001	.001
D .0005	.001	.005
E .001	.001	.001
F .0002	.0005	.001
G .001	.001	.005
H .0005	.0005	.001
J .0002	.002-.005	.001
K .0005	.002-.005	.001
L .001	.002-.005	.001
M .002-.005	.002-.005	.005
U .005-.012	.005-.010	.005
N .002-.010	.002-.004	.001

5 Insert size													
Inscribed circle, inch				Cutting edge length, metric									
						C	D	R	S	T	V	W	K
R	S	T	W										
				IC mm	IC inch								
Inscribed circle is indicated in 1/8".				3.18	1/8"					05			
				3.97	5/32"			05		06			
				5.0				09					
				6.0			06						
				6.35	1/4"		07			11	11		
				8.0				08					
				9.525	3/8"	09	11	09	09	16	16	06	16 ¹⁾
				10.0				10					
				12.0				12					
				12.7	1/2"	12	15	12	12	22	22	08	
				15.875	5/8"	16		15	15	27			
				16.0				16					
				19.0	3/4"	19		19	19	33			
				20.0				20					
				25.0				25 ¹⁾					
				25.4	1"	25		25 ²⁾	25				
				31.75	1 1/4"			31					
				32				32					
For rectangular and rhombic inserts cutting edge length is indicated in mm.				¹⁾ For insert shape K (KNMX, KNUX) only the theoretical cutting edge length is indicated.									
				²⁾ Inch base design									

6 Insert thickness, S mm, inch



Metric:		Inch:	
01	s = 1.59	1.	s = .0625
T1	s = 1.98	(1.2)	s = .075
02	s = 2.38	(1.5)	s = 3/32
03	s = 3.18	2	s = 1/8
T3	s = 3.97	(2.5)	s = 5/32
04	s = 4.76	3	s = 3/16
05	s = 5.56	4	s = 1/4
06	s = 6.35	5	s = 5/16
07	s = 7.94	6	s = 3/8
09	s = 9.52	6.3	s = .394
10	s = 10.00	7.6	s = .475
12	s = 12.00		

7 Nose radius, RE mm, inch



Metric:	Inch:
00* = 0	0 = 0
01 = 0.1	.30 = .004
02 = 0.2	.50 = .008
04 = 0.4	1 = .016
05 = 0.5	
08 = 0.8	2 = .031
10 = 1.0	
12 = 1.2	3 = .047
15 = 1.5	
16 = 1.6	4 = .063
24 = 2.4	6 = .094
32 = 3.2	8 = .125

Note: See example for approximation of metric nose radius. 16 = 1.6 mm = .063 ≈ .0625

8 Cutting edge condition

F		Sharp cutting edge
E (A)		ER treated cutting edge A (inch) E (metric)
T		Negative land
K		Double negative lands
S		Negative land and ER treated cutting edge

12 Insert Type (CBN)

To allow a variety of machining demands to be met, several types of inserts comprising CBN and PCD is manufactured. To easily identify the different types Sandvik Coromant uses a letter to denote the variants.

- A CBN, Multi Corner Inserts
 - Fully indexable
 - CBN top to bottom of the carbide carrier corners
- B CBN, Multi Corner Inserts
 - Fully indexable
 - CBN brazed to the top and bottom of the carbide carrier corners.
- E CBN, Single tip inserts
 - Non-indexable
 - CBN brazed to the top of one of the carbide carrier corners
- F CBN, Multi tip inserts
 - Indexable
 - CBN brazed to each corner of the carbide carrier
- D CBN, Full top inserts
 - Indexable
 - CBN sintered to the complete top surface of the carbide carrier
- M CBN, Solid inserts
 - Fully indexable
 - Complete insert made from CBN

9 Chamfer width

ISO mm	ANSI inch
010 BN = 0.10	03 BN = (.003)
015 BN = 0.15	06 BN = (.006)
020 BN = 0.20	08 BN = (.0078)
025 BN = 0.25	08 BN = (.0098)
070 BN = 0.70	30 BN = (.030)
150 BN = 1.50	60 BN = (.060)
200 BN = 2.00	80 BN = (.080)

10 Chamfer angle, degrees

	15 GB = 15°	30 GB = 30°
	20 GB = 20°	35 GB = 35°
	25 GB = 25°	

11 Hand of insert

Inserts designed solely for machining in left or right direction are indicated as below.

R	Right hand design
L	Left hand design

13 Wiper Geometry

Our unique Wiper and Xcel technologies can be used to boost productivity and generate superior surface finish.

- WG Wiper geometry for general purpose machining
 - Allows high feed rates in HPT
 - Suitable for finish machining of GCI
- WH Wiper geometry optimized for HPT
 - Low cutting forces for superior surface finish
 - Designed for peak performance at HPT finishing feed rates
- Xcel Allows the use of higher feed rates than other wiper geometries
 - XA Maintains surface finish

7 * Code on round inserts

Code 00 or M0 in position 7 is used on round inserts in the metric code. M0 shows that the diameter of the insert has a metric even dimension. In the inch code for round inserts, position 7 isn't used at all. It's blank.

Tailor Made

Additional tool options designed for your specific requirements.



Apart from a comprehensive standard programme we can offer tools to your dimensions on standard tool terms. In our Tailor Made offer you are free to specify your own dimensions without paying the price of a special tool.

What you can expect from us

- Quick quotation
- Easy ordering
- Performance guarantee at given product and cutting data
- Competitive delivery times

CoroMill® 490 Inquiry/ordering No.

Customer	Customer No. (Coromant Internal)	Date	
Street	Telephone	Customer attention	
Post Code/City/State	Telefax	Issuer	
Quantity	Customer denomination		

Even more possibilities thanks to tailored design!
If you do not find what you need in our comprehensive standard programme, choose the tool shape you require and we will tailor it for you to your dimensions.

- Quick quotation
- Easy to order
- Competitive delivery

main catalogue or supplement catalogue
metric std Your value/ Your choice

above standard

14 Delivered with shims
38.1-254
(with exceptions)

insertal pitch not valid for every combination
on insert size, outer diameter and pitch

Coromant Capto		HSK A	
Size	D_1 (mm)	Size	D_1 (mm)
16	19.05-25.4	32	19.05-40
20	19.05-32	34	19.05-35
25	19.05-38.1	36	19.05-45
32	19.05-45	38	19.05-50
40	19.05-50	42	20-40
50	19.05-60	45	20-45
60	19.05-75	50	20-50
75	19.05-90	60	20-60
90	19.05-110	75	20-75
110	19.05-140	90	20-90
140	19.05-180	110	20-110
180	19.05-254	140	20-140

CoroMill® 490

Standard insert: 490 08 31, 490 14 31, 490 16 31, 490 18 31

Cylindrical		Welded		Coromant Capto®		HSK type A	
Size	D_1 (mm)	Size	D_1 (mm)	Size	D_1 (mm)	Size	D_1 (mm)
16	19.05-25.4	16	19.05-25.4	C3	19.05-40	K3	20-40
20	19.05-32	20	19.05-32	C4	19.05-35	K4	19.05-35
25	19.05-38.1	25	19.05-38.1	C5	19.05-45	K5	19.05-45
32	19.05-45	32	19.05-45	C6	19.05-50	K6	19.05-50
40	19.05-50	40	19.05-50	C8	19.05-60	K8	19.05-60
50	19.05-60	50	19.05-60	C8	19.05-75	K8	19.05-75

Arbor mounting, TDA		TDB		TDC	
Size	D_1 (mm)	Size	D_1 (mm)	Size	D_1 (mm)
16	37.5-50	32	100-125	40	180-200
20	38.1-60	38.1	125-180	47.825	200-204
22.225	38.1-80	40	125-180	60	200-214
25.4	40-100	50.8	150-200	14	
27	44-100				
31.75	100-125				

Options

Insert size	08 or 14	A_2	Reach length: -08, 21 mm - 3 - D_1
D_1	-08, Diameter - 19.05-84 mm -14, Diameter - 38.1-254 mm	A_3	Total length: -08, 74-250 mm -14, 88-250 mm
Pitch type	Even or Differential	f_1	Programming length: -08, 40-175.5 mm
f_1	-08, No. of inserts 2-10 -14, No. of inserts 2-20	Coolant hole	-09, Yes - D_1 - 63 mm/No -14, Yes/No - all TDC and TDB size 50.8
Mounting type	Cylindrical, Welded, Coromant Capto, HSK/A, Arbor mounting		
d_{min}/D_{min}	Mounting size, see above		

Note: For specific details regarding the options, contact your Coromant sales representative.

The Tailor Made option is available in the following product families:

Inserts - carbide

- CoroCut® 1-2
- CoroCut® QD
- CoroCut® 3
- T-Max® Q-Cut
- CoroThread® 266
- T-Max® U-Lock

Inserts - CBN

- T-Max® P
- T-Max®
- CoroTurn® 107
- CoroTurn® TR

Inserts - PCD

- CoroTurn® 107

Tools

- CoroTurn® 300
- CoroTurn® TR
- CoroCut® 1-2
- CoroCut® QD
- CoroCut® 3
- T-Max® Q-Cut

Adaptors

- Coromant Capto®

Engineered solutions

When standard or Tailor Made solutions do not fulfill your needs you can depend on Sandvik Coromant's wide experience in engineered tool solutions to handle particularly demanding criteria. Access our Tailor Made forms at www.sandvik.coromant.com

J 9

Material cross reference list

ISO	MC	CMC	Country										
			Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan	
			Standard										
DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS				
P	Unalloyed steel												
	P1.1.Z.AN	01.1	S235JR G2	1.0038	4360 40 C	-	1311	A570.36	E 24-2 Ne	-	-	STKM 12A;C	
	P1.1.Z.AN	01.1	S235J2 G3	1.0116	4360 40 B	-	1312	A573-81 65	E 24-U	Fe37-3	-	-	
	P1.1.Z.AN	01.1	C15	1.0401	080M15	-	1350	1015	CC12	C15C16	F.111	-	
	P1.1.Z.AN	01.1	C22	1.0402	050A20	2C/2D	1450	1020	CC20	C20C21	F.112	-	
	P1.1.Z.AN	01.1	C15E	1.1141	080M15	32C	1370	1015	XC12	C16	C15K	S15C	
	P1.1.Z.AN	01.1	C25E	1.1158	-	-	-	1025	-	-	-	S25C	
	P1.1.Z.AN	01.1	S380N	1.8900	4360 55 E	-	2145	A572-60	-	FeE390KG	-	-	
	P1.1.Z.AN	01.1	17MnV7	1.0870	4360 55 E	-	2142	A572-60	NFA 35-501 E 36	-	-	-	
	P1.1.Z.AN	02.1	55Si7	1.0904	250A53	45	2085	9255	55S7	55Si8	56Si7	-	
	P1.1.Z.AN	02.2	-	-	-	-	2090	9255	55S7	-	-	-	
	P1.2.Z.AN	01.2	C35	1.0501	060A35	-	1550	1035	CC35	C35	F.113	-	
	P1.2.Z.AN	01.2	C45	1.0503	080M46	-	1650	1045	CC45	C45	F.114	-	
	P1.2.Z.AN	01.2	40Mn4	1.1157	150M36	15	-	1039	35M5	-	-	-	
	P1.2.Z.AN	01.2	36Mn5	1.1167	-	-	2120	1335	40M5	-	36Mn5	SMn438(H)	
	P1.2.Z.AN	01.2	28Mn6	1.1170	150M28	14A	-	1330	20M5	C28Mn	-	SCMn1	
	P1.2.Z.AN	01.2	C35G	1.1183	060A35	-	1572	1035	XC38TS	C36	-	S35C	
	P1.2.Z.AN	01.2	C45E	1.1191	080M46	-	1672	1045	XC42	C45	C45K	S45C	
	P1.2.Z.AN	01.2	C53G	1.1213	060A52	-	1674	1050	XC48TS	C53	-	S50C	
	P1.2.Z.AN	01.3	C55	1.0535	070M55	-	1655	1055	-	C55	-	-	
	P1.2.Z.AN	01.3	C55E	1.1203	070M55	-	-	1055	XC55	C50	C55K	S55C	
	P1.2.Z.AN	02.1	S275J2G3	1.0144	4360 43C	-	1412	A573-81	E 28-3	-	-	SM 400A;B;C	
	P1.2.Z.AN	02.1	S355J2G3+C2	1.0570	4360 50B	-	2132	-	E36-3	Fe52BFN/Fe52CFN	-	SM490A;B;C;YA;YB	
	P1.2.Z.AN	02.1	S355J2G3	1.0841	150 M 19	-	2172	5120	20 MC 5	Fe52	F-431	-	
	P1.3.Z.AN	01.3	C60E	1.0601	080A62	43D	-	1060	CC55	C60	-	-	
	P1.3.Z.AN	01.3	C60E	1.1221	080A62	43D	1678	1060	XC60	C60	-	S58C	
	P1.3.Z.AN	01.4	C101E	1.1274	060 A 96	-	1870	1095	XC 100	-	F-5117	-	
	P1.3.Z.AN	01.4	C101u	1.1545	BW 1A	-	1880	W 1	Y105	C36KU	F-5118	SK 3	
	P1.3.Z.AN	01.4	C105W1	-	BW2	-	2900	W210	Y120	C120KU	F.515	SUP4	
	P1.3.Z.AN	02.1	S340 MGC	1.0961	-	-	-	9262	60SC7	60SiCr8	60SiCr8	-	
	P1.4.Z.AN	01.1	11SMn30	1.0715	230M07	-	1912	1213	S250	CF9SMn28	11SMn28	SUM22	
	P1.4.Z.AN	01.1	11SMnPb30	1.0718	-	-	1914	12L13	S250Pb	CF9SMnPb28	11SMnPb28	SUM22L	
	P1.4.Z.AN	01.1	10SPb20	1.0722	-	-	-	-	10PbF2	CF10SPb20	10SPb20	-	
	P1.4.Z.AN	01.1	11SMn37	1.0736	240M07	1B	-	1215	S 300	CF9SMn36	12SMn35	-	
	P1.4.Z.AN	01.1	11SMnPb37	1.0737	-	-	1926	12L14	S300Pb	CF9SMnPb36	12SMnP35	-	
	P1.4.Z.AN	01.2	35S20	1.0726	212M36	8M	1957	1140	35MF4	-	F210G	-	
	P1.5.C.UT	01.1	GC16E	1.1142	030A04	1A	1325	1115	-	-	-	-	
	Steel	Low-alloy steel											
		P2.1.Z.AN	02.1	16Mo3	1.5415	1501-240	-	2912	A204Gr.A	15D3	16Mo3KW	16Mo3	-
		P2.1.Z.AN	02.1	14Ni6	1.5622	-	-	-	A350LF5	16N6	14Ni6	15Ni6	-
		P2.1.Z.AN	02.1	21NiCrMo2	1.6523	805M20	362	2506	8620	20NCD2	20NiCrMo2	20NiCrMo2	SNCM220(H)
		P2.1.Z.AN	02.1	17CrNiMo6	1.6587	820A16	-	-	-	18NCD6	-	14NiCrMo13	-
		P2.1.Z.AN	02.1	15Cr3	1.7015	523M15	-	-	5015	12C3	-	-	SCr415(H)
		P2.1.Z.AN	02.1	55Cr3	1.7176	527A60	48	-	5155	55C3	-	-	SUP9(A)
		P2.1.Z.AN	02.1	15CrMo5	1.7262	-	-	2216	-	12CD4	-	12CrMo4	SCM415(H)
		P2.1.Z.AN	02.1	13CrMo4-5	1.7335	1501-620Gr27	-	-	A182 F11;F12	15CD3.5	14CrMo4 5	14CrMo45	-
		P2.1.Z.AN	02.1	10CrMo9 10	1.7380	1501-622 Gr.31;45	-	2218	A182 F.22	12CD9, 10	12CrMo9, 10	TU.H	-
		P2.1.Z.AN	02.1	14MoV6 3	1.7715	1503-660-440	-	-	-	-	-	13MoCrV6	-
		P2.1.Z.AN	02.1	50CoMo4	1.7228	823M30	33	2512	-	-	653M31	-	-
		P2.1.Z.AN	02.2	14NiCr10	1.5732	-	-	-	3415	14NC11	16NiCr11	15NiCr11	SNC415(H)
		P2.1.Z.AN	02.2	14NiCr14	1.5752	655M13; A12	36A	-	3415;3310	12NC15	-	-	SNC815(H)
P2.1.Z.AN		02.1/02.2	16MnCr5	1.7131	(527M20)	-	2511	5115	16MC5	16MnCr5	16MnCr5	-	
P2.1.Z.AN		02.1/02.2	34CrMo4	1.7220	708A37	19B	2234	4137;4135	35CD4	35CrMo4	34CrMo4	SCM432;SCCRM3	
P2.1.Z.AN		02.1/02.2	41CrMo4	1.7223	708M40	19A	2244	4140;4142	42CD4TS	41CrMo4	42CrMo4	SCM 440	
P2.1.Z.AN		02.1/02.2	42CrMo4	1.7225	708M40	19A	2244	4140	42CD4	42CrMo4	42CrMo4	SCM440(H)	
P2.1.Z.AN		03.11	14NiCrMo134	1.6657	832M13	36C	-	-	-	15NiCrMo13	14NiCrMo131	-	
P2.2.Z.AN		02.1	31CrMo12	1.8515	722 M 24	-	2240	-	30 CD 12	30CrMo12	F-1712	-	
P2.2.Z.AN		02.1	39CrMoV13 9	1.8523	897M39	40C	-	-	-	36CrMoV12	-	-	
P2.2.Z.AN		02.1	41CrS4	1.7039	524A14	-	2092	L1	-	105WCR 5	-	-	
P2.2.Z.AN		02.1	50NiCr13	1.2721	-	-	2550	L6	55NCV6	-	F-528	-	
P2.2.Z.AN		03.11	45WCrV7	1.2542	BS1	-	2710	S1	-	45WCrV8KU	45WCrSi8	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	36CrNiMo4	1.6511	816M40	110	-	9840	40NCD3	38NiCrMo4(KB)	35NiCrMo4	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	34CrNiMo6	1.6582	817M40	24	2541	4340	35NCD6	35NiCrMo6(KB)	-	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	34Cr4	1.7033	530A32	18B	-	5132	32C4	34Cr4(KB)	35Cr4	SCr430(H)	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	41Cr4	1.7035	530A40	18	-	5140	42C4	41Cr4	42Cr4	SCr440(H)	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	32CrMo12	1.7361	722M24	40B	2240	-	30CD12	32CrMo12	F.124.A	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	51CrV4	1.8159	735A50	47	2230	6150	50CV4	50CrV4	51CrV4	SUP10	
P2.2.Z.AN/P2.5.Z.HT	02.1/02.2	41CrAlMo7	1.8509	905M39	41B	2940	-	40CAD6, 12	41CrAlMo7	41CrAlMo7	-		
P2.3.Z.AN	02.1	100Cr6	1.3505	534A99	31	2258	52100	100C6	100Cr6	F.131	SUJ2		

Material cross reference list

ISO	MC	CMC	Country										
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan		
			Standard										
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS	
P	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	105WCr6	1.2419	-	-	2140	-	105WC13	10WCr6	105WCr5	SKS31	
	P2.3.Z.AN/H1.2.Z.HA	-	-	-	-	-	-	-	-	107WCr5KU	-	SKS2, SKS3	
	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	-	1.2714	-	-	-	L6	55NCDV7	-	F520.S	SKT4	
	P2.3.Z.AN/H1.3.Z.HA	02.1/02.2	100Cr6	1.2067	BL3	-	-	L3	Y100C6	-	100Cr6	-	
	P2.4.Z.AN	02.1	16MnCr5	1.7139	-	-	2127	-	-	-	-	-	
	P2.5.Z.HT	02.1	16Mo5	1.5423	1503-245-420	-	-	4520	-	16Mo5	16Mo5	-	
	P2.5.Z.HT	02.1	40NiCrMo8-4	1.6562	311-Type 7	-	-	8740	-	40NiCrMo2(KB)	40NiCrMo2	SNCM240	
	P2.5.Z.HT	02.1	42Cr4	1.7045	-	-	2245	5140	-	-	42Cr4	Scr440	
	P2.5.Z.HT	02.1	31NiCrMo14	1.5755	830 M 31	-	2534	-	-	-	F-1270	-	
	P2.5.Z.HT	02.2	36NiCr6	1.5710	640A35	111A	-	3135	35NC6	-	-	SNC236	
	P2.6.C.UT	02.1	22Mo4	1.5419	605A32	-	2108	8620	-	-	F520.S	-	
	P2.6.C.UT	02.1/02.2	25CrMo4	1.7218	1717CDS110	-	2225	4130	25CD4	25CrMo4(KB)	AM26CrMo4	SCM420;SCM430	
	P2.6.C.UT	06.2	-	-	-	-	2223	-	-	-	-	-	
	High-alloy steel												
	P3.0.Z.AN	03.11	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU	X210Cr12	SKD1	
P3.0.Z.AN	03.11	X43Cr13	1.2083	-	-	2314	-	-	-	X250Cr12KU	-		
P3.0.Z.AN	03.11	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU	X40CrMoV5	SKD61		
P3.0.Z.AN	03.11	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X40CrMoV511KU	X100CrMoV5	SKD12		
P3.0.Z.AN	03.11	X210CrW12	1.2436	-	-	2312	-	-	X100CrMoV51KU	X210CrW12	SKD2		
P3.0.Z.AN	03.11	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU	X30WCrV9	SKD5		
P3.0.Z.AN	03.11	X165CrMoV 12	1.2601	-	-	2310	-	-	X30WCrV9 3KU	X160CrMoV12	-		
P3.0.Z.AN	03.21	X155CrMoV12-1	1.2379	-	-	2736	HNv3	-	X165CrMoW12KU	-	-		
P3.0.Z.HT	03.11	X8Ni9	1.5662	1501-509;510	-	-	ASTM A353	-	X10Ni9	XBNI09	-		
P3.0.Z.HT	03.11	12Ni19	1.5680	-	-	-	2515	Z18N5	-	-	-		
P3.1.Z.AN	03.11	S6-5-2	1.3343	4959BA2	-	2715	D3	Z40CSD10	15NiCrMo13	-	SUH3		
P3.1.Z.AN	03.13	-	-	BM 2	-	2722	M 2	Z85WDCV	HS 6-5-2-2	F-5603.	SKH 51		
P3.1.Z.AN	03.13	HS 6-5-2-5	1.3243	BM 35	-	2723	M 35	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55		
P3.1.Z.AN	03.13	HS 2-9-2	1.3348	-	-	2782	M 7	-	HS 2-9-2	F-5607	-		
P3.2.C.AQ	06.33	G-X120Mn12	1.3401	Z120M12	-	2183	L3	Z120M12	XG120Mn12	X120Mn12	SCMnH/1		
Ferritic/martensitic stainless steel													
Steel	P5.0.Z.AN	05.11/15.11	X10CrAL13	1.4724	403S17	-	-	405	Z10C13	X10CrAl12	F311	SUS405	
	P5.0.Z.AN	05.11/15.11	X10CrAL18	1.4742	430S15	60	-	430	Z10CAS18	X8Cr17	F3113	SUS430	
	P5.0.Z.AN	05.11/15.11	X10CrAL2-4	1.4762	-	-	2322	446	Z10CAS24	X16Cr26	-	SUH446	
	P5.0.Z.AN	05.11/15.11	X1CrMoTi18-2	1.4521	-	-	2326	S44400	-	-	-	-	
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr13	1.4000	403S17	-	2301	403	Z6C13	X6Cr13	F3110	SUS403	
	P5.0.Z.AN/P5.0.Z.HT	-	X7Cr14	1.4001	-	-	-	-	-	-	F8401	-	
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X10Cr13	1.4006	410S21	56A	2302	410	Z10C14	X12Cr13	F3401	SUS410	
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr17	1.4016	430S15	960	2320	430	Z8C17	X8Cr17	F3113	SUS430	
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrAL13	1.4002	405S17	-	-	405	Z8CA12	X6CrAl13	-	-	
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X20Cr13	1.4021	420S37	-	2303	420	Z20C13	X20Cr13	-	-	
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrMo17-1	1.4113	434S17	-	2325	434	Z8CD17.01	X8CrMo17	-	SUS434	
	P5.0.Z.HT	03.11	X45CrS9-3-1	1.4718	401S45	52	-	HW3	Z45CS9	X45GrS18	F322	SUH1	
	P5.0.Z.HT	05.11/15.11	X85CrMoV18-2	1.4748	443S65	59	-	HNv6	Z80CSN20.02	X80CrSiNi20	F320B	SUH4	
	P5.0.Z.HT	05.11/15.11	X20CrMoV12-1	1.4922	-	-	2317	-	-	X20CrMoNi 12 01	-	-	
	P5.0.Z.PH	05.11/15.11	X12CrS13	1.4005	416 S 21	-	2380	416	Z11CF13	X12 CrS 13	F-3411	SUS 416	
	P5.0.Z.PH	05.11/15.11	X46Cr13	1.4034	420S45	56D	2304	-	Z40CM	X40Cr14	F3405	SUS420J2	
	P5.0.Z.PH	05.11/15.11	X19CrNi17-2	1.4057	431S29	57	2321	431	Z15CNI6.02	X16CrNi16	F3427	SUS431	
	P5.0.Z.PH	05.12/15.12	X5CrNiCuNb16-4	1.4542 1.4548	-	-	-	630	Z7CNU17-04	-	-	-	
P5.0.Z.PH	15.21	X4 CrNiMo16-5	1.4418	-	-	2387	-	Z6CND16-04-01	-	-	-		
P5.1.Z.AN/P5.0.Z.HT	05.11/15.11	X14CrMoS17	1.4104	-	-	2383	430F	Z10CF17	X10CrS17	F3117	SUS430F		
Trade names													
P2.1.Z.AN	02.1												
P2.2.Z.AN	02.1		1.0045										
P2.2.Z.AN	02.1												
P2.5.Z.HT	02.2												
P1.2.Z.AN													
P1.2.Z.AN													
P1.2.Z.AN													
P2.5.Z.HT													
P2.5.Z.HT	02.2												
P2.5.Z.HT	02.2												
P2.5.Z.HT													
P2.5.Z.HT													

Material cross reference list

ISO	MC	CMC	Country										
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan		
			Standard										
DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS				
M	Austenitic stainless steel												
	M1.0.Z.AQ	05.11/15.11	X3CrNiMo13-4	1.4313	425C11	-	2385	CA6-NM	Z4CND13.4M Z38C13M	(G)X6CrNi304	-	SCS5	
	M1.0.Z.AQ/M1.0.C.UT	05.11/15.11	X53CrMnNiN21-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN21 9	-	SUH35, SUH36	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiN18-10	1.4311	304S62	-	2371	304LN	Z2CN18.10	-	-	SUS304LN	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-13-3	1.4429	-	-	2375	316LN	Z2CND17.13	-	-	SUS316LN	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo17-12-2	1.4404	316S13	-	2348	316L	Z2CND17-12	X2CrNiMo1712	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-14-3	1.4435	316S13	-	2353	316L	Z2CND17.12	X2CrNiMo17 12	-	SCS16, SUS316L	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X3CrNiMo17-3-3	1.4436	316S33	-	2343, 2347	316	Z6CND18-12-03	X8CrNiMo1713	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-15-4	1.4438	317S12	-	2367	317L	Z2CND19.15	X2CrNiMo18 16	-	SUS317L	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiNb18-10	1.4550	347S17	58F	2338	347	Z6CNNb18.10	X6CrNiNb18 11	F.3552 F.3524	SUS347	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiMoTi17-12-2	1.4571	320S17	58J	2350	316Ti	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X10CrNiMoNb 18-12	1.4583	-	-	-	318	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X15CrNiSi20-12	1.4828	309S24	-	-	309	Z15CNS20.12	-	-	SUH309	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-11-2	1.4406	301S21	58C	2370	308	Z1NCDU25.20	-	F.8414	SCS17	
	M1.0.Z.AQ	05.21/15.21	X1CrNiMoCuN20-18-7	1.4547	-	-	2378	S31254	Z1CNDU20-18-06AZ	-	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X9CrNi18-8	1.4310	-	-	2331	301	Z12CN17.07	X12CrNi17 07	F.3517	SUS301	
	M1.0.Z.PH	05.22/15.22	X7CrNiAl17-7	1.4568 1.4504	316S111	-	-	17-7PH	Z8CNA17-07	X2CrNiMo1712	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNi19-11	1.4306	304S11	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-	
	M1.1.Z.AQ	05.21/15.21	-	-	304S12	-	-	-	-	-	-	-	
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S31	58E	2332, 2333	304	Z6CN18.09	X5CrNi18 10	F.3504 F.3541	SUS304	
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S15	58E	2332	304	Z6CN18.09	X5CrNi18 10	F.3551	SUS304	
	M1.1.Z.AQ	05.21/15.21	X5CrNiMo17-2-2	1.4401	316S16	58J	2347	316	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316	
	M1.1.Z.AQ	05.21/15.21	X6CrNiTi18-10	1.4541	321S12	58B	2337	321	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321	
	M1.2.Z.AQ	05.21/15.21	X8CrNiS18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303	
	E	Super austenitic (Ni>20%) stainless steel											
		M2.0.C.AQ	20.11	G-X40NiCrSi36-18	1.4865	330C11	-	-	-	-	XG50NiCr39 19	-	SCH15
		M2.0.Z.AQ	05.21/15.21	X1NiCrMoCu25-20-5	1.4539	-	-	2562	UNS V 0890A	Z2 NCDU25-20	-	-	-
		M2.0.Z.AQ	05.21/15.21	X8CrNi25-21	1.4845	310S24	-	2361	310S	Z12CN25 20	X6CrNi25 20	F.331	SUH310
		M2.0.Z.AQ	20.11	X12NiCrSi36 16	1.4864	-	-	-	330	Z12NCS35.16	F-3313	-	SUH330
		M2.0.Z.AQ	05.23/15.23	X1NiCrMoCu31-27-4	1.4563	-	-	2584	NO8028	Z1NCDU31-27-03	-	-	-
	F	Duplex (austenitic/ferritic) stainless steel											
		M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X2CrNiN23-4	1.4362	-	-	2376	S31500	-	-	-	-
		M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X8CrNiMo27-5	-	-	-	2324	S32900	-	-	-	-
M3.2.Z.AQ/M3.2.C.AQ		05.52/15.52	X2CrNiN23-4	-	-	-	2327	S32304	Z2CN23-04AZ	-	-	-	
M3.2.Z.AQ/M3.2.C.AQ		05.52/15.52	-	-	-	-	2328	-	-	-	-	-	
M3.2.Z.AQ/M3.2.C.AQ		05.52/15.52	X2CrNiMoN22-53	-	-	-	2377	S31803	Z2CND22-05-03	-	-	-	
M1.1.Z.AQ		05.21/15.21	-	-	-	-	-	-	-	-	-	-	
M1.1.Z.AQ	05.21/15.21	-	1.0045	-	-	-	-	-	-	-	-		
M1.1.Z.AQ	05.21/15.21	-	-	-	-	-	-	-	-	-	-		
M1.1.Z.AQ	05.21/15.21	-	-	-	-	-	-	-	-	-	-		
M1.0.Z.AQ	05.23/15.23	-	-	-	-	-	-	-	-	-	-		
M2.0.Z.AQ	05.23/15.23	-	-	-	-	-	-	-	-	-	-		
M3.2.Z.AQ	05.52/15.52	-	-	-	-	-	-	-	-	-	-		
M3.2.Z.AQ	05.52/15.52	-	-	-	-	-	-	-	-	-	-		
			Trade names										
			SANMAC 304 (Sandvik Steel)										
			SANMAC 304L (Sandvik Steel)										
			SANMAC 316 (Sandvik Steel)										
			SANMAC 316L (Sandvik Steel)										
			254 SMO										
			654 SMO										
			SANMAC SAF 2205 (Sandvik Steel)										
			SANMAC SAF 2507 (Sandvik Steel)										

Material cross reference list

ISO	MC	CMC	Country										
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan		
			Standard										
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS	
K	Malleable cast iron												
	K1.1.C.NS	07.1	-	-	8 290/6	-	0814	-	MN 32-8	-	-	-	FCMB310
	K1.1.C.NS	07.1	EN-GJMB350-10	0.8135	B 340/12	-	0815	32510	MN 35-10	-	-	-	FCMW330
	K1.1.C.NS	07.2	EN-GJMB450-6	0.8145	P 440/7	-	0852	40010	Mn 450	GMN 45	-	-	FCMW370
	K1.1.C.NS	07.2	EN-GJMB550-4	0.8155	P 510/4	-	0854	50005	MP 50-5	GMN 55	-	-	FCMP490
						P 570/3	-	0858	70003	MP 60-3	-	-	FCMP540
	K1.1.C.NS	07.2	EN-GJMB650-2	0.8165	P570/3	-	0856	A220-70003	Mn 650-3	GMN 65	-	-	FCMP590
	K1.1.C.NS	07.3	EN-GJMB700-2	0.8170	P690/2	-	0862	A220-80002	Mn700-2	GMN 70	-	-	FCMP690
	Grey cast iron												
	K2.1.C.UT	08.1	-	-	-	-	0100	-	-	-	-	-	-
	K2.1.C.UT	08.1	EN-GJL-100	0.6010	-	-	0110	No 20 B	Ft 10 D	-	-	-	FC100
	K2.1.C.UT	08.1	EN-GJL-150	0.6015	Grade 150	-	0115	No 25 B	Ft 15 D	G 15	FG 15	-	FC150
	K2.1.C.UT	08.1	EN-GJL-200	0.6020	Grade 220	-	0120	No 30 B	Ft 20 D	G 20	-	-	FC200
	K2.1.C.UT	08.2	EN-GJL-250	0.6025	Grade 260	-	0125	No 35 B	Ft 25 D	G 25	FG 25	-	FC250
	K2.1.C.UT	08.2	EN-JLZ	0.6040	Grade 400	-	0140	No 55 B	Ft 40 D	-	-	-	-
	K2.2.C.UT	08.2	EN-GJL-300	0.6030	Grade 300	-	0130	No 45 B	Ft 30 D	G 30	FG 30	-	FC300
	K2.2.C.UT	08.2	EN-GJL-350	0.6035	Grade 350	-	0135	No 50 B	Ft 35 D	G 35	FG 35	-	FC350
	K2.3.C.UT	08.3	GGL-NiCr20-2	0.6660	L-NiCuCr202	-	0523	A436 Type 2	L-NC 202	-	-	-	-
	Nodular cast iron												
	K3.1.C.UT	09.1	EN-GJS-400-15	0.7040	SNG 420/12	-	0717-02	60-40-18	FCS 400-12	GS 370-17	FGE 38-17	-	FCD400
	K3.1.C.UT	09.1	EN-GJS-400-18-LT	0.7043	SNG 370/17	-	0717-12	-	FGS 370-17	-	-	-	-
K3.1.C.UT	09.1	EN-GJS-350-22-LT	0.7033	-	-	0717-15	-	-	-	-	-	-	
K3.1.C.UT	09.1	EN-GJS-800-7	0.7050	SNG 500/7	-	0727	80-55-06	FGS 500-7	GS 500	FGE 50-7	-	FCD500	
K3.2.C.UT	09.2	EN-GJS-600-3	0.7060	SNG 600/3	-	0732-03	-	FGS 600-3	-	-	-	FCD600	
K3.3.C.UT	09.2	EN-GJS-700-2	0.7070	SNG 700/2	-	0737-01	100-70-03	FGS 700-2	GS 700-2	FGS 70-2	-	FCD700	
K3.5.C.UT	-	EN-GJSA-XNiCr20-2	0.7660	Grade S6	-	0776	A43D2	S-NC 202	-	-	-	-	
Compacted graphite iron													
K4.1.C.UT	-	EN-GJV-300											
K4.1.C.UT	-	EN-GJV-350											
K4.2.C.UT	-	EN-GJV-400											
K4.2.C.UT	-	EN-GJV-450											
K4.2.C.UT	-	EN-GJV-500											
Austempered ductile iron													
K5.1.C.NS	-	EN-GJS-800-8	-	-	-	-	ASTM A897 No. 1	-	-	-	-	-	
K5.1.C.NS	-	EN-GJS-1000-5	-	-	-	-	ASTM A897 No. 2	-	-	-	-	-	
K5.2.C.NS	-	EN-GJS-1200-2	-	-	-	-	ASTM A897 No. 3	-	-	-	-	-	
K5.2.C.NS	-	EN-GJS-1400-1	-	-	-	-	ASTM A897 No. 4	-	-	-	-	-	
K5.3.C.NS	-	-	-	-	-	-	ASTM A897 No. 5	-	-	-	-	-	

Material cross reference list

ISO	MC	CMC	Country									
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan	
			Standard									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
N	Aluminium based alloys											
Non-ferrous metals	N1.3.C.AG	30.21	G-AISI9MGWA	3.2373	-	-	4251	SC64D	A-S7G	-	-	C4BS
	N1.3.C.UT	30.21	G-ALMG5	-	LM5	-	4252	GD-AISI12	A-SU12	-	-	AC4A
	N1.3.C.UT/N1.3.C.AG	30.21/30.22	-	-	LM25	-	4244	356.1	-	-	-	A5052
	N1.3.C.UT	-	GD-AISI12	-	-	-	4247	A413.0	-	-	-	A6061
	N1.3.C.AG	-	GD-AISI8Cu3	-	LM24	-	4250	A380.1	-	-	-	A7075
	N1.3.C.UT	-	G-AISI12(Cu)	-	LM20	-	4260	A413.1	-	-	-	ADC12
	N1.3.C.UT	-	G-AISI12	-	LM6	-	4261	A413.2	-	-	-	-
	N1.3.C.AG	-	G-AISI10Mg(Cu)	-	LM9	-	4253	A360.2	-	-	-	-
S	Nickel based alloys											
S2.0.Z.AG	20.22	S-NiCr13A16MoNb	LW2 4670	mar-46	-	-	5391	NC12AD	-	-	-	-
S2.0.C.UT	20.24	NiCo15Cr10MoAlTi	LW2 4674	-	-	-	AMS 5397	-	-	-	-	-
S2.0.Z.AG	20.22	NiFe35Cr14MoTi	LW2.4662	-	-	-	5660	ZSNCDT42	-	-	-	-
S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	HR8	-	-	5383	NC19eNB	-	-	-	-
S2.0.Z.AG	20.22	NiCr20TiAk	2.4631	Hr401.601	-	-	-	NC20TA	-	-	-	-
S2.0.Z.AG	20.22	NiCr19Co11MoTi	2.4973	-	-	-	AMS 5399	NC19KDT	-	-	-	-
S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	-	-	-	AMS 5544	NC20K14	-	-	-	-
S2.0.Z.AN	20.21	-	2.4603	-	-	-	5390A	NC22FeD	-	-	-	-
S2.0.Z.AN	20.21	NiCr22Mo9Nb	2.4856	-	-	-	5666	NC22FeDNB	-	-	-	-
S2.0.Z.AN	20.21	NiCr20Ti	2.4630	HR5.203-4	-	-	-	NC20T	-	-	-	-
S2.0.Z.AG	20.22	NiCu30AL3Ti	2.4375	3072-76	-	-	4676	-	-	-	-	-
	Cobalt alloys											
-	-	CoCr20W15Ni	-	-	-	-	5537C, AMS	KC20WN	-	-	-	-
S3.0.Z.AG	20.32	CoCr22W14Ni	LW2.4964	-	-	-	5772	KC22WN	-	-	-	-
	Titanium alloys											
S4.2.Z.AN	23.22	TiAl5Sn2.5	3.7115.1	TA14/17	-	-	UNS R54520	T-A5E	-	-	-	-
S4.2.Z.AN	23.22	TiAl6V4	3.7165.1	TA10-13/TA28	-	-	UNS R56401	UNS R56400	-	-	-	-
S4.3.Z.AN	23.22	TiAl5V5Mo5Cr3	-	-	-	-	-	T-A6V	-	-	-	-
S4.2.Z.AN	23.22	TiAl4Mo4Sn4Si0.5	3.7185	-	-	-	-	-	-	-	-	-
	Trade names											
	Iron based alloys											
S2.0.Z.UT/S2.0.Z.AN	20.11	Incoloy 800										
	Nickel based alloys											
S2.0.Z.AN	20.2	Haynes 600										
S2.0.Z.AN	20.2	Nimocast PD16										
S2.0.Z.AG	20.2	Nimonic PE 13										
S2.0.Z.AG	20.2	Rene 95										
S2.0.Z.AN	20.21	Hastelloy C										
S2.0.Z.AN	20.21	Incoloy 825										
S2.0.Z.AN	20.21	Inconel 600										
S2.0.Z.AN	20.21	Monel 400										
S2.0.Z.AG	20.22	Inconel 700										
S2.0.Z.AG	S2.0.Z.AG	Inconel 718										
S2.0.Z.AG	20.22	Mar - M 432										
S2.0.Z.AG	20.22	Nimonic 901										
S2.0.Z.AG	20.22	Waspaloy										
S2.0.C.NS	20.24	Jessop G 64										
	Cobalt alloys											
S3.0.Z.AG	20.3	Air Resist 213										
S3.0.Z.AG	20.3	Jetalloy 209										
H	Hardened materials											
Hardened materials	H1.2.Z.HA	04.1	X100CrMo13	1.4108	-	-	2258 08	440A	-	-	-	C4BS
	H1.3.Z.HA	04.1	X110CrMoV15	1.4111	-	-	2534 05	610	-	-	-	AC4A
	H1.2.Z.HA	04.1	X65CrMo14	-	-	-	2541 06	0-2	-	-	-	AC4A

For the sake of the environment

Get into the Sandvik Coromant Recycling Concept (CRC) now!

The Sandvik Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts and solid carbide tools offered by Sandvik Coromant to all its customers.

In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers.

Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way.

All used carbide inserts are collected in the collection box at the workplace.

When the collection box is sufficiently full, its contents are transferred to the transport box.

The full transport box is then sent to the nearest Sandvik Coromant office or to your Sandvik Coromant dealer who can also give you more information.



The benefits of the CRC speak for themselves

- A worldwide ISO and OHAS certified recycling system.
- Open to all Sandvik Coromant customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.

Order collection boxes for each lathe, milling machine, drill or for your machining centre. We recommend one collection box for inserts and one separate box for solid carbide tools for each cutting workplace.

For detailed instructions on how to sell your used cemented carbide, please visit www.sandvik.coromant.com and select your market.

Collection box:	Order numbers
Transport box for solid carbide tools (plywood):	91617
Transport box inserts (plywood):	92994
	92995

CNSC

Coolant entry style code

Code	Description	Image
0	Without coolant	
1	Axial concentric entry	
2	Radial entry	
3	Axial concentric and radial entry	
4	Axial concentric entry on circle	
5	Radial entry before adaptor	
6	Decentral over flange	
7	Decentral over flange and axial	
8	Decentral over slots on the shank	

CXSC

Coolant exit style code

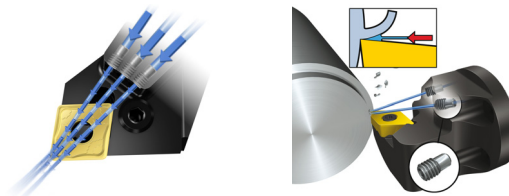
Code	Description	Image
0	No coolant exit	
1	Axial concentric exit	
2	Radial exit	
3	Axial inclined exit	
4	Axial concentric on circle	
5	Axial inclined exit with nozzle, adjustable	
6	Decentral exit with nozzle, adjustable	
7	Decentral over slots on the shank	
8	Axial or decentral with nozzle, adjustable	

Precision coolant supply

Holders with nozzles designed for precision coolant

For chip control, process security and extended tool life

Designed for coolant pressures up to 275 bar (4000 psi)



Sandvik Coromant's fixed, pre-directed high precision nozzles create parallel laminar jets of coolant with high velocity, directed at the right place of the insert edge. It is the precision and character of these jets that make the difference in terms of chip control and process security. The positive effects start at low coolant pressure, but the higher the pressure is, the more demanding material can successfully be machined.

Safety information

Safety information in connection with grinding of cemented carbide

Material composition

Tool holders

Tool holders mainly contain iron (FE), and low alloy elements such as chromium, nickel, manganese, molybdenum and silicon.

Indexable inserts/cutting tools/round tools

Substances in cemented carbide products contain mostly wolfram carbide and cobalt. They may also contain carbides and carbonitrides of the following elements: titanium, tantalum, niobium, chromium, molybdenum and vanadium.

Routes of exposure

Grinding or heating of hard metal blanks or hard metal products will produce products that give off dangerous dust and fumes. Avoiding ingestion and contact with skin or eyes is very important.

Acute toxicity

Intake of the aforementioned substances is toxic. Inhalation may cause irritation and inflammation of the airways. Significantly higher acute inhalation toxicity has been reported during simultaneous inhalation of cobalt and tungsten carbide compared to inhalation of cobalt alone.

Skin contact can cause irritation and rash. Sensitive individuals may even experience an allergic reaction.

Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction of the airways. Prolonged exposure to increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers previously exposed to high concentrations of tungsten carbide/cobalt carried an increased risk of developing lung cancer.

Cobalt and nickel are potent skin sensitizers. Repeated or prolonged contact can cause irritation and sensitization.

Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation

Toxic when inhaled

Limited evidence of a carcinogenic effect.

May cause sensitization by inhalation and skin contact

Preventive measures

Avoid formation and inhalation of dust. Use adequate local exhaust ventilation to keep personal exposure well below nationally authorised limits.

If ventilation is not available or adequate, use respirators appropriately approved for the purpose.

Use safety goggles or glasses with side shields when necessary.

Avoid repeated skin contact. Wear suitable gloves. Wash skin thoroughly after handling.

Use suitable protective clothing. Launder clothing if needed.

Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.



Conversion table

Metric to imperial

Distance

1 meter = 39.370 inch

1 meter = 3.281 feet

1 millimeter = 0.039 inch

Weight

1 kilogram = 2.205 pounds

1 kilogram = 35.274 ounces

Torque

1 Newton meter (Nm) = 0.738 pound-force feet (ft-lbs)

1 Newton meter (Nm) = 8.851 pound-force inches (in-lbs)

Imperial to metric

Distance

1 inch = 25.4 millimeter

1 foot = 0.3 meter

1 foot = 304.8 millimeter

Weight

1 pound = 0.45 kilogram

1 ounce = 28,35 gram

Torque

1 pound-force foot (ft-lbf) = 1.4 Newton meter (Nm)

1 pound-force inch (in-lbf) = 0.1 Newton meter (Nm)

Formulas and definitions:

v_c = cutting speed

n = spindle speed

v_f = table feed

z_n = total number of cutting edges

z_c = number of effective cutting edges

f_z = feed per tooth

f_n = feed per revolution

h_{ex} = maximum thickness

a_p = cutting depth

l_a = insert width

a_e = cutting width

a_e/D_c % = Radial immersion

T = machining time

Q = metal removal rate

nap = number of passes

TPI = threads per inch

k_c = specific cutting force

R_a = surface roughness

Metric

m/min (meter/minute)

rpm (revolution per minute)

mm/min

mm/z

mm/rev

mm

mm

mm

mm

%

min

cm³/min

N/mm²

μm

Imperial

ft/min (feet/minute)

inch/min

inch/z

inch/rev

inch

inch

inch

inch

%

min

inch³/min

lbs/in²

μin

Insert size

iC = inscribed circle in inch

$\frac{\Delta}{\text{---}}$ = cutting edge length in mm

To make life easier, a new standard has been developed

ISO 13399 is an international standard that strives to simplify the exchange of data for cutting tools. You will notice a slight difference through the new parameters and descriptions of each tool.

For the first time ever, there is a standardized way of describing product data regarding cutting tools. When all tools in the industry share the same parameters and definitions, communicating tool information becomes very straightforward.

What does this mean to you?

Basically, it means that your systems can talk to ours, as they all speak the same language. Download product data from our web site and use it directly in your CAD/CAM software to assemble tools that you use in production. No need to look for information in catalogues and interpret data from one system to another. Imagine how much time this will save you!

Short name	Preferred Name
ADJLX	Maximum adjustment limit
ADJRG	Adjustment range
ALP	Clearance angle axial
AN	Clearance angle major
ANN	Clearance angle minor
APMX	Depth of cut maximum
B	Shank width
BAWS	Body angle workpiece side
BAMS	Body angle machine side
BBD	Balanced by design
BBR	Balanced by rotational test
BCH	Corner chamfer length
BD	Body diameter
BHTA	Body half taper angle
BN	Face land width
BS	Wiper edge length
BSG	Basic standard group
BSR	Wiper edge radius
CDX	Cutting depth maximum
CF	Spot chamfer
CHBA	Chamfer body angle
CHBL	Chamfer body length
CHW	Corner chamfer width
CHWL	Corner chamfer width, left hand
CHWR	Corner chamfer width, right hand
CICT	Cutting item count
CND	Coolant entry diameter
CNSC	Coolant entry style code
CNT	Coolant entry thread size
COATING	Coating
CP	Max coolant pressure
CRKS	Connection retention knob thread size
CRNT	Coolant radial entry thread size
CTPT	Operation type
CUTDIA	Work piece parting diameter maximum
CW	Cutting width
CWN	Minimum cutting width
CWTOLL	Cutting width lower tolerance
CWTOLU	Cutting width upper tolerance
CWX	Cutting width maximum
CXSC	Coolant exit style code
CZC	Connection size code
CZC _{MS}	Connection size code machine side
CZC _{WS}	Connection size code workpiece side
D1	Fixing hole diameter
DAH	Diameter access hole
DAXIN	Axial groove inside diameter minimum
DAXN	Minimum axial groove outside diameter
DAXX	Axial groove outside diameter maximum
DBC	Diameter bolt circle

A	DC	Cutting diameter
	DCB	Connection bore diameter
B	DCBN	Connection bore diameter minimum
	DCBX	Connection bore diameter maximum
	DCF	Cutting diameter face contact
	DCN	Cutting diameter minimum
	DCON	Connection diameter
	DCON _{MS}	Connection diameter machine side
	DCON _{WS}	Connection diameter workpiece side
	DCSF _{MS}	Contact surface diameter machine side
	DCSF _{WS}	Contact surface diameter workpiece side
C	DCX	Cutting diameter maximum
	DIX	Tool changer interference diameter maximum
	DMIN	Minimum bore diameter
	DMM	Shank diameter
	DN	Neck diameter
	DSGN	Design
	EPSR	Insert included angle
	FHA	Flute helix angle
D	FLGT	Flange thickness
	FTDZ	For thread diameter size
	GB	Face land angle
	H	Shank height
	HA	Thread height theoretical
	HB	Thread height difference
	HBH	Head bottom offset height
	HBL	Head bottom offset length
	HC	Thread height actual
	HF	Functional height
E	HRY	Lowest point from reference plain
	HTB	Body height
	HTH	Height
	IC	Inscribed circle diameter
	INSL	Insert length
	INSUC	Insert usage code
	IZC	Insert size code
	KAPR	Tool cutting edge angle
F	KCH	Corner chamfer
	KCHL	Corner chamfer, left hand
	KCHR	Corner chamfer, right hand
	KRINS	Major cutting edge angle
	KWW	Keyway width
	L	Cutting edge length
	LAMS	Inclination angle
	LB	Body length
	LCF	Length chip flute
G	LCOX	Cut off length maximum
	LE	Cutting edge effective length
	LF	Functional length
	LH	Head length
	LPR	Protruding length
	LS	Shank length
	LSC	Clamping length
	LSCN	Clamping length minimum
H	LSCS	Distance to clamping start
	LSCX	Clamping length maximum
	LSD	Dead shank length
	LU	Usable length (max. recommended)
	LUX	Usable length maximum
	MHD	Mounting hole distance
	MIID	Master insert identification
	MMCC	Code for preset torque
	MMCX	Max. cutting torque
I	NOF	Flute count
	NT	Tooth count
	OAH	Overall height
	OAL	Overall length
	OAW	Overall width
	OH	Overhang recommended
	OHN	Overhang minimum
	OHX	Overhang maximum
J	ORDCODE	Ordercode

PCL	Peripheral cylindrical length
PDX	Profile distance ex
PDY	Profile distance ey
PHD	Premachined hole diameter
PHDX	Maximum premachined hole diameter
PL	Point length
PNA	Profile included angle
PRFRAD	Profile radius
PRSPC	Profile specification
PSIR	Tool lead angle
PSIRL	Cutting edge angle major left hand
PSIRR	Cutting edge angle major right hand
RADH	Radial body height
RADW	Radial body width
RAR	Right hand relief angle
RE	Corner radius
REEQ	Corner radius equivalent
REL	Corner radius left
RER	Corner radius right
RETOLL	Corner radius lower tolerance
RETOLU	Corner radius upper tolerance
RGL	Regrind length
RMPX	Maximum ramping angle
RPMX	Rotational speed maximum
S	Insert thickness
SDL	Step diameter length
SIG	Point angle
SPTL	Splitline
SSC	Insert seat size code
STA	Step included angle
STDNO	Standard number
SUBSTRATE	Substrate
TCDC	Tolerance class cutting diameter
TCMMM	Shank diameter tolerance
TCHA	Achievable hole tolerance
TCHAL	Achievable hole tolerance lower
TCHAU	Achievable hole tolerance upper
TCT	Tolerance class tool
TCTR	Thread tolerance class
TD	Thread diameter
TDZ	Thread diameter size
TFLA	Tap floating length ahead
TFLB	Tap floating length behind
TG	Taper gradient
THCA	Thread helix correction angle
THCHT	Threading chamfer type
THFT	Form type
THFTS	Thread form standard series
THL	Thread length
THUB	Hub thickness
TP	Thread pitch
TPI	Threads per inch
TPIN	Threads per inch minimum
TPIX	Threads per inch maximum
TPN	Thread pitch minimum
TPX	Maximum thread pitch
TQ	Torque
TSYC	Tool style code
TTP	Thread type
ULDR	Usable length diameter ratio
VCX	Maximum cutting speed
W1	Insert width
WB	Body width
WF	Functional width
WFCIRP	Width to cutting item reference point
WSC	Clamping width
WT	Weight of item
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count (ZEFP)
ZWX	Maximum number of Wiper inserts

A

Code	Page	Code	Page	Code	Page
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254R/LG	B46	830	G5	A490..EH	E14
266LG..AC..F	C25	830B	G4	A490..Oxx	E13
266LG..MJ..A	C22	870..L-10	F5	A495..Mxx	E41
266LG..MM..A	C11	870..L-3	F5	A570-2C	D10
266LG..NT..A	C18	870..L-5	F5	A570-2C..CR	D7
266LG..PT..A	C19	870..L-8	F5	AEHxx-Axx..CS	H8
266LG..RN..A	C21	870..LX-10	F5	AEHxx-Axx..SS	H4
266LG..SA..F	C26	870..LX-3	F5	AEHxx-Axx.x-SH	H6
266LG..TR..F	C24	870..LX-5	F5	AEHxx-Axx-SH	H5
266LG..UN..A	C14	870..LX-8	F5	AExx-Axx..SS	H3
266LG..VM..A	C7	870-GP	F8	C	
266LG..VW..A	C8	870-MM	F7	C..STFCR/L	A78, A80, A89
266LG..WH..A	C16	870-PM	F6	CCET-UM	A8
266R/LFA	C41, C43-C45, C47-C48	A		CCGT-UM	A9
266R/LG-BG	C28	A..DCLNR/L	A73, A88-A91	CCGX-AL	A8
266RG..AC..F	C25	A..DDUNR/L	A74, A88-A91	CCMT-MF	A7
266RG..MJ..A	C22	A..PCLNR/L	A67, A71, A74	CCMT-MM	A8
266RG..MM..A	C9-C10	A..PCLNR/L..HP	A67, A71, A83, A88	CCMT-PF	A7
266RG..MM..C	C9	A..PDUNR/L	A74	CCMT-PM	A8
266RG..MM..F	C9	A..PDUNR/L..HP	A74, A91	CCMT-PMC	A8
266RG..NF..A	C20	A..PTFNR/L	A67, A71, A74	CCMT-SMC	A8
266RG..NJ..A	C23	A..PTFNR/L..HP	A67, A71, A74,	CCMT-UF	A7
266RG..NT..A	C17	A..PTFNR/L..HP	A84, A88, A91	CCMT-UM	A9
266RG..NT..C	C17	A..SCLCR/L	A58, A60, A63, A66, A70,	CCMT-UR	A9
266RG..PT..A	C19	A..SCLCR/L	A78, A80, A83, A87, A91	CCMT-WF	A7
266RG..RD..A	C27	A..SCLCR/L -R	A57, A59, A61, A64,	CNMG-MF	A24
266RG..RN..A	C21	A..SCLCR/L -R	A68, A77, A79, A81, A85	CNMG-MM	A24
266RG..RN..F	C21	A..SCLCR/L..HP	A70, A73, A87, A91	CNMG-PF	A24
266RG..SA..F	C26	A..SCLCR/L..HP-R	A68, A72, A85, A90	CNMG-PM	A24
266RG..TR..F	C24	A..SDQCR/L	A60, A63, A66, A70, A78,	CNMG-QM	A24
266RG..UN..A	C12-C13	A..SDQCR/L	A80, A83, A87, A91	CNMG-WF	A24
266RG..UN..C	C12	A..SDQCR/L -R	A59, A61, A64, A69, A77	CXS..F..AR/L	B80-B81
266RG..UN..F	C12	A..SDQCR/L..HP	A70, A73, A87	CXS..F..BR/L	B80
266RG..VM..A	C7	A..SDQCR/L..HP-R	A68, A72, A85	CXS..FN	D3
266RG..VM..C	C7	A..SDUCR/L	A60, A63, A66, A70, A78,	CXS..R	D4
266RG..VM..F	C7	A..SDUCR/L	A80, A83, A87, A91	CXS..R/L	D4
266RG..VW..A	C8	A..SDUCR/L -ER	A59, A61	CXS-A	D11-D14, D17
266RG..VW..C	C8	A..SDUCR/L -R	A64, A68, A77,	CXS-Axx-X	D15-D16
266RG..VW..F	C8	A..SDUCR/L -R	A79, A81, A85	CXS-Exx-X	D15
266RG..WH..A	C15-C16	A..SDUCR/L..HP	A70, A73, A87, A92	CXS-xxB090..R/L	A98-A99, A101, A103
266RG..WH..C	C15	A..SDUCR/L..HP-R	A68, A72, A85, A90	CXS-xxG	B73-B79
266RG..WH..F	C15	A..SDUCR/L..RX	A64, A68, A85	CXS-xxGX	B72
325..CCxx	E37	A..SDUCR/L..X	A66, A70, A87, A91	CXS-xxR	B82-B83
325..DDxx	E37	A..SDXCR/L	A63, A66, A70, A80,	CXS-xxT045..R/L	A100, A102-A103
325R..HA	E34	A..SDXCR/L	A83, A87, A92	CXS-xxT090..R/L	A97, A99
325R..HB	E34	A..SDXCR/L-R	A61, A64, A68-A69,	CXS-xxT098..R/L	A96-A99, A101, A103
325R-BG	E35	A..SDXCR/L-R	A81, A85	CXS-xxT140..R/L	A98, A100, A102-A103
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390R..E-MM	E25	A..SRDDN-R	A64	CXS-xxTH..MM	C54
390R..E-NL	E25	A..SRXDR/L-R	A69, A85-A86	CXS-xxTH..NT	C57
390R..E-PL	E25	A..STFCR/L	A57-A58, A60, A63, A66,	CXS-xxTH..TR	C58
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390R..M-PM	E25	A..STFCR/L	A80, A83, A88, A92	CXS-xxTH..VM	C53
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490..Axx	E13	A..STUCR/L	A56-A57, A59	DCGT-UM	A11
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490R/L..M-MM	E15	A..SVQBR/L	A66, A71, A92	DCMT-PF	A10
490R/L..M-PH	E15	A..SVQBR/L -R	A69	DCMT-PM	A11
490R/L..M-PL	E15	A..SVQBR/L..HP-D	A73	DCMT-PMC	A11
490R/L..M-PM	E15	A..SVQCR/L	A67, A83	DCMT-SMC	A11
495..Axx	E40	A..SVQCR/L-ER	A65, A82	DCMT-UF	A10
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495-MM	E43	A..SVUBR/L	A88, A92-A93	DCMT-UR	A12
495-PM	E43	A..SVUBR/L -ER	A65, A69, A82, A86	DCMX-WF	A10
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DNMG-SF	A25	MB-xxTH..UN	C62	R/LF123T/U..BM	B57, B60, B62
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ENG