

Turning tools

GENERAL TURNING | PARTING & GROOVING | THREADING | TOOLING SYSTEMS

2012



How to choose your turning tool

1 Overview of tooling alternatives

Choose Coromant Capto® or shank tool, depending on clamping possibilities in turret/spindle. See chapter G, page G4

2 Identify your operation, tooling and clamping system

See page A4 for external and A6 for internal machining.

Define your type of operation

- Longitudal turning
- Profiling
- Facing
- Plunging

Define tooling systems

- Negative:
- CoroTurn® RC
 - T-Max P
- Positive:
- CoroTurn® 107
 - CoroTurn® 111
 - CoroTurn® TR

3 Select your insert

- Shape
- Size
- Geometry
- Grade

4 Cutting data

Starting values for cutting speeds and feeds are given on the insert dispensers.

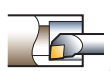


For more technical information, see our Metalcutting Technical guide

Symbols for page references:



External machining



Internal machining



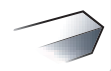
Build-in tools



Tooling systems



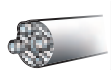
Coromant Capto® unit



Conventional holder



Conventional bar



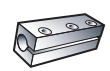
CoroTurn® SL adaptors



Inserts



Spare parts/accessories



Sleeves



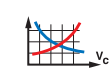
Conversion table, formulas and definitions



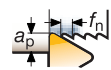
How to choose tool, overview



Grade descriptions



Cutting data, speed recommendations



Cutting data, feed and cutting depth recommendations

GENERAL TURNING

Applications

External machining	A4
Internal machining	A6
Turning productivity	A18

Products

Inserts

Insert overview	A9
Code key	A16

Negative basic-shape inserts

T-Max® P - 0° clearance angle	A19
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Positive basic-shape inserts

CoroTurn® 107 - 7° clearance angle	A45
CoroTurn® 111 - 11° clearance angle	A62
CoroTurn® TR - T-Rail interface	A189

Multi-material inserts	A67
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Advanced cutting materials

Code key	
Negative basic-shape inserts	A78
Positive basic-shape inserts	A94

Inserts for other systems

CoroTurn® XS, internal tools for small part machining	A325
CoroCut® XS, external tools for small part machining	B85
CoroCut® MB, internal tools for precision machining	B92

Holders for external machining	A101
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Holders for internal machining	A251
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Small part machining	
External	A220
Internal	A325

Cartridges for special tools	A349
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Heavy machining

Heavy Turning	A372
Bar peeling	A409
Railway wheel re-turning	A424

Tools for multi-task machining	H1
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CoroTurn SL system	I1
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Spare parts

Torque wrenches	A437
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Cutting data

Cutting depth and feed recommendations	A500
Cutting speed recommendations	A516

Grade information

	A524
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External machining

CoroTurn® RC

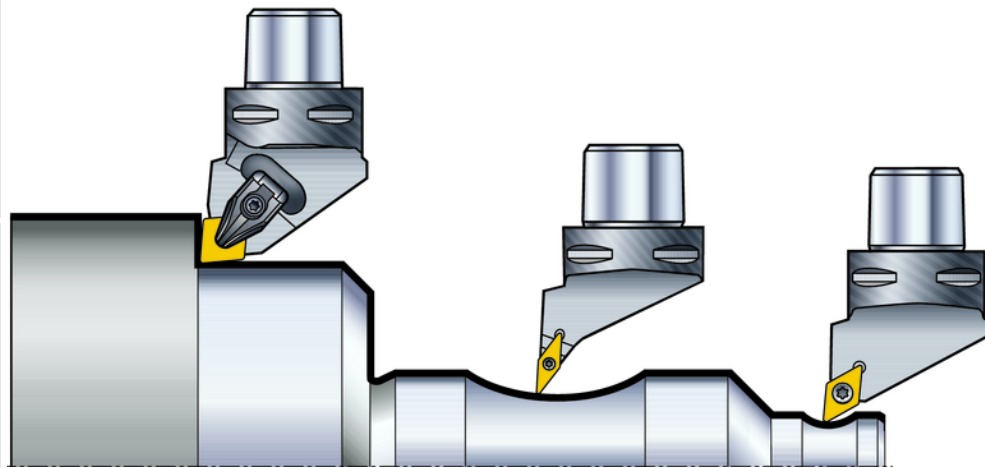
External machining, from roughing to finishing

CoroTurn® TR

First choice for external profiling






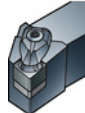








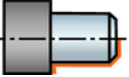
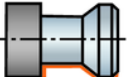

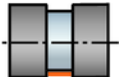
CoroTurn® 107

External machining of small, long and slender components



General points to consider

1. Use an entering angle less than 90° (lead angle larger than 0°), if possible, to reduce the impact and the forces.
2. First recommendation is to use Coromant Capto® cutting units.
3. When using conventional tools, use the largest tool holder shank possible, for maximum stability.

Tooling system	Negative basic-shape inserts			Positive basic-shape inserts		Ceramic and CBN inserts	
	CoroTurn® RC	T-Max P		CoroTurn® 107	CoroTurn TR	CoroTurn® RC	T-Max®
Coromant Capto® Shank holder SL cutting units	A115 A137 -	A124 A152 I12	A134 A159 -	A166 A174 -	A193 A195 I14	A200 A208 -	A207 A218 -
	 Rigid clamp design	 Lever design	 Wedge clamp design	 Screw clamp design	 Screw clamp design	 Rigid clamp design	 Top clamp design
							
Longitudinal turning/ facing 	• •	•	•	•	•	• •	•
Profiling 	• •	•	•	• •	• •	• •	•
Facing 	• •	•	•	•		• •	•
Plunging 		•		• •			• •

• • = Recommended tooling system

• = Alternative tooling system

External machining

Choosing insert shape, size, nose radius, geometry and grade

Insert shape depending on operation

The insert shape should be selected to the required lead angle and the accessibility or versatility required of the tool.

The largest suitable point angle on the insert should be selected for strength and economy

Insert size

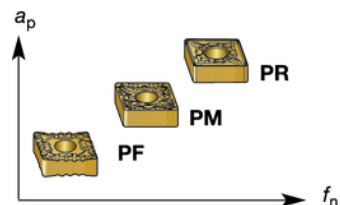
For selecting insert size, see page A8.

Insert geometries

Dedicated for:

- Different feed and depth of cut areas
- Different workpiece materials

See page A19 or for more detailed information see our Metalcutting Technical guide.



See page A18.

Wiper TECHNOLOGY



Practical tips when selecting geometry

- The Wiper geometry gives the highest productivity or the best surface finish quality.
- Select the largest possible nose radius to obtain a strong cutting edge.
- Select a smaller radius if there is a tendency to vibrate.

Insert grades

Modern productive coated and uncoated grades for all ISO material areas, see page A524.

Recommended cutting speed see page A516.

	Insert page							
Negative basic-shape inserts	A20	A26	A30	A31	A35	A41	A39	A44
T-Max P								
Positive basic-shape inserts	A46	A49	A51	A52	A54	-	A58	-
CoroTurn® 107	-	A191	-	-	-	-	A191	-
CoroTurn® TR	-							
Ceramic, CBN and PCD	A78	A82	A84	A86	A89	A91	A93	-
	A94	A95	A98	A99	A97	-	A96	-
Insert shape								
Longitudinal turning/facing								
Profiling								
Facing								
Plunging								

• • = Recommended insert shape

• = Alternative insert shape

Internal machining

CoroTurn® XS

Internal machining of extra small hole diameters, starting at 0.3 mm (.012 inch) diameters (Small part machining)

CoroCut® MB

Internal machining of small holes diameters, starting at 10 mm (.394 inch) diameter

T-Max P

Internal turning of holes from 20 mm (.750 inch) in diameter with short tool overhangs and stable conditions.

General points to consider


















1. Use an entering angle close to 90° (lead angle 0°) but never less than 75° (never more than lead angle 15°), to reduce bar deflection and vibration.
2. Use the largest bar size and smallest possible bar overhang, to provide maximum stability.

CoroTurn® 111

For optimization of internal turning operations requiring small cutting forces when machining with long tool overhangs.

CoroTurn® 107

First choice for internal machining of small and medium holes from 6 mm (.236 inch) diameter.

Tooling system External machining - Coromant Capto® cutting units for multi-task machining Shank holder SL cutting units	Negative basic-shape inserts			Positive basic-shape inserts			Ceramic and CBN inserts
	CoroTurn® RC	T-Max P		CoroTurn® 107	CoroTurn® 111	CoroTurn TR	T-Max®
	A261 A269 I21	A263 A273 I16	A266 A275 -	A280 A286 I27	- A309 I32	- - I18	- A319 -
	 Rigid clamp design	 Lever design	 Wedge clamp design	 Screw clamp design	 Screw clamp design	 Screw clamp design	 Top clamp design
							
Longitudinal turning/ facing 	• •	• •	•	• •	• •	•	•
Profiling 	•	•		• •	• •		
Facing 	•	•		• •	•	•	•

• • = Recommended insert shape

• = Alternative insert shape

Internal machining

Choosing insert shape, size, nose radius, geometry and grade

Insert shape depends on operation

The insert shape should be selected to the required lead angle and the accessibility or versatility required of the tool.

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Insert size

For selecting insert size, see page A8.

Insert geometries

Dedicated for:

- Different feed and depth of cut areas
- Different workpiece materials

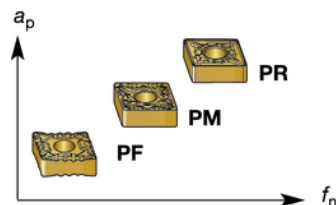
See page A19 or for more detailed information see our Metalcutting Technical guide.

Practical tips when selecting geometry

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Select a smaller radius if there is a tendency to vibrate.



See page A18.

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Recommended cutting speed see page A516.

	Insert page							
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Positive basic-shape inserts CoroTurn® 107	A46	A49	A51	A52	A54	-	A58	-
Positive basic-shape inserts CoroTurn® 111	A62	A63	-	A64	A65	A66		-
Ceramic, CBN and PCD	A78	A82	A84	A86	A89	A91	A93	-
	A94	A95	A98	A99	A97	-	A96	-
Insert shape								
Longitudinal turning/facing 	•	•	•	•	• •	•		
Profiling 		• •			•		•	• •
Facing 	• •	•	•		•	•		

• • = Recommended insert shape

• = Alternative insert shape

Selecting the insert size

Finishing

Operations at light depths of cut and feeds

$$f_n = 0.1 - 0.3 \text{ mm/r}$$

$$.004 - .012 \text{ inch/r}$$

Medium

Operations at medium to light roughing depths of cut and feeds

$$f_n = 0.2 - 0.5 \text{ mm/r}$$










$$.008 - .020 \text{ inch/r}$$

Roughing

Operations for high stock removal and feeds

$$f_n = 0.5 - 1.5 \text{ mm/r}$$

$$.020 - .059 \text{ inch/r}$$











Insert shape		Insert size  iC	Cutting depth (a_p), mm, inch															
			Finishing					Roughing										
			Medium															
			1	2	3	4	5	6	7	8	9	10	11	12	13	mm		
			.04	.08	.12	.16	.20	.24	.28	.31	.35	.40	.43	.47	.51	inch		
 80°	06	1/4																
	09	3/8																
	12	1/2																
	16	5/8																
	19	3/4																
	25	1																
 55°	07	1/4																
	11	3/8																
	13	.512																
	15	1/2																
 R	05	.197																
	06	.236																
	08	.315																
	10	.394																
	12	.472																
	15	.591																
	16	.630																
	19	.748																
	20	.787																
	25	.984																
 90°	09	3/8																
	12	1/2																
	15	5/8																
	19	3/4																
	25	1																
 60°	05	1/8																
	06	5/32																
	09	7/32																
	11	1/4																
	16	3/8																
	22	1/2																
	27	5/8																
 35°	11	1/4																
	13	.512																
	16	3/8																
	22	1/2																
 80°	02	5/32																
	04	1/4																
	06	3/8																
	08	1/2																
 55°	16	.640																












Note: Depth of cut on CBN and PCD inserts determined by tip size. See ordering page for details.











Inserts for general turning












Negative basic-shape inserts – T-Max P









Finishing

									
CNMG-WF 09-12	CNMG-WL 12	CNMG-PF 09-12	CNMG-MF 12	CNMG-KF 12	CNGG-SGF 12	CNMG-LC 12	CNMG-QF 12	CNMG-SF 12	CNMG-MF* 09-12
iC 3/8-1/2	1/2	3/8-1/2	1/2	1/2	1/2	1/2	1/2	1/2	3/8-1/2
Page A20	A20	A20	A20	A20	A20	A20	A21	A20	A21











										
CNGP 12	DNMX-WF 11-15	DNMG-PF 11-15	DNMG-MF 11-15	DNMG-KF 11-15	DNGG-SGF 15	DNMG-LC 11-15	DNMG-QF 11	DNMG-SF 15	DNMG-K 15	DNMG-MF* 11-15
1/2	3/8-1/2	3/8-1/2	3/8-1/2	3/8-1/2	1/2	3/8-1/2	3/8	1/2	1/2	3/8-1/2
A21	A26	A26	A26	A26	A26	A26	A27	A26	A27	A27












									
SNMG-PF 12	SNMG-MF 12	SNMG-QF 12	SNMG-MF* 09-12	TNMX-WF 16	TNMG-PF 16-22	TNMG-MF 16	TNMG-KF 16	TNMG-LC 16	TNMG-QF 16-22
1/2	1/2	1/2	3/8-1/2	3/8	3/8-1/2	3/8	3/8	3/8	3/8-1/2
A31	A31	A31	A31	A35	A35	A35	A35	A35	A35












										
TNMG-SF 16	TNMG-K 16	TNMG-MF* 11-22	VNMG-PF 16	VNMG-MF 16	VNGG-SGF 16	VNMG-LC 16	VNMG-SF 16	VNMG-MF* 16	VNGP 16	WNMG-WL 06-08
3/8	3/8	1/4-1/2	3/8	3/8	3/8	3/8	3/8	3/8	3/8	3/8-1/2
A35	A35	A35	A39	A39	A39	A39	A39	A39	A39	A41

							
WNMG-PF 06-08	WNMG-MF 06-08	WNMG-KF 06-08	WNMG-SF 08	WNMG-LC 06-08	WNMG-MF* 06-08	WNGG-SGF 08	WNMG-WF 06-08
3/8-1/2	3/8-1/2	3/8-1/2	1/2	3/8-1/2	3/8-1/2	1/2	3/8-1/2
A41	A41	A41	A41	A41	A41	A41	A41

Medium machining

									
CNMG-SM* 12	CNMG-SMR 12	CNMG-WMX 12-16	CNMG-PM 09-19	CNMG-MM 12-19	CNMG-KM 12-19	CNMG-QM 09-19	CNMG-HM 16-19	CNMX-SM 12	CNMG-SM* 12-16
1/2	1/2	1/2-5/8	3/8-3/4	1/2-3/4	1/2-3/4	3/8-3/4	5/8-3/4	1/2	1/2-5/8
Page A22	A22	A21	A21	A21	A22	A22	A22	A22	A22

										
DNMG-SMR 15	DNMG-SM 15	DNMX-WMX 15	DNMG-PM 11-15	DNMG-MM 11-15	DNMG-KM 11-15	DNMG-QM 11-15	DNMG-SM* 15	RCMX 10-32	RNMG 09-25	SNMG-SMR 15-19
1/2	1/2	1/2	3/8-1/2	3/8-1/2	3/8-1/2	3/8-1/2	1/2	.394-1.260	3/8-1	5/8-3/4
A28	A28	A27	A27	A27	A27	A28	A28	A30	A30	A32

										
SNMG-PM 09-15	SNMG-MM 12-19	SNMG-KM 09-19	SNMG-QM 09-19	SNMG-SM* 12	SNMG-HM 15-25	SNMG-SF 12	TNMX-WMX 16	TNMG-PM 16-22	TNMG-MM 16-22	TNMG-KM 16-22
3/8-5/8	1/2-3/4	3/8-3/4	3/8-3/4	1/2	5/8-1	1/2	3/8	3/8-1/2	3/8-1/2	3/8-1/2
A31	A31	A31	A32	A32	A32	A31	A36	A36	A36	A36

* Dedicated geometry for finishing of gummy materials.

Continued ...

Inserts for general turning

... Continued

Negative basic-shape inserts – T-Max P

TNMG-QM	TNMG-SM	TNMG-SM	VNMG-PM	VNMG-MM	VNMG-KM	VNMG-QM	VNMG-SM	WNMG-WMX	WNMG-PM	WNMG-MM
11-27	16-22	16-22	16	16	16	16	16	06-08	06-08	06-08
1/4-5/8	3/8-1/2	3/8-1/2	3/8	3/8	3/8	3/8	3/8	3/8-1/2	3/8-1/2	3/8-1/2
A36	A36	A36	A40	A40	A40	A40	A40	A41	A41	A41
WNMG-KM	WNMG-QM	WNMG-SM	WNMG-SM	WNMG-SMR						
06-08	06-08	08	08	08						
3/8-1/2	3/8-1/2	1/2	1/2	1/2						
A41	A41	A41	A41	A41						

Roughing

CNMM-WR	CNMG-PR	CNMM-PR	CNMG-MR	CNMM-MR	CNMG-KR	CNMA-KR	CNMM-QR	CNMG-SMR	CNMM-HR
12-19	12-25	12-19	12-19	12-25	12-19	12-19	12-25	16-19	19-25
1/2-3/4	1/2-1	1/2-3/4	1/2-3/4	1/2-1	1/2-3/4	1/2-3/4	1/2-1	5/8-3/4	3/4-1
Page	A23	A23	A23	A23	A23	A24	A24	A22	A24

CNMG-MR*	DNMG-PR	DNMM-PR	DNMG-MR	DNMM-MR	DNMA-KR	DNMG-KR	DNMM-QR	DNMG-MR*	SNMG-SM	SNMG-PR
12-19	15	15	15	15	15	15	15	15	15-19	12-25
1/2-3/4	1/2	1/2	1/2	1/2	1/2	1/2	1/2	1/2	5/8-3/4	1/2-1
A24	A28	A28	A28	A28	A29	A29	A29	A29	A33	A32

SNMM-PR	SNMG-MR	SNMM-MR	SNMA-KR	SNMG-KR	SNMM-QR	SNMG-SMR	SNMM-HR	SNMG-MR*	TNMX-WR	TNMG-PR
12-19	12-19	12-25	09-25	12-25	12-25	15-19	19-25	12-25	22	16-33
1/2-3/4	1/2-3/4	1/2-1	3/8-1	1/2-1	1/2-1	5/8-3/4	3/4-1	1/2-1	1/2	3/8-3/4
A32	A33	A33	A33	A33	A34	A32	A34	A34	A37	A37

TNMM-PR	TNMG-MR	TNMM-MR	TNMA-KR	TNMG-KR	TNMM-HR	TNMM-QR	TNMG-MR*	WNMG-PR	WNMG-MR
16-22	16-22	16-27	16-27	16-27	27	16-27	16-33	06-08	06-08
3/8-1/2	3/8-1/2	3/8-5/8	3/8-5/8	3/8-5/8	5/8	3/8-5/8	3/8-3/4	3/8-1/2	3/8-1/2
A37	A37	A37	A37	A37	A38	A38	A38	A43	A43

WNMM-MR	WNMG-KR	WNMA-KR	WNMG-MR*	WNMG-SMR	RNMG-SR
08	06-08	06-08	08	08	19
1/2	3/8-1/2	3/8-1/2	1/2	1/2	3/4
A43	A43	A43	A43	A43	A30

Negative basic-shape inserts – T-Max®

KNMX-71	KNUX
16	16
Inch	.640
Page	A44

* Dedicated geometry for steel and stainless steel roughing.

Inserts for general turning

Positive basic-shape inserts CoroTurn® 107

Finishing

	CCMT-WF	CCMT-PF	CCMT-MF	CCMT-KF	CCMT-UF	DCMX-WF	DCMT-PF	DCMT-MF	DCMT-KF	DCMT-UF
	06-09	06-12	06-12	06-12	06-09	07-11	07-11	07-11	07-11	07-11
iC	1/4-3/8	1/4-1/2	1/4-1/2	1/4-1/2	1/4-3/8	1/4-3/8	1/4-3/8	1/4-3/8	1/4-3/8	1/4-3/8
Page	A46	A46	A46	A46	A46	A49	A49	A49	A49	A49

	SCMT-PF	SCMT-MF	SCMT-KF	SCMT-UF	TCMX-WF	TCGX-WK	TCMT-PF	TCMT-MF	TCMT-KF	TCMT-UF	TCMX-WK
	09	09	09	09	09-16	06-11	06-16	06-16	06-16	11	05-11
	3/8	3/8	3/8	3/8	7/32-3/8	5/32-1/4	5/32-3/8	5/32-3/8	5/32-3/8	5/32-3/8	1/8-1/4
	A52	A52	A52	A52	A54	A55	A54	A54	A54	A55	A54

	TCGT-K	TCMT-UF	VBMT-PF	VBMT-MF	VBMT-KF	VBMT-UF	VCEX-F
	06-11	06-16	11-16	11-16	11-16	11	11
	5/32-1/4	5/32-3/8	1/4-3/8	1/4-3/8	1/4-3/8	1/4	1/4
	A55	A54	A58	A58	A58	A58	A58

Medium machining

	CCMT-WM	CCMT-PM	CCMT-MM	CCMT-KM	CCGT-UM	CCMW	CCMT-UM	CCET-UM	DCMX-WM	DCMT-PM
	06-12	06-12	06-12	06-12	06-12	06-09	06-12	06	11	07-11
iC	1/4-1/2	1/4-1/2	1/4-1/2	1/4-1/2	1/4-1/2	1/4-3/8	1/4-1/2	1/4	3/8	1/4-3/8
Page	A46	A46	A47	A47	A47	A47	A47	A47	A49	A49

	DCMT-MM	DCMT-KM	DCMT-UM	DCET-UM	DCGT-UM	DCMW	RCMT	RCMT-SM	SCMT-PM	SCMT-MM	SCMT-KM
	07-11	07-11	07-11	07-11	07-11	11	05-32	08-16	09-12	09-12	09-12
	1/4-3/8	1/4-3/8	1/4-3/8	1/4-3/8	1/4-3/8	3/8	3/8-3/4	1/4-1/2	3/8-1/2	3/8-1/2	3/8-1/2
	A49	A49	A50	A50	A50	A50	A51	A51	A52	A52	A52

	SCMT-UM	SCMW	TCMX-WM	TCMT-PM	TCMT-MM	TCMT-KM	TCMT-UM	TCGT-UM	TCMW	VBMT-PM	VBMT-MM
	09-12	09-12	11-16	09-22	09-22	09-22	09-16	09-16	09-16	16	16
	3/8-1/2	3/8-1/2	1/4-3/8	7/32-1/2	7/32-1/2	7/32-1/2	7/32-3/8	7/32-3/8	7/32-3/8	3/8	3/8
	A53	A53	A55	A55	A55	A55	A56	A56	A56	A58	A58

	VBMT-KM	VBMT-UM	VBGT-UM	VCGT-UM	VCET-UM	VBMW
	16	16	16	11	11	16
	3/8	3/8	3/8	1/4	1/4	3/8
	A58	A59	A59	A59	A59	A59

Note: CoroTurn® 107 VCMT inserts available on page A12.

Continued ...

B

C

G

H











I











J

Inserts for general turning

... Continued











Roughing






									
CCMT-PR	CCMT-MR	CCMT-KR	CCMT-UR	DCMT-PR	DCMT-MR	DCMT-KR	DCMT-UR	SCMT-PR	SCMT-MR
06-12	06-12	06-12	06-12	11	11	11	11	09-12	09-12
1/4-1/2	1/4-1/2	1/4-1/2	1/4-1/2	3/8	3/8	3/8	3/8	3/8-1/2	3/8-1/2
A47	A48	A48	A48	A50	A50	A50	A50	A53	A53

									
SCMT-UR	SCMT-KR	TCMT-PR	TCMT-MR	TCMT-KR	TCMT-UR	VBMT-PR	VBMT-MR	VBMT-KR	VBMT-UR
09-12	09-12	11-22	11-22	11-22	11-16	16	16	16	16
3/8-1/2	3/8-1/2	1/4-1/2	1/4-1/2	1/4-1/2	1/4-3/8	3/8	3/8	3/8	3/8
A53	A53	A56	A56	A56	A56	A59	A59	A59	A59












Positive basic-shape inserts CoroTurn® 111/107






Finishing

									
CPMT-PF	CPMT-MF	CPMT-KF	DPMT-PF	DPMT-MF	DPMT-KF	TPMT-PF	TPMT-MF	TPMT-KF	VCMT-PF
06-09	06-09	06	07	07	07	06-16	06-16	06-16	11
1/4-3/8	1/4-3/8	1/4	1/4	1/4	1/4	5/32-3/8	5/32-3/8	5/32-3/8	1/4
A62	A62	A62	A63	A63	A63	A65	A65	A65	A61

¹⁾ 	¹⁾ 	¹⁾ 		
VCMT-MF	VCMT-KF	WPMT-PF	WPMT-MF	WPMT-KF
11	11	02-04	02-04	04
1/4	1/4	5/32-1/4	5/32-1/4	1/4
A61	A61	A66	A66	A66




Medium

										
CPMT-UM	CPMT-PM	CPMT-MM	CPMT-KM	DPMT-PM	DPMT-MM	DPMT-KM	SPMT-UM	TPMT-PM	TPMT-MM	TPMT-KM
06-09	06-09	06-09	06	07-11	07-11	07-11	09-12	09-16	09-16	09-16
1/4-3/8	1/4-3/8	1/4-3/8	1/4	1/4-3/8	1/4-3/8	1/4-3/8	3/8-1/2	7/32-3/8	7/32-3/8	7/32-3/8
A62	A62	A62	A62	A63	A63	A63	A64	A65	A65	A65

	¹⁾ 	¹⁾ 	¹⁾ 	
VCMT-PM	VCMT-MM	VCMT-KM	WPMT-PM	WPMT-MM
11	11	11	04	04
1/4	1/4	1/4	1/4	1/4
A61	A61	A61	A66	A66

¹⁾ CoroTurn® 107 inserts with 7° clearance angle

Positive basic-shape inserts CoroTurn TR

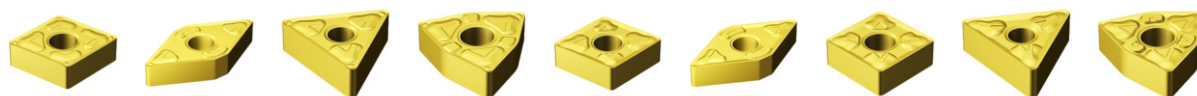
		
TR-DC-F	TR-DC-M	TR-VB-F
13	13	13
A191	A191	A192

Inserts for general turning

T-Max P

Negative basic-shape inserts

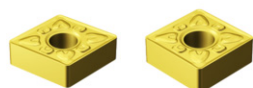
Finishing



Medium

	CNMG-XF	DNMG-XF	TNMG-XF	WNMG-XF	CNMG-XM	DNMG-XM	SNMG-XM	TNMG-XM	WNMG-XM
	12	15	16	08	12	15	12	16	08
iC	1/2	1/2	3/8	1/2	1/2	1/2	1/2	3/8	1/2
Page	A68	A68	A70	A69	A68	A68	A100	A69	A70

Roughing

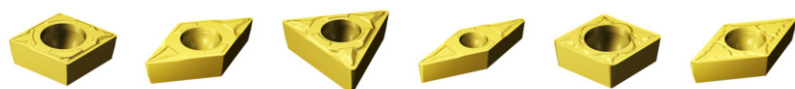


	CNMG-XMR	SNMG-XMR
	12-19	12-19
iC	1/2-3/4	1/2-3/4
Page	A68	A69

CoroTurn® 107

Positive basic-shape inserts

Finishing

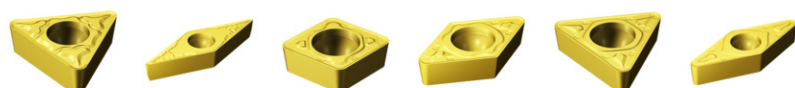


Medium

	CCMT-XF	DCMT-XF	TCMT-XF	VBMT-XF	CCMT-XM	DCMT-XM
	09	11	11	16	09	11
iC	3/8	3/8	1/4	3/8	3/8	3/8
Page	A71	A71	A73	A73	A71	A71

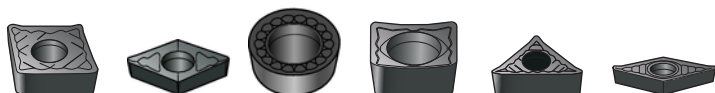
Medium

Roughing



	TCMT-XM	VBMT-XM	CCMT-XR	DCMT-XR	TCMT-XR	VBMT-XR
	11	16	09	11	16	16
iC	1/4	3/8	3/8	3/8	3/8	3/8
Page	A73	A73	A71	A71	A73	A73

Positive basic-shape inserts for machining in non-ferrous material



	CCGX-AL	DCGX-AL	RCGX-AL	SCGX-AL	TCGX-AL	VCGX-AL
	06-12	07-11	06-10	09	06-16	11-22
iC	1/4-1/2	1/4-3/8	.236-.472	3/8	5/32-3/8	1/4-1/2
Page	A48	A50	A51	A53	A56	A59

Polycrystalline diamond (PCD)

























	CCMW FP	DCMW FP	SPUN FP	TCMW FP	TCMW FRP	TPUN FP	TPUN FPR	VCMW FP
	06-09	11	09-12	09-16	16	11-16	16	11-16
iC	1/4-3/8	3/8	1/2	7/32-3/8	3/8	1/4-3/8	3/8	1/4-3/8
Page	A94	A95	A99	A97	A97	A100	A100	A96

Inserts for general turning







Inserts for machining in advanced material

Ceramics, negative basic-shape inserts












										
	CNGA-WG	CNGQ-WG	CNGA	CNGQ	CNGN	CNGX	DNGA	DNGQ	DNGN	DNGX
	12	12	12-19	12-16	12-16	12	15	15	15	15
	1/2	1/2	1/2-3/4	1/2-5/8	1/2-5/8	1/2	1/2	1/2	1/2	1/2
Page	A78	A79	A79	A79	A81	A80	A82	A82	A84	A83











											
	RNGA	RNGN	SNGA	SNGQ	SNGN	TNGA	TNGN	WNGA-WG	WNGA-WH	WNGA	VNGA
	12	09-25	12	SNGQ	09-19	16-22	11-22	08	08	08	16
	1/2	3/8-1	1/2	1/2	3/8-3/4	3/8-1/2	1/4-1/2	1/2	1/2	1/2	3/8
	A84	A85	A86	A86	A88	A89	A90	A91	A91	A91	A93

Ceramics, positive basic-shape inserts












					
	RPGN	RCGX	RPGX	SPGN	TPGN
	06-12	06-25	06-12	12	11-16
	1/4-1/2	1/4-1	1/4-1/2	1/2	1/4-3/8
Page	A98	A98	A98	A99	A100

Cubic boron nitride (CBN), negative basic shape

										
	CNGA-WG	CNMA	CNGA WH	CNGA	CNGX-AXA	DNMA	DNGA	RNGA	RNGN	SNGA
	12	12	09-12	09-12	12	15	11-15	09	12	09-12
	1/2	3/8-1/2	3/8-1/2	3/8-1/2	1/2	1/2	3/8-1/2	3/8	1/2	3/8-1/2
Page	A78	A80	A79	A80	A80	A83	A83	A84	A85	A86








										
	SNMA	SNGX	SNGN-FD	TNGA	TNMA	TNGN-FD	WNGA-WG	WNGA-WH	WNGA	VNGA
	12	12	12	11-16	16-22	22	06-08	06-08	06-08	16
	1/2	1/2	1/2	1/4-3/8	3/8-1/2	1/2	3/8-1/2	3/8-1/2	3/8-1/2	3/8
	A87	A87	A88	A89	A89	A90	A91	A91	A91	A93





Cubic boron nitride (CBN), positive basic shape, CoroTurn® 107

										
	CCGW	CCGW-WH	DCMW	DCGW	SCGW	TCMW	TCGW	TPGW	VBMW	VBGW
	06-09	06-09	11	07-11	08	09-11	09-11	11	16	16
	1/4-3/8	1/4-3/8	3/8	1/4-3/8	3/8	7/32-1/4	7/32-1/4	1/4	3/8	3/8
Page	A94	A94	A95	A95	A99	A97	A97	A97	A96	A96










Inserts for small part machining

CoroTurn® XS








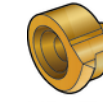

	Turning				Grooving	Profiling
						
	CXS-xxT 045	CXS-xxT 090	CXS-xxTE 98	CXS-xxT 098	CXS-xxG	CXS-xxR
	05-07	04-05	04-06	04-07	04-07	04-07
Page	A328	A328	A333	A329	A334	A337

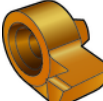

	Face grooving	Pre-parting	Threading
			
	CXS-xxF	CXS-xxGX	CXS-xxTH
	06	05	04-07
Page	A338	A338	A339

CoroCut® XS

	Parting off				Grooving	Turning	Back turning	Threading
								
	MAC-N	MAC-R	MAC-L	MAC-T	MAG	MAF	MAB	MAT
	3	3	3	3	3	3	3	3
Page	B87	B87	B87	B87	B88	B90	B90	B90

CoroCut® MB

	Grooving	Profiling	Pre-parting	Turning		Copying	Back boring	Threading
								
	MB-..G	MB-..R	MB-..GX	MB-..T045	MB-..T093	MB-..TE93	MB-..B	MB-..TH
	07-09	07-09	07	07	07	07	07	07
Page	B94	B100	B100	B96	B96	B96	B96	B102

	Face grooving
	
	MB-FA
	09
Page	B101

Inserts for general turning

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

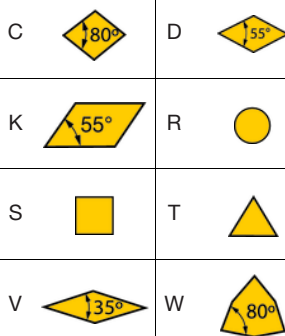
Inserts, advanced cutting materials, metric

C	N	M	G	12	04	08	-	T	010	20
1	2	3	4	5	6	7		8	10	11

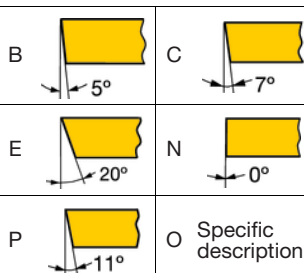
Inserts, advanced cutting materials, inch

C	N	G	A	4	3	2	-	T	03	20
1	2	3	4	5	6	7		8	10	11

1 Insert shape



2 Insert clearance angle



3 Tolerances, metric

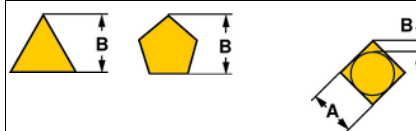
Class	s	iC / iW
G	±0.13	±0.025
M	±0.13	±0.05 – ±0.15 ¹⁾
U	±0.13	±0.08 – ±0.25 ¹⁾
E	±0.025	±0.025

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		
6.35		
8.0		
9.525		
10.0		
12.0		
12.7		
15.875		
16.0		
19.05		
20.0		
25.0		
25.4		
31.75		
32.0		

For positive inserts iC is valid for a sharp corner. See cutting edge condition F. (Picture 8).

3 Tolerances, inch



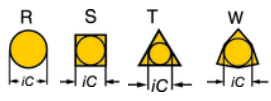


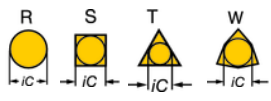




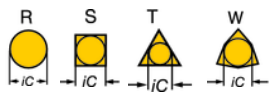




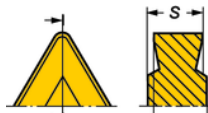







A: Theoretical diameter of the insert
T: Thickness of the insert.
B: See figures.

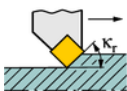
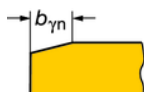
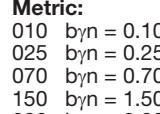
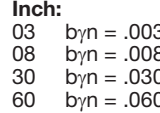

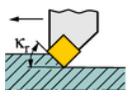
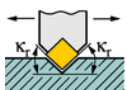
Tolerances in inch

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

Inserts for general turning

4 Insert type		5 Insert size											
A		Q		 Inscribed circle is indicated in 1/8".									
G		R		 Inscribed circle is indicated in 1/8".									
M		T											
N		W		 Inscribed circle is indicated in 1/8".									
P		X											
Special design													

6 Insert thickness, s mm, inch				7 Nose radius, r_e mm, inch			8 Cutting edge condition	
								
Metric		Inch		Metric:	Inch:	Actual inch		
01	s = 1.59	1	s = .0625	00 = 0	00	Round	F	 Sharp cutting edge
T1	s = 1.98	(1.2)	s = .075	01 = 0.1	03	.004	A	 ER treated cutting edge (ANSI)
02	s = 2.38	(1.5)	s = 3/32	02 = 0.2	0	.008	E	 ER treated cutting edge
03	s = 3.18	2	s = 1/8	04 = 0.4	1 = 1/64	.0156	T	 Negative land
T3	s = 3.97	(2.5)	s = 5/32	05 = 0.5			K	 Double negative lands
04	s = 4.76	3	s = 3/16	08 = 0.8	2 = 1/32	.0312	S	 Negative land and ER treated cutting edge
05	s = 5.56	4	s = 1/4	10 = 1.0				
06	s = 6.35	5	s = 5/16	12 = 1.2	3 = 3/64	.047		
07	s = 7.94	6	s = 3/8	15 = 1.5				
09	s = 9.52	6.3	s = .394	16 = 1.6	4 = 1/16	.0625		
10	s = 10.00	7.6	s = .475	24 = 2.4	6 = 3/32	.094		
12	s = 12.00			32 = 3.2	8 = 1/8	.125		

9 Hand of tool		10 Chamfer width metric, inch		11 Chamfer angle	
R		 Metric:  Inch: 		 15 γ _n = 15° 20 γ _n = 20°	
L					
N		For more information, see code key on page A76			

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.	

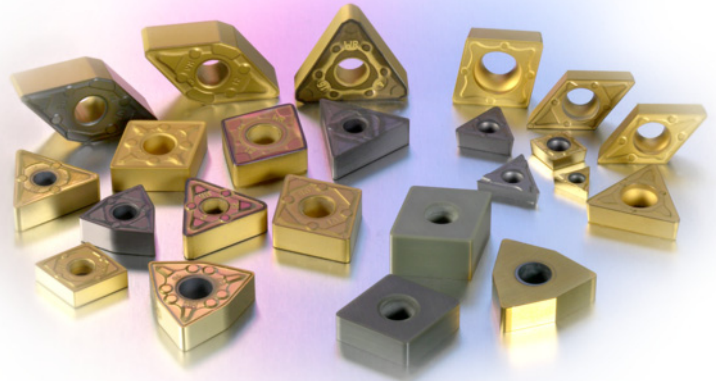
- WF = Wiper – finishing
- WMX = Wiper, medium machining
- PF = ISO P – finishing
- PR = ISO P – roughing

Turning productivity

Wiper technology for high feed machining

Increasing feed rate with Wiper inserts is one of the most effective ways of improving turning productivity.

The development of Wiper inserts from Sandvik Coromant started with cemented carbide T-Max P inserts many years ago. Today the Wiper assortment is available in both negative and positive insert styles. Ceramics and cubic boron nitride as well as cemented carbide can be used for internal and external machining and parting and grooving operations.



Eliminate grinding

Wiper inserts can achieve excellent surface finish and eliminate many grinding operations. Wipers also improve component quality and roundness compared to grinding.

Feed is the main influence on the time taken to perform a turning operation. If the feed can be doubled, cutting time can be halved to produce almost twice as many components in the same time.

The corner-radius design of a Wiper insert allows increased feed without affecting surface finish.

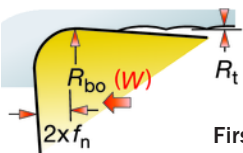
A new first-choice

-WMX is the first choice Wiper geometry for turning with negative inserts. It has superior chip breaking and metal removal capability compared to existing Wipers and improves cutting action over a wider application area.

The -WMX geometry increases feed and surface far beyond today's Wiper inserts. It is the first-choice Wiper over a wide application area, providing maximum productivity and versatility – with productive Wiper alternatives also available when conditions change.

Wiper radius

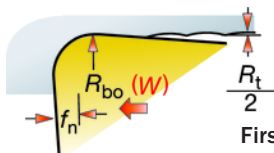
Two times the feed rate



First choice for productivity

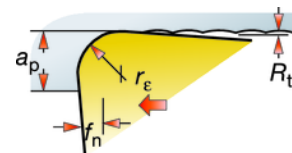
Wiper radius

Same feed rate



First choice for surface finish

Standard corner radius



Why should you use a Wiper?

- Improved machining economy
- Excellent surface finish
- Eliminate expensive grinding operations
- Undisturbed production
- Less need for supervision
- Reduced inventory

TECHNOLOGY
Wiper

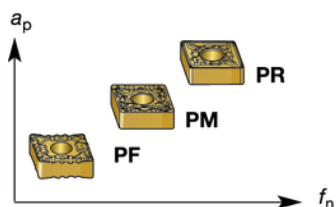
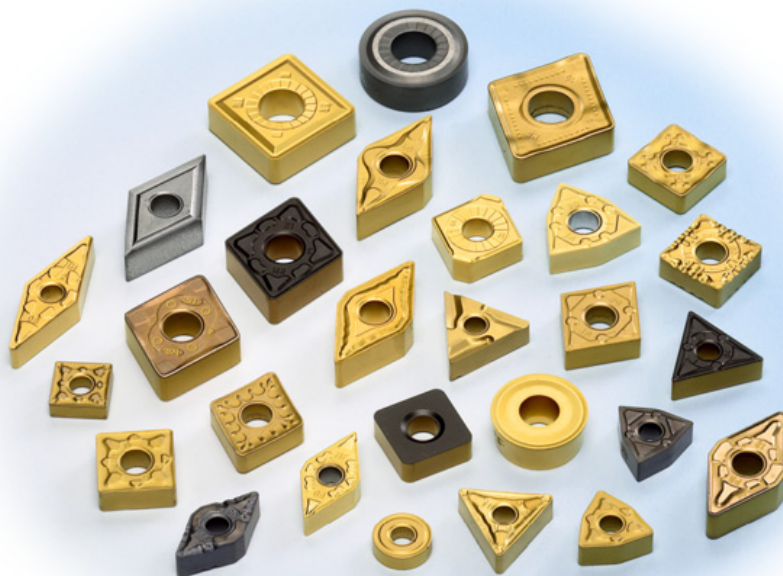


T-Max P

Negative basic-shape inserts

For external turning operations and internal machining

The T-Max P inserts comply with ISO standards and all type of insert shapes are available



Insert geometries

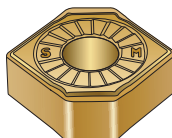
Dedicated for:

- Different feed and depth of cut areas
- Different workpiece materials

Insert grades

Modern productive coated and uncoated grades for all ISO material areas

- Cemented carbide
- Cermet
- Ceramics
- Cubic boron nitride



Available in the range of steel turning grades: GC4205, GC4215, GC4225 and GC4235.



Wiper Technology

Sandvik Coromant's productivity booster.

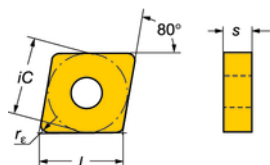
- Double feed - Same surface finish
- Same feed - Twice as good surface finish

Innovative solutions - Xcel

A radical new tooling solution for turning into a shoulder especially in titanium and heat resistant super alloys. Xcel combines a host of design advantages not previously available from a single tool.

ISO application areas:



Rhombic 80° 

For dimensions, see code key on page A16.

[illegible]

★= First choice



A graph with v_c on the horizontal axis and v_e on the vertical axis. Two curves intersect: a blue curve that is convex to the origin and a red curve that is concave to the origin.

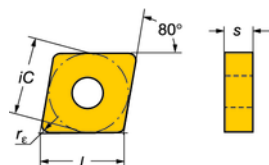
A diagram showing a mechanical assembly. A yellow wedge is positioned against a vertical wall. A blue spring is attached to the wedge and a horizontal bar. The horizontal bar is labeled a_p and f_n .



A2

T-Max P

Rhombic 80°

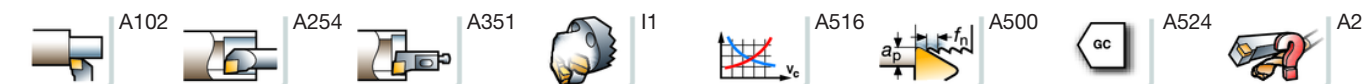


For dimensions, see code key on page A16.

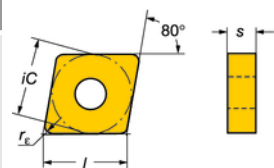
[illegible]

* Dedicated geometry for finishing of gummy materials.

★= First choice



Rhombic 80°



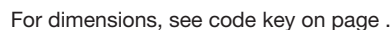
For dimensions, see code key on page A16.

[illegible]

★= First choice

* Complementary geometry for semi-roughing in steel materials.



Rhombic 80° 

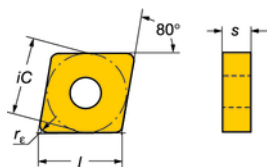
★= First choice






T-Max P

Rhombic 80°

For dimensions, see code key on page A16.



						P										M					K				N	S					ANSI		
						GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC			
						1515	1525	4205	4215	4225	4235	5015	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	H13A	1005	1105	1115	1125	H10A	H13A		S05F	
Roughing	 CNMM-HR	ISO		iC																													
		CNMM 19 06 16-HR	19	3/4					☆	☆	☆					☆														CNMM 644-HR			
		CNMM 19 06 24-HR							☆	☆	☆																			CNMM 646-HR			
		CNMM 25 09 24-HR	25	1					☆	☆	☆																			CNMM 866-HR			
	CNMM 25 09 32-HR							☆	☆																				CNMM 868-HR				
	 CNMG-MR*	CNMG 12 04 08-MR	12	1/2					☆	☆	☆	☆				☆															CNMG 432-MR		
		CNMG 12 04 12-MR							☆	☆	☆	☆				☆															CNMG 433-MR		
		CNMG 12 04 16-MR							☆	☆	☆	☆																			CNMG 434-MR		
		CNMG 16 06 08-MR	16	5/8					☆	☆	☆	☆				☆															CNMG 542-MR		
		CNMG 16 06 12-MR							☆	☆	☆	☆				☆															CNMG 543-MR		
		CNMG 16 06 16-MR							☆	☆	☆	☆																			CNMG 544-MR		
		CNMG 19 06 08-MR	19	3/4					☆	☆	☆	☆				☆															CNMG 642-MR		
CNMG 19 06 12-MR								☆	☆	☆	☆				☆															CNMG 643-MR			
CNMG 19 06 16-MR							☆	☆	☆	☆				☆															CNMG 644-MR				
								P25	P15	P05	P15	P25	P35	P10	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	N15	S15	S15	S20	S25	S10	S15	S05

* Dedicated geometry for steel and stainless steel roughing.

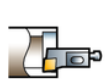
★ = First choice



A102



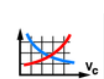
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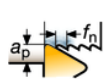
A351



I1



A516



A500



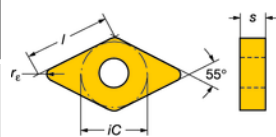
A524



A2

T-Max P

Rhombic 55°



For dimensions, see code key on page A16.

		ISO	t	iC	P								M								K								S								ANSI
					1515	1525	4205	4215	4225	4235	5015	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	1105	1115	1125	H10A	H13A	S05F									
	DNMX 11 04 04-WF	11	3/8	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 331-WF		
	DNMX 11 04 08-WF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 332-WF		
	DNMX 15 04 04-WF	15	1/2				☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 331-WF		
	DNMX 15 04 08-WF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 432-WF		
	DNMX 15 04 12-WF						☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 433-WF		
	DNMX 15 06 04-WF						☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 441-WF		
	DNMX 15 06 08-WF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 442-WF		
	DNMX 15 06 12-WF						☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMX 443-WF		
	DNMG 11 04 04-PF	11	3/8	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 331-PF		
	DNMG 11 04 08-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 332-PF		
	DNMG 11 04 12-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 333-PF		
	DNMG 15 04 04-PF	15	1/2	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 431-PF		
	DNMG 15 04 08-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 432-PF		
	DNMG 15 04 12-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 433-PF		
	DNMG 15 06 04-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 441-PF		
	DNMG 15 06 08-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 442-PF		
	DNMG 15 06 12-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DNMG 443-PF		
	DNMG 11 04 04-MF	11	3/8									☆	☆	☆	☆								☆	☆	☆	☆									DNMG 331-MF		
	DNMG 11 04 08-MF											☆	☆	☆	☆								☆	☆	☆	☆									DNMG 332-MF		
	DNMG 15 04 04-MF	15	1/2									☆	☆	☆	☆								☆	☆	☆	☆									DNMG 431-MF		
	DNMG 15 04 08-MF											☆	☆	☆	☆								☆	☆	☆	☆									DNMG 432-MF		
	DNMG 15 04 12-MF											☆	☆	☆	☆								☆	☆	☆	☆									DNMG 433-MF		
	DNMG 15 06 04-MF											☆	☆	☆	☆								☆	☆	☆	☆									DNMG 441-MF		
	DNMG 15 06 08-MF											☆	☆	☆	☆								☆	☆	☆	☆									DNMG 442-MF		
	DNMG 15 06 12-MF											☆	☆	☆	☆								☆	☆	☆	☆									DNMG 443-MF		
	DNMG 11 04 04-KF	11	3/8														☆		☆																DNMG 331-KF		
	DNMG 11 04 08-KF																☆		☆																DNMG 332-KF		
	DNMG 15 04 04-KF	15	1/2														☆		☆																DNMG 431-KF		
	DNMG 15 04 08-KF																☆		☆																DNMG 432-KF		
	DNMG 15 06 04-KF																☆		☆																DNMG 441-KF		
	DNMG 15 06 08-KF																☆		☆																DNMG 442-KF		
	DNMG 15 06 12-KF																☆		☆																DNMG 443-KF		
	DNMG 11 04 04-SF	11	3/8																				☆	☆	☆	☆		☆	☆						DNMG 331-SF		
	DNMG 11 04 08-SF																						☆	☆	☆	☆		☆	☆						DNMG 332-SF		
	DNMG150404-SF	15	1/2																				☆	☆	☆	☆		☆	☆						DNMG 431-SF		
	DNMG150408-SF																						☆	☆	☆	☆		☆	☆						DNMG 432-SF		
	DNMG150412-SF																						☆	☆	☆	☆		☆	☆						DNMG 433-SF		
	DNMG150604-SF																						☆	☆	☆	☆		☆	☆						DNMG 441-SF		
	DNMG150608-SF																						☆	☆	☆	☆		☆	☆						DNMG 442-SF		
	DNMG150612-SF																						☆	☆	☆	☆		☆	☆						DNMG 443-SF		
	DNMG 11 04 04-LC	11	3/8	☆	☆		☆	☆																											DNMG 331-LC		
	DNMG 11 04 08-LC			☆	☆		☆	☆																											DNMG 332-LC		
	DNMG 15 04 04-LC	15	1/2	☆	☆		☆	☆																											DNMG 431-LC		
	DNMG 15 04 08-LC			☆	☆		☆	☆																											DNMG 432-LC		
	DNMG 15 06 04-LC			☆	☆		☆	☆																											DNMG 441-LC		
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★ = First choice



A102



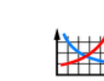
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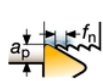
A351



I1



A516



A500



A524

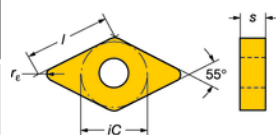


A2

Rhombic 55° 

★= First choice



Rhombic 55° 

For dimensions, see code key on page A16.

[illegible]

★= First choice

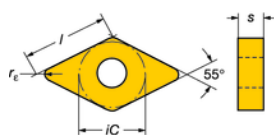
* Complementary geometry for semi-roughing in steel materials.










A2

T-Max P

Rhombic 55°

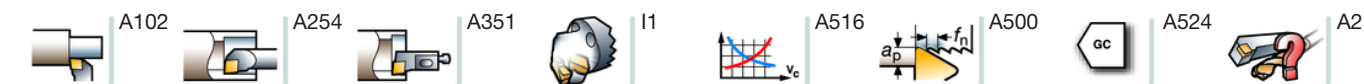


For dimensions, see code key on page A16.

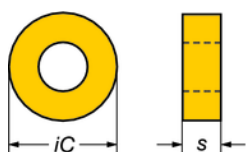
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Roughing	 DNMG-MR	DNMG 15 04 08-MR	15	1/2											☆	★	☆																	DNMG 432-MR		
		DNMG 15 04 12-MR														☆	★	☆																DNMG 433-MR		
		DNMG 15 04 16-MR														☆	★	☆																DNMG 434-MR		
		DNMG 15 06 08-MR														☆	★	☆																DNMG 442-MR		
		DNMG 15 06 12-MR														☆	★	☆																DNMG 443-MR		
		DNMG 15 06 16-MR																★																	DNMG 444-MR	
	 DNMM-MR	DNMM 15 06 08-MR	15	1/2												★																			DNMM 442-MR	
		DNMM 15 06 12-MR															★																		DNMM 443-MR	
		DNMM 15 06 16-MR						☆	☆																										DNMM 444-MR	
	 DNMG-KR	DNMG 15 04 08-KR	15	1/2																		☆	★	☆											DNMG 432-KR	
		DNMG 15 04 12-KR																					☆	★	☆										DNMG 433-KR	
		DNMG 15 06 08-KR																					☆	★	☆										DNMG 442-KR	
		DNMG 15 06 12-KR																					☆	★	☆										DNMG 443-KR	
		DNMG 15 06 16-KR																					☆	★	☆										DNMG 444-KR	
	 DNMA-KR	DNMA 15 04 08-KR	15	1/2																			★	☆	☆										DNMA 432-KR	
		DNMA 15 04 12-KR																						★	☆	☆									DNMA 433-KR	
		DNMA 15 06 08-KR																						★	☆	☆									DNMA 442-KR	
		DNMA 15 06 12-KR																							★	☆	☆								DNMA 443-KR	
		DNMA 15 06 16-KR																								★	☆	☆							DNMA 444-KR	
	 DNMM-QR	DNMM 15 04 08-QR	15	1/2					☆																										DNMM 432-QR	
		DNMM 15 04 12-QR							☆																											DNMM 433-QR
		DNMM 15 06 08-QR							☆	☆																										DNMM 442-QR
		DNMM 15 06 12-QR							☆	☆	☆																									DNMM 443-QR
		DNMM 15 06 16-QR								☆																										DNMM 444-QR
	 DNMG-MR*	DNMG 15 04 08-MR	15	1/2			☆	☆	☆																										DNMG 432-MR	
		DNMG 15 04 12-MR					☆	☆	☆																										DNMG 433-MR	
		DNMG 15 06 08-MR					☆	☆	☆	☆							☆																		DNMG 442-MR	
		DNMG 15 06 12-MR					☆	☆	☆	☆																									DNMG 443-MR	
DNMG 15 06 16-MR						☆	☆	☆	☆																									DNMG 444-MR		
					P25	P15	P05	P15	P25	P35	P10	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	S15	S20	S25	S10	S15	S05								

★ = First choice

* Dedicated geometry for finishing of gummy materials.




Round




For dimensions, see code key on page A16.


Metric version

		ISO	P		M		K		N		S		ANSI		
			GC	GC	GC	GC	GC	GC	-	-	-	GC			
Medium		10	RCMX 10 03 00E	4205	4215	4225	4235	235	3210	3215	H13A	-	H13A	S05F	RCMX 10 03 00E
		12	RCMX 12 04 00E					☆						☆	RCMX 12 04 00E
		10	RCMX 10 03 00	☆	☆	☆	☆	☆			☆	☆	☆		RCMX 10 03 00
		12	RCMX 12 04 00	☆	☆	☆	☆				☆	☆	☆		RCMX 12 04 00
		16	RCMX 16 06 00	☆	☆	☆	☆				☆	☆	☆		RCMX 16 06 00
		20	RCMX 20 06 00	☆	☆	☆	☆				☆	☆	☆		RCMX 20 06 00
		25	RCMX 25 07 00	☆	☆	☆	☆				☆	☆	☆		RCMX 25 07 00
		32	RCMX 32 09 00	☆	☆	☆	☆								RCMX 32 09 00
					P05	P15	P25	P35	M35	K10	K15	K20	N15	S15	S05

Inch version

						P				M	K	N	S					
						GC	GC	GC	GC	GC	GC	GC	·		·	·	GC	
Medium	 RNMG	/C	ANSI			4205	4215	4225	4235	235	3210	H13A	H13A	·	·	S05F	ISO	
		3/8	RNMG 32															RNMG 09 03 00
		1/2	RNMG 43	☆	☆	☆	☆	☆	☆	☆								RNMG 12 04 00
		5/8	RNMG 54	☆	☆	☆	☆	☆										RNMG 15 06 00
		3/4	RNMG 64	☆	☆	☆	☆	☆			☆							RNMG 19 06 00
		1	RNMG 86				☆	☆				☆						RNMG 25 09 00
						P05	P15	P25	P35	M35	K10	K15	K20	N15	S15	S05		

Round

					S	
				GO	.	
		ISO	IO	/C	1115 H13A	ANSI
Roughing		RNMG 19 06 00-SR	19	3/4	★ ☆	RNMG 64-SR
					S15 S15	

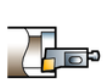
★= First choice



A102



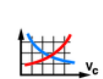
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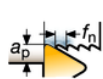
A351



11



A516



A500



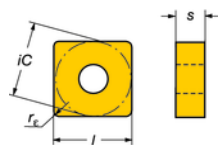
A524











A2

T-Max P

Square

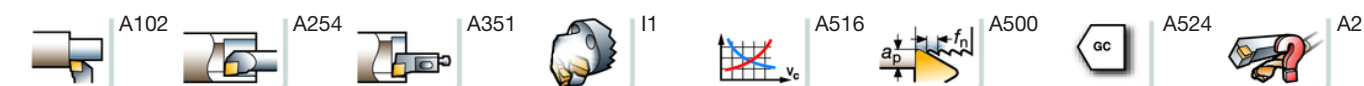


For dimensions, see code key on page A16.

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Finishing	 SNMG-PF	SNMG 12 04 08-PF	12	1/2	☆	☆	☆	★	☆	☆																							SNMG 432-PF				
		SNMG 12 04 12-PF		1/2	☆	☆	☆	★	☆	☆																							SNMG 433-PF				
	 SNMG-MF	SNMG 12 04 04-MF	12	1/2							☆	☆	★	☆													☆	☆					SNMG 431-MF				
		SNMG 12 04 08-MF		1/2							☆	☆	★	☆													☆	☆					SNMG 432-MF				
	 SNMG-QF	SNMG 12 04 04-QF	12	1/2					☆																								SNMG 431-QF				
		SNMG 12 04 08-QF		1/2					☆	☆																							SNMG 432-QF				
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	SNMG 09 03 08-MF		3/8							☆																						SNMG 322-MF					
	SNMG 09 03 12-MF		3/8							☆																						SNMG 323-MF					
	SNMG 12 04 04-MF	12	1/2							☆																						SNMG 431-MF					
	SNMG 12 04 08-MF		1/2					☆	☆	☆	☆					☆																SNMG 432-MF					
	SNMG 12 04 12-MF		1/2					☆	☆	☆						☆																SNMG 433-MF					
Medium	 SNMG-PM	SNMG 12 04 16-MF		1/2						☆																							SNMG 434-MF				
		SNMG 09 03 04-PM	09	3/8				☆	★	☆																							SNMG 321-PM				
		SNMG 09 03 08-PM		3/8				☆	★	☆																							SNMG 322-PM				
		SNMG 12 04 04-PM	12	1/2				☆	★	☆																							SNMG 431-PM				
		SNMG 12 04 08-PM		1/2				☆	★	☆																							SNMG 432-PM				
		SNMG 12 04 12-PM		1/2				☆	★	☆																							SNMG 433-PM				
	 SNMG-MM	SNMG 12 04 16-PM		1/2				☆	★	☆																							SNMG 434-PM				
		SNMG 15 06 12-PM	15	5/8				☆	★	☆	★	☆																					SNMG 543-PM				
		SNMG 15 06 16-PM		5/8				☆	★	☆																							SNMG 544-PM				
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		SNMG 12 04 16-MM		1/2									☆	★	☆																		SNMG 434-MM				
	 SNMG-KM	SNMG 15 06 12-MM	15	5/8																													SNMG 543-MM				
		SNMG 15 06 16-MM		5/8																													SNMG 544-MM				
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	SNMG 12 04 16-KM		1/2																													SNMG 434-KM					
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	SNMG 15 06 16-KM		5/8																													SNMG 544-KM					
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SNMG 12 04 16-SM		1/2																													SNMG 434-SM						
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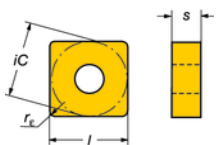
* Dedicated geometry for finishing of gummy materials.

★ = First choice



T-Max P

Square



For dimensions, see code key on page A16.

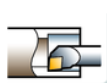
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		SNMG 15 06 16-QM		5/8					☆	☆	☆	☆					☆								☆	☆	☆	☆	☆			SNMG 544-QM	
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		SNMG 19 06 12-QM		3/4					☆	☆	☆	☆					☆								☆	☆	☆	☆	☆			SNMG 643-QM	
		SNMG 19 06 16-QM		3/4					☆	☆	☆	☆					☆								☆	☆	☆	☆	☆			SNMG 644-QM	
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		SNMG 19 06 12-SM	19	3/4											☆										★	☆	☆	☆	☆			SNMG 643-SM	
		SNMG 12 04 08-SM	12	1/2					☆	☆	☆																					SNMG 432-SM	
		SNMG 12 04 12-SM		1/2					☆	☆	☆																					SNMG 433-SM	
	SNMG-HM	SNMG 15 06 12-HM	15	5/8			☆	☆	★	★	★				★																	SNMG 543-HM	
		SNMG 15 06 16-HM		5/8			☆	☆	★	★	★				★																	SNMG 544-HM	
		SNMG 19 06 12-HM	19	3/4			☆	☆	★	★	★				★																	SNMG 643-HM	
		SNMG 19 06 16-HM		3/4			☆	☆	★	★	★				★																	SNMG 644-HM	
		SNMG 19 06 24-HM		3/4			☆	☆	★	★	★				★																	SNMG 646-HM	
		SNMG 25 09 24-HM	25	1			☆	☆	★	★	★				★																	SNMG 866-HM	
		SNMG 09 03 08	09	3/8					☆	☆	☆						☆															SNMG 322	
Roughing	SNMG-PR	SNMG 12 04 08-PR	12	1/2			☆	☆	★	★	★																					SNMG 432-PR	
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		SNMG 15 06 16-PR		5/8			☆	☆	★	★	★																					SNMG 544-PR	
		SNMG 15 06 24-PR		5/8			☆	☆	★	★	★																					SNMG 546-PR	
		SNMG 19 06 08-PR	19	3/4			☆	☆	★	★	★																					SNMG 642-PR	
		SNMG 19 06 12-PR		3/4			☆	☆	★	★	★																					SNMG 643-PR	
		SNMG 19 06 16-PR		3/4			☆	☆	★	★	★				☆																	SNMG 644-PR	
		SNMG 19 06 24-PR		3/4			☆	☆	★	★	★																					SNMG 646-PR	
		SNMG 25 07 16-PR	25	1					★	★	★																					SNMG 854-PR	
		SNMG 25 07 24-PR		1					☆	☆	☆																					SNMG 856-PR	
		SNMG 25 09 24-PR		1					☆	☆	☆																					SNMG 866-PR	

★ = First choice

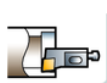
* Complementary geometry for semi-roughing in steel materials.



A102



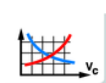
A254



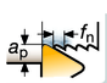
A351



I1



A516



A500



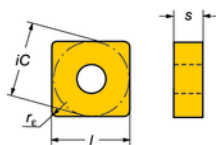
A524







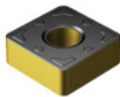

A2

T-Max P

Square



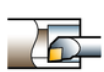
For dimensions, see code key on page A16.

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					1515	1525	4205	4215	4225	4235	5015	1115	1125	2015	2025	2035	235	4235	3005	3205	3210	3215	HT3A	1105	1115	1125	HT3A	S05F	
Roughing		SNMM 12 04 08-PR	12	1/2																						SNMM 432-PR			
		SNMM 12 04 12-PR		1/2			☆	☆	★	☆																SNMM 433-PR			
		SNMM 15 06 12-PR	15	5/8			☆	☆	★	☆																	SNMM 543-PR		
		SNMM 15 06 16-PR		5/8			☆	☆	★	☆																	SNMM 544-PR		
		SNMM 19 06 12-PR	19	3/4			☆	☆	★	☆																	SNMM 643-PR		
		SNMM 19 06 16-PR		3/4			☆	☆	★	☆																	SNMM 644-PR		
	SNMM 19 06 24-PR		3/4			☆	☆	★	☆																	SNMM 646-PR			
		SNMG 12 04 08-MR	12	1/2								☆	★	☆													SNMG 432-MR		
		SNMG 12 04 12-MR		1/2								☆	★	☆													SNMG 433-MR		
		SNMG 15 06 12-MR	15	5/8								★	☆														SNMG 543-MR		
		SNMG 15 06 16-MR		5/8								★	☆														SNMG 544-MR		
		SNMG 19 06 12-MR	19	3/4								☆	★	☆													SNMG 643-MR		
		SNMG 19 06 16-MR		3/4								☆	★	☆													SNMG 644-MR		
	SNMG 19 06 24-MR		3/4										★													SNMG 646-MR			
		SNMM 12 04 08-MR	12	1/2									★	☆													SNMM 432-MR		
		SNMM 12 04 12-MR		1/2				☆		☆			★	☆													SNMM 433-MR		
		SNMM 12 04 16-MR		1/2									★														SNMM 434-MR		
		SNMM 15 06 12-MR	15	5/8			☆						★														SNMM 543-MR		
		SNMM 15 06 16-MR		5/8			☆	☆					★														SNMM 544-MR		
		SNMM 15 06 24-MR		5/8			☆	☆	☆																		SNMM 546-MR		
		SNMM 19 06 12-MR	19	3/4			☆	☆					★														SNMM 643-MR		
		SNMM 19 06 16-MR		3/4			☆		☆	☆			★	☆													SNMM 644-MR		
		SNMM 19 06 24-MR		3/4			☆	☆		☆			★	☆													SNMM 646-MR		
		SNMM 19 06 32-MR		3/4				☆	☆	☆				★													SNMM 648-MR		
		SNMM 25 07 24-MR	25	1				☆	☆	☆				★	☆												SNMM 856-MR		
		SNMM 25 07 32-MR		1				☆	☆	☆				★													SNMM 858-MR		
	SNMM 25 09 24-MR		1					☆	☆				★													SNMM 866-MR			
	SNMM 25 09 32-MR		1					☆					★													SNMM 868-MR			
	SNMG 12 04 08-KR	12	1/2														☆	★	☆							SNMG 432-KR			
	SNMG 12 04 12-KR		1/2														☆	★	☆							SNMG 433-KR			
	SNMG 12 04 16-KR		1/2														☆	★	☆							SNMG 434-KR			
	SNMG 15 06 12-KR	15	5/8														☆	★	☆							SNMG 543-KR			
	SNMG 15 06 16-KR		5/8														☆	★	☆							SNMG 544-KR			
	SNMG 19 06 16-KR	19	3/4														☆	★	☆							SNMG 644-KR			
SNMG 25 07 24-KR	25	1														☆	★	☆							SNMG 856-KR				
	SNMG 12 04 12-KRR	12	1/2														☆	☆	★							SNMG 433-KRR			
	SNMG 12 04 16-KRR		1/2														☆	☆	★							SNMG 434-KRR			
	SNMG 15 06 16-KRR	15	5/8														☆	☆	★							SNMG 544-KRR			
	SNMA 09 03 08-KR	09	3/8																☆							SNMA 322-KR			
	SNMA 12 04 08-KR	12	1/2														★	☆	☆							SNMA 432-KR			
	SNMA 12 04 12-KR		1/2														★	☆	☆							SNMA 433-KR			
	SNMA 12 04 16-KR		1/2														★	☆	☆							SNMA 434-KR			
	SNMA 15 06 12-KR	15	5/8														★	☆	☆							SNMA 543-KR			
	SNMA 15 06 16-KR		5/8														★	☆	☆							SNMA 544-KR			
	SNMA 19 06 08-KR	19	3/4														★									SNMA 642-KR			
	SNMA 19 06 12-KR		3/4														★		☆							SNMA 643-KR			
SNMA 19 06 16-KR		3/4														★	☆	☆							SNMA 644-KR				
SNMA 25 07 24-KR	25	1														★	☆	☆							SNMA 856-KR				
						P25	P15	P05	P15	P25	P35	P10	M15	M25	M15	M25	M35	M35	M25	K10	K05	K10	K15	K20	S15	S20	S25	S15	S05

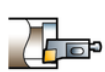
★= First choice



A102



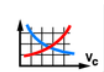
A254



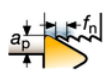
A351



11



A516



A500

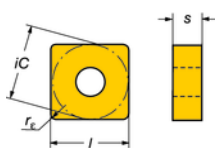


A524



A2

Square



For dimensions, see code key on page A16.

[illegible]

★= First choice

* Dedicated geometry for steel and stainless steel roughing.



A cross-sectional diagram of a ballpoint pen tip. The tip is shown in contact with a surface, with a small amount of ink being deposited. The diagram illustrates the mechanism of the ballpoint pen, where the ball rotates and carries ink from the reservoir to the surface.



A graph with v_c on the horizontal axis and v_e on the vertical axis. A blue curve slopes downwards from left to right. A red curve slopes upwards from left to right. The two curves intersect at a point.

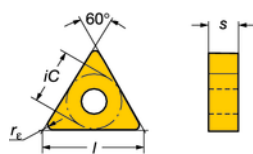
A diagram showing a wedge with a normal force f_n applied at a perpendicular distance a_p from the pivot point.













A2

T-Max P

Triangular



For dimensions, see code key on page A16.

		ISO		iC	P					M					K					S					ANSI			
					GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC					
Finishing	 TNMX-WF 	TNMX 16 04 04-WF	16	3/8	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TNMX 331-WF
		TNMX 16 04 08-WF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TNMX 332-WF
	 TNMG-PF	TNMG 16 04 04-PF	16	3/8	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TNMG 331-PF	
		TNMG 16 04 08-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TNMG 332-PF	
		TNMG 16 04 12-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TNMG 333-PF	
		TNMG 22 04 08-PF	22	1/2	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TNMG 432-PF	
		TNMG 22 04 12-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TNMG 433-PF	
	 TNMG-MF	TNMG 16 04 04-MF	16	3/8							☆	☆	☆	☆								☆	☆				TNMG 331-MF	
		TNMG 16 04 08-MF									☆	☆	☆	☆								☆	☆				TNMG 332-MF	
		TNMG 16 04 12-MF									☆	☆	☆	☆								☆	☆				TNMG 333-MF	
	 TNMG-KF	TNMG 16 04 04-KF	16	3/8												☆		☆									TNMG 331-KF	
		TNMG 16 04 08-KF														☆		☆									TNMG 332-KF	
	 TNMG-SF	TNMG 16 04 12-SF	16	3/8																	☆	☆	☆	☆	☆	☆	TNMG 333-SF	
		TNMG 16 04 04-SF																			☆	☆	☆	☆	☆	☆	TNMG 331-SF	
		TNMG 16 04 08-SF																			☆	☆	☆	☆	☆	☆	TNMG 332-SF	
	 TNMG-LC	TNMG 16 04 04-LC	16	3/8	☆	☆	☆	☆	☆				☆														TNMG 331-LC	
		TNMG 16 04 08-LC			☆	☆	☆	☆	☆				☆														TNMG 332-LC	
	 TNMG-QF	TNMG 16 03 08-QF	16	3/8				☆	☆																		TNMG 322-QF	
		TNMG 16 04 04-QF					☆	☆	☆	☆																	TNMG 331-QF	
		TNMG 16 04 08-QF					☆	☆	☆	☆																	TNMG 332-QF	
		TNMG 16 04 12-QF					☆	☆	☆	☆																	TNMG 333-QF	
		TNMG 22 04 04-QF	22	1/2					☆	☆																	TNMG 431-QF	
	 TNMG-K	TNMG 16 04 04L-K	16	3/8		☆		☆	☆	☆					☆												TNMG 331L-K	
		TNMG 16 04 04R-K				☆		☆	☆	☆					☆												TNMG 331R-K	
		TNMG 16 04 08L-K				☆		☆	☆	☆					☆												TNMG 332L-K	
		TNMG 16 04 08R-K				☆		☆	☆	☆					☆												TNMG 332R-K	
																									</			

R = Right hand, L = Left hand

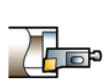
★ = First choice



A102



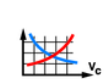
A254



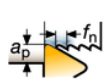
A351



I1



A516



A500

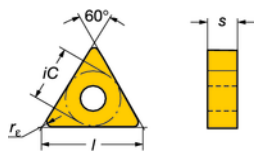


A524








A2

Triangular



For dimensions, see code key on page A16.

		ISO		iC	P					M					K					S					ANSI				
					1515	1525	4205	4215	4235	5015	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	-	1105	1115		1125	H13A	-	S05F
Finishing	 TNMG-MF*	TNMG 11 03 02-MF	11	1/4				☆	☆	☆																	TNMG 220-MF		
		TNMG 11 03 04-MF					☆	☆	☆	☆																	TNMG 221-MF		
		TNMG 11 03 08-MF					☆	☆	☆	☆																	TNMG 222-MF		
		TNMG 11 03 12-MF					☆	☆	☆	☆																	TNMG 223-MF		
		TNMG 16 04 04-MF	16	3/8				☆	☆	☆	☆																	TNMG 331-MF	
		TNMG 16 04 08-MF						☆	☆	☆	☆																	TNMG 332-MF	
		TNMG 16 04 12-MF						☆	☆	☆	☆																	TNMG 333-MF	
		TNMG 16 04 16-MF						☆	☆	☆	☆																	TNMG 334-MF	
		TNMG 22 04 04-MF	22	1/2					☆	☆	☆	☆																	TNMG 431-MF
		TNMG 22 04 08-MF							☆	☆	☆	☆																	TNMG 432-MF
TNMG 22 04 12-MF								☆	☆	☆	☆																TNMG 433-MF		
Medium	 TNMX-WMX Wiper TECHNOLOGY	TNMX 16 04 08-WMX	16	3/8			☆	★	☆	☆																	TNMX 332-WMX		
		TNMX 16 04 12-WMX					☆	★	☆	☆																	TNMX 333-WMX		
	 TNMX-WM Wiper TECHNOLOGY	TNMX 16 04 08-WM	16	3/8			☆	☆	★	☆	☆																	TNMX 332-WM	
		TNMX 16 04 12-WM					☆	☆	★	☆	☆																	TNMX 333-WM	
 TNMG-PM	TNMG 16 04 04-PM	16	3/8				☆	☆	★	☆	☆																TNMG 331-PM		
	TNMG 16 04 08-PM					☆	☆	☆	★	☆	☆																TNMG 332-PM		
	TNMG 16 04 12-PM					☆	☆	☆	★	☆	☆																TNMG 333-PM		
	TNMG 22 04 04-PM	22	1/2				☆	☆	★	☆	☆																TNMG 431-PM		
	TNMG 22 04 08-PM						☆</																						

* Dedicated geometry for finishing of gummy materials.

★= First choice



A102



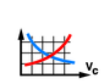
A254



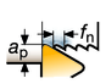
A351



11



A516



A500



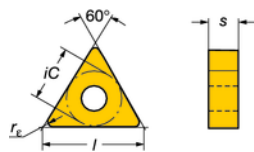
A524



A2

T-Max P

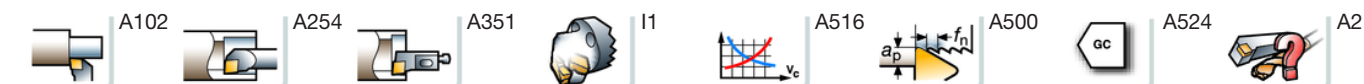
Triangular



For dimensions, see code key on page A16.

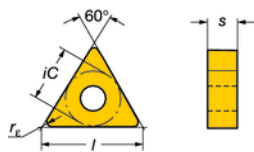
[illegible]

★= First choice



T-Max P

Triangular



For dimensions, see code key on page A16.

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					GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC			
C	TNMM-MR	TNMM 16 04 08-MR	16	3/8																					TNMM 332-MR		
		TNMM 16 04 12-MR																							TNMM 333-MR		
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		TNMM 22 04 12-MR																							TNMM 433-MR		
		TNMM 22 04 16-MR																							TNMM 434-MR		
		TNMM 27 06 12-MR	27	5/8																					TNMM 543-MR		
		TNMM 27 06 16-MR																							TNMM 544-MR		
		TNMM 27 06 24-MR																							TNMM 546-MR		
	TNMG-KR	TNMG 16 04 08-KR	16	3/8																					TNMG 332-KR		
		TNMG 16 04 12-KR																							TNMG 333-KR		
		TNMG 16 04 16-KR																							TNMG 334-KR		
		TNMG 22 04 08-KR	22	1/2																					TNMG 432-KR		
		TNMG 22 04 12-KR																							TNMG 433-KR		
G	TNMG 16 04 08-KRR	TNMG 16 04 08-KRR	16	3/8																					TNMG 332-KRR		
		TNMG 16 04 12-KRR																							TNMG 333-KRR		
	TNMA-KR	TNMA 16 04 04-KR	16	3/8																					TNMA 331-KR		
		TNMA 16 04 08-KR																							TNMA 332-KR		
		TNMA 16 04 12-KR																							TNMA 333-KR		
		TNMA 16 04 16-KR																							TNMA 334-KR		
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		TNMA 22 04 08-KR																							TNMA 432-KR		
		TNMA 22 04 12-KR																							TNMA 433-KR		
		TNMA 22 04 16-KR																							TNMA 434-KR		
H	TNMM-QR	TNMM 22 04 32-KR																							TNMA 438-KR		
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		TNMM 16 04 08-QR	16	3/8																					TNMM 332-QR		
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		TNMM 27 06 16-QR																							TNMM 544-QR		
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I	TNMG-MR*	TNMM 27 06 24-HR																							TNMM 546-HR		
	TNMG-MR*	TNMG 16 04 08-MR	16	3/8																					TNMG 332-MR		
		TNMG 16 04 12-MR																							TNMG 333-MR		
		TNMG 22 04 08-MR	22	1/2																					TNMG 432-MR		
		TNMG 22 04 12-MR																							TNMG 433-MR		
		TNMG 22 04 16-MR																							TNMG 434-MR		
		TNMG 22 04 24-MR																							TNMG 436-MR		
		TNMG 27 06 08-MR	27	5/8																					TNMG 542-MR		
		TNMG 27 06 12-MR																							TNMG 543-MR		
		TNMG 27 06 16-MR																							TNMG 544-MR		
		TNMG 33 09 24-MR	33	3/4																					TNMG 666-MR		
J					P25	P15	P05	P15	P25	P35	P10	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	S15	S20	S25	S15	S05

★ = First choice

* Dedicated geometry for steel and stainless steel roughing.



A102



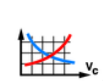
A254



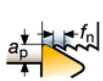
A351



I1



A516



A500



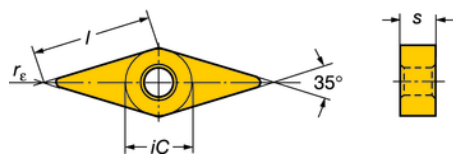
A524




A2

T-Max P

Rhombic 35°

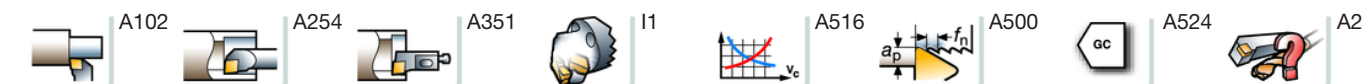


For dimensions, see code key on page A16.

						P							M							K							S							
						GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		
Finishing	ISO			iC	1515	1525	4205	4215	4225	4235	5015	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	1005	1105	1115	1125	H13A	S05F	ANSI					
	VNMG 16 04 04-PF		16	3/8	☆	☆	☆	★	☆	☆	☆																		VNMG 331-PF					
	VNMG 16 04 08-PF				☆	☆	☆	★	☆	☆	☆																		VNMG 332-PF					
															</																			

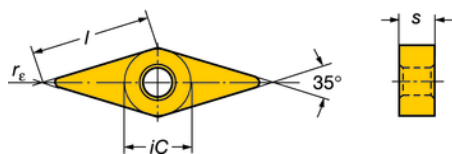
★ = First choice

* Dedicated geometry for finishing of gummy materials.

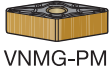

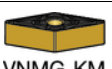

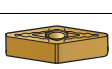


T-Max P

Rhombic 35°



For dimensions, see code key on page A16.

						P								M				K				S								
						GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC					
Medium	 VNMG-PM	ISO	16	3/8		1515	1525	4205	4215	4225	4235	5015	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	1005	1105	1115	1125	H13A	S05F	ANSI
		VNMG 16 04 08-PM				☆		☆	☆	★	☆																			VNMG 332-PM
		VNMG 16 04 12-PM						☆	☆	★	☆																			VNMG 333-PM
	 VNMG-MM	VNMG 16 04 08-MM	16	3/8									☆	☆	☆	★	☆													VNMG 332-MM
	 VNMG-KM	VNMG 16 04 08-KM	16	3/8															☆	☆	★	☆								VNMG 332-KM
		VNMG 16 04 12-KM																	☆	☆	★	☆								VNMG 333-KM
	 VNMG-SM	VNMG 16 04 04-SM	16	3/8																					★	☆	☆	☆	☆	VNMG 331-SM
		VNMG 16 04 08-SM																							★	☆	☆	☆	☆	VNMG 332-SM
		VNMG 16 04 12-SM																							★	☆	☆	☆	☆	VNMG 333-SM
	 VNMG-QM	VNMG 16 04 04-QM	16	3/8				☆	☆				☆				☆					☆		☆	☆	☆	☆			VNMG 331-QM
		VNMG 16 04 08-QM						☆	☆	☆	☆		☆			☆						☆		☆	☆	☆	☆			VNMG 332-QM
		VNMG 16 04 12-QM							☆														☆			☆	☆			VNMG 333-QM
H						P25	P15	P05	P15	P25	P35	P10	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	S15	S15	S20	S25	S15	S05	

★ = First choice



A102



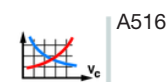
A254



A351



I1



A516



A500

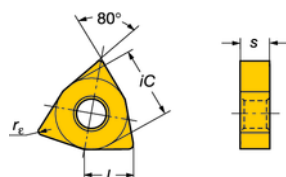


A524



A2

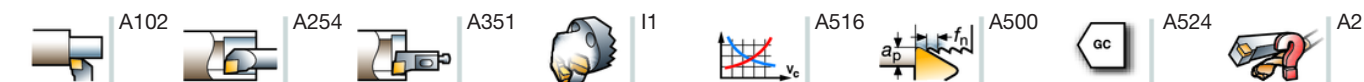
Trigon 80°



B

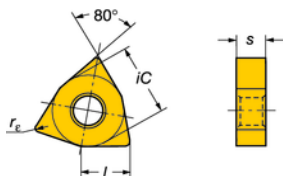
C

★= First choice







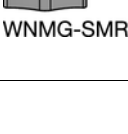


T-Max P

Trigon 80°



For dimensions, see code key on page A16.

		ISO	Δ	iC	P										M										K										S										ANSI							
					1515	1525	GC	4205	GC	4215	GC	4225	GC	4235	5015	1115	GC	1125	GC	2015	GC	2025	GC	2035	GC	235	GC	3005	GC	3205	GC	3210	GC	3215	GC	H13A	GC	1105	GC	1115	GC	1125	GC	H13A	GC	S05F						
	WNLGM 06 04 08-WMX	06	3/8			☆	☆	☆											☆									☆		☆		☆													WNLGM 332-WMX							
	WNLGM 06 04 12-WMX					☆	☆	☆											☆									☆		☆		☆															WNLGM 333-WMX					
	WNLGM 08 04 08-WMX	08	1/2			☆	☆	☆											☆									☆		☆		☆																WNLGM 432-WMX				
	WNLGM 08 04 12-WMX					☆	☆	☆											☆									☆		☆		☆																WNLGM 433-WMX				
	WNLGM 06 04 08-WM	06	3/8		☆	☆	☆	☆											☆								☆		☆		☆																	WNLGM 332-WM				
	WNLGM 06 04 12-WM				☆	☆	☆	☆											☆								☆		☆		☆		☆															WNLGM 333-WM				
	WNLGM 08 04 08-WM	08	1/2		☆	☆	☆	☆											☆								☆		☆		☆		☆															WNLGM 432-WM				
	WNLGM 08 04 12-WM				☆	☆	☆	☆											☆								☆		☆		☆		☆															WNLGM 433-WM				
	WNLGM 06 04 08-PM	06	3/8		☆	☆	☆	☆																																								WNLGM 332-PM				
	WNLGM 06 04 12-PM				☆	☆	☆	☆																																										WNLGM 333-PM		
	WNLGM 08 04 08-PM	08	1/2		☆	☆	☆	☆																																									WNLGM 432-PM			
	WNLGM 08 04 12-PM				☆	☆	☆	☆																																										WNLGM 433-PM		
	WNLGM 06 04 08-MM	06	3/8															☆	☆	☆	☆																											WNLGM 332-MM				
	WNLGM 06 04 12-MM																	☆	☆	☆	☆																													WNLGM 333-MM		
	WNLGM 08 04 08-MM	08	1/2															☆	☆	☆	☆																												WNLGM 432-MM			
	WNLGM 08 04 12-MM																	☆	☆	☆	☆																											WNLGM 433-MM				
	WNLGM 06 04 08-KM	06	3/8																										☆	☆																				WNLGM 332-KM		
	WNLGM 06 04 12-KM																												☆	☆																					WNLGM 333-KM	
	WNLGM 08 04 08-KM	08	1/2																									☆	☆	☆	☆																			WNLGM 432-KM		
	WNLGM 08 04 12-KM																											☆	☆	☆	☆																			WNLGM 433-KM		
	WNLGM 08 04 04-SM	08	1/2																																		☆	☆	☆	☆	☆								WNLGM 431-SM			
	WNLGM 08 04 08-SM																																			☆	☆	☆	☆	☆									WNLGM 432-SM			
	WNLGM 08 04 12-SM																																			☆	☆	☆	☆	☆									WNLGM 433-SM			
	WNLGM 08 04 08-SMR	08	1/2																																	☆	☆	☆	☆	☆									WNLGM432-SMR			
	WNLGM 08 04 12-SMR																																			☆	☆	☆	☆	☆									WNLGM433-SMR			
					P25	P15	P05	P15	P25	P35	P10	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	S15	S20	S25	S15	S05																									

★ = First choice



A102



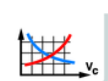
A254



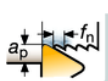
A351



I1



A516



A500

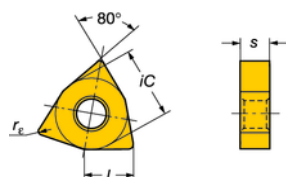


A524



A2

Trigon 80°



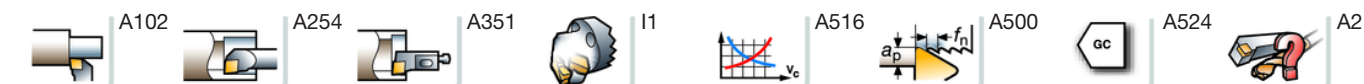
For dimensions, see code key on page A16.

[illegible]

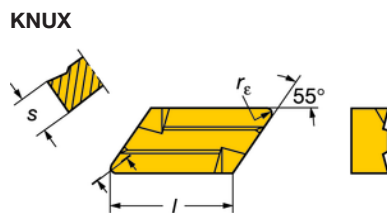
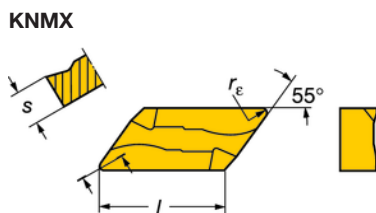
★= First choice

1) Complementary geometry for semi-roughing in steel materials




* Dedicated geometry for steel and stainless steel roughing.



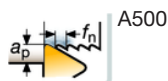
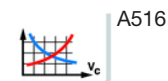
B



For dimensions, see code key on page A16.

					P				M		K		
					GC	GC	CT	-	GC	GC	-		-
					4215	4225	5015	IS1P	2025	235	H13A		-
Finishing	 KNMX-71	ISO		16	☆	☆	☆	☆	☆	☆	☆	ANSI	
		KNMX 16 04 05 L-71	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNMX 16 04 05 L-71	
		KNMX 16 04 05 R-71	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNMX 16 04 05 R-71	
		KNMX 16 04 10 L-71	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNMX 16 04 10 L-71	
		KNMX 16 04 10 R-71	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNMX 16 04 10 R-71	
	 KNUX	KNUX 16 04 05F L12	16	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 05F L12	
		KNUX 16 04 05F R12	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 05F R12	
		KNUX 16 04 05L11	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 05L11	
		KNUX 16 04 05L12	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 05L12	
		KNUX 16 04 05R11	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 05R11	
		KNUX 16 04 05R12	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 05R12	
		KNUX 16 04 10F L12	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 10F L12	
		KNUX 16 04 10F R12	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 10F R12	
		KNUX 16 04 10L11	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 10L11	
KNUX 16 04 10L12		☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 10L12		
KNUX 16 04 10R11	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 10R11			
KNUX 16 04 10R12	☆	☆	☆	☆	☆	☆	☆	☆	☆	KNUX 16 04 10R12			
	KNUX 16 04 15F R13										KNUX 16 04 15F R13		
					P15	P25	P10	P10	M25	M35	M15	K20	

R = Right hand, L = Left hand

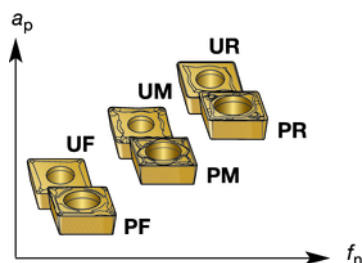


CoroTurn® 107/111

Positive basic-shape inserts

For external machining of small, long, slender components and internal machining

The CoroTurn® 107/111 inserts comply with ISO standards and many types of insert shapes are available



Insert geometries

Dedicated for:

- Different feed and depth of cut areas
- Different workpiece materials

Insert grades

Modern productive coated and uncoated grades for all ISO material areas

- Polycrystalline diamond, see page A524
- Cubic boron nitride, see page A524

Available in the range of steel turning grades: GC4205, GC4215, GC4225 and GC4235.

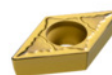
ISO application areas:



Wiper Technology

Sandvik Coromant's productivity booster.

- Double feed - Same surface finish
- Same feed - Twice as good surface finish



The positive insert shape combines low cutting forces with good edge strength. The screw clamping ensures stability and unobstructed chip flow.

CoroTurn® 107 (7° clearance angle)

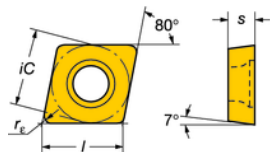
Inserts with first choice for external machining of small, long and slender components and internal machining.

CoroTurn® 111 (11° clearance angle)

For optimized internal turning operations requiring small cutting forces.

CoroTurn® 107

Rhombic 80°



For dimensions, see code key on page A16.

B











C

G

H

I

J

		ISO		IC	P										M					K				N		S				ANSI							
					1105	1125	1515	1525	4205	4215	4225	4235	5015	1105	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	1125	H10	1105	1115		1125	H10A	H13A				
Finishing	 CCMT-WF 	CCMT 06 02 02-WF	06	1/4	★						☆			★													★	☆							CCMT 2(1.5)0-WF		
		CCMT 06 02 04-WF				☆	☆		★			☆			☆	★			☆			★					★	☆							CCMT 2(1.5)1-WF		
		CCMT 06 02 08-WF				☆	☆		★			☆			☆	★			☆			★					★	☆							CCMT 2(1.5)2-WF		
		CCMT 09 T3 02-WF	09	3/8	★							☆			★														★	☆						CCMT 3(2.5)0-WF	
		CCMT 09 T3 04-WF				☆	☆		★			☆			☆	★			☆			★					★	☆								CCMT 3(2.5)1-WF	
		CCMT 09 T3 08-WF				☆	☆		★			☆			☆	★			☆			★					★	☆								CCMT 3(2.5)2-WF	
	 CCMT-PF	CCMT 06 02 02-PF	06	1/4		☆				★		☆																								CCMT 2(1.5)0-PF	
		CCMT 06 02 04-PF				☆			★	☆		☆																									CCMT 2(1.5)1-PF
		CCMT 09 T3 02-PF	09	3/8		☆				★		☆																									CCMT 3(2.5)0-PF
		CCMT 09 T3 04-PF				☆			★	☆		☆																									CCMT 3(2.5)1-PF
		CCMT 09 T3 08-PF				☆			★	☆		☆																									CCMT 3(2.5)2-PF
		CCMT 12 04 04-PF	12	1/2		☆			★	☆		☆																									CCMT 431-PF
	 CCMT-MF	CCMT 06 02 02-MF	06	1/4									☆	★													★	☆	☆								CCMT 2(1.5)0-MF
		CCMT 06 02 04-MF											☆	★	☆												★	☆	☆								CCMT 2(1.5)1-MF
		CCMT 09 T3 02-MF	09	3/8									☆	★													★	☆	☆								CCMT 3(2.5)0-MF
		CCMT 09 T3 04-MF											☆	★	☆	☆											★	☆	☆								CCMT 3(2.5)1-MF
		CCMT 09 T3 08-MF											☆	★	☆	☆											★	☆	☆								CCMT 3(2.5)2-MF
		CCMT 12 04 04-MF	12	1/2									☆	★	☆	☆											★	☆									CCMT 431-MF
 CCMT-KF	CCMT 06 02 02-KF	06	1/4																															☆		CCMT 2(1.5)0-KF	
	CCMT 06 02 04-KF																	☆				★											☆			CCMT 2(1.5)1-KF	
	CCMT 09 T3 02-KF	09	3/8																			★												☆			CCMT 3(2.5)0-KF
	CCMT 09 T3 04-KF																	☆				★												☆			CCMT 3(2.5)1-KF
	CCMT 12 04 04-KF	12	1/2																			★												☆			CCMT 431-KF
 CCMT-UF	CCMT 06 02 02-UF	06	1/4			☆					☆																										CCMT 2(1.5)0-UF
	CCMT 06 02 04-UF					☆					☆	☆						☆																			CCMT 2(1.5)1-UF
	CCMT 06 02 08-UF										☆																										CCMT 2(1.5)2-UF
	CCMT 09 T3 02-UF	09	3/8			☆							☆																								CCMT 3(2.5)0-UF
	CCMT 09 T3 04-UF					☆			☆			☆																									CCMT 3(2.5)1-UF
Medium	 CCMT-WM 	CCMT 06 02 08-WM	06	1/4			☆			★	☆			★														★									CCMT 2(1.5)2-WM
		CCMT 09 T3 04-WM	09	3/8			☆	☆	☆	★	☆			☆		★												★									CCMT 3(2.5)1-WM
		CCMT 09 T3 08-WM				☆	☆	☆	★	☆				☆		★			☆			★					★										CCMT 3(2.5)2-WM
		CCMT 12 04 04-WM	12	1/2			☆			★	☆			☆		★			☆			★					★										CCMT 431-WM
		CCMT 12 04 08-WM					☆			★	☆			☆		★			☆			★					★										CCMT 432-WM
	 CCMT-PM	CCMT 06 02 04-PM	06	1/4			☆	☆		☆	★	☆	☆																								CCMT 2(1.5)1-PM
		CCMT 06 02 08-PM					☆	☆		☆	★	☆	☆																								CCMT 2(1.5)2-PM
		CCMT 09 T3 04-PM	09	3/8			☆	☆	☆	★	☆	☆	☆																								CCMT 3(2.5)1-PM
		CCMT 09 T3 08-PM					☆	☆	☆	★	☆	☆	☆																								CCMT 3(2.5)2-PM
		CCMT 12 04 04-PM	12	1/2			☆			☆	★	☆	☆																								CCMT 431-PM
		CCMT 12 04 08-PM					☆			☆	★	☆	☆																								CCMT 432-PM
		CCMT 12 04 12-PM									★	☆	☆	☆																							CCMT 433-PM

★ = First choice



A102



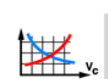
A254



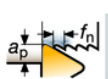
A351



I1



A516



A500



A524

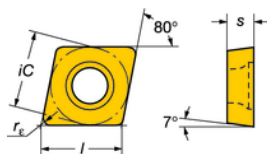











A2

CoroTurn® 107

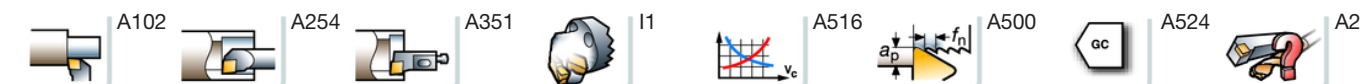
Rhombic 80°

For dimensions, see code key on page A16.



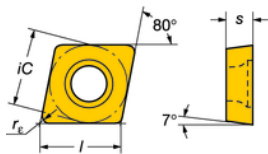
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					1105	1125	1515	1525	4205	4215	4225	4235	5015	1105	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	H10	1105	1115	1125	H10A		H13A		
Medium	 CCMT-MM	CCMT 06 02 04-MM	06	1/4										☆	☆	★									★	☆	☆				CCMT 2(1.5)1-MM			
		CCMT 06 02 08-MM												☆	☆	★									★	☆	☆				CCMT 2(1.5)2-MM			
		CCMT 09 T3 04-MM	09	3/8										☆	☆	☆	★	☆							★	☆	☆				CCMT 3(2.5)1-MM			
		CCMT 09 T3 08-MM												☆	☆	☆	★	☆							★	☆	☆				CCMT 3(2.5)2-MM			
		CCMT 12 04 04-MM	12	1/2										☆	☆	☆	★	☆							★	☆	☆				CCMT 431-MM			
		CCMT 12 04 08-MM												☆	☆	☆	★	☆							★	☆	☆				CCMT 432-MM			
		CCMT 12 04 12-MM												☆	★																CCMT 433-MM			
	 CCMT-KM	CCMT 06 02 04-KM	06	1/4															☆			★	☆							☆	CCMT 2(1.5)1-KM			
		CCMT 06 02 08-KM																	☆			★	☆							☆	CCMT 2(1.5)2-KM			
		CCMT 09 T3 04-KM	09	3/8															☆		★	☆	☆							☆	CCMT 3(2.5)1-KM			
		CCMT 09 T3 08-KM																	☆		★	☆	☆							☆	CCMT 3(2.5)2-KM			
		CCMT 12 04 04-KM	12	1/2															☆		★	☆	☆							☆	CCMT 431-KM			
	 CCET-UM	CCET 06 02 01-UM	06	1/4	☆	★								☆	★	☆							☆		★	☆					CCET 2(1.5)03-UM			
		CCET 06 02 02-UM			☆	★								☆	★	☆							☆		★	☆					CCET 2(1.5)0-UM			
		CCET 06 02 04-UM			☆	★								☆	★	☆							☆		★	☆					CCET 2(1.5)1-UM			
 CCGT-UM	CCGT 06 02 01-UM	06	1/4	☆									☆	☆	☆							☆		★	☆	☆		☆		CCGT 2(1.5)03-UM				
	CCGT 06 02 02-UM			☆		☆							☆	☆	☆							☆		★	☆	☆		☆		CCGT 2(1.5)0-UM				
	CCGT 06 02 04-UM			☆		☆							☆	☆	☆							☆		★	☆	☆		☆		CCGT 2(1.5)1-UM				
	CCGT 09 T3 01-UM	09	3/8										☆	☆	☆							☆		★	☆	☆		☆		CCGT 3(2.5)03-UM				
	CCGT 09 T3 02-UM					☆							☆	☆	☆							☆		★	☆	☆		☆		CCGT 3(2.5)0-UM				
	CCGT 09 T3 04-UM					☆							☆	☆	☆							☆		★	☆	☆		☆		CCGT 3(2.5)1-UM				
	CCGT 09 T3 08-UM					☆							☆	☆	☆							☆		★	☆	☆		☆		CCGT 3(2.5)2-UM				
	CCGT 12 04 04-UM	12	1/2																								★			CCGT 431-UM				
	CCGT 12 04 08-UM																										★			CCGT 432-UM				
	CCMW 06 02 04	06	1/4																			☆									CCMW 2(1.5)1			
 CCMW	CCMW 09 T3 04	09	3/8							☆											☆										CCMW 3(2.5)1			
 CCMT-UM	CCMT 06 02 04-UM	06	1/4			☆	☆			☆	☆					☆									☆	☆	☆				CCMT 2(1.5)1-UM			
	CCMT 06 02 08-UM					☆				☆	☆					☆									☆	☆	☆				CCMT 2(1.5)2-UM			
	CCMT 09 T3 04-UM	09	3/8			☆	☆		☆	☆			☆	☆	☆						☆			☆	☆	☆		☆			CCMT 3(2.5)1-UM			
	CCMT 09 T3 08-UM					☆	☆		☆	☆			☆	☆	☆									☆	☆	☆					CCMT 3(2.5)2-UM			
	CCMT 12 04 08-UM	12	1/2							☆																☆	☆				CCMT 432-UM			
 CCMT-PR	CCMT 06 02 08-PR	06	1/4					☆	★	☆																					CCMT 2(1.5)2-PR			
	CCMT 09 T3 08-PR	09	3/8					☆	★	☆																					CCMT 3(2.5)2-PR			
	CCMT 09 T3 12-PR							★	★																						CCMT 3(2.5)3-PR			
	CCMT 12 04 08-PR	12	1/2					☆	★	☆																					CCMT 432-PR			
	CCMT 12 04 12-PR							☆	★	☆																					CCMT 433-PR			
 CCMT-MR	CCMT 06 02 08-MR	06	1/4											★		☆															CCMT 2(1.5)2-MR			
	CCMT 09 T3 08-MR	09	3/8											☆	★	☆															CCMT 3(2.5)2-MR			
	CCMT 09 T3 12-MR														★																CCMT 3(2.5)3-MR			
	CCMT 12 04 08-MR	12	1/2												★	☆															CCMT 432-MR			
	CCMT 12 04 12-MR														★	☆															CCMT 433-MR			

★ = First choice







CoroTurn® 107

Rhombic 80°



For dimensions, see code key on page A16.

					P										M					K				N		S								
					GC	GC	GC	GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		GC	GC	GC
Roughing	 CCMT-KR	ISO		IC	1105	1125	1515	1525	4205	4215	4225	4235	5015	1105	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	1125	H10	1105	1115	1125	H10A	H13A	ANSI	
		CCMT 06 02 08-KR	06	1/4																			★	★	★							★	CCMT 2(1.5)2-KR	
		CCMT 09 T3 08-KR	09	3/8																			★	★	★							★	CCMT 3(2.5)2-KR	
		CCMT 09 T3 12-KR																					★	★	★							★	CCMT 3(2.5)3-KR	
		CCMT 12 04 08-KR	12	1/2																		★	★	★	★							★	CCMT 432-KR	
	CCMT 12 04 12-KR																					★	★	★	★							★	CCMT 433-KR	
	 CCMT-UR	CCMT 06 02 04-UR	06	1/4							★									★														CCMT 2(1.5)1-UR
		CCMT 09 T3 04-UR	09	3/8							★	★	★							★														CCMT 3(2.5)1-UR
		CCMT 09 T3 08-UR								★	★	★							★															CCMT 3(2.5)2-UR
		CCMT 12 04 08-UR	12	1/2							★	★								★														CCMT 432-UR
Aluminium	 CCGX-AL	CCGX 06 02 02-AL	06	1/4	★								★													★	★						CCGX 2(1.5)0-AL	
		CCGX 06 02 04-AL			★									★													★	★						CCGX 2(1.5)1-AL
		CCGX 09 T3 04-AL	09	3/8	★									★													★	★						CCGX 3(2.5)1-AL
		CCGX 09 T3 08-AL			★									★													★	★						CCGX 3(2.5)2-AL
		CCGX 12 04 04-AL	12	1/2																							★	★						CCGX 431-AL
		CCGX 12 04 08-AL																									★	★						CCGX 432-AL
					P05	P25	P25	P15	P05	P15	P25	P35	P10	M15	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	N25	N15	S15	S20	S25	S10	S15		

★ = First choice



A102



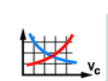
A254



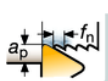
A351



I1



A516



A500



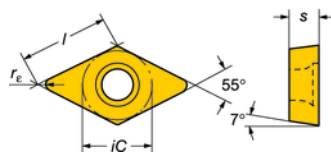
A524



A2

CoroTurn® 107

Rhombic 55°



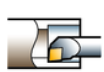
For dimensions, see code key on page A16.

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Finishing		DCMX 07 02 02-WF	07	1/4	★							☆																				DCMX 2(1.5)0-WF		
	DCMX-WF	DCMX 07 02 04-WF				☆	☆		★			☆		☆	★													★	☆			DCMX 2(1.5)1-WF		
		DCMX 07 02 08-WF					☆	☆		★				☆	☆	★												★	☆			DCMX 2(1.5)2-WF		
		DCMX 11 T3 02-WF	11	3/8	★							☆		★																		DCMX 3(2.5)0-WF		
		DCMX 11 T3 04-WF					☆	☆		★			☆	★						☆	★							★	☆			DCMX 3(2.5)1-WF		
		DCMX 11 T3 08-WF					☆	☆		★		☆		☆	★			★										★	☆			DCMX 3(2.5)2-WF		
	DCMT-PF	DCMT 07 02 02-PF	07	1/4			☆				★		☆																				DCMT 2(1.5)0-PF	
		DCMT 07 02 04-PF					☆				★		☆																				DCMT 2(1.5)1-PF	
		DCMT 11 T3 02-PF	11	3/8			☆				★		☆																				DCMT 3(2.5)0-PF	
		DCMT 11 T3 04-PF					☆				★	☆		☆																			DCMT 3(2.5)1-PF	
		DCMT 11 T3 08-PF					☆				★	☆		☆																			DCMT 3(2.5)2-PF	
	DCMT-MF	DCMT 07 02 02-MF	07	1/4										☆	★														★	☆	☆			DCMT 2(1.5)0-MF
		DCMT 07 02 04-MF												☆	☆	★	☆												★	☆	☆			DCMT 2(1.5)1-MF
		DCMT 11 T3 02-MF	11	3/8										☆	★														★	☆	☆			DCMT 3(2.5)0-MF
		DCMT 11 T3 04-MF												☆	☆	★	☆												★	☆	☆			DCMT 3(2.5)1-MF
		DCMT 11 T3 08-MF												☆	☆	★	☆												★	☆	☆			DCMT 3(2.5)2-MF
DCMT-KF	DCMT 07 02 02-KF	07	1/4																			★									☆		DCMT 2(1.5)0-KF	
	DCMT 07 02 04-KF																					★									☆		DCMT 2(1.5)1-KF	
	DCMT 11 T3 02-KF	11	3/8																			★									☆		DCMT 3(2.5)0-KF	
	DCMT 11 T3 04-KF																					★									☆		DCMT 3(2.5)1-KF	
DCMT-UF	DCMT 07 02 02-UF	07	1/4			☆						☆																					DCMT 2(1.5)0-UF	
	DCMT 07 02 04-UF					☆					☆																						DCMT 2(1.5)1-UF	
	DCMT 11 T3 04-UF	11	3/8			☆				☆	☆		☆																				DCMT 3(2.5)1-UF	
	DCMT 11 T3 08-UF									☆																							DCMT 3(2.5)2-UF	
Medium		DCMX 11 T3 04-WM	11	3/8			☆	☆	☆	★	☆			☆	★			★			★							★					DCMX 3(2.5)1-WM	
	DCMX-WM	DCMX 11 T3 08-WM					☆	☆	☆	★	☆			☆	★					★	☆							★					DCMX 3(2.5)2-WM	
	DCMT-PM	DCMT 07 02 04-PM	07	1/4			☆	☆			☆	★	☆	☆																				DCMT 2(1.5)1-PM
		DCMT 07 02 08-PM					☆	☆			☆	★	☆	☆																				DCMT 2(1.5)2-PM
		DCMT 11 T3 04-PM	11	3/8			☆	☆	☆		☆	★	☆	☆	☆																			DCMT 3(2.5)1-PM
		DCMT 11 T3 08-PM					☆	☆	☆	☆	★	☆	☆	☆																				DCMT 3(2.5)2-PM
		DCMT 11 T3 12-PM					☆	☆	☆	☆	★	☆	☆	☆																				DCMT 3(2.5)3-PM
	DCMT-MM	DCMT 07 02 04-MM	07	1/4											☆	☆	☆												★	☆	☆			DCMT 2(1.5)1-MM
		DCMT 07 02 08-MM													☆	☆	☆	★	☆										★	☆	☆			DCMT 2(1.5)2-MM
		DCMT 11 T3 04-MM	11	3/8											☆	☆	☆	★	☆										★	☆	☆			DCMT 3(2.5)1-MM
		DCMT 11 T3 08-MM													☆	☆	☆	★	☆										★	☆	☆			DCMT 3(2.5)2-MM
		DCMT 11 T3 12-MM													☆	☆		★	☆										★	☆				DCMT 3(2.5)3-MM
DCMT-KM	DCMT 07 02 04-KM	07	1/4																	☆	☆		★	☆							☆		DCMT 2(1.5)1-KM	
	DCMT 07 02 08-KM																					★	☆	☆									DCMT 2(1.5)2-KM	
	DCMT 11 T3 04-KM	11	3/8																	☆	☆		★	☆	☆						☆		DCMT 3(2.5)1-KM	
	DCMT 11 T3 08-KM																			☆	☆		★	☆	☆						☆		DCMT 3(2.5)2-KM	

★= First choice



A102



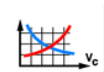
A254



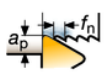
A351



11



A516



A500



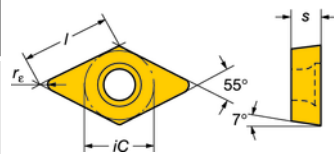
A524



A2

CoroTurn® 107

Rhombic 55°



For dimensions, see code key on page A16.

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Medium	DCET-UM	DCET 07 02 00-UM	07	1/4	☆	★							☆	★	☆									☆		☆	★	☆					DCET 2(1.5)00-UM	
		DCET 07 02 01-UM			☆	★							☆	★	☆									☆		☆	★	☆					DCET 2(1.5)03-UM	
		DCET 11 T3 01-UM	11	3/8	★								☆	★	☆									☆		☆	★	☆					DCET 3(2.5)03-UM	
		DCET 11 T3 02-UM			★								☆	★	☆									☆		☆	★	☆					DCET 3(2.5)0-UM	
		DCET 11 T3 04-UM			★								☆	★	☆									☆		☆	★	☆					DCET 3(2.5)2-UM	
	DCGT-UM	DCGT 07 02 01-UM	07	1/4	☆								☆	☆										☆		★	☆	☆	☆				DCGT 2(1.5)03-UM	
		DCGT 07 02 02-UM			☆	☆							☆	☆										☆		★	☆	☆	☆				DCGT 2(1.5)0-UM	
		DCGT 07 02 04-UM			☆	☆						☆	☆	☆		☆								☆		★	☆	☆	☆				DCGT 2(1.5)1-UM	
		DCGT 07 02 08-UM			☆	☆						☆	☆											☆		★	☆	☆	☆				DCGT 2(1.5)2-UM	
		DCGT 11 T3 01-UM	11	3/8								☆	☆	☆										☆		★	☆	☆	☆				DCGT 3(2.5)03-UM	
	DCMW	DCGT 11 T3 02-UM				☆						☆	☆	☆		☆								☆		★	☆	☆	☆				DCGT 3(2.5)0-UM	
		DCGT 11 T3 04-UM				☆						☆	☆	☆		☆								☆		★	☆	☆	☆	☆			DCGT 3(2.5)1-UM	
		DCGT 11 T3 08-UM				☆						☆	☆	☆		☆								☆		★	☆	☆	☆	☆			DCGT 3(2.5)2-UM	
		DCMW 11 T3 04	11	3/8																				☆				☆					DCMW 3(2.5)1	
Roughing	DCMT-UM	DCMT 07 02 04-UM	07	1/4		☆	☆			☆			☆	☆					☆								☆	☆					DCMT 2(1.5)1-UM	
		DCMT 07 02 08-UM				☆				☆			☆	☆													☆	☆					DCMT 2(1.5)2-UM	
		DCMT 11 T3 04-UM	11	3/8		☆	☆		☆	☆	☆		☆	☆		☆										☆	☆						DCMT 3(2.5)1-UM	
		DCMT 11 T3 08-UM				☆	☆		☆	☆	☆		☆	☆		☆										☆	☆						DCMT 3(2.5)2-UM	
	DCMT-PR	DCMT 11 T3 08-PR	11	3/8				☆	☆	★	☆																						DCMT 3(2.5)2-PR	
		DCMT 11 T3 12-PR						☆	☆	★	☆																						DCMT 3(2.5)3-PR	
	DCMT-MR	DCMT 11 T3 08-MR	11	3/8											☆	★	☆																DCMT 3(2.5)2-MR	
		DCMT 11 T3 12-MR													☆	★	☆																DCMT 3(2.5)3-MR	
	DCMT-KR	DCMT 11 T3 08-KR	11	3/8																☆	★	☆	☆										DCMT 3(2.5)2-KR	
		DCMT 11 T3 12-KR																		☆	★	☆											DCMT 3(2.5)3-KR	
	DCMT-UR	DCMT 11 T3 04-UR	11	3/8					☆	☆																								DCMT 3(2.5)1-UR
		DCMT 11 T3 08-UR						☆	☆	☆						☆																		DCMT 3(2.5)2-UR
		DCMT 11 T3 12-UR						☆	☆	☆																								DCMT 3(2.5)3-UR
Aluminium	DCGX-AL	DCGX 07 02 02-AL	07	1/4	☆								☆													☆	★						DCGX 2(1.5)0-AL	
		DCGX 07 02 04-AL			☆								☆												☆	★							DCGX 2(1.5)1-AL	
		DCGX 11 T3 02-AL	11	3/8	☆								☆												☆	★							DCGX 3(2.5)0-AL	
		DCGX 11 T3 04-AL			☆								☆												☆	★							DCGX 3(2.5)1-AL	
		DCGX 11 T3 08-AL			☆								☆												☆	★							DCGX 3(2.5)2-AL	

★ = First choice



A102



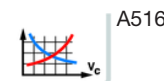
A254



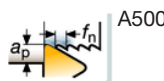
A351



I1



A516



A500



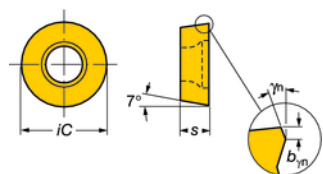
A524



A2

CoroTurn® 107




Round



iC	b_n mm	b_n in.	γ_n
05-08	0.1	.004	0°
10	0.1	.004	15°
12	0.1	.004	15°
16-25	0.1	.006	15°
32	0.2	.008	15°



For dimensions, see code key on page A16.

Metric version

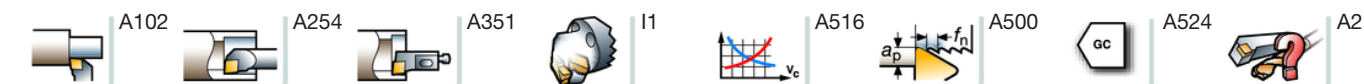
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				GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	-	GC	-	GC	GC	GC		GC	-	GC	
Aluminium		06	RCGX 06 02 M0-AL															★								RCGX 06 02 M0-AL	
		08	RCGX 08 03 M0-AL															★								RCGX 08 03 M0-AL	
		10	RCGX 10 T3 M0-AL	☆						☆								☆	★	★							RCGX 10 T3 M0-AL
		12	RCGX 12 04 M0-AL	☆						☆								☆	★	★							RCGX 12 04 M0-AL
Medium		05	RCMT 05 02 M0					★	☆	☆		☆	☆	★			★			★	☆	☆	☆	☆	☆	RCMT 05 02 M0	
		06	RCMT 06 02 M0		☆		☆	★	☆	☆		☆	☆	★	☆		★		★	☆	☆	☆	☆	☆	☆	RCMT 06 02 M0	
		08	RCMT 08 03 M0		☆		☆	★	☆	☆				★	☆	★	☆	☆					★		☆	RCMT 08 03 M0	
		10	RCMT 10 T3 M0		☆	☆	☆	★	☆					★	☆	★	☆	☆					★		☆	RCMT 10 T3 M0	
		12	RCMT 12 04 M0 ¹⁾		☆	☆	☆	★	☆					★	☆	★	☆	☆					★		☆	RCMT 12 04 M0	
		16	RCMT 16 06 M0 ¹⁾			☆	☆	☆	☆					★	☆	☆	☆	☆					★		☆	RCMT 16 06 M0	
		20	RCMT 20 06 M0 ¹⁾			☆	☆	★	☆					★	☆	★	☆	☆					★		☆	RCMT 20 06 M0	
		25	RCMT 25 07 M0 ¹⁾			☆	☆	★	☆						★		★						★		☆	RCMT 25 07 M0	
		32	RCMT 32 09 M0 ¹⁾			☆	☆	★	☆						★		★						★		☆	RCMT 32 09 M0	
		08	RCMT 08 03 M0-SM								☆	☆					☆			★	☆	☆	☆	☆	☆	RCMT 08 03 M0-SM	
		10	RCMT 10 T3 M0-SM								☆	☆					☆			★	☆	☆	☆	☆	☆	RCMT 10 T3 M0-SM	
		12	RCMT 12 04 M0-SM								☆	☆					☆			★	☆	☆	☆	☆	☆	RCMT 12 04 M0-SM	
		16	RCMT 16 06 M0-SM								☆	☆					☆			★	☆	☆	☆	☆	☆	RCMT 16 06 M0-SM	
				P05	P25	P05	P15	P25	P35	P10	M15	M15	M25	M25	M35	K10	K15	K20	N10	N15	S15	S20	S25	S15	S05		

¹⁾ The inserts will fit both CoroTurn® 107 and T-Max P holders.

Inch version

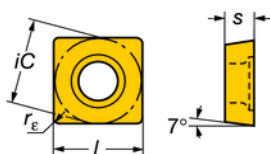
				P					M				K		S									
				GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	-	GC	GC	GC	GC	-	GC			
		iC	ANSI	1105	1515	4205	4215	4225	4235	1105	1115	1125	2025	235	3210	H13A	1005	1105	1115	1125	H13A	S05F	ISO	
Medium		1/4	RCMT 22-SM	☆						☆	☆	☆				☆		★	☆	☆	☆	☆	RCMT 06 03 00-SM	
		3/8	RCMT 3(2.5)-SM	☆							☆	☆	☆					☆	☆	☆	☆	☆	☆	RCMT 09 T3 00-SM
		1/2	RCMT 43-SM	☆							☆	☆	☆				☆	★	☆	☆	☆	☆	☆	RCMT 12 04 00-SM
		3/8	RCMT 3(2.5)M0					★	☆					★		★						★		RCMT 09 T3 00-M0
		1/2	RCMT 43 M0					★	☆						★		★					★		RCMT 12 04 00-M0
		3/4	RCMT 64 M0												★		★					★		RCMT 19 06 00-M0
		1/4	RCMT 22		☆		☆	★	☆						★		★	☆				★		RCMT 06 03 00
		3/8	RCMT 3(2.5)		☆		☆	★	☆						★	★	☆	☆				★		RCMT 09 T3 00
		1/2	RCMT 43		☆	☆	☆	★	☆						★	★	☆	☆				★		RCMT 12 04 00
	3/4	RCMT 64				☆	☆							★	★	☆	☆				★		RCMT 19 06 00	
				P05	P25	P05	P15	P25	P35	M15	M15	M25	M25	M35	K10	K20	S15	S15	S20	S25	S15	S05		

★ = First choice



CoroTurn® 107

Square



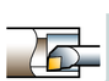
For dimensions, see code key on page A16.

					P										M										K					N					S					
					GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		
		ISO		iC	1515	1525	4205	4215	4225	4235	5015	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	3215	H13A	H10	H10	H105	1105	1115	1125	H13A								ANSI		
Finishing	SCMT-PF	SCMT 09 T3 04-PF	09	3/8	☆		★	☆		☆																													SCMT 3(2.5)1-PF	
		SCMT 09 T3 08-PF			☆		★	☆		☆																												SCMT 3(2.5)2-PF		
	SCMT-MF	SCMT 09 T3 04-MF	09	3/8								☆	☆	★													★	☆										SCMT 3(2.5)1-MF		
		SCMT 09 T3 08-MF										☆	☆	★													★	☆										SCMT 3(2.5)2-MF		
G	SCMT-KF	SCMT 09 T3 04-KF	09	3/8													★																					SCMT 3(2.5)1-KF		
		SCMT 09 T3 08-KF															★																					SCMT 3(2.5)2-KF		
H	SCMT-UF	SCMT 09 T3 08-UF	09	3/8				☆																															SCMT 3(2.5)2-UF	
	SCMT-PM	SCMT 09 T3 04-PM	09	3/8	☆	☆	☆	★	☆	☆																													SCMT 3(2.5)1-PM	
		SCMT 09 T3 08-PM			☆	☆	☆	★	☆	☆																													SCMT 3(2.5)2-PM	
Medium	SCMT-MM	SCMT 12 04 04-PM	12	1/2	☆	☆	☆	★	☆	☆																													SCMT 431-PM	
		SCMT 12 04 08-PM			☆	☆	☆	★	☆	☆																													SCMT 432-PM	
	SCMT-MM	SCMT 12 04 12-PM			☆		☆	★	☆	☆																													SCMT 433-PM	
I	SCMT-KM	SCMT 09 T3 04-MM	09	3/8								☆	☆	★	☆												★	☆	☆										SCMT 3(2.5)1-MM	
		SCMT 09 T3 08-MM										☆	☆	★	☆												★	☆	☆										SCMT 3(2.5)2-MM	
	SCMT-KM	SCMT 12 04 04-MM	12	1/2								☆	☆	★	☆												★	☆											SCMT 431-MM	
		SCMT 12 04 08-MM										☆	☆	★	☆												★	☆											SCMT 432-MM	
J	SCMT-KM	SCMT 12 04 12-MM										☆		★	☆												★												SCMT 433-MM	
	SCMT-KM	SCMT 09 T3 04-KM	09	3/8													☆	★	☆	☆																		SCMT 3(2.5)1-KM		
		SCMT 09 T3 08-KM															☆	★	☆	☆																		SCMT 3(2.5)2-KM		
		SCMT 12 04 08-KM	12	1/2														★	☆	☆																		SCMT 432-KM		
					P25	P15	P05	P15	P25	P35	P10	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	N15	S15	S20	S25	S15													

★ = First choice



A102



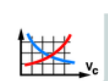
A254



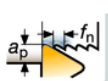
A351



I1



A516



A500



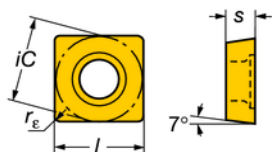
A524




A2

CoroTurn® 107

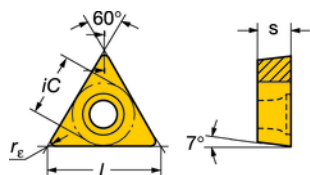
Square








For dimensions, see code key on page A16.

						P										M										K										N	S																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
						ISO	iC	1515	1525	4205	4215	4225	4235	5015	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	-	H10	-	1105	1115	1125	H13A	ANSI																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																												
Medium		SCMW	09	3/8																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									

Triangular



For dimensions, see code key on page A16.

		ISO		IC	P												M												K				N				S				ANSI
					1025	1105	1125	1515	1525	235	4205	4215	4225	4235	5015	1025	1105	1115	1125	2015	2025	2035	235	3005	3205	3215	3215	H13A	1125	H10	H13A	1025	1105	1115	1125	H10A	H13A				
					GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC			
Finishing	 TCMX-WF 	TCMX 09 02 02-WF	09	7/32			★					☆																								TCMX 1.8(1.5)0-WF					
		TCMX 09 02 04-WF					☆					★						★					☆								★				TCMX 1.8(1.5)1-WF						
		TCMX 09 02 08-WF					★																	★							★				TCMX 1.8(1.5)2-WF						
		TCMX 11 03 02-WF	11	1/4			★						☆						★														★			TCMX 220-WF					
		TCMX 11 03 04-WF					☆	☆				★						☆	★													★	☆		TCMX 221-WF						
		TCMX 11 03 08-WF					☆	☆				★						☆	☆	★												★	☆		TCMX 222-WF						
	 TCMT-PF	TCMX 16 T3 04-WF	16	3/8			☆					★					★							★							★				TCMX 3(2.5)1-WF						
		TCMX 16 T3 08-WF					☆	☆				★					☆	★														★			TCMX 3(2.5)2-WF						
		TCMT 06 T1 02-PF	06	5/32				☆				★	☆																							TCMT 1.2(1.2)0-PF					
		TCMT 06 T1 04-PF					☆					★	☆																						TCMT 1.2(1.2)1-PF						
		TCMT 06 T1 08-PF					☆					★	☆																						TCMT 1.2(1.2)2-PF						
		TCMT 09 02 02-PF	09	7/32			☆					★	☆																							TCMT 1.8(1.5)0-PF					
		TCMT 09 02 04-PF					☆					★	☆																						TCMT 1.8(1.5)1-PF						
		TCMT 11 03 02-PF	11	1/4			☆					★	☆																							TCMT 220-PF					
		TCMT 11 03 04-PF					☆					★	☆																							TCMT 221-PF					
		TCMT 11 03 08-PF					☆					★	☆																							TCMT 222-PF					
		TCMT 16 T3 04-PF	16	3/8			☆					★	☆																							TCMT 3(2.5)1-PF					
		 TCMT-MF	TCMT 06 T1 02-MF	06	5/32													☆	★													★	☆	☆		TCMT 1.2(1.2)					

★= First choice



A graph with v_c on the vertical axis and v_e on the horizontal axis. Two curves intersect: a blue curve that is convex to the origin and a red curve that is concave to the origin.

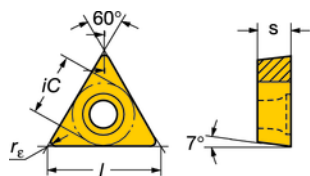


A2

CoroTurn® 107

Triangular

For dimensions, see code key on page A16.



		ISO		ic	P										M					K				N		S					ANSI						
					1025	1105	1125	1515	1525	235	4205	4215	4225	4235	5015	1025	1105	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	H10	H13A	1025	1105	1125	H10A	H13A			
	TCEx	TCEx 05 01 00L-F	05	1/8	☆	☆										☆	☆									☆									TCEx 1(1)00L-F		
		TCEx 05 01 00R-F			☆	☆										☆	☆									☆									TCEx 1(1)00R-F		
		TCEx 05 01 01L-F			☆	☆										☆	☆									☆									TCEx 1(1)03L-F		
		TCEx 05 01 01R-F			☆	☆										☆	☆									☆									TCEx 1(1)03R-F		
		TCEx 06 T1 00L-F	06	5/32	☆	☆										☆	☆									☆									TCEx 1.2(1.2)00L-F		
		TCEx 06 T1 00R-F			☆	☆										☆	☆									☆									TCEx 1.2(1.2)00R-F		
		TCEx 06 T1 01L-F			☆	☆										☆	☆									☆									TCEx 1.2(1.2)03L-F		
		TCEx 06 T1 01R-F			☆	☆										☆	☆									☆									TCEx 1.2(1.2)03R-F		
		TCEx 06 T1 02L-F			☆	☆										☆	☆									☆									TCEx 1.2(1.2)0L-F		
		TCEx 09 02 00L-F	09	7/32	☆	☆									☆	☆	☆									☆									TCEx 1.8(1.5)00L-F		
		TCEx 09 02 00R-F			☆	☆									☆	☆	☆									☆									TCEx 1.8(1.5)00R-F		
		TCEx 09 02 01L-F			☆	☆									☆	☆	☆									☆									TCEx 1.8(1.5)03L-F		
		TCEx 09 02 01R-F			☆	☆									☆	☆	☆									☆									TCEx 1.8(1.5)03R-F		
		TCEx 09 02 02L-F			☆	☆									☆	☆	☆									☆									TCEx 1.8(1.5)0L-F		
		TCEx 11 03 00L-F	11	1/4	☆	☆									☆	☆	☆									☆									TCEx 22(00)L-F		
		TCEx 11 03 00R-F			☆	☆									☆	☆	☆									☆									TCEx 22(00)R-F		
		TCEx 11 03 01L-F			☆	☆									☆	☆	☆									☆									TCEx 22(03)L-F		
		TCEx 11 03 01R-F			☆	☆									☆	☆	☆									☆									TCEx 22(03)R-F		
		TCEx 11 03 02L-F			☆	☆									☆	☆	☆									☆									TCEx 220L-F		
	TCGX-WK Wiper TECHNOLOGY	TCGX 06 T1 04L-WK	06	5/32			☆									☆	☆															☆	☆		TCGX 1.2(1.2)1L-WK		
		TCGX 06 T1 04R-WK					☆									☆	☆																☆	☆		TCGX 1.2(1.2)1R-WK	
		TCGX 09 02 04L-WK	09	7/32			☆								☆	☆	☆																☆	☆		TCGX 1.8(1.5)1L-WK	
		TCGX 09 02 04R-WK					☆								☆	☆	☆																☆	☆		TCGX 1.8(1.5)1R-WK	
		TCGX 11 02 04L-WK	11	1/4											☆	☆	☆																☆	☆		TCGX 2(1.5)1L-WK	
		TCGX 11 02 04R-WK													☆	☆	☆																☆	☆		TCGX 2(1.5)1R-WK	
		TCGX 11 03 04L-WK					☆								☆	☆	☆																☆	☆		TCGX 221L-WK	
		TCGX 11 03 04R-WK					☆								☆	☆	☆																☆	☆		TCGX 221R-WK	
	TCGT-K	TCGT 06 T1 02L-K	06	5/32			☆									☆	☆																		TCGT 1.2(1.2)0L-K		
		TCGT 06 T1 02R-K					☆									☆	☆																			TCGT 1.2(1.2)0R-K	
		TCGT 06 T1 04L-K					☆									☆	☆																			TCGT 1.2(1.2)1L-K	
		TCGT 06 T1 04R-K					☆									☆	☆																			TCGT 1.2(1.2)1R-K	
		TCGT 09 02 02L-K	09	7/32			☆	☆							☆	☆	☆																			TCGT 1.8(1.5)0L-K	
		TCGT 09 02 02R-K					☆	☆							☆	☆	☆																			TCGT 1.8(1.5)0R-K	
		TCGT 09 02 04L-K					☆	☆							☆	☆	☆																			TCGT 1.8(1.5)1L-K	
		TCGT 09 02 04R-K					☆	☆							☆	☆	☆																			TCGT 1.8(1.5)1R-K	
		TCGT 11 02 02L-K	11	1/4				☆							☆	☆	☆																			TCGT 2(1.5)0L-K	
		TCGT 11 02 02R-K													☆	☆	☆																			TCGT 2(1.5)0R-K	
		TCGT 11 02 04L-K						☆							☆	☆	☆																			TCGT 2(1.5)1L-K	
		TCGT 11 02 04R-K						☆							☆	☆	☆																			TCGT 2(1.5)1R-K	
		TCGT 11 03 02L-K					☆								☆	☆	☆																			TCGT 220L-K	
		TCGT 11 03 02R-K					☆								☆	☆	☆																			TCGT 220R-K	
		TCGT 11 03 04L-K					☆								☆	☆	☆																			TCGT 221L-K	
		TCGT 11 03 04R-K					☆								☆	☆	☆																			TCGT 221R-K	
	TCMT-UF	TCMT 06 T1 02-UF	06	5/32																																TCMT 1.2(1.2)0-UF	
		TCMT 06 T1 04-UF																																			TCMT 1.2(1.2)1-UF
		TCMT 09 02 04-UF	09	7/32											☆	☆																				TCMT 1.8(1.5)1-UF	
		TCMT 09 02 08-UF																																			TCMT 1.8(1.5)2-UF
		TCMT 11 02 02-UF	11	1/4											☆	☆	☆																			TCMT 2(1.5)0-UF	
		TCMT 11 02 04-UF													☆	☆	☆																			TCMT 2(1.5)1-UF	
		TCMT 11 02 08-UF													☆	☆	☆																			TCMT 2(1.5)2-UF	
		TCMT 16 T3 08-UF	16	3/8																																TCMT 3(2.5)2-UF	

★ = First choice

R = Right hand, L = Left hand



A102



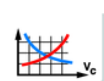
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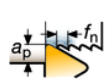
A351



I1



A516



A500



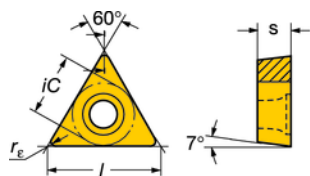
A524



A2

CoroTurn® 107

Triangular



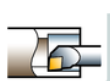
For dimensions, see code key on page A16.

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	TCMX-WM TECHNOLOGY Wiper	TCMX 11 03 04-WM	11	1/4			☆				★					★									★										TCMX 221-WM
		TCMX 11 03 08-WM									★	☆												★											TCMX 222-WM
		TCMX 16 T3 08-WM	16	3/8			☆			☆	★	☆											★	☆											TCMX 3(2.5)2-WM
	TCMT-PM	TCMT 09 02 04-PM	09	7/32			☆	☆			★	☆	☆																						TCMT 1.8(1.5)1-PM
		TCMT 09 02 08-PM					☆	☆			★	☆	☆																						TCMT 1.8(1.5)2-PM
		TCMT 11 03 04-PM	11	1/4			☆	☆			★	☆	☆																						TCMT 221-PM
		TCMT 11 03 08-PM					☆	☆			★	☆	☆																						TCMT 222-PM
		TCMT 11 03 12-PM									★																								TCMT 223-PM
		TCMT 16 T3 04-PM	16	3/8			☆	☆			★	☆	☆																						TCMT 3(2.5)1-PM
		TCMT 16 T3 08-PM					☆	☆		☆	★	☆	☆																						TCMT 3(2.5)2-PM
		TCMT 16 T3 12-PM					☆				★	☆	☆																						TCMT 3(2.5)3-PM
	TCMT-MM	TCMT 22 04 08-PM	22	1/2								★																							TCMT 432-PM
		TCMT 09 02 04-MM	09	7/32	☆											☆	☆	☆	☆	★	☆										★	☆		TCMT 1.8(1.5)1-MM	
		TCMT 09 02 08-MM			☆											☆	☆	☆	☆	★	☆										★	☆	☆	TCMT 1.8(1.5)2-MM	
		TCMT 11 03 04-MM	11	1/4												☆	☆	☆	★	☆											★	☆	☆	TCMT 221-MM	
		TCMT 11 03 08-MM														☆	☆	☆	★	☆											★	☆	☆	TCMT 222-MM	
		TCMT 16 T3 04-MM	16	3/8												☆	☆	☆	★	☆											★	☆	☆	TCMT 3(2.5)1-MM	
		TCMT 16 T3 08-MM														☆	☆	☆	★	☆											★	☆	☆	TCMT 3(2.5)2-MM	
		TCMT 16 T3 12-MM														☆	☆	★													★	☆		TCMT 3(2.5)3-MM	
	TCMT-KM	TCMT 22 04 08-MM	22	1/2																★														TCMT 432-MM	
		TCMT 09 02 04-KM	09	7/32													☆	★	☆	☆													☆	TCMT 1.8(1.5)1-KM	
		TCMT 09 02 08-KM															☆	★	☆	☆													☆	TCMT 1.8(1.5)2-KM	
		TCMT 11 03 04-KM	11	1/4													☆	★	☆	☆													☆	TCMT 221-KM	
		TCMT 11 03 08-KM															☆	★	☆	☆													☆	TCMT 222-KM	
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		TCGT 11 03 01-UM											☆																			★		TCGT 22(03)-UM	
		TCGT 11 03 02-UM					☆						☆																			★		TCGT 220-UM	
	TCMW	TCGT 11 03 04-UM					☆						☆																			★		TCGT 221-UM	
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		TCGT 16 T3 04-UM	16	3/8									☆																			★		TCGT 3(2.5)1-UM	
		TCGT 16 T3 08-UM											☆																			★		TCGT 3(2.5)2-UM	
	TCMT-UM	TCMW 11 02 04	11	1/4									☆																					TCMW 2(1.5)1	
		TCMW 11 03 04																																	TCMW 221
		TCMW 16 T3 04	16	3/8																															TCMW 3(2.5)1
		TCMW 16 T3 08											☆																						TCMW 3(2.5)2
	TCMT-UM	TCMT 09 02 04-UM	09	7/32			☆	☆			☆					☆	☆																		TCMT 1.8(1.5)1-UM
		TCMT 09 02 08-UM					☆				☆																								TCMT 1.8(1.5)2-UM
		TCMT 11 02 04-UM	11	1/4			☆				☆	☆	☆																						TCMT 2(1.5)1-UM
		TCMT 11 02 08-UM					☆				☆	☆	☆																						TCMT 2(1.5)2-UM
		TCMT 16 T3 04-UM	16	3/8			☆				☆	☆	☆																						TCMT 3(2.5)1-UM
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★ = First choice



A102



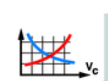
A254



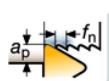
A351



I1



A516



A500



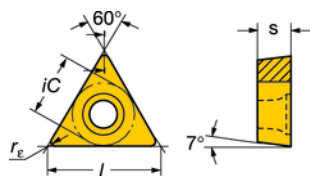
A524



A2

CoroTurn® 107

Triangular



For dimensions, see code key on page A16.

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						GC	GC	GC	GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC

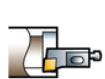
★ = First choice



A102



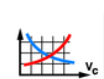
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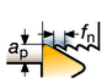
A351



I1



A516



A500



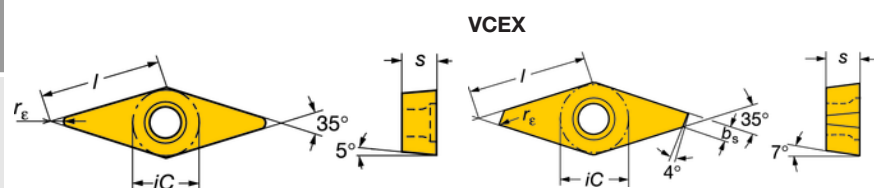
A524







A2

CoroTurn® 107

Rhombic 35°

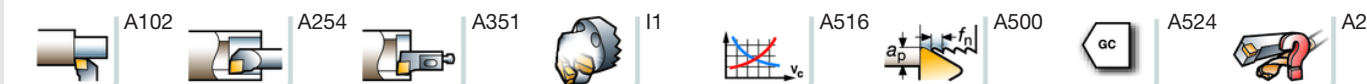


For dimensions, see code key on page A16.

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Finishing	 VBMT-PF	VBMT 11 03 02-PF	11	1/4			☆	☆			★	★	☆	☆																						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	
		VBMT 16 04 02-PF	16	3/8			☆						★																						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
	 VBMT-MF	VBMT 11 03 02-MF	11	1/4																										★	☆	☆			VBMT 220-MF	
		VBMT 11 03 04-MF												★	☆														★	☆	☆				VBMT 221-MF	
		VBMT 11 03 08-MF			☆								☆	☆	★	☆													★	☆					VBMT 222-MF	
		VBMT 16 04 02-MF	16	3/8										☆	★														★	☆	☆				VBMT 330-MF	
		VBMT 16 04 04-MF												☆	★	★	☆												★	☆	☆				VBMT 331-MF	
		VBMT 16 04 08-MF												☆	☆	★	☆												★	☆	☆				VBMT 332-MF	
		VBMT 16 04 12-MF													★															☆					VBMT 333-MF	
		 VBMT-KF	VBMT 11 03 02-KF	11	1/4																☆													☆		VBMT 220-KF
	VBMT 11 03 04-KF																			☆		★	☆										☆		VBMT 221-KF	
	VBMT 11 03 08-KF																			☆		★													VBMT 222-KF	
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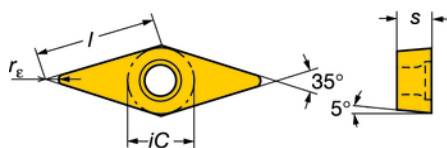
★= First choice

R = Right hand, L = Left hand













CoroTurn® 107

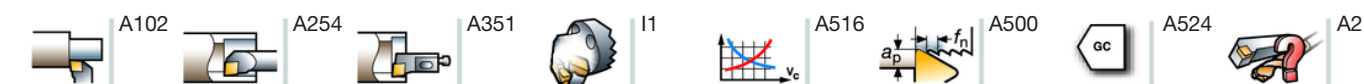
Rhombic 35°



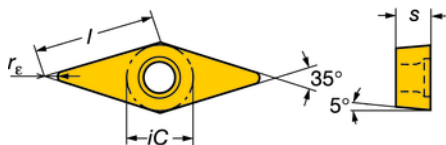
For dimensions, see code key on page A16.

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Medium	 VBGT-UM	VBGT 16 04 01-UM VBGT 16 04 02-UM VBGT 16 04 04-UM VBGT 16 04 08-UM	16	3/8			☆						☆	☆							☆	☆							★	☆	☆	☆	VBGT 3303-UM VBGT 330-UM VBGT 331-UM VBGT 332-UM
	 VCET-UM	VCET 11 03 01-UM VCET 11 03 02-UM	11	1/4	★						☆	★	☆												☆			★	☆			VCET 22(03)-UM VCET 220-UM	
	 VCGT-UM	VCGT 11 03 01-UM VCGT 11 03 02-UM VCGT 11 03 04-UM	11	1/4			☆					☆	☆								☆	☆							★	☆	☆	VCGT 2203-UM VCGT 220-UM VCGT 221-UM	
	 VBMW	VBMW 16 04 04	16	3/8																	☆										☆	VBMW 331	
	 VBMT-UM	VBMT 16 04 04-UM VBMT 16 04 08-UM VBMT 16 04 12-UM	16	3/8		☆	☆		☆	☆	☆		☆	☆		☆					☆	☆							☆	☆	☆	☆	VBMT 331-UM VBMT 332-UM VBMT 333-UM
	Roughing	 VBMT-PR	VBMT 16 04 08-PR VBMT 16 04 12-PR	16	3/8				☆	☆	★	☆																					VBMT 332-PR VBMT 333-PR
		 VBMT-MR	VBMT 16 04 08-MR VBMT 16 04 12-MR	16	3/8									☆	★	☆													★				VBMT 332-MR VBMT 333-MR
		 VBMT-KR	VBMT 16 04 08-KR VBMT 16 04 12-KR	16	3/8														☆	★	☆	☆										☆	VBMT 332-KR VBMT 333-KR
		 VBMT-UR	VBMT 16 04 04-UR VBMT 16 04 08-UR VBMT 16 04 12-UR	16	3/8					☆	☆	☆					☆					☆	☆									☆	VBMT 331-UR VBMT 332-UR VBMT 333-UR



★ = First choice



Rhombic 35°



For dimensions, see code key on page A16.

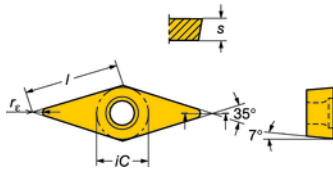
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					GC	GC	GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		GC		
					1125	1515	1525	4205	4215	4225	4235	5015	1105	1115	1125	2015	2025	2035	235	3005	3205	3210	3215	H13A	1005	1020	1125	H10	1105	1115		1125	H13A	S05F
Aluminium	VCGX-AL	VCGX 11 02 02-AL	11	1/4																					*						VCGX 2(1.5)0-AL			
		VCGX 11 02 04-AL																							*						VCGX 2(1.5)1 -AL			
		VCGX 11 03 02-AL																							*						VCGX 220-AL			
		VCGX 11 03 04-AL																							*						VCGX 221-AL			
		VCGX 16 04 04-AL	16	3/8																			☆	☆	*						VCGX 331-AL			
		VCGX 16 04 08-AL																					☆	☆	*						VCGX 332-AL			
		VCGX 16 04 12-AL																					☆	☆	*						VCGX 333-AL			
		VCGX 22 05 20-AL	22	1/2																					*						VCGX 22 05 20-AL			
		VCGX 22 05 30-AL																							*						VCGX 22 05 30-AL			
					P25	P25	P15	P05	P15	P25	P35	P10	M15	M15	M25	M15	M25	M35	M35	K10	K05	K10	K15	K20	N10	N25	N25	N15	S15	S20	S25	S15	S05	

★= First choice

CoroTurn® 107

Rhombic 35°

For dimensions, see code key on page A16.

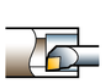


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					1515	1525	4215	4235	4235	5015	1125	2015	2025	3215
Finishing	VCMT-PF	ISO												ANSI
		VCMT 11 03 02-PF	11	1/4	☆					★				VCMT 220-PF
		VCMT 11 03 04-PF			☆	★	☆		☆					VCMT 221-PF
	VCMT-MF	VCMT 11 03 02-MF	11	1/4							★			VCMT 220-MF
		VCMT 11 03 04-MF								☆	★			VCMT 221-MF
	VCMT-KF	VCMT 11 03 04-KF	11	1/4									★	VCMT 221-KF
Medium	VCMT-PM	VCMT 11 03 04-PM	11	1/4		☆	☆	★	☆					VCMT 221-PM
		VCMT 11 03 08-PM			☆		☆	★						VCMT 222-PM
	VCMT-MM	VCMT 11 03 04-MM	11	1/4							☆	★		VCMT 221-MM
		VCMT 11 03 08-MM										★		VCMT 222-MM
	VCMT-KM	VCMT 11 03 08-KM	11	1/4									★	VCMT 222-KM
					P25	P15	P15	P25	P35	P10	M25	M15	M25	K15

★ = First choice



A102



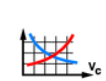
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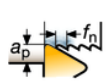
A351



I1



A516



A500



A524

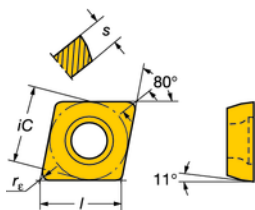


A2

CoroTurn® 111

Rhombic 80°

For dimensions, see code key on page A16.

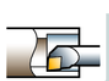


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	ISO		iC		1515	4215	4225	4235	5015	1125	2015	2025	2035	3215	H13A	-	H13A	-
Finishing	CPMT-PF	CPMT 06 02 02-PF CPMT 06 02 04-PF CPMT 09 T3 02-PF CPMT 09 T3 04-PF CPMT 09 T3 08-PF	06 09	1/4 3/8	★ ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★
	CPMT-MF	CPMT 06 02 02-MF CPMT 06 02 04-MF CPMT 09 T3 02-MF CPMT 09 T3 04-MF CPMT 09 T3 08-MF	06 09	1/4 3/8	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★
	CPMT-KF	CPMT 06 02 04-KF	06	1/4	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★	 ★ ★ ★ ★
Medium	CPMT-PM	CPMT 06 02 04-PM CPMT 06 02 08-PM CPMT 09 T3 04-PM CPMT 09 T3 08-PM	06 09	1/4 3/8	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★	★ ★ ★ ★
	CPMT-MM	CPMT 06 02 04-MM CPMT 06 02 08-MM CPMT 09 T3 04-MM CPMT 09 T3 08-MM	06 09	1/4 3/8	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★	 ★ ★ ★
	CPMT-KM	CPMT 06 02 04-KM CPMT 06 02 08-KM	06	1/4	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★	 ★ ★
	CPMT-UM	CPMT 06 02 04-UM CPMT 06 02 08-UM CPMT 09 T3 02-UM CPMT 09 T3 04-UM CPMT 09 T3 08-UM	06 09	1/4 3/8	★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★	 ★ ★ ★ ★ ★

★ = First choice



A102



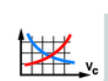
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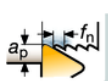
A351



I1



A516



A500



A524

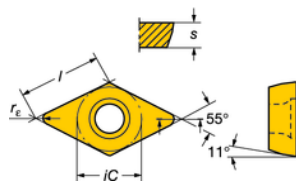


A2

CoroTurn® 111

Rhombic 55°

For dimensions, see code key on page A16.



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					GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	H13A	H13A	
Finishing	DPMT-PF	ISO	07	1/4	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	DPMT 2(1.5)0-PF DPMT 2(1.5)1-PF
		DPMT 07 02 02-PF			☆																
		DPMT 07 02 04-PF			☆	★	☆		☆												
Finishing	DPMT-MF	ISO	07	1/4							★	★	☆								DPMT 2(1.5)0-MF DPMT 2(1.5)1-MF
		DPMT 07 02 02-MF									★	★	☆								
		DPMT 07 02 04-MF									☆	★	☆								
Finishing	DPMT-KF	ISO	07	1/4														★			DPMT 2(1.5)1-KF
		DPMT 07 02 04-KF																★			
Medium	DPMT-PM	ISO	07	1/4	☆	☆	★														DPMT 2(1.5)1-PM DPMT 2(1.5)2-PM DPMT 3(2.5)1-PM DPMT 3(2.5)2-PM
		DPMT 07 02 04-PM			☆	☆	★														
		DPMT 07 02 08-PM			☆	☆	★	☆	☆												
		DPMT 11 T3 04-PM	11	3/8	☆	☆	★														
	DPMT-MM	ISO	07	1/4							☆	★	☆		★	☆					DPMT 2(1.5)1-MM DPMT 2(1.5)2-MM DPMT 3(2.5)1-MM DPMT 3(2.5)2-MM
		DPMT 07 02 04-MM									☆	★	☆		★	☆					
		DPMT 07 02 08-MM									☆	★	☆		★	☆					
		DPMT 11 T3 04-MM	11	3/8							☆	★	☆		★	☆					
Medium	DPMT-KM	ISO	07	1/4														★	☆		DPMT 2(1.5)1-KM DPMT 2(1.5)2-KM DPMT 3(2.5)1-KM DPMT 3(2.5)2-KM
		DPMT 07 02 04-KM																★	☆		
		DPMT 07 02 08-KM																★	☆		
		DPMT 11 T3 04-KM	11	3/8														★	☆		

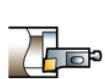
★ = First choice



A102



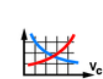
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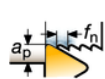
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I1



A516



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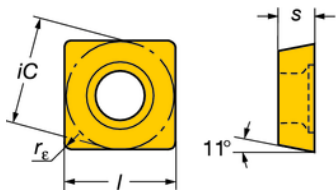


A524



A2

Square



B

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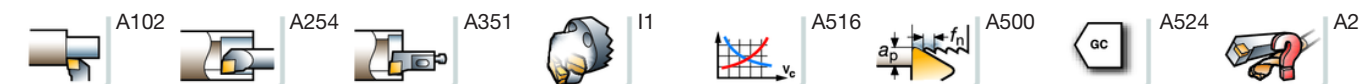
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G

H

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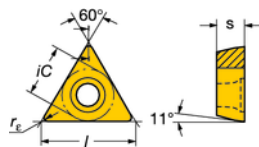
J



CoroTurn® 111

Triangular

For dimensions, see code key on page A16.



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Finishing	TPMT-PF	TPMT 06 T1 02-PF	06	5/32	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.2(1.2)0-PF
		TPMT 06 T1 04-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.2(1.2)1-PF
		TPMT 09 02 02-PF	09	7/32	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.8(1.5)0-PF
		TPMT 09 02 04-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.8(1.5)1-PF
		TPMT 11 03 02-PF	11	1/4	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TPMT 220-PF
		TPMT 11 03 04-PF			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TPMT 221-PF
	TPMT-MF	TPMT 16 T3 04-PF	16	3/8	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TPMT 3(2.5)1-PF
		TPMT 06 T1 02-MF	06	5/32						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.2(1.2)0-MF
		TPMT 06 T1 04-MF								☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.2(1.2)1-MF
		TPMT 09 02 02-MF	09	7/32						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.8(1.5)0-MF
		TPMT 09 02 04-MF								☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.8(1.5)1-MF
		TPMT 11 03 02-MF	11	1/4						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 220-MF
Medium	TPMT-KF	TPMT 11 03 04-MF								☆	☆	☆	☆	☆	☆	☆	☆	TPMT 221-MF
		TPMT 16 T3 04-MF	16	3/8						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 3(2.5)1-MF
		TPMT 06 T1 04-KF	06	5/32										☆	☆	☆	☆	TPMT 1.2(1.2)1-KF
		TPMT 09 02 04-KF	09	7/32										☆	☆	☆	☆	TPMT 1.8(1.5)1-KF
		TPMT 11 03 04-KF	11	1/4										☆	☆	☆	☆	TPMT 221-KF
		TPMT 16 T3 04-KF	16	3/8										☆	☆	☆	☆	TPMT 3(2.5)1-KF
	TPMT-PM																	
		TPMT 09 02 04-PM	09	7/32	☆	☆	☆	☆	☆									TPMT 1.8(1.5)1-PM
		TPMT 09 02 08-PM																TPMT 1.8(1.5)2-PM
		TPMT 11 03 04-PM	11	1/4	☆	☆	☆	☆	☆									TPMT 221-PM
		TPMT 11 03 08-PM																TPMT 222-PM
		TPMT 16 T3 04-PM	16	3/8														TPMT 3(2.5)1-PM
Medium	TPMT-MM	TPMT 16 T3 08-PM			☆	☆	☆	☆	☆									TPMT 3(2.5)2-PM
		TPMT 09 02 04-MM	09	7/32						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 1.8(1.5)1-MM
		TPMT 11 03 04-MM	11	1/4						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 221-MM
		TPMT 11 03 08-MM								☆	☆	☆	☆	☆	☆	☆	☆	TPMT 222-MM
		TPMT 16 T3 04-MM	16	3/8						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 3(2.5)1-MM
		TPMT 16 T3 08-MM								☆	☆	☆	☆	☆	☆	☆	☆	TPMT 3(2.5)2-MM
	TPMT-KM																	
		TPMT 09 02 04-KM	09	7/32										☆	☆	☆	☆	TPMT 1.8(1.5)1-KM
		TPMT 09 02 08-KM												☆	☆	☆	☆	TPMT 1.8(1.5)2-KM
		TPMT 11 03 08-KM	11	1/4										☆	☆	☆	☆	TPMT 222-KM
		TPMT 16 T3 08-KM	16	3/8										☆	☆	☆	☆	TPMT 3(2.5)2-KM
		TPMT 16 T3 12-KM												☆	☆	☆	☆	TPMT 3(2.5)3-KM
Medium	TPMT-UM																	
		TPMT 11 02 04-UM	11	1/4						☆	☆	☆	☆	☆	☆	☆	☆	TPMT 2(1.5)1-UM
		TPMT 11 02 08-UM								☆	☆	☆	☆	☆	☆	☆	☆	TPMT 2(1.5)2-UM
		TPMT 16 T3 08-UM	16	3/8	☆	☆	☆	☆	☆									TPMT 3(2.5)2-UM
		TPMT 22 04 08-UM	22	1/2	☆	☆	☆	☆	☆									TPMT 432-UM
					P25	P15	P25	P35	P10	M25	M15	M35	K15	K20	S25	S15		

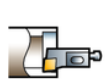
★ = First choice



A102



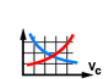
A254



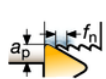
A351



I1



A516



A500



A524

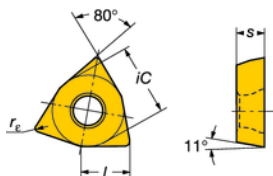







A2

CoroTurn® 111

Trigon 80°

For dimensions, see code key on page A16.



					iC	P				M				K	ANSI
						GC	GC	GC	CT	GC	GC	GC	GC		
		ISO				1515	4215	4225	5015	1125	2015	2025	3215		
Finishing	 WPMT-PF	WPMT 02 01 02-PF	02	5/32	☆				★						WPMT 1.2(1)0-PF
		WPMT 02 01 04-PF			☆	★	☆								WPMT 1.2(1)1-PF
		WPMT 04 02 02-PF	04	1/4	☆				★						WPMT 2(1.5)0-PF
		WPMT 04 02 04-PF			☆	★	☆								WPMT 2(1.5)1-PF
	 WPMT-MF	WPMT 02 01 02-MF	02	5/32						★					WPMT 1.2(1)0-MF
		WPMT 02 01 04-MF								☆	★	☆			WPMT 1.2(1)1-MF
		WPMT 04 02 02-MF	04	1/4						★					WPMT 2(1.5)0-MF
		WPMT 04 02 04-MF								★					WPMT 2(1.5)1-MF
	 WPMT-KF	WPMT 04 02 04-KF	04	1/4									★		WPMT 2(1.5)1-KF
Medium	 WPMT-PM	WPMT 04 02 04-PM	04	1/4				★							WPMT 2(1.5)1-PM
		WPMT 04 02 08-PM						★							WPMT 2(1.5)2-PM
	 WPMT-MM	WPMT 04 02 04-MM	04	1/4						☆	★				WPMT 2(1.5)1-MM
		WPMT 04 02 08-MM								☆	★				WPMT 2(1.5)2-MM
						P25	P15	P25	P10	M25	M15	M25	K15		

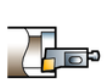
★ = First choice



A102



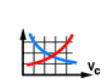
A254



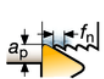
A351



I1



A516



A500

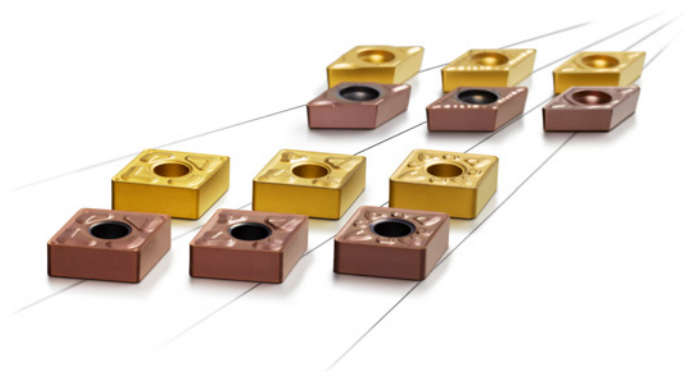


A524



A2

Multi-material inserts



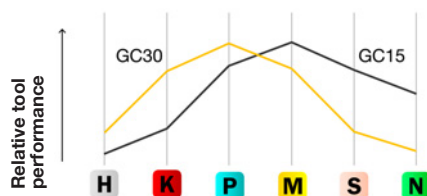
If you have a flexible production with many different materials and components, these inserts are something for you. With a minimum set of geometries and grades, you have a simplified choice of inserts that are designed to efficiently machine different materials in various cutting conditions.

Technical features

- Geometries are designed to meet a wide application area in terms of feed rates, depths of cut
- Two grades, GC15 and GC30, that provide secure performance also in difficult cuts in most workpiece materials

GC30

- Steel
- Long times in cut
- Abrasive materials
- Moderate to low cutting data



T-Max P geometries:



Finishing -XF

- Designed for light cutting action
- Optimum chip breaking when finishing
- Smooth chip forming in medium machining



Medium -XM

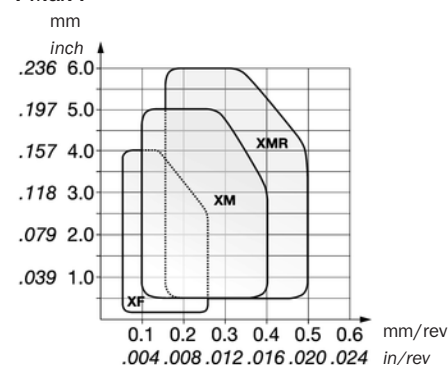
- Light cutting, strong geometry for flexible machining
- Balanced edge rounding for medium rough to finish machining
- Chip former for medium rough to finish machining



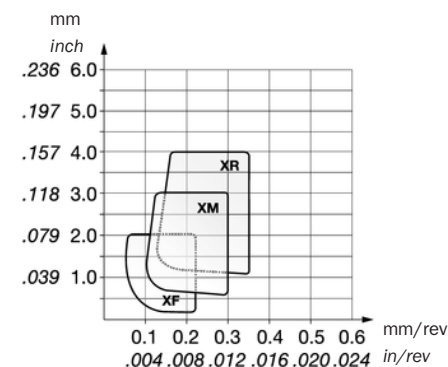
Medium roughing -XMR

- Re-inforced cutting edge for toughness demanding operations
- Strong 100° corner for security in high feed operations
- Large contact surfaces for secure and stable machining

T-Max P



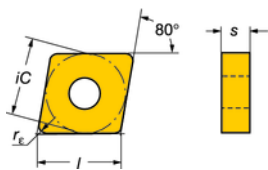
CoroTurn 107



GC15

- Stainless steel, HRSA
- Interrupted cuts
- Small components
- Moderate to low cutting data

T-Max P

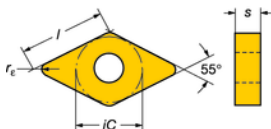


For dimensions, see code key on page A16.

Rhombic 80°

		ISO	iC	1/2	P	M	K	S	ANSI
					GC15 GC30	GC15 GC30	GC15 GC30	GC15 GC30	
Finishing		CNMG 12 04 04-XF	12	1/2	★	★	★	★	CNMG 431-XF
		CNMG 12 04 08-XF			★	★	★	★	CNMG 432-XF
Medium		CNMG 12 04 04-XM	12	1/2	★	★	★	★	CNMG 431-XM
		CNMG 12 04 08-XM			★	★	★	★	CNMG 432-XM
		CNMG 12 04 12-XM			★	★	★	★	CNMG 433-XM
Roughing		CNMG 12 04 08-XMR	12	1/2	★	★	★	★	CNMG 432-XMR
		CNMG 12 04 12-XMR			★	★	★	★	CNMG 433-XMR
		CNMG 12 04 16-XMR			★	★	★	★	CNMG 434-XMR
		CNMG 16 06 12-XMR	16	5/8	★	★	★	★	CNMG 543-XMR
		CNMG 16 06 16-XMR			★	★	★	★	CNMG 544-XMR
		CNMG 19 06 12-XMR	19	3/4	★	★	★	★	CNMG 643-XMR
		CNMG 19 06 16-XMR			★	★	★	★	CNMG 644-XMR
					P20	P30	M25	M20	
					K05	K10	K15	K40	
					S15	S20	S25	S20	
					S15	S15	S05F	S05	

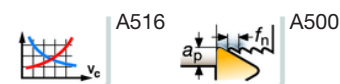
★ = First choice



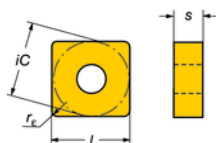
Rhombic 55°

		ISO	iC	1/2	P	M	K	S	ANSI
					GC15 GC30	GC15 GC30	GC15 GC30	GC15 GC30	
Finishing		DNMG 15 04 04-XF	15	1/2	★	★	★	★	DNMG 431-XF
		DNMG 15 04 08-XF			★	★	★	★	DNMG 432-XF
		DNMG 15 06 04-XF			★	★	★	★	DNMG 441-XF
		DNMG 15 06 08-XF			★	★	★	★	DNMG 442-XF
Medium		DNMG 15 04 04-XM	15	1/2	★	★	★	★	DNMG 431-XM
		DNMG 15 04 08-XM			★	★	★	★	DNMG 432-XM
		DNMG 15 06 04-XM			★	★	★	★	DNMG 441-XM
		DNMG 15 06 08-XM			★	★	★	★	DNMG 442-XM
					P20	P30	M15	M20	
					K05	K10	K15	K40	
					S15	S20	S25	S20	
					S15	S15	S05F	S05	

★ = First choice

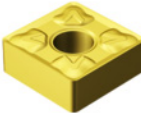

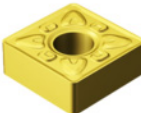


T-Max P

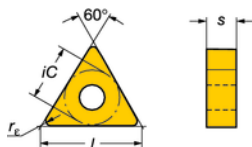


For dimensions, see code key on page A16.



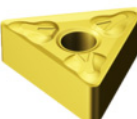
Square

						P		M		K		S									
						GC15	GC30	GC2025	GC15	GC30	GC3205	GC3210	GC3215	GC30	GC1105	GC1115	GC15	H13A	S05F		
Medium		ISO		i/C		☆	★		★	☆				☆			★			ANSI	
		SNMG 12 04 08-XM	12	1/2		☆	★		★	☆					☆			★			SNMG 432-XM
		SNMG 12 04 12-XM				☆	★		★	☆					☆			★			SNMG 433-XM
Roughing		SNMG 12 04 08-XMR	12	1/2	☆	★		★	☆					☆			★			SNMG 432-XMR	
		SNMG 12 04 12-XMR			☆	★		★	☆					☆			★			SNMG 433-XMR	
		SNMG 12 04 16-XMR			☆	★		★	☆					☆			★			SNMG 434-XMR	
		SNMG 19 06 12-XMR	19	3/4	☆	★		★	☆					☆			★			SNMG 643-XMR	
		SNMG 19 06 16-XMR			☆	★		★	☆					☆			★			SNMG 644-XMR	
					P20	P30	M25	M15	M20	K05	K10	K15	K40	S15	S20	S25	S15	S05			

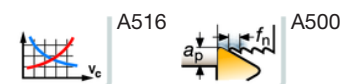
★= First choice



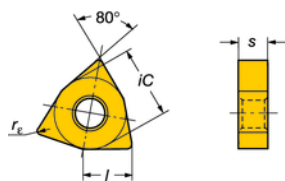
Triangular

		ISO		r/c	P	M	K			S					ANSI				
					GC15	GC30	GC15	GC30	3205	3210	3215	GC30	1105	1115		1125	GC15	H13A	S05F
Finishing		TNMG 16 04 04-XF	16	3/8	☆	★	★	☆						★				TNMG 331-XF	
		TNMG 16 04 08-XF			☆	★	★	☆					☆		★			TNMG 332-XF	
		TNMG 16 04 12-XF			☆	★	★	☆					☆		★			TNMG 333-XF	
Medium		TNMG 16 04 04-XM	16	3/8	☆	★	★	☆					☆		★			TNMG 331-XM	
		TNMG 16 04 08-XM			☆	★	★	☆					☆		★			TNMG 332-XM	
		TNMG 16 04 12-XM			☆	★	★	☆					☆		★			TNMG 333-XM	
					P20	P30	M15	M20	K05	K10	K15	K40	S15	S20	S25	S20	S15	S05	

★= First choice



T-Max P

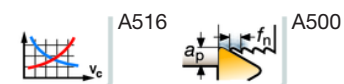


For dimensions, see code key on page A16.

Trigon 80°

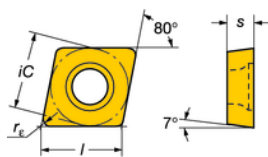
		ISO	Δ	iC	P	M	K	S	ANSI
					GC15 GC30	GC15 GC30	GC15 GC30	GC15 GC30	
Finishing		WNMG 08 04 04-XF	08	1/2	☆	★	☆	☆	★ WNMG 431-XF
		WNMG 08 04 08-XF			☆	★	☆	☆	★ WNMG 432-XF
Medium		WNMG 08 04 04-XM	08	1/2	☆	★	☆	☆	★ WNMG 431-XM
		WNMG 08 04 08-XM			☆	★	☆	☆	★ WNMG 432-XM
		WNMG 08 04 12-XM			☆	★	☆	☆	★ WNMG 433-XM
G					P20	M15	K05	K10	
					P30	M20	K10	K15	
							K40	K40	
							S20	S20	

★ = First choice



CoroTurn 107

For dimensions, see code key on page A16.



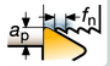
Rhombic 80°

					P				M				K				S				
					GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
		ISO		iC	1105	1125	GC15	GC30	1105	1115	1125	GC15	GC30	3205	3210	3215	GC30	1105	1115	GC15	ANSI
Finishing		CCMT 09 T3 04-XF	09	3/8			☆	★				★	☆				☆			★	CCMT 3(2.5)1-XF
		CCMT 09 T3 08-XF					☆	★				★	☆				☆			★	CCMT 3(2.5)2-XF
Medium		CCMT 09 T3 04-XM	09	3/8			☆	★				★	☆				☆			★	CCMT 3(2.5)1-XM
		CCMT 09 T3 08-XM					☆	★				★	☆				☆			★	CCMT 3(2.5)2-XM
Roughing		CCMT 09 T3 08-XR	09	3/8			☆	★				★	☆				☆			★	CCMT 3(2.5)2-XR
		CCMT 09 T3 12-XR					☆	★				★	☆				☆			★	CCMT 3(2.5)3-XR
					P25	P20	P30	M15	M15	M25	M15	M20	K05	K10	K15	K40	S15	S20	S20		

★ = First choice

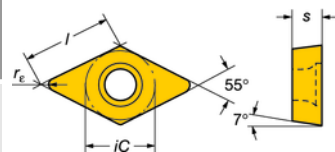


A516



A500

CoroTurn 107

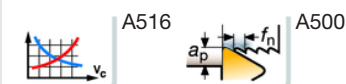


For dimensions, see code key on page A16.

Rhombic 55°

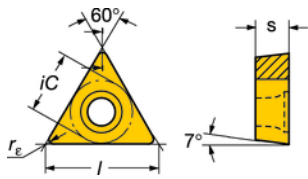
		ISO		iC	P			M			K			S			ANSI				
					GC15	GC15	GC30	GC15	GC15	GC30	GC15	GC15	GC30	H13A	GC15	GC15		H13A			
Finishing		DCMT 11 T3 04-XF	11	3/8		☆	★		★	☆			☆		★		DCMT 3(2.5)1-XF				
		DCMT 11 T3 08-XF				☆	★		★	☆			☆		★		DCMT 3(2.5)2-XF				
Medium		DCMT 11 T3 04-XM	11	3/8		☆	★		★	☆			☆		★		DCMT 3(2.5)1-XM				
		DCMT 11 T3 08-XM				☆	★		★	☆			☆		★		DCMT 3(2.5)2-XM				
Roughing		DCMT 11 T3 08-XR	11	3/8		☆	★		★	☆			☆		★		DCMT 3(2.5)2-XR				
		DCMT 11 T3 12-XR				☆	★		★	☆			☆		★		DCMT 3(2.5)3-XR				
						P25	P20	P30	M15	M25	M15	M20	K05	K10	K15	K40	K20	S15	S25	S20	S15

★= First choice


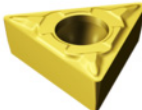
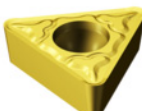
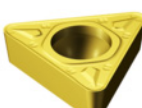


CoroTurn 107

For dimensions, see code key on page A16.



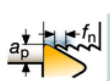
Triangular

		ISO		iC	P				M								K				S				ANSI	
					GC105	GC1125	CT	GC15	GC30	GC105	GC1115	GC1125	GC2015	GC2025	GC2035	GC15	GC30	GC3205	GC3210	GC3215	GC30	GC105	GC1115	GC1125		GC15
Finishing		TCMT 11 03 04-XF	11	1/4				☆	★							★	☆				☆				★	TCMT 221-XF
		TCMT 11 03 08-XF						☆	★							★	☆				☆				★	TCMT 222-XF
Medium		TCMT 11 03 04-XM	11	1/4				☆	★							★	☆				☆				★	TCMT 221-XM
		TCMT 11 03 08-XM						☆	★							★	☆				☆				★	TCMT 222-XM
Roughing		TCMT 16 T3 08-XR	16	3/8				☆	★							★	☆				☆				★	TCMT 3(2.5)2-XR
		TCMT 16 T3 12-XR						☆	★							★	☆				☆				★	TCMT 3(2.5)3-XR
						P25	P10	P20	P30	M15	M15	M25	M15	M25	M35	M15	M20	K05	K10	K15	K40	S15	S20	S25	S20	

★ = First choice

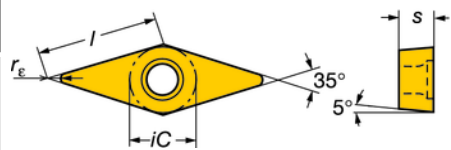


A516




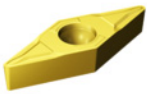
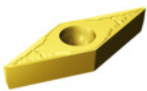

A500

CoroTurn 107

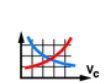


For dimensions, see code key on page A16.

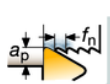
Rhombic 35°

		ISO		iC	P				M				K				S				ANSI					
					1105	1515	GC15	GC30	1105	1115	1125	2015	2025	GC15	GC30	3205	3210	3215	GC30	H13A		+	1105	1115	1125	GC15
Finishing		VBMT 16 04 04-XF	16	3/8		☆	★							★	☆									★		VBMT 331-XF
		VBMT 16 04 08-XF				☆	★							★	☆				☆					★		VBMT 332-XF
Medium		VBMT 16 04 04-XM	16	3/8		☆	★							★	☆				☆					★		VBMT 331-XM
		VBMT 16 04 08-XM				☆	★							★	☆				☆					★		VBMT 332-XM
Roughing		VBMT 16 04 08-XR	16	3/8		☆	★							★	☆				☆					★		VBMT 332-XR
		VBMT 16 04 12-XR				☆	★							★	☆				☆					★		VBMT 333-XR
						P25	P20	P30	M15	M15	M25	M15	M25	M15	M20	K05	K10	K15	K40	K20	S15	S20	S25	S20	S15	

★ = First choice



A516

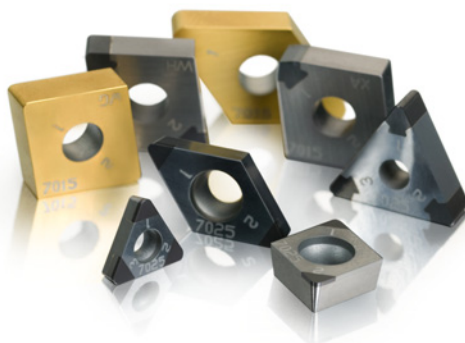


A500

Advanced cutting materials

In negative and positive basic-shape inserts

Cubic Boron Nitride (CBN) and ceramic inserts for the machining of hardened steel, cast iron and heat resistant super alloys. Polycrystalline diamond (PCD) for machining of nonferrous materials.



Cubic Boron Nitride (CBN)

Unique CBN grade chain for hand part turning (HPT) with materials designed for high performance in target application area. Available in both positive and negative basic shape inserts.

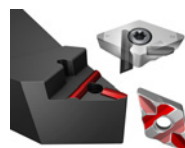
Ceramics

The ceramic grade chain includes solutions for machining cast iron, heat resistant super alloys and hardened materials. Available as negative basic shape inserts.

Polycrystalline Diamond (PCD)

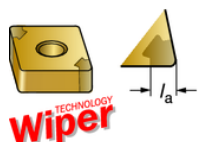
Effective in the machining of non-ferrous materials. Available as positive basic-shape inserts.

CoroTurn® TR



CoroTurn inserts with CBN add a new dimension to hard part profile turning. The T-rail insert interface provides the stability essential for this demanding application area to improve component tolerances. For ordering see CoroTurn TR section in this chapter.

Wiper and Xcel



Xcel

Our patented wiper and Xcel inserts drive surface quality and productivity forward. Wiper inserts generate the same surface finish as a regular insert but at up to three times higher feed rate. Xcel takes the wiper concept further in open cuts at high stability and generates excellent surface finish at even higher feed rates.



Even more options in turning inserts are available thanks to tailored design. For more information on our Tailor Made program go to our website, www.sandvik.coromant.com.

Other Machining Areas:

CoroCut®



CBN, ceramic and PCD inserts available, see chapter B.

CoroThread



V-profile inserts in CBN are available, see chapter C.

Additional code key information for advanced materials









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

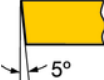
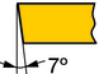
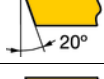
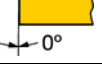
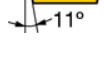
Inch

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

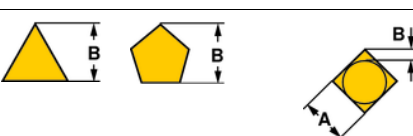
3 Tolerances, metric

Class	s	iC / iW
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		
6.35		
8.0		
9.525		
10.0		
12.0		
12.7		
15.875		
16.0		
19.05		
20.0		
25.0		
25.4		
31.75		
32.0		

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









R	S	T	W
			
iC mm	iC mm	iC mm	iC mm
3.18			
3.97			
5.0			
6.0			
6.35			
8.0			
9.525			
10.0			
12.0			
12.7			
15.875			
16.0			
19.0			
20.0			
25.0			
25.4			
31.75			
32			

Cutting edge length, inch

C	D	L	M	V	W	X	Y	Z
								
iC mm	iC mm	iC mm	iC mm	iC mm	iC mm	iC mm	iC mm	iC mm
3.18								
3.97								
5.0								
6.0								
6.35								
8.0								
9.525								
10.0								
12.0								
12.7								
15.875								
16.0								
19.0								
20.0								
25.0								
25.4								
31.75								
32								

For rectangular and rhombic inserts cutting edge length is indicated in mm.

Cutting edge length, metric

		C	D	R	S	T	V	W	K
iC mm	iC inch								
3.18	1/8"					05			
3.97	5/32"					06			
5.0				05					
6.0			06	09					
6.35	1/4"	06	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					

¹⁾ For insert shape K (KNMX, KNUX) only the theoretical cutting edge length is indicated.

¹⁾ Metric base design

²⁾ Inch base design

<div>6</div> <div>Insert thickness, s mm, inch</div> <div><div><div><div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></div><div></d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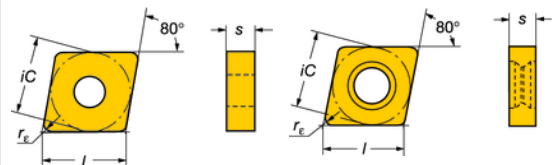
Negative basic-shape inserts

Negative basic inserts - T-MAX® P

Rhombic 80°


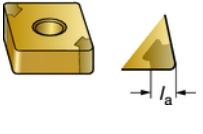
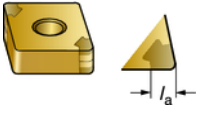




CNGA

CNGQ



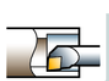
For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

	ISO	12	1/2	I _a mm	I _a inch	K				S	H						ANSI
						CC	CC	CC	CC	CC	CC	CC	CC	CC	CC	CB	
	CNGA120408S02035AWH			2.0	.079										☆		CNGA432S0835AWH
	CNGA090308S02035A	09	3/8	2.0	.079										☆		CNGA322S0835A
	CNGA120404S02035A	12	1/2	1.8	.071										☆		CNGA431S0835A
	CNGA120408S02035A			2.7	.106									☆	☆		CNGA432S0835A
	CNGA120412S02035A			2.7	.106									☆	☆		CNGA433S0835A
	CNGA120416S02035A			2.7	.106										☆		CNGA434S0835A
	CNGA120404S02035B	12	1/2	2.8	.11										☆		CNGA431S0835B
	CNGA120408S01530B			2.0	.079										☆		CNGA432S0630B
	CNGA120408S02035B			2.0	.079										☆		CNGA432S0835B
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	CNGA120412S02035B			2.3	.091										☆		CNGA433S0835B
	CNGA120404T01020BWG	12	1/2	2.8	.11				☆						☆		CNGA431T0320BWG
	CNGA120408T01020BWG			2.7	.106				☆						☆		CNGA432T0320BWG
	CNGA120408T01020WG	12	1/2				☆		☆	☆		☆					CNGA432T0320WG
	CNGA120412T01020WG						☆		☆	☆		☆					CNGA433T0320WG
	CNGA120416T01020WG						☆										CNGA434T0320WG
	CNGQ 120708 T02520WG	12	1/2				☆										CNGQ452T0820WG
	CNGQ120712T02520WG						☆										CNGQ453T0820WG
	CNGA120404S01525WH	12	1/2							☆							CNGA431S0625WH
	CNGA120408S01525WH									☆							CNGA432S0625WH
	CNGA120412S01525WH									☆							CNGA433S0625WH
	CNGA120408T01525WH									☆							CNGA432T0625WH
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A102



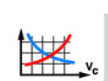
A254



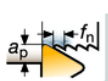
A351



I1



A516



A500



A524



A2

Negative basic-shape inserts

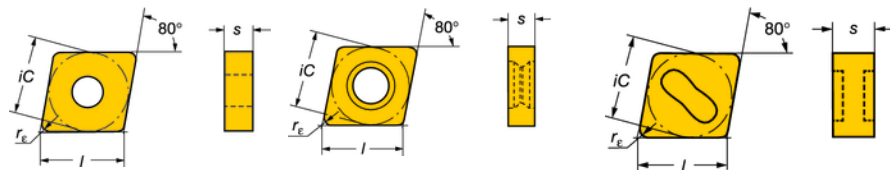
Negative basic inserts - T-MAX® P

Rhombic 80°

CNGA

CNGQ

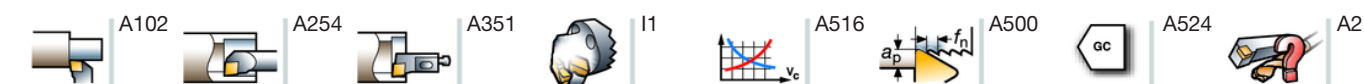
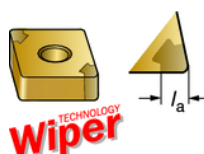
CNGX



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

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	CNGA 12 04 08S01525											☆				CNGA432S0625
	CNGA 12 04 12S01525											☆				CNGA433S0625
	CNGA 12 04 08T01525											☆				CNGA432T0625
	CNGA 12 04 08T01020	12	1/2							☆	☆	☆				CNGA432T0320
	CNGA 12 04 12T01020									☆	☆	☆				CNGA433T0320
	CNGA 12 04 16T01020									☆	☆	☆				CNGA434T0320
	CNGA 16 06 08T01020	16	5/8							☆	☆	☆				CNGA542T0320
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	CNGA 12 04 08T02520	12	1/2			☆	☆	☆								CNGA432T0820
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	CNGA 12 04 16T02520					☆	☆									CNGA434T0820
	CNGA 16 06 12T02520	16	5/8							☆						CNGA543T0820
	CNGA 16 06 16T02520									☆						CNGA544T0820
	CNGA 19 06 16T02520	19	3/4							☆						CNGA644T0820
	CNGQ 12 07 08T02520	12	1/2							☆						CNGQ452T0820
	CNGQ 12 07 12T02520									☆						CNGQ453T0820
	CNGQ 12 07 16T02520									☆						CNGQ454T0820
	CNGX120712T02520	12	1/2							☆						CNGX453T0820
	CNGX120716T02520									☆						CNGX454T0820
	CNGA120408S01030AWG	12	1/2	2.7	.106							☆	☆			CNGA432S0330AWG
	CNGA120412S01030AWG			2.7	.106							☆	☆			CNGA433S0330AWG
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	CNGA090308S01030AWH			2.2	.087								☆			CNGA322S0330AWH
	CNGA120404S01030AWH	12	1/2	2.8	.11								☆			CNGA431S0330AWH
	CNGA120408S01030AWH			2.7	.106								☆	☆		CNGA432S0330AWH
	CNGA120412S01030AWH			2.7	.106								☆	☆		CNGA433S0330AWH
	CNGA090304T01030AWH	09	3/8	2.3	.091								☆			CNGA321T0330AWH
	CNGA090308T01030AWH			2.2	.087								☆			CNGA322T0330AWH
	CNGA120404T01030AWH	12	1/2	2.8	.11								☆			CNGA431T0330AWH
	CNGA120408T01030AWH			2.7	.106								☆			CNGA432T0330AWH
	CNGA120412T01030AWH			2.7	.106								☆			CNGA433T0330AWH
						K10	K10	K01	K01	K05	S05	H05	H10	H15	H25	H15



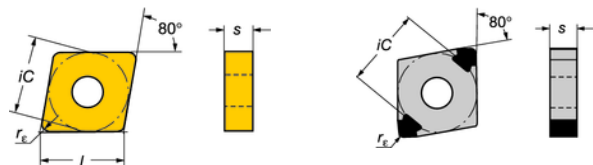
Negative basic-shape inserts

Negative basic inserts - T-MAX® P

Rhombic 80°

CNGA, CNMA

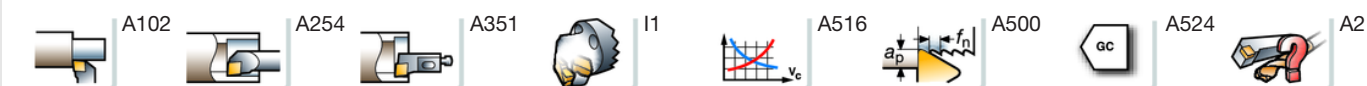
CNGX



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

						K				S		H						ANSI
						CC	CC	CC	CC	CB	CC	CC	CB	CB	CB	CB	CB	
	ISO	iC	iC	l _a mm	l _a inch	1690	6190	620	650	7525	650	6050	650	7015	7025	7525	CB20	
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	CNGA090308S01030A			2.2	.087									☆	☆			CNGA322S0330A
	CNGA120404S01030A	12	1/2	2.8	.11									☆	☆			CNGA431S0330A
	CNGA120408S01018A			2.7	.106									☆	☆			CNGA432S0318A
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	CNGA120412S01030A			2.7	.106									☆	☆			CNGA433S0330A
	CNGA120416S01030A			2.6	.102									☆	☆			CNGA434S0330A
	CNGA120404S01020A			1.4	.055										☆			CNGA431S0320A
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	CNGX1204L025-18AXA	12	1/2	2.6	.102									☆	☆			CNGX1204L025-18AXA
	CNMA120404S01020E	12	1/2	2.8	.11												☆	CNMA431S0320E
	CNMA120408S01020E			2.8	.11												☆	CNMA432S0320E
	CNMA120412S01020E			2.7	.106												☆	CNMA433S0320E
						K10	K10	K01	K01	K05	S05	H05	H05	H10	H15	H25	H15	



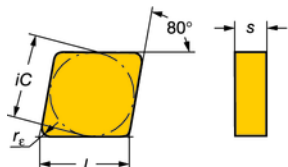
Negative basic-shape inserts

Negative basic inserts – T-Max®

Rhombic 80°

CNGN/CNG

For dimensions, see code key on page A16.



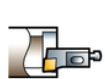
	ISO	12	iC	l _a inch	K					S					H		ANSI
					CC	CC	CC	CC	CB	CC	CC	CC	CC	CC	CC	CC	
					1690	6190	620	650	7925	6060	6065	650	670	650	670		
	CNGN120408E	12	1/2							☆							CNG432A
	CNGN120412E									☆							CNG433A
	CNGN120708E									☆							CNG452A
	CNGN120712E									☆							CNG453A
	CNGN 12 04 08T01020							☆				☆	☆	☆	☆		CNG432T0320
	CNGN 12 04 12T01020							☆				☆	☆	☆	☆		CNG433T0320
	CNGN 12 04 16T01020							☆				☆	☆	☆	☆		CNG434T0320
	CNGN 12 07 08T01020							☆		☆		☆	☆	☆	☆		CNG452T0320
	CNGN 12 07 12T01020							☆		☆		☆	☆	☆	☆		CNG453T0320
	CNGN 12 07 16T01020							☆		☆		☆	☆	☆	☆		CNG454T0320
	CNGN 16 07 08T01020	16	5/8					☆				☆		☆			CNG552T0320
	CNGN 16 07 12T01020							☆				☆		☆			CNG553T0320
	CNGN 16 07 16T01020							☆				☆		☆			CNG554T0320
	CNGN 12 04 08T02520	12	1/2			☆											CNG432T0820
	CNGN 12 04 12T02520					☆	☆	☆				☆	☆	☆	☆		CNG433T0820
	CNGN 12 04 16T02520					☆	☆										CNG434T0820
	CNGN 12 07 08T02520					☆	☆										CNG452T0820
	CNGN 12 07 12T02520					☆	☆	☆	☆			☆		☆			CNG453T0820
	CNGN 12 07 16T02520					☆	☆										CNG454T0820
	CNGN120412S02520M	12	1/2						☆								CNG433S0820M
	CNGN120416S02520M								☆								CNG434S0820M
						K10	K10	K01	K01	K05	S10	S15	S05	S15	H05	H10	



A102



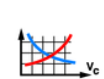
A254



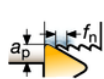
A351



I1



A516



A500



A524



A2

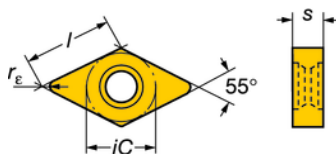
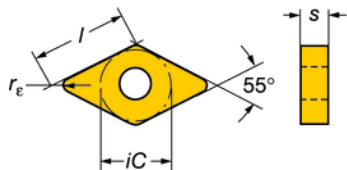
Negative basic-shape inserts

Negative basic inserts - T-MAX® P

Rhombic 55°

DNGA

DNGQ



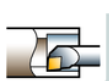
For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

	ISO	iC	l _a mm	l _a inch	K				S	H						ANSI
					CC	CC	CC	CB	CC	CC	CC	CB	CB	CB	CB	
					1690	6190	620	650	7525	650	6050	650	7015	7025	7525	
	DNGA110408S02035A	11	3/8	2.1	.083									☆		DNGA332S0835A
	DNGA150404S01020A	15	1/2	1.8	.071									☆		DNGA431S0320A
	DNGA150404S02035A			1.8	.071									☆		DNGA431S0835A
	DNGA150408S01020A			2.1	.083									☆		DNGA432S0320A
	DNGA150408S02035A			2.1	.083								☆	☆		DNGA432S0835A
	DNGA150412S02035A			2.4	.094								☆	☆		DNGA433S0835A
	DNGA150408S01530B	15	1/2	2.1	.083										☆	DNGA432S0630B
	DNGA150412S01530B			2.4	.094										☆	DNGA433S0630B
	DNGA 15 04 04S01525	15	1/2								☆					DNGA431S0625
	DNGA150408S01525										☆					DNGA432S0625
	DNGA150412S01525										☆					DNGA433S0625
	DNGA150604S01525										☆					DNGA441S0625
	DNGA150608S01525										☆					DNGA442S0625
	DNGA150612S01525										☆					DNGA443S0625
	DNGA150408T01525										☆					DNGA432T0625
	DNGA150608T01525										☆					DNGA442T0625
	DNGA 15 04 08T01020	15	1/2					☆	☆	☆						DNGA432T0320
	DNGA 15 04 12T01020							☆	☆	☆						DNGA433T0320
	DNGA 15 04 16T01020							☆	☆	☆						DNGA434T0320
	DNGA 15 04 08T02520					☆	☆	☆								DNGA432T0820
	DNGA 15 04 12T02520					☆	☆									DNGA433T0820
	DNGA 15 04 16T02520						☆									DNGA434T0820
	DNGQ 150708 T02520	15	1/2					☆								DNGQ452T0820
	DNGQ 150712 T02520							☆								DNGQ453T0820
	DNGQ 150716 T02520							☆								DNGQ454T0820
	DNGA150408S01030AWH	15	1/2	3.4	.134							☆	☆			DNGA432S0330AWH
	DNGA150412S01030AWH			3.0	.118							☆	☆			DNGA433S0330AWH
	DNGA110404S01030A	11	3/8	3.0	.118							☆	☆			DNGA331S0330A
	DNGA110408S01030A			2.6	.102							☆	☆			DNGA332S0330A
	DNGA110412S01030A			2.2	.087							☆				DNGA333S0330A
	DNGA 150416S01030A	15	1/2	2.7	.106							☆	☆			DNGA434S0330A
	DNGA150404S01030A			3.8	.15							☆	☆			DNGA431S0330A
	DNGA150408S01030A			3.4	.134							☆	☆			DNGA432S0330A
	DNGA150412S01030A			3.0	.118							☆	☆			DNGA433S0330A
	DNGA110404S01020A	11	3/8	1.3	.051								☆			DNGA331S0320A
	DNGA110408S01020A			1.0	.039								☆			DNGA332S0320A
						K10	K10	K01	K05	S05	H05	H05	H10	H15	H25	H15



A102



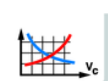
A254



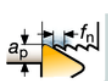
A351



I1



A516



A500



A524



A2

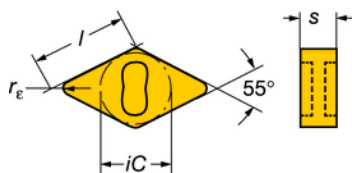
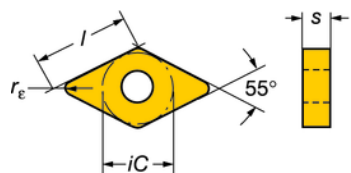
Negative basic-shape inserts

Negative basic inserts - T-MAX® P

Rhombic 55°

DNGA, DNMA

DNGX



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

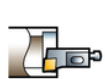
						K				S	H						
						CC	CC	CC	CC	CB	CC	CC	CC	CB	CB	CB	
	ISO		iC	l _a mm	l _a inch	1690	6190	620	650	7525	650	6050	650	7015	7025	7525	CB20
	DNGA110404T01020B	11	3/8	3.4	.134					☆						☆	ANSI DNGA331T0320B
	DNGA110408T01020B			3.0	.118					☆						☆	ANSI DNGA332T0320B
	DNMA150404S01020E	15	1/2	3.3	.13											☆	ANSI DNMA431S0320E
	DNMA150408S01020E			2.9	.114											☆	ANSI DNMA432S0320E
	DNMA150412S01020E			2.6	.102											☆	ANSI DNMA433S0320E
	DNGX150712T02520	15	1/2				☆										ANSI DNGX453T0820
	DNGX150716T02520						☆										ANSI DNGX454T0820
						K10	K10	K01	K01	K05	S05	H05	H05	H10	H15	H25	H15



A102



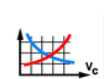
A254



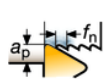
A351



I1



A516



A500



A524



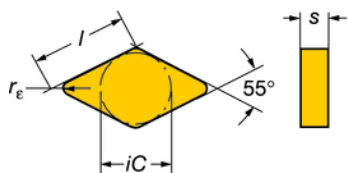
A2

Negative basic-shape inserts

Negative basic inserts – T-Max®

Rhombic 55°

DNGN/DNG

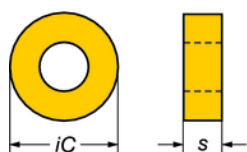


For dimensions, see code key on page A16.

	ISO		iC	l _a inch	K	S	H	ANSI
					CC	CC	CC	
					620	650	670	
	DNGN 15 04 08T01020	15	1/2		☆	☆	☆	DNG432T0320
	DNGN 15 04 12T01020				☆	☆	☆	DNG433T0320
	DNGN 15 04 16T01020				☆	☆	☆	DNG434T0320
	DNGN 15 07 08T01020				☆	☆	☆	DNG452T0320
	DNGN 15 07 12T01020				☆	☆	☆	DNG453T0320
	DNGN 15 07 16T01020				☆	☆	☆	DNG454T0320
	DNGN 15 07 12T02520				☆	☆	☆	DNG453T0820
	DNGN 15 07 16K07015				☆	☆	☆	DNG454K3015
	DNGN 15 07 16T07015				☆	☆	☆	DNG454T3015
					K01	S05	H05	

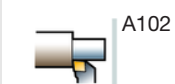
Round

RNGA



For dimensions, see code key on page A16.

	ISO		iC	l _a inch	K	S	H	ANSI
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					650	650	CB20	
	RNGA 12 04 00T01020	12	1/2		☆	☆		RNGA43T0320
	RNGA090300S01020D	09	3/8				☆	RNGA32S0320D
					K01	S05	H05	



A102



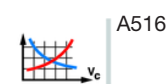
A254



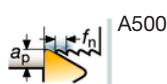
A351



I1



A516



A500



A524



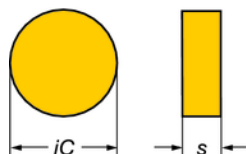
A2

Negative basic-shape inserts


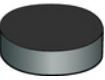

Negative basic inserts – T-Max®

Round

RNGN/RNG



For dimensions, see code key on page A16.

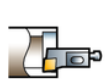
	ISO	iO	iC	K					S					H					ANSI
				CC	CC	CC	CC	CB	CC	CC	CC	CC	CC	CC	CC	CB			
	RNGN090300E	09	3/8							☆								RNG32A	
	RNGN120400E	12	1/2							☆	☆							RNG43A	
	RNGN120700E									☆	☆		☆		☆			RNG45A	
	RNGN150700E	15	5/8							☆								RNG55A	
	RNGN190700E	19	3/4							☆	☆							RNG65A	
	RNGN250700E	25	1							☆			☆					RNG85A	
	RNGN 09 03 00T01020	09	3/8				☆					☆	☆	☆	☆			RNG32T0320	
	RNGN 12 04 00T01020	12	1/2					☆				☆	☆	☆	☆	☆		RNG43T0320	
	RNGN 12 07 00T01020							☆				☆	☆	☆	☆	☆		RNG45T0320	
	RNGN 15 07 00T01020	15	5/8											☆		☆		RNG55T0320	
	RNGN 190700 T01020	19	3/4							☆			☆		☆			RNG65T0320	
	RNGN 12 04 00T02520	12	1/2			☆	☆											RNG43T0820	
	RNGN 12 07 00T02520					☆	☆	☆	☆				☆		☆			RNG45T0820	
	RNGN 15 07 00T02520	15	5/8					☆				☆		☆				RNG55T0820	
	RNGN 12 07 00T15015	12	1/2					☆				☆		☆				RNG45T6015	
	RNGN 15 07 00T20015	15	5/8					☆				☆		☆				RNG55T8015	
	RNGN 19 07 00T20015	19	3/4					☆				☆		☆				RNG65T8015	
	RNGN 25 07 00T20015	25	1					☆				☆		☆				RNG85T8015	
	RNGN 12 07 00K15015	12	1/2					☆				☆		☆				RNG45K6015	
	RNGN 19 07 00K20015	19	3/4					☆				☆		☆	☆	☆		RNG65K8015	
	RNGN 25 07 00K20015	25	1					☆				☆		☆	☆	☆		RNG85K8015	
	RNGN120400FD	12	1/2						☆								☆	RNG43FD	
	RNGN060300S02520M	06	1/4						☆									RNG22S1020M	
	RNGN060400S02520M								☆									RNG23S1020M	
	RNGN090300S02520M	09	3/8						☆									RNG32S1020M	
	RNGN120300S02520M	12	1/2						☆									RNG42S1020M	
	RNGN120400S02520M								☆									RNG43S1020M	
	RNGN150400S02520M	15	5/8						☆									RNG53S1020M	
	RNGN250400S02520M	25	1						☆									RNG83S1020M	
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A102



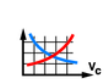
A254



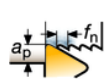
A351



I1



A516



A500



A524



A2

Negative basic-shape inserts

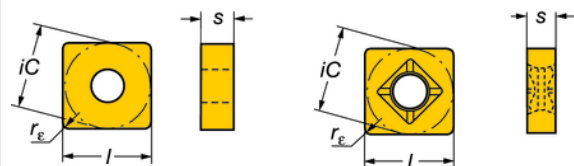
Negative basic inserts - T-MAX® P

Square

SNGA/SNMA

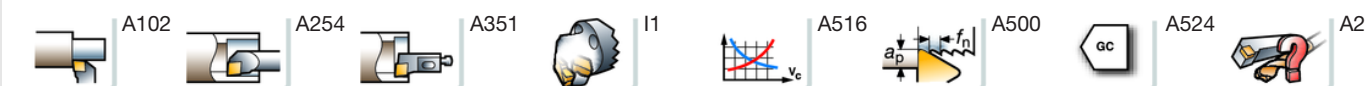
SNGQ

For dimensions, see code key on page A16.



Note! Grade CB7025 is uncoated.

						K			S	H						ANSI	
						CC	CC	CC	CB	CC	CC	CC	CB	CB	CB		CB
	ISO		iC	l _a mm	l _a inch	1690	6190	650	7525	650	6050	650	7015	7025	7525	CB20	
	SNGA120412S02035A	12	1/2	2.8	.11									☆			SNGA433S0835A
	SNGA120412S02035B	12	1/2	2.8	.11										☆		SNGA433S0835B
	SNGA120408S01525	12	1/2								☆						SNGA432S0625
	SNGA120412S01525										☆						SNGA433S0625
	SNGA120408T01525										☆						SNGA432T0625
	SNGA 12 04 08T01020	12	1/2					☆		☆		☆					SNGA432T0320
	SNGA 12 04 12T01020									☆		☆					SNGA433T0320
	SNGA120416T01020									☆		☆					SNGA434T0320
	SNGA 12 04 08T02520					☆	☆										SNGA432T0820
	SNGA 12 04 12T02520					☆	☆										SNGA433T0820
	SNGA 12 04 16T02520						☆										SNGA434T0820
	SNGQ 120708 T02520	12	1/2				☆										SNGQ452T0820
	SNGQ 120712 T02520						☆										SNGQ453T0820
	SNGQ 120716 T02520						☆										SNGQ454T0820
	SNGA090308S01030A	09	3/8	2.1	.083								☆	☆			SNGA322S0330A
	SNGA120408S01030A	12	1/2	2.7	.106								☆	☆			SNGA432S0330A
	SNGA120412S01030A			2.7	.106								☆	☆			SNGA433S0330A
	SNGA120408T01020B	12	1/2	2.7	.106			☆							☆		SNGA432T0320B
	SNGA120412T01020B			2.7	.106			☆							☆		SNGA433T0320B
						K10	K10	K01	K05	S05	H05	H05	H10	H15	H25	H15	



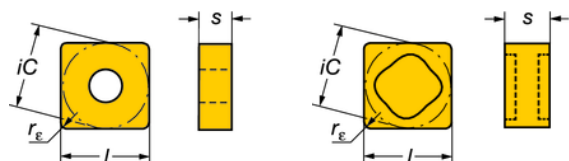
Negative basic-shape inserts

Negative basic inserts - T-MAX® P

Square

SNGA/SNMA

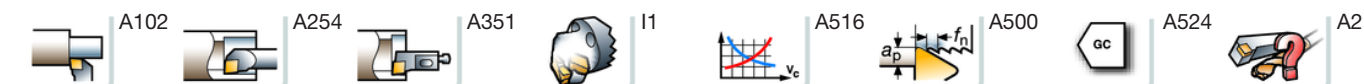
SNGX



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

						K				S	H						
						CC	CC	CC	CB	CC	CC	CC	CB	CB	CB	CB	
	ISO		iC	l_a mm	l_a inch	1690	6190	650	7525	650	6050	650	7015	7025	7525	CB20	ANSI
	SNMA120408S01020E	12	1/2	3.4	.134											☆	SNMA432S0320E
	SNMA120412S01020E			3.4	.134											☆	SNMA433S0320E
	SNGX120712T02520	12	1/2				☆										SNGX453T0820
	SNGX120716T02520						☆										SNGX454T0820
						K10	K10	K01	K05	S05	H05	H05	H10	H15	H25	H15	

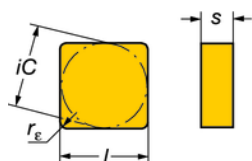


Negative basic-shape inserts

Negative basic inserts – T-Max®

Square

SNGN/SNG



For dimensions, see code key on page A16.

B

C

G

H

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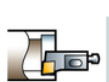
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				CC	CC	CC	CC	CB	CB	CC	CC	CC	CC	CC	CC	CC	CB	
	SNGN120412E	12	1/2								☆						SNG433A	
	SNGN120712E										☆						SNG453A	
	SNGN190724E	19	3/4								☆						SNG656A	
	SNGN 09 03 08T01020	09	3/8			☆					☆	☆	☆	☆			SNG322T0320	
	SNGN 09 03 12T01020					☆					☆	☆	☆	☆			SNG323T0320	
	SNGN 12 04 08T01020	12	1/2			☆					☆	☆	☆	☆			SNG432T0320	
	SNGN 12 04 12T01020					☆					☆	☆	☆	☆			SNG433T0320	
	SNGN 12 04 16T01020					☆					☆	☆	☆	☆			SNG434T0320	
	SNGN 12 07 08T01020					☆					☆	☆	☆	☆			SNG452T0320	
	SNGN 12 07 12T01020					☆			☆		☆	☆	☆	☆			SNG453T0320	
	SNGN 12 07 16T01020					☆					☆	☆	☆	☆			SNG454T0320	
	SNGN 15 07 08T01020	15	5/8			☆					☆		☆				SNG552T0320	
	SNGN 15 07 12T01020					☆					☆	☆	☆	☆			SNG553T0320	
	SNGN 15 07 16T01020					☆					☆	☆	☆	☆			SNG554T0320	
	SNGN 19 07 24T01020	19	3/4			☆					☆	☆	☆	☆			SNG656T0320	
	SNGN 190716 T01020					☆					☆		☆				SNG654T0320	
	SNGN 12 04 08T02520	12	1/2		☆												SNG432T0820	
	SNGN 12 04 12T02520				☆	☆					☆		☆				SNG433T0820	
	SNGN 12 04 16T02520				☆	☆											SNG434T0820	
	SNGN 12 07 08T02520				☆	☆	☆										SNG452T0820	
	SNGN 12 07 12T02520				☆	☆	☆	☆			☆		☆				SNG453T0820	
	SNGN 12 07 16T02520				☆	☆	☆										SNG454T0820	
	SNGN120408FD	12	1/2					☆								☆	SNG432FD	
	SNGN120412FD							☆								☆	SNG433FD	
	SNGN120416FD							☆								☆	SNG434FD	
	SNGN090312S02520M	09	3/8				☆										SNG323S1020M	
	SNGN120412S02520M	12	1/2				☆										SNG433S1020M	
	SNGN120416S02520M						☆										SNG434S1020M	
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A102



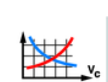
A254



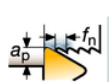
A351



I1



A516



A500



A524



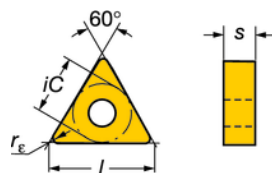
A2

Negative basic-shape inserts

Negative basic inserts - T-MAX® P

Triangular

TNGA, TNMA



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

	ISO		iC	l _a mm	l _a inch	K				S	H						ANSI
						1690	6190	620	650	7525	650	6050	650	7015	7025	7525	
	TNGA160408S02035A	16	3/8	2.0	.079												TNGA332S0835A
	TNGA160412S02035A			2.4	.094										☆		TNGA333S0835A
	TNGA160408S01530B	16	3/8	2.0	.079											☆	TNGA332S0630B
	TNGA160408S02035B			2.0	.079											☆	TNGA332S0835B
	TNGA160404S01525	16	3/8								☆						TNGA331S0625
	TNGA160408S01525										☆						TNGA332S0625
	TNGA160412S01525										☆						TNGA333S0625
	TNGA160408T01525										☆						TNGA332T0625
	TNGA 16 04 08T01020	16	3/8					☆		☆		☆					TNGA332T0320
	TNGA 16 04 12T01020						☆	☆		☆		☆					TNGA333T0320
	TNGA 16 04 16T01020							☆		☆		☆					TNGA334T0320
	TNGA 22 04 08T01020	22	1/2					☆		☆		☆					TNGA432T0320
	TNGA 22 04 12T01020							☆		☆		☆					TNGA433T0320
	TNGA 22 04 16T01020							☆		☆		☆					TNGA434T0320
	TNGA 16 04 08T02520	16	3/8			☆	☆	☆									TNGA332T0820
	TNGA 16 04 12T02520					☆											TNGA333T0820
	TNGA 16 04 16T02520					☆											TNGA334T0820
	TNGA110304S01030A	11	1/4	1.6	.063								☆	☆			TNGA221S0330A
	TNGA110308S01030A			1.3	.051								☆	☆			TNGA222S0330A
	TNGA160404S01030A	16	3/8	2.9	.114								☆	☆			TNGA331S0330A
	TNGA160408S01030A			2.6	.102								☆	☆			TNGA332S0330A
	TNGA160412S01030A			2.3	.091								☆	☆			TNGA333S0330A
	TNGA110304T01020B	11	1/4	1.6	.063					☆					☆		TNGA221T0320B
	TNGA110308T01020B			1.3	.051					☆					☆		TNGA222T0320B
	TNGA160404T01020B	16	3/8	2.9	.114					☆					☆		TNGA331T0320B
	TNGA160408T01020B			2.6	.102					☆					☆		TNGA332T0320B
	TNGA160412T01020B			2.3	.091					☆					☆		TNGA333T0320B
	TNMA160404S01020E	16	3/8	3.6	.142											☆	TNMA331S0320E
	TNMA160408S01020E			3.3	.13											☆	TNMA332S0320E
	TNMA160412S01020E			3.0	.118											☆	TNMA333S0320E
	TNMA220408S01020E	22	1/2	3.2	.126											☆	TNMA432S0320E
	TNMA220412S01020E			2.9	.114											☆	TNMA433S0320E
						K10	K10	K01	K01	K05	S05	H05	H05	H10	H15	H15	



A102



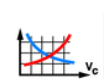
A254



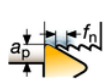
A351



I1



A516



A500



A524



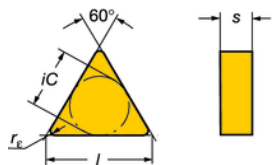
A2

Negative basic-shape inserts

Negative basic inserts – T-Max®

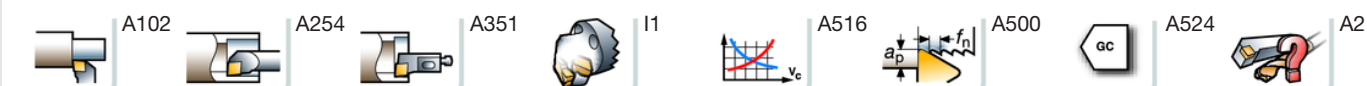
Triangular

TNGN/TNG



For dimensions, see code key on page A16.

						K				N		S		H		
						CC	CB	CB	CD	CC	CC	CC	CC	CC	CB	
	ISO		iC	l _a mm	l _a inch	650	7925	CB50	CD10	650	670	650	670	CB50		ANSI
	TNGN 11 03 08T01020	11	1/4			☆				☆		☆				TNG222T0320
	TNGN 11 03 12T01020					☆						☆				TNG223T0320
	TNGN 16 04 08T01020	16	3/8			☆				☆		☆				TNG332T0320
	TNGN 16 04 12T01020					☆				☆		☆				TNG333T0320
	TNGN 16 04 16T01020					☆				☆		☆				TNG334T0320
	TNGN 16 07 08T01020					☆				☆		☆				TNG352T0320
	TNGN 16 07 12T01020					☆				☆		☆				TNG353T0320
	TNGN 22 04 08T01020	22	1/2								☆		☆			TNG432T0320
	TNGN220412FD	22	1/2					☆						☆		TNG433FD
	TNGN160408S02520M	16	3/8				☆									TNG332S1020M
	TNGN160412S02520M						☆									TNG333S1020M
						K01	K05	K05	N05	S05	S15	H05	H10	H25		

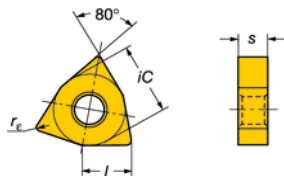


Negative basic-shape inserts

Negative basic inserts - T-MAX® P













Trigon 80°

WNGA



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

			iC	l _a mm	l _a inch	K		H			ANSI	
						CC	CB	CC	CB	CB		CB
	ISO					6190	7525	6050	7015	7025	7525	
 	WNGA080408S02035A	08	1/2	2.0	.079				☆	☆		WNGA432S0835A
  	WNGA060404T01020BWG	06	3/8	2.3	.091			☆			☆	WNGA331T0320BWG
	WNGA060408T01020BWG			2.2	.087			☆			☆	WNGA332T0320BWG
	WNGA080404T01020BWG	08	1/2	2.8	.11			☆			☆	WNGA431T0320BWG
	WNGA080408T01020BWG			2.7	.106			☆			☆	WNGA432T0320BWG
 	WNGA 080408 T01020WG	08	1/2			☆						WNGA432T0320WG
	WNGA 080412 T01020WG					☆						WNGA433T0320WG
 	WNGA080404S01525WH	08	1/2					☆				WNGA431S0625WH
	WNGA080408S01525WH							☆				WNGA432S0625WH
	WNGA080408T01525WH							☆				WNGA432T0625WH
	WNGA080404S01525	08	1/2					☆				WNGA431S0625
	WNGA080408S01525							☆				WNGA432S0625
	WNGA080408T01525							☆				WNGA432T0625
	WNGA 08 04 08T02520	08	1/2			☆						WNGA432T0820
	WNGA 08 04 12T02520					☆						WNGA433T0820
	WNGA 08 04 16T02520					☆						WNGA434T0820
						K10	K05	H05	H10	H15	H25	



A102



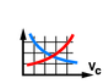
A254



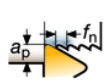
A351



11



A516



A500



A524



A2

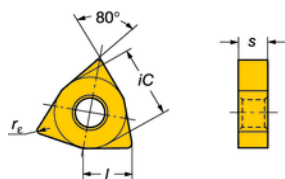
Negative basic-shape inserts

Negative basic inserts - T-MAX® P

Trigon 80°

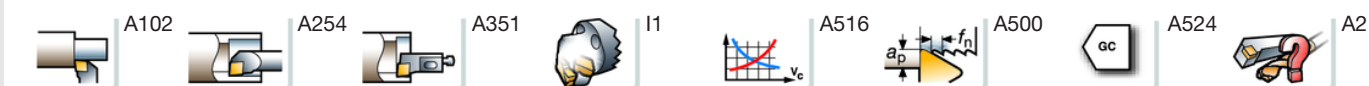
WNGA

For dimensions, see code key on page A16.



Note! Grade CB7025 is uncoated.

							K		H				
							CC	CB	CC	CB	CB	CB	
	ISO		iC	l _a mm	l _a inch		6190	7525	6050	7015	7025	7525	ANSI
	WNGA060404S01030AWH	06	3/8	2.3	.091						☆		WNGA331S0330AWH
	WNGA060408S01030AWH			2.2	.087						☆		WNGA332S0330AWH
	WNGA080404S01030AWH	08	1/2	2.8	.11						☆		WNGA431S0330AWH
	WNGA080408S01030AWH			2.7	.106						☆		WNGA432S0330AWH
	WNGA080412S01030AWH			2.7	.106						☆		WNGA433S0330AWH
	WNGA060404T01030AWH	06	3/8	2.3	.091					☆			WNGA331T0330AWH
	WNGA060408T01030AWH			2.2	.087					☆			WNGA332T0330AWH
	WNGA080404T01030AWH	08	1/2	2.8	.11					☆			WNGA431T0330AWH
	WNGA080408T01030AWH			2.7	.106					☆			WNGA432T0330AWH
	WNGA080412T01030AWH			2.7	.106					☆			WNGA433T0330AWH
	WNGA060404S01030A	06	3/8	2.3	.091					☆	☆		WNGA331S0330A
	WNGA060408S01030A			2.2	.087					☆	☆		WNGA332S0330A
	WNGA080404S01030A	08	1/2	2.8	.11					☆	☆		WNGA431S0330A
	WNGA080408S01030A			2.7	.106					☆	☆		WNGA432S0330A
	WNGA080412S01030A			2.7	.106					☆	☆		WNGA433S0330A
	WNGA060404T01020B	06	3/8	2.3	.091		☆				☆		WNGA331T0320B
	WNGA060408T01020B			2.2	.087		☆				☆		WNGA332T0320B
	WNGA080404T01020B	08	1/2	2.8	.11		☆				☆		WNGA431T0320B
	WNGA080408T01020B			2.7	.106		☆				☆		WNGA432T0320B
	WNGA080412T01020B			2.7	.106		☆				☆		WNGA433T0320B
							K10	K05	H05	H10	H15	H25	

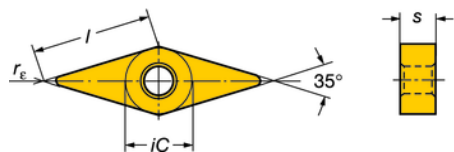


Negative basic-shape inserts

Negative basic inserts - T-MAX® P






Rhombic 35°

VNGA



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

							H			
							CC	CB	CB	
 	ISO	16	3/8	l_a mm	l_a inch		6050	7015	7025	ANSI
	VNGA160404S01020A			2.1	.083				☆	VNGA331S0320A
	VNGA160408S01020A			2.4	.094				☆	VNGA332S0320A
	VNGA160408S02035A			2.4	.094				☆	VNGA332S0835A
	VNGA160404S01525	16	3/8				☆			VNGA331S0625
	VNGA160408S01525						☆			VNGA332S0625
	VNGA160412S01525						☆			VNGA333S0625
	VNGA160408T01525						☆			VNGA332T0625
 	VNGA160404S01030A	16	3/8	4.2	.165		☆	☆		VNGA331S0330A
	VNGA160408S01030A			3.3	.13		☆	☆		VNGA332S0330A
							H05	H10	H15	



A102



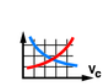
A254



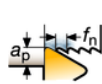
A351



I1



A516



A500



A524



A2

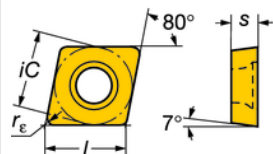
Positive basic-shape inserts


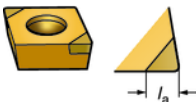
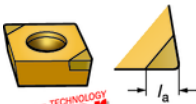
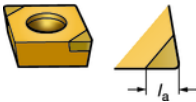
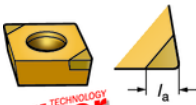
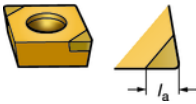
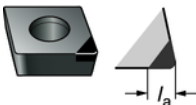
Positive basic inserts - CoroTurn® 107

Rhombic 80°

CCGW

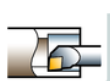
For dimensions, see code key on page A16.

**Note!** Grade CB7025 is uncoated.

							K		N		H			
							CB	CD	CD	CB	CB	CB		
	ISO		iC	l _a mm	l _a inch	7525	1810	CD10	7015	7025	7525	ANSI		
	CCGW060202T01030F	06	1/4	1.5	.059				☆	☆		CCGW2(1.5)0T0330F		
	CCGW060204S01020F			1.8	.071				☆	☆		CCGW2(1.5)1S0320F		
	CCGW060204S01030F			1.8	.071				☆	☆	☆	CCGW2(1.5)1S0330F		
	CCGW060208S01030F			2.0	.079				☆	☆		CCGW2(1.5)2S0330F		
 Wiper	CCGW060204T01030FWH	06	1/4	1.8	.071				☆	☆		CCGW2(1.5)1T0330FWH		
	CCGW060208T01030FWH			2.0	.079				☆	☆		CCGW2(1.5)2T0330FWH		
	CCGW09T304S01530FWH	09	3/8	1.8	.071					☆		CCGW3(2.5)1S0630FWH		
	CCGW060204T01020F	06	1/4	2.6	.102	☆						CCGW2(1.5)1T0320F		
	CCGW09T304T01020F	09	3/8	2.6	.102	☆						CCGW3(2.5)1T0320F		
	CCGW09T308T01020F			2.5	.098	☆						CCGW3(2.5)2T0320F		
 Wiper	CCGW09T304S01020FWH	09	3/8	2.6	.102					☆		CCGW3(2.5)1S0320FWH		
	CCGW09T308S01020FWH			2.6	.102					☆		CCGW3(2.5)2S0320FWH		
	CCGW09T312S01020FWH			2.6	.102					☆		CCGW3(2.5)3S0320FWH		
	CCGW09T304T01020FWH			2.6	.102					☆		CCGW3(2.5)1T0320FWH		
	CCGW09T308T01020FWH			2.5	.098					☆		CCGW3(2.5)2T0320FWH		
	CCGW09T304S01020F	09	3/8	2.6	.102				☆	☆		CCGW3(2.5)1S0320F		
	CCGW09T308S01020F			2.5	.098				☆	☆		CCGW3(2.5)2S0320F		
	CCGW09T312S01020F			2.6	.102				☆			CCGW3(2.5)3S0320F		
	CCGW09T304S01530F			1.8	.071				☆	☆	☆	CCGW3(2.5)1S0630F		
	CCGW09T308S01530F			2.0	.079				☆	☆	☆	CCGW3(2.5)2S0630F		
	CCGW09T312S01530F			2.3	.091				☆	☆		CCGW3(2.5)3S0630F		
	CCMW060204FP	06	1/4	2.9	.114			☆				CCMW2(1.5)1FP		
	CCMW09T304FP	09	3/8	4.3	.169			☆				CCMW3(2.5)1FP		
	CCMW09T308FP			4.2	.165			☆				CCMW3(2.5)2FP		



A102



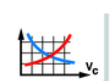
A254



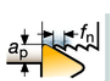
A351



I1



A516



A500



A524



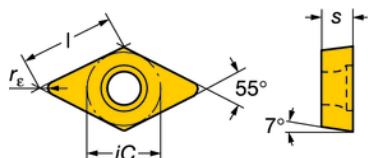
A2

Positive basic-shape inserts

Positive basic inserts – CoroTurn® 107

Rhombic 55°

DCMW, DCGW



For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

[illegible]

A102



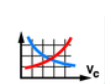
A254



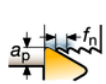
A351



11



A516



A500



A524



A2

Positive basic-shape inserts

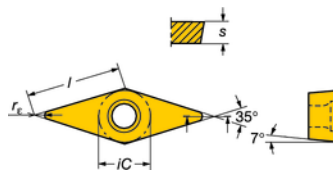
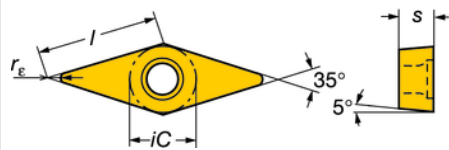
Positive basic inserts – CoroTurn® 107

Rhombic 35°

VBMW, VBGW

VCMW

For dimensions, see code key on page A16.

**Note!** Grade CB7025 is uncoated.

	ISO		iC	l _a mm	l _a inch	K N H						ANSI
						CB	CD	CD	CB	CB	CB	
						7525	1810	CD10	7015	7025	CB20	
	VBGW160404T01020F	16	3/8	4.2	.165	☆						VBGW331T0320F
	VBGW160408T01020F			3.3	.13	☆						VBGW332T0320F
	VBGW160404S01020F			4.2	.165				☆	☆		VBGW331S0320F
	VBGW160408S01020F			3.3	.13				☆	☆		VBGW332S0320F
	VBGW160404S01530F			3.0	.118				☆			VBGW331S0630F
	VBGW160408S01530F			3.0	.118				☆	☆		VBGW332S0630F
	VBMW160404S01020E	16	3/8	4.7	.185						☆	VBMW331S0320E
	VBMW160408S01020E			4.1	.162						☆	VBMW332S0320E
	VCMW 110304FP	11	1/4	4.4	.173			☆				VCMW221FP
	VCMW110204FP			4.4	.173			☆				VCMW2(1.5)1FP
	VCMW160404FP	16	3/8	4.4	.173			☆				VCMW331FP
	VCMW160408FP			3.5	.138			☆				VCMW332FP
	VCMW160412FP			2.7	.106			☆				VCMW333FP
						K05	N10	N05	H10	H15	H15	

★ = First choice



A102



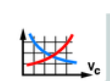
A254



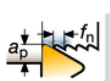
A351



I1



A516



A500



A524



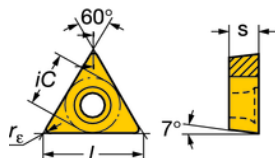
A2

Positive basic-shape inserts

Positive basic inserts – CoroTurn® 107

Triangular

TCGW, TCMW

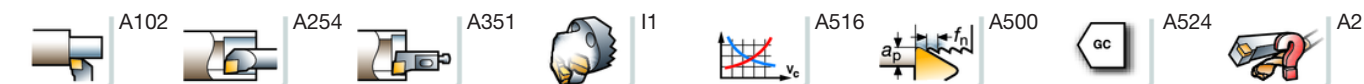


For dimensions, see code key on page A16.

Note! Grade CB7025 is uncoated.

[illegible]

★= First choice



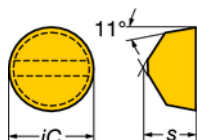
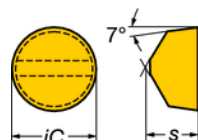
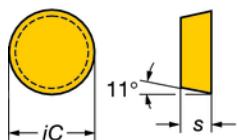
Positive basic inserts – T-Max®

Round



RPGN/RPG

RCGX

RPGX



For dimensions, see code key on page A16.

	ISO	F	iC	I _a inch	K					S					H			ANSI
					CC	CC	CC	CC	CB	CB	CC	CC	CC	CC	CC	CC	CB	
	RPGN060300E	06	1/4							☆							RPG22A	
	RPGN090300E	09	3/8							☆							RPG32A	
	RPGN120400E	12	1/2							☆							RPG43A	
	RPGN060300T01020	06	1/4										☆				RPG22T0320	
	RPGN 09 03 00T01020	09	3/8				☆					☆	☆	☆	☆		RPG32T0320	
	RPGN120400T01020	12	1/2										☆				RPG43T0320	
	RCGX060600E	06	1/4				☆			☆	☆	☆	☆	☆	☆		RCGX24A	
	RCGX090700E	09	3/8				☆			☆	☆	☆	☆	☆	☆		RCGX35A	
	RCGX120700E	12	1/2							☆	☆		☆		☆		RCGX45A	
	RCGX 06 06 00T01020	06	1/4				☆			☆		☆	☆	☆	☆		RCGX24T0320	
	RCGX 09 07 00T01020	09	3/8				☆			☆	☆	☆	☆	☆	☆		RCGX35T0320	
	RCGX 12 07 00T01020	12	1/2				☆			☆		☆	☆	☆	☆		RCGX45T0320	
	RCGX 12 07 00T02520						☆					☆		☆			RCGX45T0820	
	RCGX 12 07 00T15015						☆					☆		☆			RCGX45T6015	
	RCGX 15 10 00T20015	15	5/8				☆					☆		☆			RCGX5(6.3)T8015	
	RCGX 19 10 00T20015	19	3/4				☆					☆		☆			RCGX6(6.3)T8015	
	RCGX 25 12 00T20015	25	1				☆					☆		☆			RCGX8(7.6)T8015	
	RCGX 12 07 00K15015	12	1/2				☆					☆		☆			RCGX45K6015	
	RCGX 19 10 00K20015	19	3/4				☆					☆		☆			RCGX6(6.3)K8015	
	RCGX 25 12 00K20015	25	1				☆					☆		☆			RCGX8(7.6)K8015	
	RPGX 060600 E	06	1/4								☆							RPGX24A
	RPGX090700E	09	3/8								☆	☆						RPGX35A
	RPGX120700E	12	1/2								☆	☆						RPGX45A
	RPGX060600T01020	06	1/4											☆				RPGX24T0320
RPGX 09 07 00T01020	09	3/8								☆					☆		RPGX35T0320	
RPGX 12 07 00T01020	12	1/2								☆			☆		☆		RPGX45T0320	
RCGX 09 07 00T07015	09	3/8				☆						☆					RCGX35T3015	
						K10	K10	K01	K01	K05	K05	S10	S15	S05	S15	H05	H10	H25



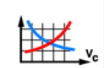
A254



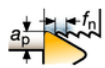
A351



11



A516



A500



A524



A2

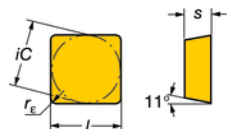
Positive basic-shape inserts

Positive basic inserts – T-Max®

Square

SPGN/SPG, SPUN/SPU

For dimensions, see code key on page A16.



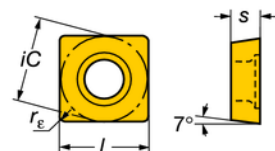
						K					N	S					H			
						CC	CC	CC	CC	CB	CB	CC	CC	CC	CC	CC	CC	CC	CB	
	ISO		iC	l _a mm	l _a inch	1690	6190	620	650	7925	CB50	CD10	6060	6065	650	670	650	670	CB50	ANSI
	SPGN 12 04 08T01020	12	1/2						☆						☆		☆			SPG432T0320
	SPGN 12 04 12T01020								☆						☆		☆			SPG433T0320
	SPUN120304FP	12	1/2	4.6	.181							☆								SPU421FP
						K10	K10	K01	K01	K05	K05	N05	S10	S15	S05	S15	H05	H10	H25	

Positive basic inserts – CoroTurn® 107

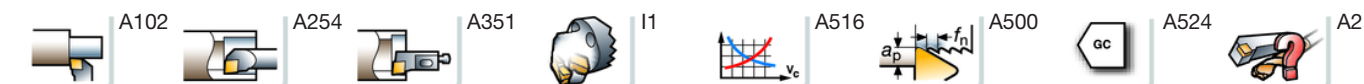
Square

SCGW

For dimensions, see code key on page A16.



						H		
						CB	CB	
	ISO		iC	l _a mm	l _a inch	7015	7025	ANSI
	SCGW09T304S01030F	09	3/8	1.8	.071	☆	☆	SCGW3(2.5)1S0330F
	SCGW09T308S01030F			2.1	.083	☆	☆	SCGW3(2.5)2S0330F
						H10	H15	



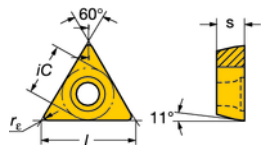
Positive basic-shape inserts

Positive basic inserts – CoroTurn® 111

Triangular

TPGW

For dimensions, see code key on page A16.



Note! Grade CB7025 is uncoated.

	ISO		iC	l _a mm	l _a inch	H		ANSI
						CB	CB	
	TPGW110304S01020F	11	1/4	3.0	.118	☆	☆	TPGW221S0320F
	TPGW110308S01020F			2.7	.106	☆	☆	TPGW222S0320F
						H10	H15	

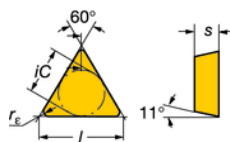
★ = First choice

Positive basic inserts – T-Max®

Triangular

TPUN/TPU TPGN/TPG

For dimensions, see code key on page A16.



	ISO		iC	l _a mm	l _a inch	K		N		S		H		ANSI
						CC	CB	CC	CB	CC	CC	CC	CB	
	TPGN 11 03 04T01020	11	1/4			☆	☆	☆	☆	☆	☆	☆	☆	TPG221T0320
	TPGN 11 03 08T01020					☆	☆	☆	☆	☆	☆	☆	☆	TPG222T0320
	TPGN 16 03 04T01020	16	3/8			☆	☆	☆	☆	☆	☆	☆	☆	TPG321T0320
	TPGN 16 03 08T01020					☆	☆	☆	☆	☆	☆	☆	☆	TPG322T0320
	TPGN 16 03 12T01020					☆	☆	☆	☆	☆	☆	☆	☆	TPG323T0320
	TPUN110304FP	11	1/4	2.7	.106			☆						TPU221FP
	TPUN160304FP	16	3/8	2.7	.106			☆						TPU321FP
	TPUN160304FR/LP			7.4	.291			☆						TPU321FLP
	TPGN 16 03 08E	16	3/8			☆		☆		☆				TPG322A
						K01	K05	K05	N05	S05	S15	H05	H10	H25

★ = First choice



A102



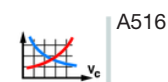
A254



A351



I1



A516



A500



A524



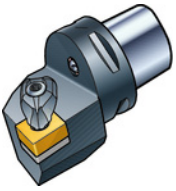
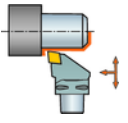
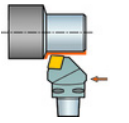
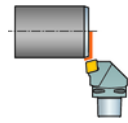
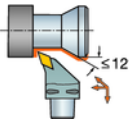
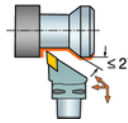





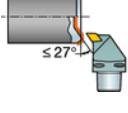
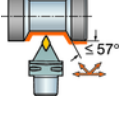
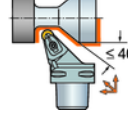
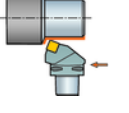
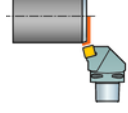





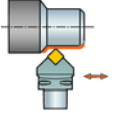
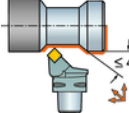
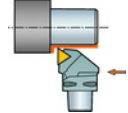
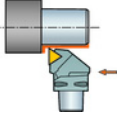
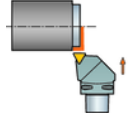






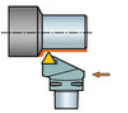
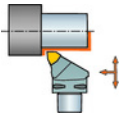
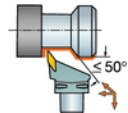



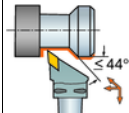

A2

GENERAL TURNING

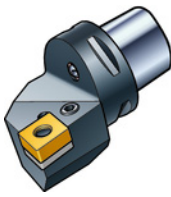
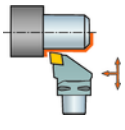
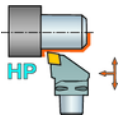
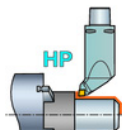
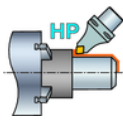
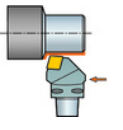
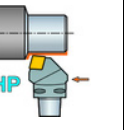
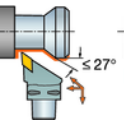
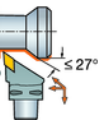








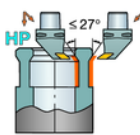
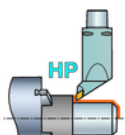
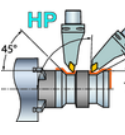
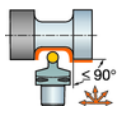
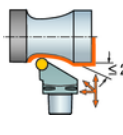
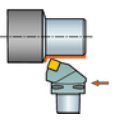
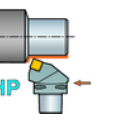
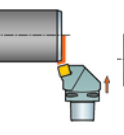
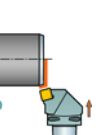








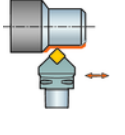
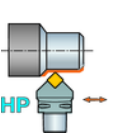
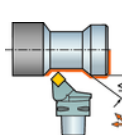
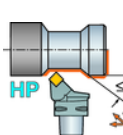
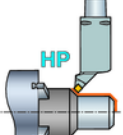












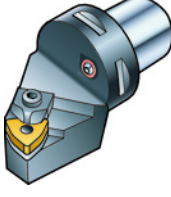
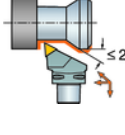
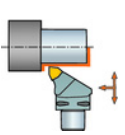


Holdings for external machining

Introduction	A114
Tool holder overview	A102
Code key	A112
Holdings for negative basic-shape inserts	
CoroTurn® RC, rigid clamping, Coromant Capto cutting units	A115
CoroTurn® RC, rigid clamping, shank holders	A137
T-Max® P Lever clamping, Coromant Capto cutting units	A129
T-Max® P, lever clamping, shank holders	A152
T-Max® P, wedge clamping, Coromant Capto cutting units	A134
T-Max® P, wedge clamping, shank holders	A159
T-Max® P, top clamping, shank holders	A163
Holdings for positive basic-shape inserts	
CoroTurn® 107 - 7° clearance angle, Coromant Capto cutting units	A165
CoroTurn® 107 - 7° clearance angle, shank holders	A168
CoroTurn® TR, T-Rail, Coromant Capto cutting units	A174
CoroTurn® TR, T-Rail, shank holders	A193
Holdings for ceramic inserts	
CoroTurn® RC, rigid clamping, Coromant Capto cutting units	A199
CoroTurn® RC, rigid clamping, shank holders	A200
T-Max® P, top clamping, Coromant Capto cutting units	A208
T-Max® P, lever clamping, shank holders	A207
High pressure coolant machining	
CoroTurn® HP lever clamping, Coromant Capto cutting units	A218
CoroTurn® HP, screw clamping, Coromant Capto cutting units	A123
Tools for small part machining	
CoroTurn® 107 shank holders	A124
CoroTurn® TR, T-Rail, shank holders	A166
Short holder for QS™ holding system	A257
CoroCut® XS shank holders	A224
Tools for multi-task machining	
	A230
	A233
	B91
CoroTurn SL cutting units for external machining	
	H1
	I12
Spare parts	
Torque wrenches	A438
	A437

Coromant Capto® cutting units for negative basic-shape inserts


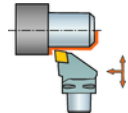

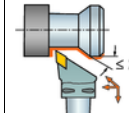

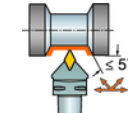

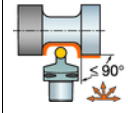

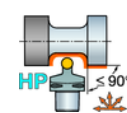

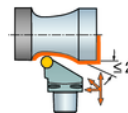

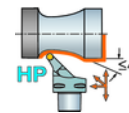

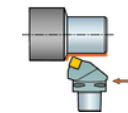

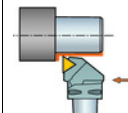

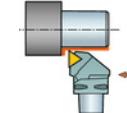

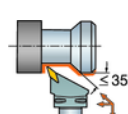

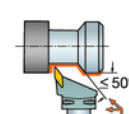

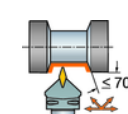

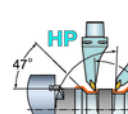

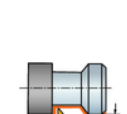

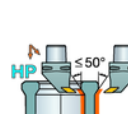

CoroTurn® RC rigid clamp design 	Entering angle (Lead angle)				
	$\kappa_r 95^\circ (-5^\circ)$	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 75^\circ (15^\circ)$	$107.5^\circ (-17.5^\circ)$	$93^\circ (-3^\circ)$
					
					
Insert size, mm	DCLNR/L	DCRNR/L	DCKNR/L	DDHNR/L	DDJNR/L
Insert size <i>iC</i> , inch	09-25	12-19	12-19	15	11-15
Coromant Capto® size	3/8-1	1/2-3/4	1/2-3/4	1/2	3/8-1/2
	C3-C8	C4-C8	C4-C8	C4-C8	C3-C8
Page	A115	A115	A115	A116	A116
Entering angle (Lead angle) $93^\circ (-3^\circ)$	$62.5^\circ (27.5^\circ)$	-	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 75^\circ (15^\circ)$	
					
					
	DDUNR/L	DDNNN	DRSNR/L	DSRNR/L	DSKNR/L
Insert size, mm	15	11-15	12	12-25	12-25
Insert size <i>iC</i> , inch	1/2	3/8-1/2	1/2	1/2-1	1/2-1
Coromant Capto® size	C4-C8	C4-C8	C4-C6	C3-C8	C3-C8
Page	A116	A116	A117	A118	A118
Entering angle (Lead angle) $45^\circ (45^\circ)$	$45^\circ (45^\circ)$	$93^\circ (-3^\circ)$	$91^\circ (-1^\circ)$	$91^\circ (-1^\circ)$	
					
					
	DSDNN	DSSNR/L	DTJNR/L	DTGNR/L	DTFNR/L
Insert size, mm	12-25	12-25	16-27	16-22	16-22
Insert size <i>iC</i> , inch	1/2-1	1/2-1	3/8-5/8	3/8-1/2	3/8-1/2
Coromant Capto® size	C3-C8	C3-C8	C3-C6	C4-C6	C3-C6
Page	A118	A118	A120	A120	A120
Entering angle (Lead angle) $60^\circ (30^\circ)$	$95^\circ (-5^\circ)$	$93^\circ (-3^\circ)$	$72.5^\circ (17.5^\circ)$	T-Max M, Top Clamp 	
					
					
	DTTNR/L	DWLNR/L	DVJNR/L	DVNN	Entering angle (Lead angle) $93^\circ (-3^\circ)$
Insert size, mm	16-22	06-08	16	16	
Insert size <i>iC</i> , inch	3/8-1/2	3/8-1/2	3/8	3/8	
Coromant Capto® size	C4-C6	C3-C8	C4-C8	C4-C8	MVJNR/L
Page	A120	A122	A121	A121	16
					3/8
					C4-C5
					A136

Coromant Capto® cutting units for negative basic-shape inserts

T-Max® P lever design 	Entering angle (Lead angle) 95° (-5°)		95° (-5°)		95° (-5°)		95° (-5°)		75° (15°)		κ_r 75° (15°)		κ_r 93° (-3°)		93° (-3°)		
																	
																	
	PCLNR/L	PCLNR/L-HP	PCLNR/L-HP	PCMNN-HP	PCNRN/L	PCNRN/L-HP	PDJNR/L	PDJNR/L-HP									
	Insert size, mm 12-25	12-19	12	12	12-19	16-19	11-15	15									
Insert size i/C, inch 1/2-1	1/2-3/4	1/2	1/2	1/2-3/4	5/8-3/4	3/8-1/2	1/2										
Coromant Capto® size C3-C10	C4-C10	C6	C6-C8	C5-C6	C6-C8	C3-C6	C4-C10										
Page A129	A124	H22	H22	A129	A124	A130	A125										
Entering angle (Lead angle) 93° (-3°) 	93° (-3°)		93° (-3°)		-		-		75° (15°)		κ_r 75° (15°)		75° (15°)		κ_r 75° (15°)		
																	
																	
	PDUNR/L-HP	PDJNR/L-HP	PDMNR/L-HP	PRDCN	PRSCR/L	PSNRN/L	PSNRN/L-HP	PSKNR/L	PSKNR/L-HP								
	15 1/2 C6-C8	15 1/2 C6	15 1/2 C6	25-32 .984-1.260 C6-C8	20-32 .787-1.260 C6-C8	12-25 1/2-1 C4-C8	15-19 5/8-3/4 C6-C8	12-25 1/2-1 C4-C8	15-19 5/8-3/4 C6-C8								
A126	H23	H23 A125	A131	A131	A132	A127	A132	A127									
Entering angle (Lead angle) 45° (45°) 	45° (45°)		45° (45°)		45° (45°)		45° (45°)		45° (45°)		45° (45°)		45° (45°)		45° (45°)		
																	
																	
	PSDNN	PSDNN-HP	PSSNR/L	PSSNR/L-HP	PSSNR/L-HP												
	12-25 1/2-1 C4-C8	15-19 5/8-3/4 C6	12-19 1/2-3/4 C3-C6	12-19 1/2-3/4 C5-C10	12 1/2 C6												
A133	A127	A133	A128	H24													
T-Max P wedge clamp design 	Entering angle (Lead angle) 93° (-3°)		95° (-5°)														
																	
																	
	MTJNR/L	MWLNR/L															
	16-27 3/8-5/8 C3-C6	06-08 3/8-1/2 C3-C5															
A134	A135																


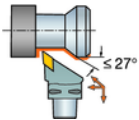
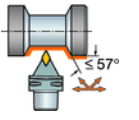
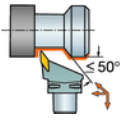
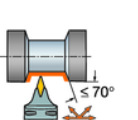




CoroTurn® HP, high pressure Coromant Capto® cutting units, see page A123

Coromant Capto® cutting units for positive basic-shape inserts

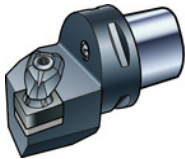
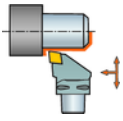
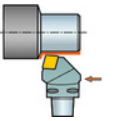
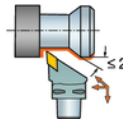
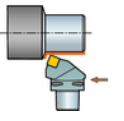








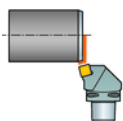
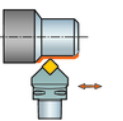
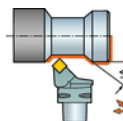
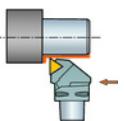








CoroTurn® 107 screw clamp design 	Entering angle (Lead angle)					
	95° (-5°)	93° (-3°)	62.5° (27.5°)	-	-	
	  SCLCR/L	  SDJCR/L	  SDNCN	  SRDCN	  SRDCN-HP	
Insert size, mm	09-12	07-11	11	05-20	12	
Insert size iC, inch	3/8-1/2	1/4-3/8	3/8	.197-.787	.472	
Coromant Capto® size	C3-C6	C3-C6	C3-C5	C3-C6	C6	
Page	A168	A168	A168	A169	A166	
	Entering angle (Lead angle)					
	-	-	75° (15°)	93° (-3°)	91° (-1°)	
	  SRSCR/L	  SRSCR/L-HP	  SSRCR/L	  STJCR/L	  STGCR/L	
Insert size, mm	06-20	10-12	09-12	11-16	11-16	
Insert size iC, inch	.236-.787	.394-.472	3/8-1/2	1/4-3/8	1/4-3/8	
Coromant Capto® size	C3-C6	C5-C6	C3-C5	C3-C5	C3-C6	
Page	A170	A166	A171	A172	A172	
	Entering angle (Lead angle)					
	107.5° (-17.5°)	93° (-3°)	72.5° (17.5°)	50° (40°)	93° (-3°)	93° (-3°)
	  SVHBR/L	  SVJBR/L	  SVVBN	  SVMBR/L-HP	  SVJBR/L-HP	  SVUBR/L-HP
Insert size, mm	11-16	11-16	11-16	16	16	16
Insert size iC, inch	1/4-3/8	1/4-3/8	1/4-3/8	3/8	3/8	3/8
Coromant Capto® size	C3-C6	C3-C6	C3-C6	C6	C4-C8	C4-C8
Page	A173	A173	A173	H25	A167	A167

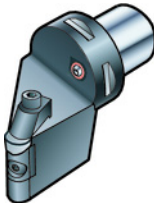
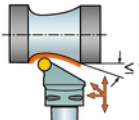
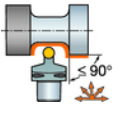
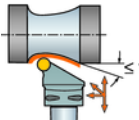



CoroTurn® HP, high pressure Coromant Capto® cutting units, see page

Coromant Capto® cutting units for positive basic-shape inserts

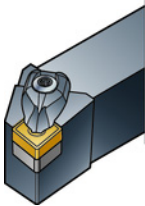
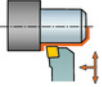
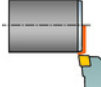
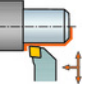
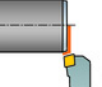
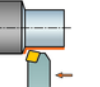
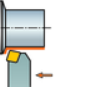
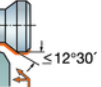
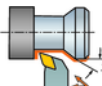
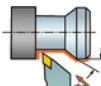
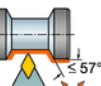
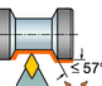
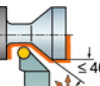
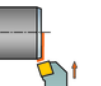
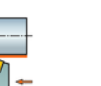
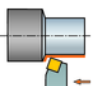
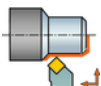
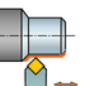
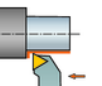
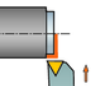
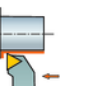

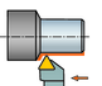
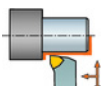
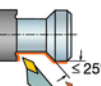
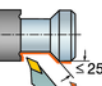
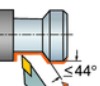
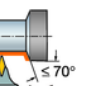
CoroTurn® TR screw clamp design 	Entering angle (Lead angle)			
	93° (-3°)	62.5° (27.5°)	93° (-3°)	72.5° (-17.5°)
				
				
Insert size, mm	D13JCR/L	D13NCN	V13JBR/L	V13VBN
Coromant Capto® size	13 C4-C6	13 C4-C6	13 C4-C6	13 C4-C6
Page	A193	A193	A194	A194

Coromant Capto® cutting units for ceramic inserts

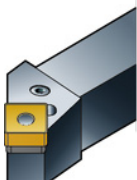
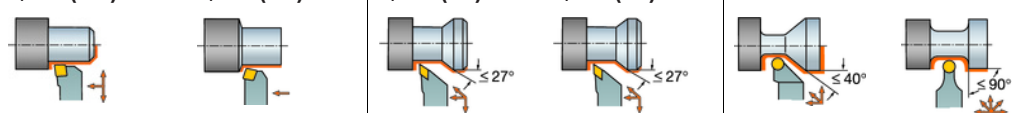

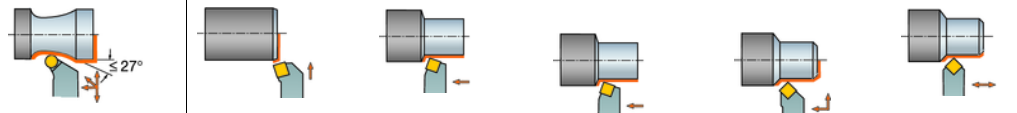

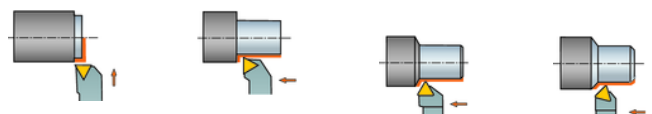

CoroTurn® RC rigid clamp design 	Entering angle (Lead angle)							
	95° (-5°)		75° (15°)		93° (-3°)		75° (15°)	
								
	 		 		 		 	
Insert size, mm	DCLNR/L	CCLNR/L	DCRNR/L	CCRNR/L	DDJNR/L	CDJNR/L	DSRNR/L	CSRNR/L
Insert size iC, inch	12-16 1/2-5/8	12-16 1/2-5/8	12-16 1/2-5/8	12-16 1/2-5/8	15 1/2	15 1/2	12 1/2	12-15 1/2-5/8
Coromant Capto® size	C4-C6	C4-C6	C4-C6	C4-C6	C5-C6	C5-C6	C4-C6	C4-C6
Page	A200	A201	A200	A201	A202	A202	A203	A204
	Entering angle (Lead angle)							
	75° (15°)		45° (45°)		45° (45°)		91° (-1°)	
								
	 		 		 		 	
Insert size, mm	DSKNR/L	CSKNR/L	DSDNN	CSDNN	DSSNR/L	CSSNR/L	DTGNR/L	CTGNR/L
Insert size iC, inch	12 1/2	12 1/2	12 1/2	12-15 1/2-5/8	12 1/2	12-15 1/2-5/8	22 1/2	22 1/2
Coromant Capto® size	C4-C6	C4-C6	C4-C6	C4-C6	C4-C6	C4-C6	C4-C6	C4-C6
Page	A203	A204	A203	A204	A205	A205	A206	A206

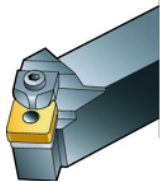
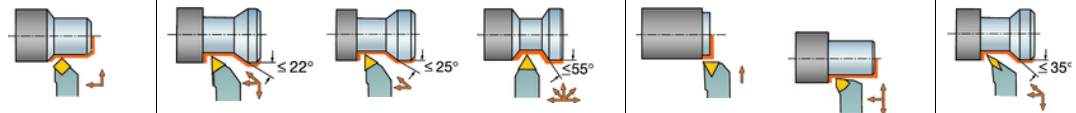

T-Max® top clamp design 	Entering angle (Lead angle)		
			
			
	CRSCR/L	CRDCN	CRSNR/L
Insert size, mm	9-12	9-12	9-12
Insert size iC, inch	3/8-1/2	3/8-1/2	3/8-1/2
Coromant Capto® size	C5	C5	C3-C6
Page	A207	A207	A207

Shank tools for negative basic-shape inserts

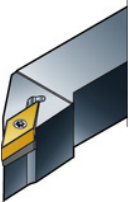
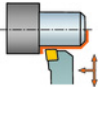
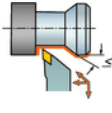
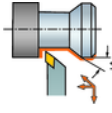
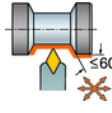
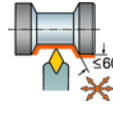
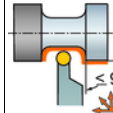
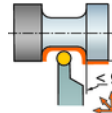
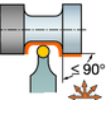
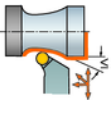
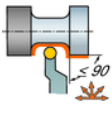
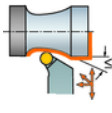
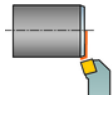
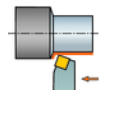
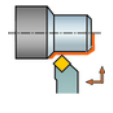
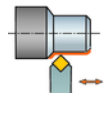
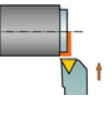
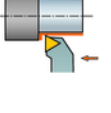
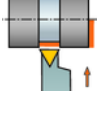
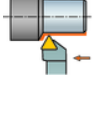
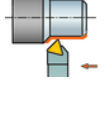
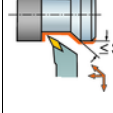
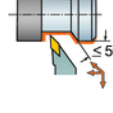
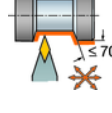

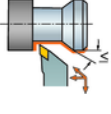
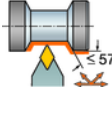
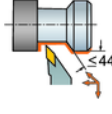
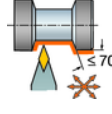
CoroTurn® RC rigid clamp design 	Entering angle (Lead angle)						
	$\kappa_r 95^\circ (-5^\circ)$	$\kappa_r 91^\circ (-1^\circ)$	$\kappa_r 91^\circ (-1^\circ)$	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 107.5^\circ (-17.5^\circ)$
							
	DCLNR/L	DCFNR/L	DCGNR/L	DCKNR/L	DCBNR/L	DCRNR/L	DDHNR/L
Insert size, mm	09-25	12	12-19	12-16	12-19	12-19	15
Insert size iC, inch	3/8-1	1/2	1/2-3/4	1/2-5/8	1/2-3/4	1/2-3/4	1/2
Shank size, mm	16-50	—	—	20-40	20-40	—	20-32
Shank size, inch	.625-1.500	1.000	1.000-1.250	.750-1.250	—	.750-1.500	—
Page	A137	A138	A138	A138	A139	A139	A140
	Entering angle (Lead angle)						
	$\kappa_r 107.5^\circ (-17.5^\circ)$	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 62.5^\circ (27.5^\circ)$	$\kappa_r 62.5^\circ (27.5^\circ)$	—	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 75^\circ (15^\circ)$
							
	DDQNR/L	DDJNR/L	DDPNN	DDNNN	DRSNR/L	DSKNR/L	DSBNR/L
Insert size, mm	—	11-15	—	11-15	09-25	09-25	09-25
Insert size iC, inch	3/8-1/2	3/8-1/2	3/8-1/2	3/8-1/2	3/8-1	3/8-1	3/8-1
Shank size, mm	—	16-40	—	20-40	20-40	20-50	16-50
Shank size, inch	.750-1.500	.625-1.500	.750-1.250	—	.750-1.250	.750-2.000	—
Page	A140	A140	A141	A141	A142	A143	A144
	Entering angle (Lead angle)						
	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 45^\circ (45^\circ)$	$\kappa_r 45^\circ (45^\circ)$	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 91^\circ (-1^\circ)$	$\kappa_r 91^\circ (-1^\circ)$	$\kappa_r 75^\circ (15^\circ)$
							
	DSRNR/L	DSSNR/L	DSDNN	DTJNR/L	DTFNR/L	DTGNR/L	DTRNR/L
Insert size, mm	—	09-25	09-25	16-27	16-33	16-27	—
Insert size iC, inch	3/8-1	3/8-1	3/8-1	3/8-5/8	3/8-3/4	3/8-3/4	3/8-1/2
Shank size, mm	—	16-40	16-40	16-40	16-40	16-40	—
Shank size, inch	.625-2.000	.625-1.500	.625-1.500	.750-1.500	.625-1.500	.625-1.500	.750-1.000
Page	A144	A145	A146	A147	A148	A149	A149
	Entering angle (Lead angle)						
	$\kappa_r 60^\circ (30^\circ)$	$\kappa_r 95^\circ (-5^\circ)$	$\kappa_r 117.5^\circ (-27.5^\circ)$	$\kappa_r 117.5^\circ (-27.5^\circ)$	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 72.5^\circ (17.5^\circ)$	
							
	DTTNR/L	DWLR/L	DVPR/L	DVTNR/L	DVJNR/L	DVNN	
Insert size, mm	16-22	06-08	16	—	16	16	
Insert size iC, inch	3/8-1/2	3/8-1/2	3/8	3/8	3/8	3/8	
Shank size, mm	16-25	16-40	25-40	—	20-40	20-40	
Shank size, inch	.625-1.000	.625-1.500	—	1.000-1.500	.750-1.500	.750-1.500	
Page	A149	A151	A150	A150	A150	A150	

Shank tools for negative basic-shape inserts

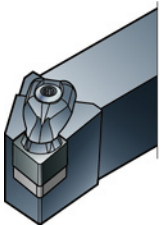

































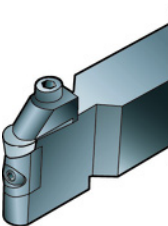










T-Max® P lever design  Insert size, mm Insert size <i>iC</i> , inch Shank size, mm Page	Entering angle (Lead angle) $\kappa_r 95^\circ (-5^\circ)$ $\kappa_r 75^\circ (15^\circ)$ $\kappa_r 93^\circ (-3^\circ)$ $\kappa_r 93^\circ (-3^\circ)$ - -   PCLNR/L PCBNR/L PDJNR/L R/L 171.35 PRGNR/L PRDCN 09-25 12-19 11-15 15 09-25 10-32 3/8-1 1/2-3/4 3/8-1/2 1/2 .354-.984 .394-1.260 16-50 25-40 16-32 25-32 20-40 20-50 A152 A152 A153 A153 A154 A154					
	Entering angle (Lead angle) - $\kappa_r 75^\circ (15^\circ)$ $\kappa_r 75^\circ (15^\circ)$ $\kappa_r 75^\circ (15^\circ)$ $\kappa_r 45^\circ$ $\kappa_r 45^\circ$   PRGCR/L PSKNR/L PSBNR/L PSRNR/L PSSNR/L PSDNN 10-32 09-25 09-25 09 09-25 09-25 .394-1.260 3/8-1 3/8-1 3/8 3/8-1 3/8-1 20-50 16-50 12-50 12 16-40 10-40 A154 A155 A155 A155 A156 A156					
	Entering angle (Lead angle) $\kappa_r 91^\circ (-1^\circ)$ $\kappa_r 91^\circ (-1^\circ)$ $\kappa_r 60^\circ (30^\circ)$ $\kappa_r 45^\circ$   PTFNR/L PTGNR/L PTTNR/L PTDNR/L 11-33 11-27 11-22 22 1/4-3/4 1/4-5/8 1/4-1/2 1/2 12-40 10-40 10-25 25 A157 A157 A158 A158					

T-Max P wedge clamp design  Insert size, mm Insert size <i>iC</i> , inch Shank size, mm Shank size, inch Page	Entering angle (Lead angle) $\kappa_r 45^\circ$ $\kappa_r 93^\circ (-3^\circ)$ $\kappa_r 91^\circ (-1^\circ)$ $\kappa_r 60^\circ (30^\circ)$ $\kappa_r 91^\circ (-1^\circ)$ $\kappa_r 95^\circ (-5^\circ)$ $\kappa_r 117.5^\circ (-27.5^\circ)$   MSSNR/L WTJNR/L WTGNR/L WTENN WTFNR/L MWLNR/L MVTNR/L 12-25 16-22 22 22 - 06-08 16 1/2-1 3/8-5/8 1/2 1/2-5/8 (1/2) 2020-3225 3/8 25-40 20-25 25-32 25-32 - - 19.5 - .750-1.500 1.000 1.000-1.250 1.000 - .750 A159 A160 A161 A161 A160 A162 A163						
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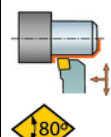
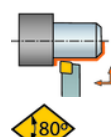
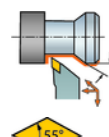
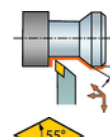
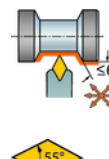
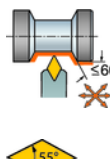
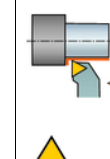
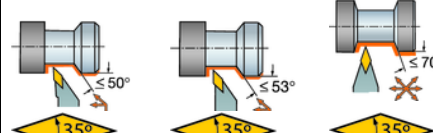
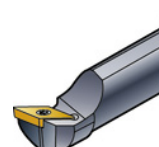
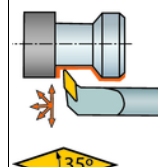
Shank tools for positive basic-shape inserts


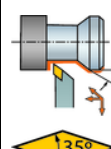
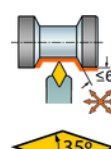
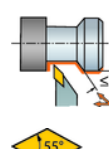
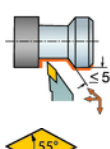

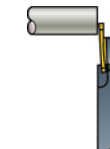
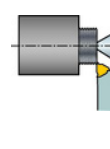
CoroTurn® 107 screw clamp design 	Entering angle (Lead angle)								
	$\kappa_r 95^\circ (-5^\circ)$	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 90^\circ (0^\circ)$	$\kappa_r 62.5^\circ (27.5^\circ)$	$\kappa_r 62.5^\circ (27.5^\circ)$	-	-	-	-
									
Insert size, mm (inch)	06-12 (1/4-1/2)	07-11 (1/4-3/8)	07-11 (1/4-3/8)	07-11 (1/4-3/8)	07-11 (1/4-3/8)	05-08 (.197-.315)	(1/4-1/2)	05-20 (.197-.787)	
Shank size, mm (inch)	08-25 (.375-1.250)	08-25 (.375-1.000)	08-16 (.375-.750)	10-25	(.375-1.000)	20-25	(1.000-1.250)	10-32 (.500-.625)	
Page	A174	A176	A177	A177	A177	A178	A178	A178	
Entering angle (Lead angle) Metric Inch -									
	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 45^\circ (45^\circ)$	$\kappa_r 45^\circ (45^\circ)$	$\kappa_r 91^\circ (-1^\circ)$				
									
Insert size, mm (inch)	05-20	(1/4-1)	(3/8-3/4)	09 (3/8)	09-12 (3/8-1/2)	09-12 (3/8-1/2)	09 (3/8)	09-16 (1/4-3/8)	
Shank size, mm (inch)	20-32	(.750-1.500)	(.750-1.250)	16 (.625)	16-25	16-25 (.625-1.000)	12-16 (.500-1.000)	10-25 (.375-1.000)	
Page	A179	A179	A179	A180	A180	A180	A180	A183	
Entering angle (Lead angle) $\kappa_r 91^\circ (-1^\circ)$ $\kappa_r 90^\circ (0^\circ)$ $\kappa_r 60^\circ (30^\circ)$ $\kappa_r 45^\circ (45^\circ)$									
	$\kappa_r 107.5^\circ (-17.5^\circ)$	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 72.5^\circ (17.5^\circ)$						
									
Insert size, mm (inch)	09-16 (1/4-3/8)	11-16 (1/4-3/8)	11-16 (3/8)	09-16 (1/4-3/8)	16-22 (3/8-1/2)	11-16 (1/4)	11-16 (1/4-3/8)		
Shank size, mm (inch)	08-25 (.375-1.000)	20-25	16-25 (.750-1.000)	10-25 (.375-.750)	20-25 (.750-1.000)	10-25 (.500-1.000)	12-25 (.500-1.250)		
Page	A181	A181	A182	A182	A184	A185	A187		
CoroTurn® TR HP screw clamp design 	Entering angle (Lead angle)								
	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 62.5^\circ (27.5^\circ)$	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 72.5^\circ (17.5^\circ)$					
									
Insert size, mm	13	13	13	13					
Shank size, mm (inch)	16-25 (.625-1.000)	16-25 (.625-1.000)	16-25 (.625-1.000)	16-25 (.625-1.000)					
Page	A195	A195	A197	A197					

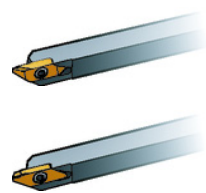
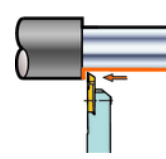
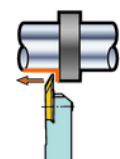
Shank tools for ceramic inserts

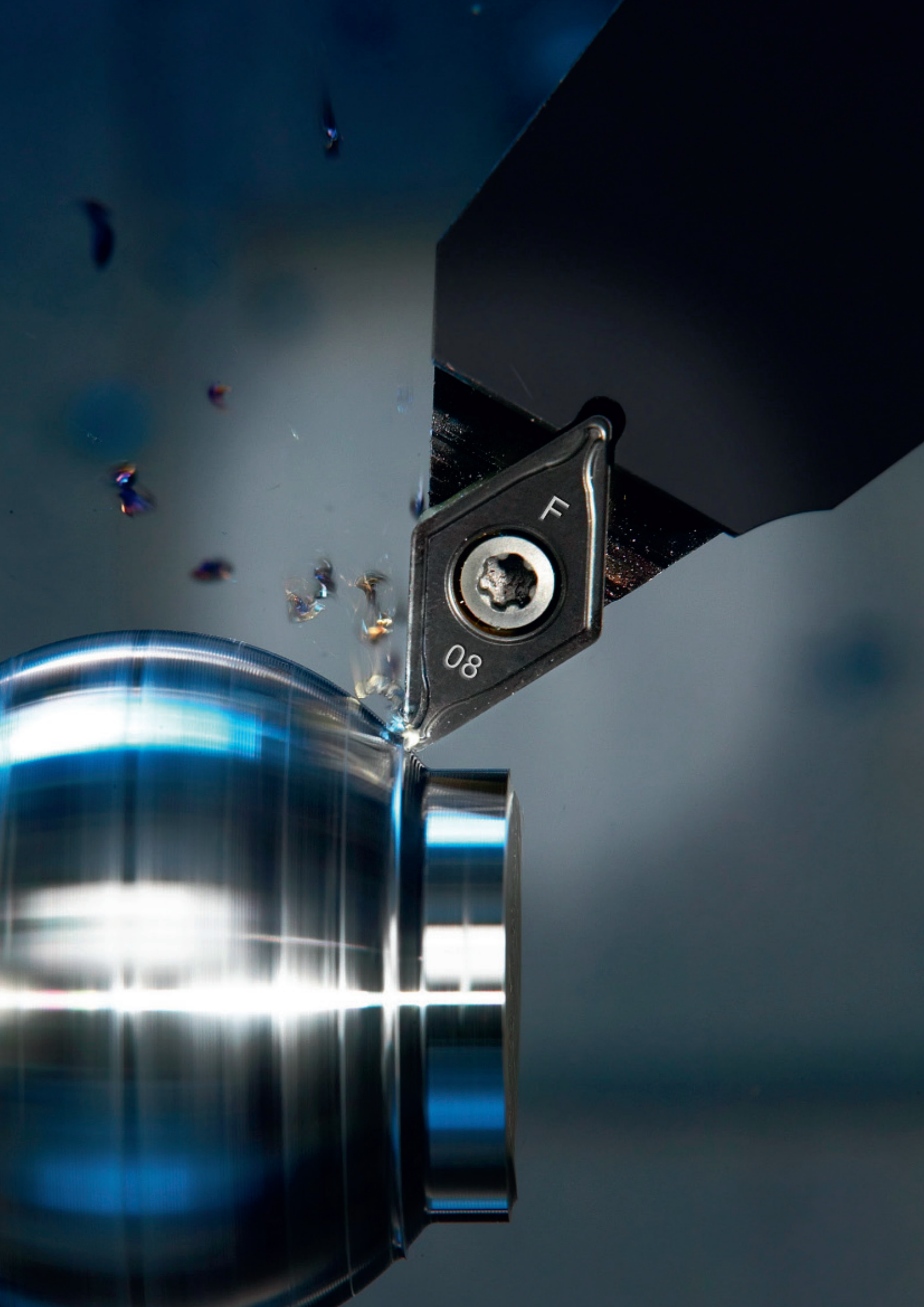
<div>CoroTurn® RC rigid clamp design</div> <div></div> <div>Insert size, mm Insert size iC, inch Shank size, mm Shank size, inch</div> <div>Page</div>	<div>Entering angle (Lead angle)</div> <div><div><div>κ_r 95° (-5°)</div><div></div><div></div><div></div><div>DCLNR/L</div><div>CCLNR/L</div></div><div><div>κ_r 75° (15°)</div><div></div><div></div><div></div><div>DCRNR/L DCBNR/L</div><div>CCRNR/L CCBNR/L</div></div><div><div>κ_r 93° (-3°)</div><div></div><div></div><div></div><div>DDJNR/L</div><div>CDJNR/L</div></div><div><div>κ_r 62.5° (27.5°)</div><div></div><div></div><div></div><div>DDNNR/L</div><div>CDNNR/L</div></div></div> <div><div>12-16 1/2-5/8 25-32 .750-1.500</div><div>12-16 1/2-5/8 25-32 .750-1.500</div><div>12-16 1/2-5/8 25-32 .750-1.500</div><div>12-16 1/2-5/8 25-32 .750-1.000</div><div>15 1/2 25-32 1.000-1.500</div><div>15 1/2 25-32 1.000-1.250</div><div>15 1/2 32 1.250</div></div> <div><div>A208</div><div>A209</div><div>A208</div><div>A209</div><div>A210</div><div>A211</div><div>A210</div><div>A211</div></div>							
	<div>Entering angle (Lead angle)</div> <div><div><div>κ_r 62.5° (27.5°)</div><div></div><div></div><div></div><div>DDNNN</div><div>CDNNN</div></div><div><div>κ_r 75° (15°)</div><div></div><div></div><div></div><div>DSRNR/L</div><div>CSRNR/L</div></div><div><div>κ_r 75° (15°)</div><div></div><div></div><div></div><div>DSKNR/L</div><div>CSKNR/L</div></div><div><div>κ_r 75° (15°)</div><div></div><div></div><div></div><div>DSBNR/L</div><div>CSBNR/L</div></div></div> <div><div>15 1/2 50</div><div>15 1/2 50</div><div>12 1/2 25-32 .750-1.500</div><div>12-15 1/2-5/8 25-32 .750-1.500</div><div>12 1/2 25-32 1.000</div><div>12 1/2 25 1.000</div><div>12 1/2 25</div></div> <div><div>A210</div><div>A211</div><div>A212</div><div>A214</div><div>A212</div><div>A214</div><div>A212</div><div>A214</div></div>							
	<div>Entering angle (Lead angle)</div> <div><div><div>κ_r 45° (45°)</div><div></div><div></div><div></div><div>DSSNR/L</div><div>CSSNR/L</div></div><div><div>κ_r 45° (45°)</div><div></div><div></div><div></div><div>DSDNN</div><div>CSDNN</div></div><div><div>κ_r 91° (-1°)</div><div></div><div></div><div></div><div>DTGNR/L</div><div>CTGNR/L</div></div></div> <div><div>12 1/2 25-32 1.000-1.250</div><div>12 1/2 25-32 1.000-1.250</div><div>12 1/2 25-32 1.000-1.250</div><div>12 1/2 25-32 1.000-1.250</div><div>22 1/2 32 1.250</div><div>22 1/2 32 1.250</div></div> <div><div>A212</div><div>A214</div><div>A212</div><div>A214</div><div>A216</div><div>A217</div></div>							
	<div>T-Max® top clamp design</div> <div></div> <div>Insert size, mm Insert size iC, inch Shank size, mm Shank size, inch</div> <div>Page</div>							
	<div>Entering angle (Lead angle)</div> <div><div><div></div><div></div><div>CRDCR/L</div></div><div><div></div><div></div><div>R/L176.9</div></div><div><div></div><div></div><div>CRDCN</div></div><div><div></div><div></div><div>CRDNN</div></div><div><div></div><div></div><div>CRSNR/L</div></div></div> <div><div>09-12 3/8-1/2 32</div><div>06 1/4 32</div><div>06-25 1/4-1 32-50</div><div>09-12 3/8-1/2 25-32</div><div>09-25 3/8-1 25-50</div></div> <div><div>A218</div><div>A218</div><div>A218</div><div>A219</div><div>A219</div></div>							

Shank tools for small part machining

CoroTurn® 107 screw clamp design	Entering angle (Lead angle) $\kappa_r 95^\circ (-5^\circ)$ $\kappa_r 90^\circ (0^\circ)$ $\kappa_r 93^\circ (-3^\circ)$ $\kappa_r 90^\circ (0^\circ)$ $\kappa_r 62.5^\circ (27.5^\circ)$ $\kappa_r 62.5^\circ (27.5^\circ)$ $\kappa_r 93^\circ (-3^\circ)$						
							
SCLCR/L	SCACR/L	SDJCR/L	SDACR/L	SDNCN	SDPCN	STJCR/L	
06-09	06-09	07-11	07-11	07-11	3/8	11	
1/4-3/8	1/4-3/8	1/4-3/8	1/4-3/8	1/4-3/8		1/4	
08-16	08-16	08-16	08-16	10-16		10-16	
.375-.750	.375-.750	.375-.750	.375-.750		.500-.750	.375-.625	
A224	A224	A225	A225	A225	A225	A226	
A238	A238	A239	-	A239	A239	A240	
Entering angle (Lead angle) $\kappa_r 93^\circ (-3^\circ)$ $\kappa_r 90^\circ (0^\circ)$ $\kappa_r 72.5^\circ (17.5^\circ)$			Inch boring bars		Entering angle (Lead angle) $\kappa_r 93^\circ (-3^\circ)$		
							
SVJBR/L	SVABR/L	SVVBN			SVUBL		
11-16	11-16	11	Insert size, mm		11		
1/4-3/8	1/4-3/8	1/4	Insert size iC, inch		1/4		
10-16	10-16	08-16	Bar diameter, inch		.750-1.000		
.375-.750	.375-.750	.375-.625					
A227	A228	A228	Page		A229		
A241	A241	A241	-				

CoroTurn® TR screw clamp design	Entering angle (Lead angle) $\kappa_r 93^\circ (-3^\circ)$ $\kappa_r 62.5^\circ (27.5^\circ)$ $\kappa_r 93^\circ (-3^\circ)$ $\kappa_r 72.5^\circ (17.5^\circ)$				CoroCut® 1-2	CoroCut® 3	CoroThread® 266
							
D13JCR/L	D13NCN	V13JBR/L	V13VBN		R/LF123	RF123T LF123U	266 R/LFA
13	13	13	13		-	-	10-16
16	16	16	16			10-16	
.625	.625	.625	.625		.375-670		.375-.625
A230	A230	A231	A231		B37 A244	B55 A242	C37 A245
-	-	-	-				

CoroCut® XS For total assortment, parting, grooving, threading and turning inserts, see page B85	Shank holder  SMALR/L	Inserts Turning  MAFR/L 3	Back turning  MABR/L 3
Insert size, mm	10-16		
Shank size, mm	.500-.625		
Shank size, inch			
Page	B91 A243	B89	B89
QS-holding system page			



Code key for shank tools and Coromant Capto® cutting units

Coromant Capto®

C3	-	D	C	L	N	R	22	040	-	09	-	
1		2	3	4	5	6	9	10		11		12







Shank tool, metric

D	C	L	N	R	25	25	M	12	-	2
2	3	4	5	6	7	8	10	11		13






























Shank tool, inch

D	C	L	N	R	16	4	D	-	
2	3	4	5	6	7-8	11	10		12

C

1 Coupling size, mm	2 Clamping system				
C = Coromant Capto® D _{5m} = Coupling size					
 C3 D _{5m} = 32 C4 D _{5m} = 40 C5 D _{5m} = 50 C6 D _{5m} = 63 C8 D _{5m} = 80 Coromant Capto®	C  Top clamping	D  Top and hole clamping (RC)	M, W  Top and hole clamping	P  Hole clamping	S  Screw clamping

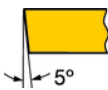
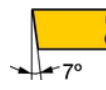


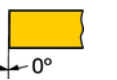

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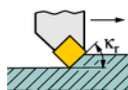
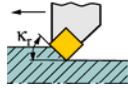
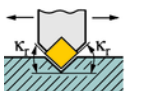
3 Insert shape		4 Holder style entering angle (lead angle)															
C		D		A		B		D		E		F		G		H	
K		R		J		K		L		M		N		Q		R	
S		T															
V		W		S		T		U		V		Y(X)		Y(Z)		P	

H



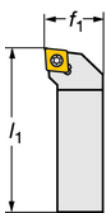


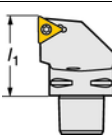
I










J

5 Insert clearance angle	
B 	C 
D 	E 
N 	P 
O Specific description	

6 Hand of tool	
R 	Feed
L 	Feed
N 	Feed

7 & 8 Shank size (b, width and h, height) inch	
05 = 5/16 X 5/16	85 = 1 X 1 1/4
06 = 3/8 X 3/8	86 = 1 X 1 1/2
08 = 1/2 X 1/2	20 = 1 1/4 X 1 1/4
10 = 5/8 X 5/8	24 = 1 1/2 X 1 1/2
12 = 3/4 X 3/4	32 = 2 X 2
16 = 1 X 1	
The seventh and eight position shall be a single significant two digit number which indicates the holders cross section. For shanks 5/8" square and over the number will represent the number of sixteenths inch of width and height.	
For shanks under 5/8" square the number of sixteenths inch of cross section will be preceded by a zero.	
For rectangular holders the first digit represents the number of eighths inch width, and the second digit the number of quarters inch of height.	

7 & 8 Shank size (b, width and h, height) metric		9 f_1 dimension, Coromant Capto®	10 Tool length and width, inch																								
7	Shank height  * Integers to be preceded by 0, e.g. h = 8 mm indicated by 08	 f_1 -dimension in mm (2 digits)	 <table><tr><td>A</td><td>$l_1 = 4''$</td></tr><tr><td>B</td><td>$l_1 = 4.5''$</td></tr><tr><td>C</td><td>$l_1 = 5''$</td></tr><tr><td>D</td><td>$l_1 = 6''$</td></tr><tr><td>E</td><td>$l_1 = 7''$</td></tr><tr><td>F</td><td>$l_1 = 8''$</td></tr><tr><td>M</td><td>$l_1 = 4''$</td></tr><tr><td>N</td><td>$l_1 = 4.5''$</td></tr><tr><td>P</td><td>$l_1 = 5''$</td></tr><tr><td>R</td><td>$l_1 = 6''$</td></tr><tr><td>S</td><td>$l_1 = 7''$</td></tr><tr><td>T</td><td>$l_1 = 8''$</td></tr></table>	A	$l_1 = 4''$	B	$l_1 = 4.5''$	C	$l_1 = 5''$	D	$l_1 = 6''$	E	$l_1 = 7''$	F	$l_1 = 8''$	M	$l_1 = 4''$	N	$l_1 = 4.5''$	P	$l_1 = 5''$	R	$l_1 = 6''$	S	$l_1 = 7''$	T	$l_1 = 8''$
A	$l_1 = 4''$																										
B	$l_1 = 4.5''$																										
C	$l_1 = 5''$																										
D	$l_1 = 6''$																										
E	$l_1 = 7''$																										
F	$l_1 = 8''$																										
M	$l_1 = 4''$																										
N	$l_1 = 4.5''$																										
P	$l_1 = 5''$																										
R	$l_1 = 6''$																										
S	$l_1 = 7''$																										
T	$l_1 = 8''$																										
8	Shank width  * Integers to be preceded by 0, e.g. b = 8 mm indicated by 08		SANDVIK standard <table><tr><td>G</td><td>$l_1 = 5.5''$</td></tr><tr><td>U</td><td>$l_1 = 5.5''$</td></tr><tr><td>V</td><td>$l_1 = 3.5''$</td></tr><tr><td>K</td><td>$l_1 = 14''$</td></tr></table>	G	$l_1 = 5.5''$	U	$l_1 = 5.5''$	V	$l_1 = 3.5''$	K	$l_1 = 14''$																
G	$l_1 = 5.5''$																										
U	$l_1 = 5.5''$																										
V	$l_1 = 3.5''$																										
K	$l_1 = 14''$																										
10 Shank tool length, metric  <table><tr><td>A = 32 mm</td><td>N = 150 mm</td></tr><tr><td>B = 40 mm</td><td>P = 170 mm</td></tr><tr><td>C = 50 mm</td><td>Q = 180 mm</td></tr><tr><td>D = 60 mm</td><td>R = 200 mm</td></tr><tr><td>E = 70 mm</td><td>S = 250 mm</td></tr><tr><td>G = 80 mm</td><td>T = 300 mm</td></tr><tr><td>H = 100 mm</td><td>U = 350 mm</td></tr><tr><td>J = 110 mm</td><td>V = 400 mm</td></tr><tr><td>K = 125 mm</td><td>W = 400 mm</td></tr><tr><td>L = 140 mm</td><td></td></tr><tr><td>M = 150 mm</td><td>X = Special</td></tr></table>		A = 32 mm	N = 150 mm	B = 40 mm	P = 170 mm	C = 50 mm	Q = 180 mm	D = 60 mm	R = 200 mm	E = 70 mm	S = 250 mm	G = 80 mm	T = 300 mm	H = 100 mm	U = 350 mm	J = 110 mm	V = 400 mm	K = 125 mm	W = 400 mm	L = 140 mm		M = 150 mm	X = Special	10 Coromant Capto® tool length, metric  l_1 -dimension in mm (3 digits)			
A = 32 mm	N = 150 mm																										
B = 40 mm	P = 170 mm																										
C = 50 mm	Q = 180 mm																										
D = 60 mm	R = 200 mm																										
E = 70 mm	S = 250 mm																										
G = 80 mm	T = 300 mm																										
H = 100 mm	U = 350 mm																										
J = 110 mm	V = 400 mm																										
K = 125 mm	W = 400 mm																										
L = 140 mm																											
M = 150 mm	X = Special																										

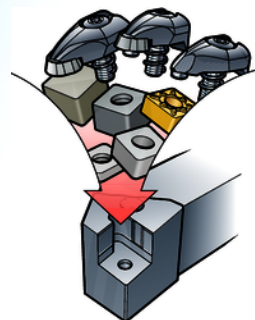
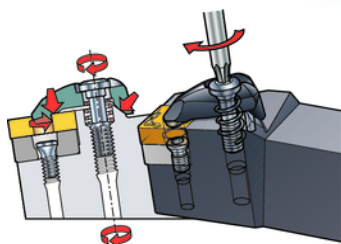
<p>11 Insert size</p> <p>Metric Cutting edge length</p> <div style="display: flex;"> <div style="width: 50%;">    </div> <div style="width: 50%;"> <p>Cutting edge length is indicated in mm.</p> </div> </div> <div style="display: flex;"> <div style="width: 50%;">    </div> <div style="width: 50%;"> <p>Integer (not rounded off).</p> </div> </div>	<p>Inch Inscribed circle is indicated in 1/8".</p> <div style="display: flex;"> <div style="width: 50%;">    </div> <div style="width: 50%;"> <p>1.2 = 5/32 1.5 = 3/16 1.8 = 7/32 2 = 1/4 2.5 = 5/8 3 = 3/8 4 = 1/2 5 = 5/8 6 = 3/4 8 = 1 10 = 1 1/4</p> </div> </div>	<p>12 Manufacturer's option</p> <p>When required a supplementary symbol of max 3 letters may be added to the ISO code, separated by a dash, e.g. W for wedge design.</p> <p>13 Clamping system ceramics</p> <p>-2 = CoroTurn® RC holders for inserts with hole</p> <p>-4 = CoroTurn® RC holders for inserts without hole</p>
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CoroTurn® RC rigid clamping

External tools for T-Max P negative basic-shape inserts

First choice for stability and security in productive turning

CoroTurn® RC system is available in Coromant Capto® cutting units and conventional shank design for all insert shapes and angles



The 1st choice system for turning, giving:

- Unique stability
- Excellent function even in dirty environments e.g. cast iron machining
- User-friendly handling; one Torx Plus key for insert and shim change
- Easy access even if holder is in up side down position

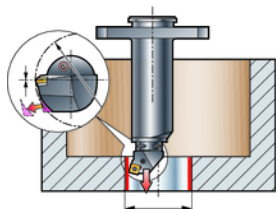
A flexible system

The tip seat on all CoroTurn® RC holders has been designed for total interchangeability, by changing clamp set and/or shim

CoroTurn® RC can hold:

- Cemented carbide inserts
- Ceramic inserts with holes
- Ceramic inserts without holes
- Different insert thicknesses

For further information see page A445.



Coromant Capto® cutting units for internal machining

All CoroTurn® RC cutting units have radial and axial reliefs to allow internal machining.



Multi-task machining

Coromant Capto® and CoroTurn® RC are secure and productive solutions for multi-task machining. CoroPlex™ an assortment of tools specially developed for multi-task machining, is available giving you superior accessibility and productivity.

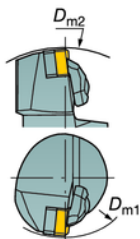
Coromant Capto® cutting units

CoroTurn® RC rigid clamp

Entering angle:
Lead angle:

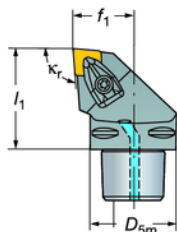


CNMM, CNGP
 CNMG
 CNMA, CNGA



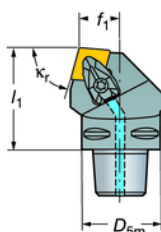
DCLNR/L

κ_r 95°
-5°



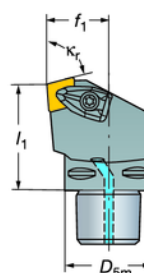
DCRNR/L

κ_r 75°
15°





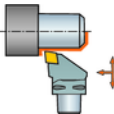
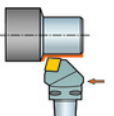
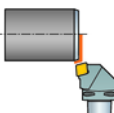
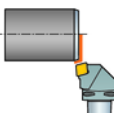
DCKNR/L

κ_r 75°
15°



Coolant inlet: Axial through the center

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)											Gauge inserts		
				D _{5m}	D _{m1} min mm ⁴⁾	D _{m1} min in. ⁴⁾	D _{m2} min mm ⁴⁾	D _{m2} min in. ⁴⁾	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _S ²⁾		ISO	ANSI
	09	3/8	C3-DCLNR/L-22040-09	32	60	2.362	116	4.567	22.0	.866	40.0	1.575	-6° -6°	0.2	CNMG 09 03 08	CNMG 322	1.7
			C4-DCLNR/L-27050-09	40	60	2.362	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.4	CNMG 09 03 08	CNMG 322	1.7
	12	1/2	C3-DCLNR/L-22045-12	32	60	2.362	121	4.764	22.0	.866	45.0	1.772	-6° -6°	0.2	CNMG 12 04 08	CNMG 432	3.9
			C4-DCLNR/L-27050-12	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.4	CNMG 12 04 08	CNMG 432	3.9
			C5-DCLNR/L-35060-12	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.8	CNMG 12 04 08	CNMG 432	3.9
			C6-DCLNR/L-45065-12	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	1.4	CNMG 12 04 08	CNMG 432	3.9
			C8-DCLNR/L-55080-12	80	110	4.331	250	9.842	55.0	2.165	80.0	3.150	-6° -6°	2.6	CNMG 12 04 08	CNMG 432	3.9
	16	5/8	C4-DCLNR/L-27055-16	40	125	4.921	145	5.709	27.0	1.063	55.0	2.165	-6° -6°	0.5	CNMG 16 06 12	CNMG 543	6.4
			C5-DCLNR/L-35060-16	50	125	4.921	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.8	CNMG 16 06 12	CNMG 543	6.4
			C6-DCLNR/L-45065-16	63	125	4.921	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	1.4	CNMG 16 06 12	CNMG 543	6.4
			C8-DCLNR/L-55080-16	80	125	4.921	250	9.842	55.0	2.165	80.0	3.150	-6° -6°	2.5	CNMG 16 06 12	CNMG 543	6.4
	19	3/4	C5-DCLNR/L-35060-19	50	80	3.150	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.9	CNMG 19 06 12	CNMG 643	6.4
			C6-DCLNR/L-45065-19	63	81	3.189	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	1.4	CNMG 19 06 12	CNMG 643	6.4
			C8-DCLNR/L-55080-19	80	100	3.937	250	9.842	55.0	2.165	80.0	3.150	-6° -6°	2.6	CNMG 19 06 12	CNMG 643	6.4
	25	1	C8-DCLNR/L-55080-25	80	150	5.906	250	9.842	55.0	2.165	80.0	3.150	-6° -6°	2.7	CNMG 25 09 24	CNMG 866	9.5
	12	1/2	C4-DCRNR/L-22050-12	40			140	5.512	22.0	.866	50.0	1.968	-6° -6°	0.5	CNMG 12 04 08	CNMG 432	3.9
			C5-DCRNR/L-27060-12	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	0.8	CNMG 12 04 08	CNMG 432	3.9
			C6-DCRNR/L-35065-12	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	1.4	CNMG 12 04 08	CNMG 432	3.9
	16	5/8	C5-DCRNR/L-27060-16	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	0.8	CNMG 16 06 12	CNMG 543	6.4
			C6-DCRNR/L-35065-16	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	1.3	CNMG 16 06 12	CNMG 543	6.4
			C8-DCRNR/L-55080-16	80			250	9.842	55.0	2.165	80.0	3.150	-6° -6°	2.7	CNMG 16 06 12	CNMG 543	6.4
	19	3/4	C5-DCRNR/L-27060-19	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	0.8	CNMG 19 06 12	CNMG 643	6.4
			C6-DCRNR/L-35065-19	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	1.3	CNMG 19 06 12	CNMG 643	6.4
			C8-DCRNR/L-55080-19	80			250	9.842	55.0	2.165	80.0	3.150	-6° -6°	2.5	CNMG 19 06 12	CNMG 643	6.4
	12	1/2	C4-DCKNR/L-27050-12	40	110	4.331			27.0	1.063	50.0	1.968	-6° -6°	0.5	CNMG 12 04 08	CNMG 432	3.9
			C5-DCKNR/L-35060-12	50	110	4.331			35.0	1.378	60.0	2.362	-6° -6°	0.8	CNMG 12 04 08	CNMG 432	3.9
			C6-DCKNR/L-45065-12	63	110	4.331			45.0	1.772	65.0	2.559	-6° -6°	1.5	CNMG 12 04 08	CNMG 432	3.9
	16	5/8	C4-DCKNR/L-27050-16	40	125	4.921			27.0	1.063	50.0	1.968	-6° -6°	0.5	CNMG 16 06 12	CNMG 543	6.4
			C5-DCKNR/L-35060-16	50	125	4.921			35.0	1.378	60.0	2.362	-6° -6°	0.9	CNMG 16 06 12	CNMG 543	6.4
			C6-DCKNR/L-45065-16	63	125	4.921			45.0	1.772	65.0	2.559	-6° -6°	1.5	CNMG 16 06 12	CNMG 543	6.4
	19	3/4	C6-DCKNR/L-45065-19	63	81	3.189			45.0	1.772	65.0	2.559	-6° -6°	1.5	CNMG 19 06 12	CNMG 643	6.4
			C8-DCKNR/L-55080-19	80	100	3.937			55.0	2.165	80.0	3.150	-6° -6°	2.9	CNMG 19 06 12	CNMG 643	6.4

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

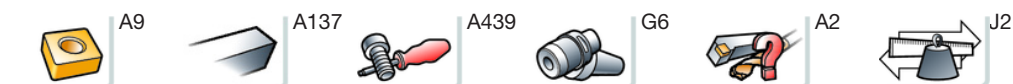
4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

Insert size			Shim screw				Shim		Key (Torx Plus)		Complete clamp set		Key (Torx Plus)	
iC	Coromant Capto® size													
09	3/8	C3-C4	5513 020-04	5322 236-04	5680 051-03 (9IP)	5412 028-011								
12	1/2	C3	5513 020-02	5322 236-03	5680 049-01 (15IP)	5412 028-021 ¹⁾								
12	1/2	C4-C8	5513 020-02	5322 234-01	5680 049-01 (15IP)	5412 028-021 ¹⁾								
16	5/8	C4-C8	5513 020-07	5322 234-03	5680 043-14 (20IP)	5412 028-031 ¹⁾								
19	3/4	C5-C8	5513 020-07	5322 236-01	5680 043-14 (20IP)	5412 028-041								
25	1	C8	5513 020-08	5322 234-05	5680 043-15 (25IP)	5412 028-051								

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



Coromant Capto® cutting units

CoroTurn® RC rigid clamp

Entering angle:
Lead angle:

DDJNR/L
 $\kappa_r 93^\circ$
-3°

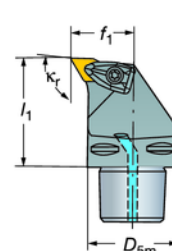
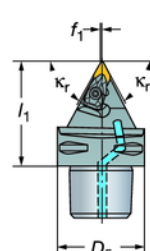
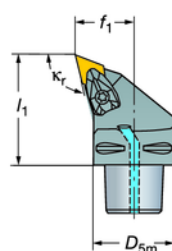
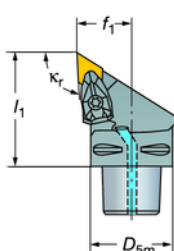
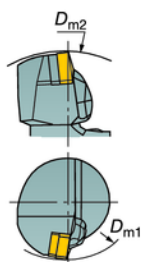
DDHNR/L
 $\kappa_r 107.5^\circ$
-17.5°

DDNNN
 $\kappa_r 62.5^\circ$
27.5°

DDUNR/L
 $\kappa_r 93^\circ$
-3°



DNMM, DNGP,
DNMX
DNMG
DNMA, DNGA



Coolant inlet: Axial through the center
Right hand style shown unless otherwise stated

Neutral

Main application		iC	Ordering code ⁵⁾	Dimensions, millimeter, inch (mm, in.)												Gauge inserts		
				D _{5m}	D _{m1} mm 4)	D _{m1} min in. 4)	D _{m2} mm 4)	D _{m2} min in. 4)	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾		ISO	ANSI	Nm ³⁾
	11	3/8	C3-DDJNR/L-22045-11	32	60	2.3622	121	4.7638	22.0	0.8661	45.0	1.7717	-6° -7°	0.2		DNMG 11 04 08	DNMG 332	1.7
			C4-DDJNR/L-27050-11	40	60	2.3622	140	5.5118	27.0	1.063	50.0	1.9685	-6° -7°	0.4		DNMG 11 04 08	DNMG 332	1.7
			C5-DDJNR/L-35060-11	50	65	2.5591	165	6.4961	35.0	1.378	60.0	2.3622	-6° -7°	0.7		DNMG 11 04 08	DNMG 332	1.7
			C6-DDJNR/L-45065-11	63	81	3.189	190	7.4803	45.0	1.7717	65.0	2.5591	-6° -7°	1.2		DNMG 11 04 08	DNMG 332	1.7
	15	1/2	C4-DDJNR/L-27055-15	40	110	4.3307	145	5.7087	27.0	1.063	55.0	2.1654	-6° -7°	0.5		DNMG 15 06 08	DNMG 442	3.9
			C4-DDJNR/L-27055-1504	40	110	4.3307	145	5.7087	27.0	1.063	55.0	2.1654	-6° -7°	0.5		DNMG 15 04 08	DNMG 432	3.9
			C5-DDJNR/L-35060-15	50	110	4.3307	165	6.4961	35.0	1.378	60.0	2.3622	-6° -7°	0.8		DNMG 15 06 08	DNMG 442	3.9
			C5-DDJNR/L-35060-1504	50	110	4.3307	165	6.4961	35.0	1.378	60.0	2.3622	-6° -7°	0.8		DNMG 15 04 08	DNMG 432	3.9
			C6-DDJNR/L-45065-15	63	110	4.3307	190	7.4803	45.0	1.7717	65.0	2.5591	-6° -7°	1.2		DNMG 15 06 08	DNMG 442	3.9
			C6-DDJNR/L-45065-1504	63	110	4.3307	190	7.4803	45.0	1.7717	65.0	2.5591	-6° -7°	1.2		DNMG 15 04 08	DNMG 432	3.9
	15	1/2	C8-DDJNR/L-55080-15	80	110	4.3307	250	9.8425	55.0	2.1654	80.0	3.1496	-6° -7°	2.3		DNMG 15 06 08	DNMG 442	3.9
			C8-DDJNR/L-55080-1504	80	110	4.3307	250	9.8425	55.0	2.1654	80.0	3.1496	-6° -7°	2.3		DNMG 15 04 08	DNMG 432	3.9
			C4-DDHNR/L-27055-15	40	110	4.3307	145	5.7087	27.0	1.063	55.0	2.1654	-6° -7°	0.4		DNMG 15 06 08	DNMG 442	3.9
			C4-DDHNR/L-27055-1504	40	110	4.3307	145	5.7087	27.0	1.063	55.0	2.1654	-6° -7°	0.4		DNMG 15 04 08	DNMG 432	3.9
			C5-DDHNR/L-35060-15	50	110	4.3307	165	6.4961	35.0	1.378	60.0	2.3622	-6° -7°	0.8		DNMG 15 06 08	DNMG 442	3.9
			C5-DDHNR/L-35060-1504	50	110	4.3307	165	6.4961	35.0	1.378	60.0	2.3622	-6° -7°	0.8		DNMG 15 04 08	DNMG 432	3.9
	15	1/2	C6-DDHNR/L-45065-15	63	110	4.3307	190	7.4803	45.0	1.7717	65.0	2.5591	-6° -7°	1.3		DNMG 15 06 08	DNMG 442	3.9
			C6-DDHNR/L-45065-1504	63	110	4.3307	190	7.4803	45.0	1.7717	65.0	2.5591	-6° -7°	1.3		DNMG 15 04 08	DNMG 432	3.9
			C8-DDHNR/L-55080-15	80	110	4.3307	250	9.8425	55.0	2.1654	80.0	3.1496	-6° -7°	2.6		DNMG 15 06 08	DNMG 442	3.9
			C8-DDHNR/L-55080-1504	80	110	4.3307	250	9.8425	55.0	2.1654	80.0	3.1496	-6° -7°	2.6		DNMG 15 04 08	DNMG 432	3.9
	11	3/8	C4-DDNNN-00050-11	40			140	5.5118	0.5	0.0197	50.0	1.9685	-5° -9°	0.4		DNMG 11 04 08	DNMG 332	1.7
			C5-DDNNN-00060-11	50			165	6.4961	0.5	0.0197	60.0	2.3622	-5° -9°	0.6		DNMG 11 04 08	DNMG 332	1.7
	15	1/2	C4-DDNNN-00055-15	40			145	5.7087	0.5	0.0197	55.0	2.1654	-5° -9°	0.4		DNMG 15 06 08	DNMG 442	3.9
			C4-DDNNN-00055-1504	40			145	5.7087	0.5	0.0197	55.0	2.1654	-5° -9°	0.4		DNMG 15 04 08	DNMG 432	3.9
			C5-DDNNN-00060-15	50			165	6.4961	0.5	0.0197	60.0	2.3622	-5° -9°	0.6		DNMG 15 06 08	DNMG 442	3.9
			C5-DDNNN-00060-1504	50			165	6.4961	0.5	0.0197	60.0	2.3622	-5° -9°	0.6		DNMG 15 04 08	DNMG 432	3.9
			C6-DDNNN-00065-15	63			190	7.4803	0.5	0.0197	65.0	2.5591	-5° -9°	1.1		DNMG 15 06 08	DNMG 442	3.9
			C6-DDNNN-00065-1504	63			190	7.4803	0.5	0.0197	65.0	2.5591	-5° -9°	1.1		DNMG 15 04 08	DNMG 432	3.9
			C8-DDNNN-00080-15	80			250	9.8425	0.5	0.0197	80.0	3.1496	-5° -9°	2.1		DNMG 15 06 08	DNMG 442	3.9
			C8-DDNNN-00080-1504	80			250	9.8425	0.5	0.0197	80.0	3.1496	-5° -9°	2.1		DNMG 15 04 08	DNMG 432	3.9
	15	1/2	C4-DDUNR/L-27050-15	40	110	4.3307	140	5.5118	27.0	1.063	50.0	1.9685	-6° -7°	0.4		DNMG 15 06 08	DNMG 442	3.9
			C4-DDUNR/L-27050-1504	40	110	4.3307	140	5.5118	27.0	1.063	50.0	1.9685	-6° -7°	0.4		DNMG 15 04 08	DNMG 432	3.9
			C5-DDUNR/L-35060-15	50	110	4.3307	165	6.4961	35.0	1.378	60.0	2.3622	-6° -7°	0.8		DNMG 15 06 08	DNMG 442	3.9
			C5-DDUNR/L-35060-1504	50	110	4.3307	165	6.4961	35.0	1.378	60.0	2.3622	-6° -7°	0.8		DNMG 15 04 08	DNMG 432	3.9
			C6-DDUNR/L-45065-15	63	110	4.3307	190	7.4803	45.0	1.7717	65.0	2.5591	-6° -7°	1.4		DNMG 15 06 08	DNMG 442	3.9
			C6-DDUNR/L-45065-1504	63	110	4.3307	190	7.4803	45.0	1.7717	65.0	2.5591	-6° -7°	1.4		DNMG 15 04 08	DNMG 432	3.9
			C8-DDUNR/L-55080-15	80	110	4.3307	250	9.8425	55.0	2.1654	80.0	3.1496	-6° -7°	2.6		DNMG 15 06 08	DNMG 442	3.9
			C8-DDUNR/L-55080-1504	80	110	4.3307	250	9.8425	55.0	2.1654	80.0	3.1496	-6° -7°	2.6		DNMG 15 04 08	DNMG 432	3.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

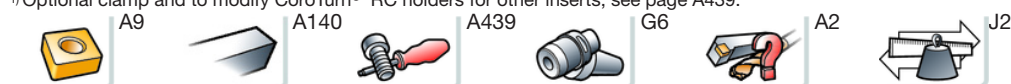
5) -1504 in the end of the ordering code = For inserts with thickness 4.76 mm (1/4")

R = Right hand, L = Left hand

Main spare parts

Insert size			Coromant Capto® size				
iC			Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
11	3/8	C3-C6	5513 020-04	5322 267-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
1506 (DNMG 44)	1/2	C4-C8	5513 020-02	5322 266-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
1504 (DNMG 43)	1/2		5513 020-02	5322 266-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



Coromant Capto® cutting units

CoroTurn® RC rigid clamp

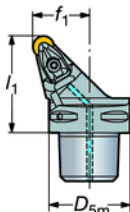
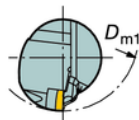
Neg.

DRSNR/L



RNMG

RNGA



Coolant inlet: Axial through the center

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)												Gauge inserts		
				D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_{s^{2)}$		ISO	ANSI	Nm ³⁾
	12	1/2	C4-DRSNR/L-27050-12	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6°	-6°	0.4	RNMG 12 04 00	RNMG 43	3.9
			C5-DRSNR/L-35060-12	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6°	-6°	0.7	RNMG 12 04 00	RNMG 43	3.9
			C6-DRSNR/L-45065-12	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6°	-6°	1.2	RNMG 12 04 00	RNMG 43	3.9

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

Insert size							
O	iC	Coromant Capto® size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
12	1/2	C4-C6	5513 020-02	5322 155-02	5680 049-01 (9IP)	5412 028-021	5680 049-01 (15IP)



A9



A142



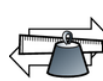
A439



G6



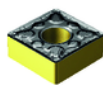
A2



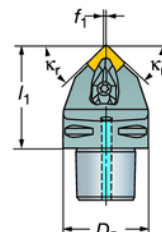
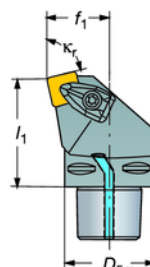
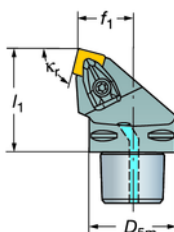
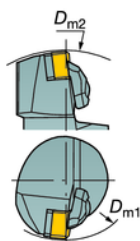
J2

Coromant Capto® cutting units

CoroTurn® RC rigid clamp

Entering angle:
Lead angle:DSRNR/L
 $\kappa_r 75^\circ$
15°DSKNR/L
 $\kappa_r 75^\circ$
15°DSDNN
 $\kappa_r 45^\circ$
45°

SNMM
 SNMG
 SNMA, SNGA



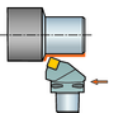
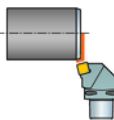
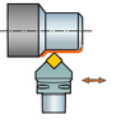


B

C

Coolant inlet: Axial through the center
Right hand style shown unless otherwise stated

Neutral

			Dimensions, millimeter, inch (mm, in.)													Gauge inserts			
Main application		iC	Ordering code	D _{5m}	D _{m1} min mm ⁴⁾ D _{m1} min in. ⁴⁾		D _{m2} min mm ⁴⁾ D _{m2} min in. ⁴⁾		f ₁ mm f ₁ in.		l ₁ mm l ₁ in.		γ ¹⁾	λ _s ²⁾		ISO	ANSI	Nm ³⁾	
	12	1/2	C3-DSRNR/L-19048-12	32			124	4.882	19.0	.748	48.0	1.890	-6°	-6°		SNMG 12 04 08	SNMG 432	3.9	
			C4-DSRNR/L-22050-12	40			140	5.512	22.0	.866	50.0	1.968	-6°	-6°	0.4	SNMG 12 04 08	SNMG 432	3.9	
			C5-DSRNR/L-27060-12	50			165	6.496	27.0	1.063	60.0	2.362	-6°	-6°	0.8	SNMG 12 04 08	SNMG 432	3.9	
			C6-DSRNR/L-35065-12	63			190	7.480	35.0	1.378	65.0	2.559	-6°	-6°	1.4	SNMG 12 04 08	SNMG 432	3.9	
	15	5/8	C5-DSRNR/L-27060-15	50			165	6.496	27.0	1.063	60.0	2.362	-6°	-6°	0.8	SNMG 15 06 12	SNMG 543	6.4	
			C6-DSRNR/L-35065-15	63			190	7.480	35.0	1.378	65.0	2.559	-6°	-6°	1.3	SNMG 15 06 12	SNMG 543	6.4	
	19	3/4	C5-DSRNR/L-27060-19	50			165	6.496	27.0	1.063	60.0	2.362	-6°	-6°	0.8	SNMG 19 06 12	SNMG 643	6.4	
			C6-DSRNR/L-35065-19	63			190	7.480	35.0	1.378	65.0	2.559	-6°	-6°	1.3	SNMG 19 06 12	SNMG 643	6.4	
		C8-DSRNR/L-45080-19	80			250	9.842	45.0	1.772	80.0	3.150	-6°	-6°	2.5	SNMG 19 06 12	SNMG 643	6.4		
	25	1	C8-DSRNR/L-45080-25	80			250	9.842	45.0	1.772	80.0	3.150	-6°	-6°	2.6	SNMG 25 07 24	SNMG 856	9.5	
	12	1/2	C3-DSKNR/L-22040-12	32	60	2.362			22.0	.866	40.0	1.575	-6°	-6°		SNMG 12 04 08	SNMG 432	3.9	
			C4-DSKNR/L-27050-12	40	110	4.331			27.0	1.063	50.0	1.968	-6°	-6°	0.5	SNMG 12 04 08	SNMG 432	3.9	
			C5-DSKNR/L-35060-12	50	110	4.331			35.0	1.378	60.0	2.362	-6°	-6°	0.8	SNMG 12 04 08	SNMG 432	3.9	
			C6-DSKNR/L-45065-12	63	110	4.331			45.0	1.772	65.0	2.559	-6°	-6°	1.4	SNMG 12 04 08	SNMG 432	3.9	
	15	5/8	C5-DSKNR/L-35060-15	50	125	4.921			35.0	1.378	60.0	2.362	-6°	-6°	0.8	SNMG 15 06 12	SNMG 543	6.4	
			C6-DSKNR/L-45065-15	63	125	4.921			45.0	1.772	65.0	2.559	-6°	-6°	1.5	SNMG 15 06 12	SNMG 543	6.4	
	19	3/4	C5-DSKNR/L-35060-19	50	125	4.921			35.0	1.378	60.0	2.362	-6°	-6°		SNMG 19 06 12	SNMG 643	6.4	
			C6-DSKNR/L-45065-19	63	125	4.921			45.0	1.772	65.0	2.559	-6°	-6°	1.5	SNMG 19 06 12	SNMG 643	6.4	
		C8-DSKNR/L-55080-19	80	125	4.921			55.0	2.165	80.0	3.150	-6°	-6°	2.7	SNMG 19 06 12	SNMG 643	6.4		
	25	1	C8-DSKNR/L-55080-25	80	150	5.906			55.0	2.165	80.0	3.150	-6°	-6°	2.9	SNMG 25 07 24	SNMG 856	9.5	
	12	1/2	C3-DSDNN-00048-12	32			124	4.882	0.3	.012	48.0	1.890	-6°	-6°	0.3	SNMG 12 04 08	SNMG 432	3.9	
			C4-DSDNN-00050-12	40			140	5.512	0.3	.012	50.0	1.968	-6°	-6°	0.4	SNMG 12 04 08	SNMG 432	3.9	
			C5-DSDNN-00060-12	50			165	6.496	0.3	.012	60.0	2.362	-6°	-6°	0.8	SNMG 12 04 08	SNMG 432	3.9	
			C6-DSDNN-00065-12	63			190	7.480	0.3	.012	65.0	2.559	-6°	-6°	1.3	SNMG 12 04 08	SNMG 432	3.9	
	15	5/8	C5-DSDNN-00060-15	50			165	6.496	0.5	.020	60.0	2.362	-6°	-6°	0.7	SNMG 15 06 12	SNMG 543	6.4	
			C6-DSDNN-00065-15	63			190	7.480	0.5	.020	65.0	2.559	-6°	-6°	1.2	SNMG 15 06 12	SNMG 543	6.4	
	19	3/4	C5-DSDNN-00065-19	50			170	6.693	0.5	.020	65.0	2.559	-6°	-6°	0.8	SNMG 19 06 12	SNMG 643	6.4	
			C6-DSDNN-00070-19	63			195	7.677	0.5	.020	70.0	2.756	-6°	-6°	1.1	SNMG 19 06 12	SNMG 643	6.4	
	25	1	C8-DSDNN-00080-25	80			250	9.842	1.0	.039	80.0	3.150	-6°	-6°	2.9	SNMG 25 07 24	SNMG 856	9.5	

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

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

Main spare parts

Insert size

□	iC	Coromant Capto® size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
12	1/2	C3	5513 020-02	5322 426-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
12	1/2	C4-C6	5513 020-02	5322 425-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
15	5/8	C5-C6	5513 020-07	5322 425-03	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
19	3/4	C5-C8	5513 020-07	5322 425-04	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)
25	1	C8	5513 020-08	5322 425-07	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)

1) Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.

J



A9



A143



A439



G6



A2



J2

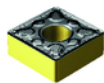
Coromant Capto® cutting units

CoroTurn® RC rigid clamp

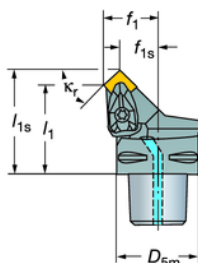
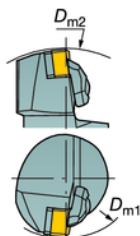
Entering angle:
Lead angle:

DSSNR/L


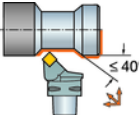
κ_r 45°
45°



SNMM
SNMG
SNMA, SNGA



Coolant inlet: Axial through the center
Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, mm, inch									Gauge inserts		
				D _{5m}	D _{m1} min ⁴⁾	D _{m2} min ⁴⁾	f ₁	f _{1s}	l ₁	l _{1s}	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾
	12	1/2	C3-DSSNR/L-22040-12	32	60	124	22	13.7	40	48.3	-8°	0°	SNMG 12 04 08	SNMG 432	3.9
					2.3622	4.882	.866	.539	1.575	1.902	-8°	0°			
			C4-DSSNR/L-27042-12	40	110	140	27	18.7	42	50.3	-8°	0°	SNMG 12 04 08	SNMG 432	3.9
					4.3307	5.512	1.063	.736	1.654	1.980	-8°	0°			
			C5-DSSNR/L-35052-12	50	110	165	35	26.7	52	60.3	-8°	0°	SNMG 12 04 08	SNMG 432	3.9
					4.3307	6.496	1.378	1.051	2.047	2.374	-8°	0°			
			C6-DSSNR/L-45056-12	63	110	190	45	36.7	56	64.3	-8°	0°	SNMG 12 04 08	SNMG 432	3.9
					4.3307	7.480	1.772	1.445	2.205	2.532	-8°	0°			
	15	5/8	C4-DSSNR/L-27045-15	40	125	145	27	16.8	45	55.2	-8°	0°	SNMG 15 06 12	SNMG 543	6.4
					4.9213	5.709	1.063	.661	1.772	2.173	-8°	0°			
			C5-DSSNR/L-35050-15	50	125	165	35	24.8	50	60.2	-8°	0°	SNMG 15 06 12	SNMG 543	6.4
					4.9213	6.496	1.378	.976	1.968	2.370	-8°	0°			
			C6-DSSNR/L-45054-15	63	125	190	45	34.8	54	64.2	-8°	0°	SNMG 15 06 12	SNMG 543	6.4
					4.9213	7.480	1.772	1.370	2.126	2.528	-8°	0°			
	19	3/4	C5-DSSNR/L-35048-19	50	125	165	35	22.5	48	60.5	-8°	0°	SNMG 19 06 12	SNMG 643	6.4
					4.9213	6.496	1.378	.886	1.890	2.382	-8°	0°			
		C6-DSSNR/L-45052-19	63	125	190	45	32.5	52	64.5	-8°	0°	SNMG 19 06 12	SNMG 643	6.4	
				4.9213	7.480	1.772	1.280	2.047	2.539	-8°	0°				
25	1	C8-DSSNR/L-55070-25	80	150	256	55	39.0	70	86.0	-8°	0°	SNMG 25 07 24	SNMG 856	9.5	
				5.9055	10.079	2.165	1.535	2.756	3.386	-8°	0°				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

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

Main spare parts

Insert size

□	iC	Coromant Capto® size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
12	1/2	C3	5513 020-02	5322 426-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
12	1/2	C4-C6	5513 020-02	5322 425-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
15	5/8	C5-C6	5513 020-07	5322 425-03	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
19	3/4	C5-C8	5513 020-07	5322 425-04	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)
25	1	C8	5513 020-08	5322 425-07	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A143



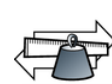
A439



G6



A2



J2

Coromant Capto® cutting units

CoroTurn® RC rigid clamp

Entering angle:
Lead angle:

DTJNR/L

 $\kappa_r 93^\circ$
-3°

DTGNR/L

 $\kappa_r 91^\circ$
-1°

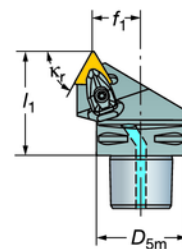
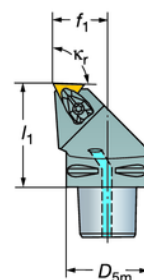
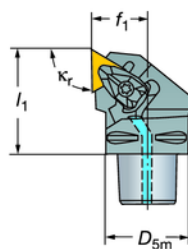
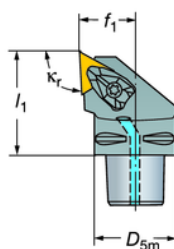
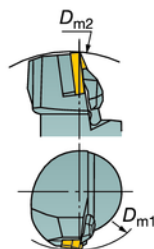
DTFNR/L

 $\kappa_r 91^\circ$
-1°

DTTNR/L



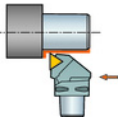
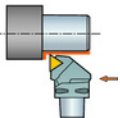
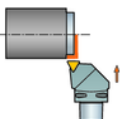
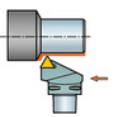
 $\kappa_r 60^\circ$
30°


TNMM, TNMX
TNMG
TNMA, TNGA



Coolant inlet: Axial through the center

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)												Gauge inserts		
				D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^1)$	$\lambda_s^{2)}$		ISO	ANSI	Nm ³⁾
	16	3/8	C3-DTJNR/L-22040-16	32	60	2.362	116	4.567	22.0	.866	40.0	1.575	-6° -6°	0.2	TNMG 16 04 08	TNMG 332	1.7	
			C4-DTJNR/L-27050-16	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.4	TNMG 16 04 08	TNMG 332	1.7	
			C5-DTJNR/L-35060-16	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.8	TNMG 16 04 08	TNMG 332	1.7	
			C6-DTJNR/L-45065-16	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	1.3	TNMG 16 04 08	TNMG 332	1.7	
	22	1/2	C4-DTJNR/L-27050-22	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.4	TNMG 22 04 08	TNMG 432	3.9	
			C5-DTJNR/L-35060-22	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	1.0	TNMG 22 04 08	TNMG 432	3.9	
	27	5/8	C6-DTJNR/L-45065-27	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	1.4	TNMG 27 06 12	TNMG 543	6.4	
			C4-DTGNR/L-27050-16	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.5	TNMG 16 04 08	TNMG 332	1.7	
			C5-DTGNR/L-35060-16	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.8	TNMG 16 04 08	TNMG 332	1.7	
			C6-DTGNR/L-45065-16	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	1.4	TNMG 16 04 08	TNMG 332	1.7	
	22	1/2	C4-DTGNR/L-27050-22	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.5	TNMG 22 04 08	TNMG 432	3.9	
			C5-DTGNR/L-35060-22	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.9	TNMG 22 04 08	TNMG 432	3.9	
	16	3/8	C3-DTFNR/L-22040-16	32	60	2.362	116	4.567	22.0	.866	40.0	1.575	-6° -6°	0.2	TNMG 16 04 08	TNMG 332	1.7	
			C4-DTFNR/L-27050-16	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.4	TNMG 16 04 08	TNMG 332	1.7	
			C5-DTFNR/L-35060-16	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.8	TNMG 16 04 08	TNMG 332	1.7	
			C6-DTFNR/L-45065-16	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	1.4	TNMG 16 04 08	TNMG 332	1.7	
	22	1/2	C4-DTFNR/L-27050-22	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	0.5	TNMG 22 04 08	TNMG 432	3.9	
			C5-DTFNR/L-35060-22	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	0.8	TNMG 22 04 08	TNMG 432	3.9	
	16	3/8	C4-DTTNR/L-22050-16	40			140	5.512	22.0	.866	50.0	1.968	-6° -6°	0.4	TNMG 16 04 08	TNMG 332	1.7	
			C5-DTTNR/L-27060-16	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	0.7	TNMG 16 04 08	TNMG 332	1.7	
			C5-DTTNR/L-27060-22	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	0.7	TNMG 22 04 08	TNMG 432	3.9	
			C6-DTTNR/L-35065-22	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	1.2	TNMG 22 04 08	TNMG 432	3.9	


1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

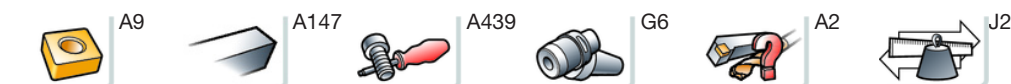
3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Coromant Capto® size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
16	3/8	C3	5513 020-04	5322 316-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
16	3/8	C4-C6	5513 020-04	5322 315-02	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
22	1/2	C4-C6	5513 020-02	5322 315-04	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
27	5/8	C6	5513 020-07	5322 315-05	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.

Coromant Capto® cutting units

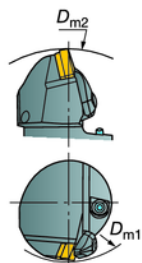
CoroTurn® RC rigid clamp



VNMG

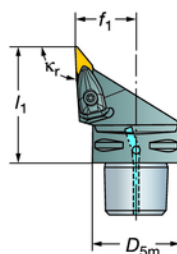
VNGP

Entering angle:
Lead angle:



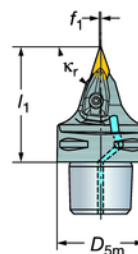
DVJNR/L

$\kappa_r 93^\circ$
-3°



DVVNN



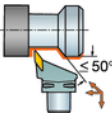
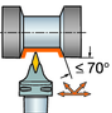
$\kappa_r 72^\circ 30'$
17.5°



Neutral

Coolant inlet: Axial through the center

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)												Gauge inserts			
				D_{5m}	D_{m1} min mm 4)	D_{m1} min in.4)	D_{m2} min mm 4)	D_{m2} min in.4)	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^1)$	$\lambda_s^2)$		ISO	ANSI	Nm 3)	
	16	3/8	C4-DVJNR/L-27062-16	40	60	2.362	152	5.984	27.0	1.063	62.0	2.441	-4°	-13°	0.5	VNMG 16 04 08	VNMG 332	3.0	
			C5-DVJNR/L-35065-16	50	65	2.559	170	6.693	35.0	1.378	65.0	2.559	-4°	-13°	0.8	VNMG 16 04 08	VNMG 332	3.0	
			C6-DVJNR/L-45065-16	63	81	3.189	190	7.480	45.0	1.772	65.0	2.559	-4°	-13°	1.3	VNMG 16 04 08	VNMG 332	3.0	
			C8-DVJNR/L-55080-16	80	100	3.937	250	9.842	55.0	2.165	80.0	3.150	-4°	-13°	2.2	VNMG 16 04 08	VNMG 332	3.0	
	16	3/8	C4-DVVNN-00062-16	40			152	5.984	0.6	.024	62.0	2.441	-4°	-13°	0.4	VNMG 16 04 08	VNMG 332	3.0	
			C5-DVVNN-00065-16	50			170	6.693	0.6	.024	65.0	2.559	-4°	-13°	0.5	VNMG 16 04 08	VNMG 332	3.0	
			C6-DVVNN-00065-16	63			190	7.480	0.6	.024	65.0	2.559	-4°	-13°	1.0	VNMG 16 04 08	VNMG 332	3.0	
			C8-DVVNN-00080-16	80			250	9.842	0.6	.024	80.0	3.150	-4°	-13°	2.0	VNMG 16 04 08	VNMG 332	3.0	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Insert size							
	iC	Coromant Capto® size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
16	3/8	C4-C8	5513 020-09	5322 269-01	5680 049-01 (15IP)	5412 028-061	5680 049-01 (15IP)



A9



A150



A439



G6



A2



J2

Coromant Capto® cutting units

CoroTurn® RC rigid clamp

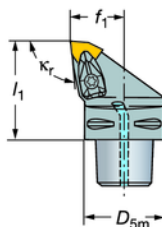
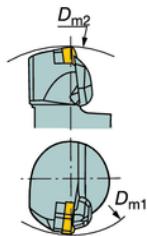
Entering angle:
Lead angle:

DWLNR/L

$\kappa_r 95^\circ$
 -5°



WNMM,
WNMG
WNGA, WNMA



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application	γ	iC	Ordering code	Dimensions, millimeter, inch (mm, in.)												Gauge inserts		
				D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^1)$	$\lambda_s^2)$	$\lambda_s^2)$	ISO	ANSI	Nm ³⁾
	06	3/8	C3-DWLNR/L-22040-06	32	60	2.362	116	4.567	22.0	.866	40.0	1.575	-6°	-6°	0.2	WNMG 06 04 08	WNMG 332	1.7
			C4-DWLNR/L-27050-06	40	60	2.362	140	5.512	27.0	1.063	50.0	1.968	-6°	-6°	0.4	WNMG 06 04 08	WNMG 332	1.7
			C5-DWLNR/L-35060-06	50	65	2.559	165	6.496	35.0	1.378	60.0	2.362	-6°	-6°	0.7	WNMG 06 04 08	WNMG 332	1.7
			C6-DWLNR/L-45065-06	63	81	3.189	190	7.480	45.0	1.772	65.0	2.559	-6°	-6°	1.3	WNMG 06 04 08	WNMG 332	1.7
	08	1/2	C4-DWLNR/L-27050-08	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6°	-6°	0.4	WNMG 08 04 08	WNMG 432	3.9
			C5-DWLNR/L-35060-08	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6°	-6°	0.8	WNMG 08 04 08	WNMG 432	3.9
			C6-DWLNR/L-45065-08	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6°	-6°	1.4	WNMG 08 04 08	WNMG 432	3.9
			C8-DWLNR/L-55080-08	80	110	4.331	250	9.842	55.0	2.165	80.0	3.150	-6°	-6°	2.6	WNMG 08 04 08	WNMG 432	3.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

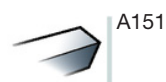
Main spare parts

Insert size						
γ	iC	Coromant Capto® size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set
06	3/8	C3-C6	5513 020-04	5322 328-01	5680 051-03 (9IP)	5412 028-011
08	1/2	C4-C8	5513 020-02	5322 331-12	5680 049-01 (15IP)	5412 028-021 ¹⁾

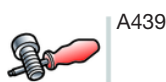
¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A151



A439



G6



A2



J2

CoroTurn® HP

Coromant Capto tools for High Pressure coolant

Increased cutting speed for rough to medium machining

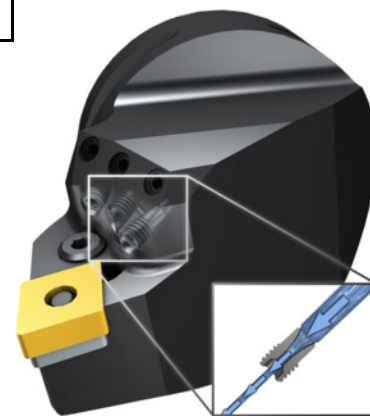
Chip control in finishing - secure unmanned production

When to use

Any turning machine where both high pressure coolant and Coromant Capto® coupling are available:

- Multi-task machines
- Vertical turning lathes (VTL)
- Turning centres

The characteristic reduced depth of cut and reduced feed rate in finishing operations always leads to challenges for chip control. In automated production, be it high volume mass production or machines with automatic tool changing (multi-task and vertical turning lathes), any chips gathering around the tool will result in costly machine stoppages. This new technology will provide you with total chip control giving security in unmanned production.



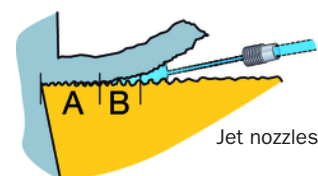
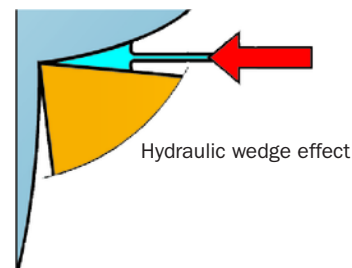
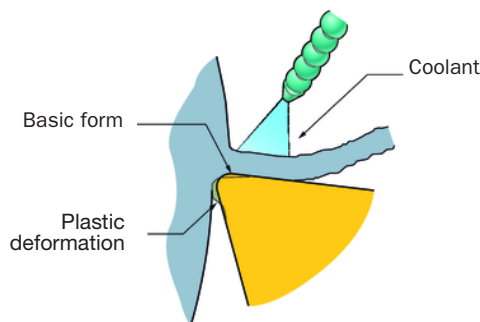
Fixed coolant-nozzle technology

The high pressure coolant application by way of CoroTurn HP is based on carefully developed nozzle technology based on decades of experience. Optimized nozzles give parallel laminar jets of coolant with high velocity accurately directed at the right place on the insert. The precision and character of these jets make the difference. CoroTurn HP has fixed, pre-directed, high precision nozzles mounted on the tool targeting the right place, at the right angle on the cutting edge. No setting with trials are needed, performance and security is built in with only normal tool maintenance needed.

A directional jet for maximum effect

The principle of turning with high pressure coolant is to accurately position the jet of coolant through small, sighted nozzles (dia 1 mm) to give a parallel laminar flow. This high velocity jet of coolant creates a hydraulic wedge between the top surface of the insert and the underside of the chip being removed from the component. The coolant jet has three main effects:

1. To provide localized cooling of the insert in the contact zone (A)
2. To force the chip away from the insert face quickly, reducing wear on the insert (B)
3. To help break the chip into smaller pieces and evacuate it from the cutting area



CoroTurn HP tools with screw clamp, see page A166.

CoroTurn HP tools for Multi-Task machines, see page H21.

CoroTurn HP with SL coupling, see page I12.

CoroTurn® HP cutting units

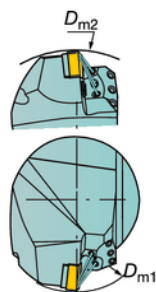
T-Max® P lever design

With high pressure coolant



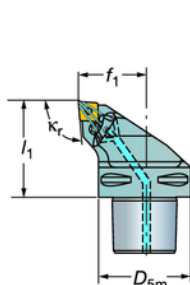
CNMM, CNGP
CNMG
CNMA, CNGA

Entering angle:
Lead angle



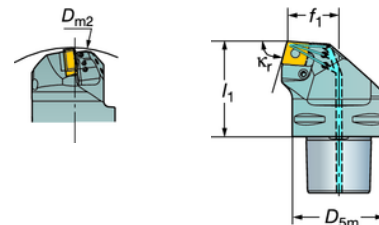
Cx-PCLNR/L-HP

$\kappa_r 95^\circ$
 -5°




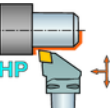

Cx-PCNR/L-HP

$\kappa_r 75^\circ$
 15°



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)											Gauge inserts		
				D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm. ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^1)$	$\lambda_s^{2)}$	R_{ISO}	ISO	ANSI
	12	1/2	C4-PCLNR/L-27050-12HP	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6° 0.4		CNMG 12 04 08	CNMG 432	5.0
			C5-PCLNR/L-35060-12HP	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6° 0.8		CNMG 12 04 08	CNMG 432	5.0
			C6-PCLNR/L-45065-12HP	63	110	4.331	195	7.677	45.0	1.772	65.0	2.559	-6° -6° 1.2		CNMG 12 04 08	CNMG 432	5.0
			C8-PCLNR/L-55080-12HP	80	110	4.331	250	9.842	55.0	2.165	80.0	3.150	-6° -6° 2.5		CNMG 12 04 08	CNMG 432	5.0
	16	5/8	C5-PCLNR/L-35060-16HP	50	125	4.921	165	6.496	35.0	1.378	60.0	2.362	-6° -6° 0.8		CNMG 16 06 12	CNMG 543	5.0
			C6-PCLNR/L-45065-16HP	63	110	4.331	195	7.677	45.0	1.772	65.0	2.559	-6° -6° 1.2		CNMG 16 06 12	CNMG 543	5.0
			C8-PCLNR/L-55080-16HP	80	125	4.921	250	9.842	55.0	2.165	80.0	3.150	-6° -6° 2.5		CNMG 16 06 12	CNMG 543	5.0
	19	3/4	C6-PCLNR/L-45065-19HP	63	110	4.331	195	7.677	45.0	1.772	65.0	2.559	-6° -6° 1.2		CNMG 19 06 12	CNMG 643	10.0
			C8-PCLNR/L-55080-19HP	80	150	5.906	250	9.842	55.0	2.165	80.0	3.150	-6° -6° 2.5		CNMG 19 06 12	CNMG 643	10.0
			C10-PCLNR/L-68110-19HP	100	220	8.661	315	12.402	68.0	2.677	110.0	4.331	-6° -6° 5.2		CNMG 19 06 12	CNMG 643	10.0
	16	5/8	C6-PCNRN/L-35065-16HP	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6° 1.4		CNMG 16 06 12	CNMG 543	5.0
	19	3/4	C6-PCNRN/L-35065-19HP	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6° 1.3		CNMG 19 06 12	CNMG 643	10.0

1) γ = Rake angle (valid with flat insert).


2) λ = Angle of inclination

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

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

Main spare parts

Insert size							
	iC	Coupling size	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia. mm)
12	1/2	C4-C8	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M	5691 026-03 (1.0)
16	5/8	C5-C8	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852	5691 026-03 (1.0)
19	3/4	C6-C8	174.3-842M	174.3-822M	3021 010-040 (4.0)	171.31-851M	5691 026-03 (1.0)
19	3/4	C10	174.3-842M	174.3-822M	3021 010-040(4.0)	171.35-851M	5691 034-03 (3.5) ¹⁾

¹⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04.



A9



A464



G6



A2

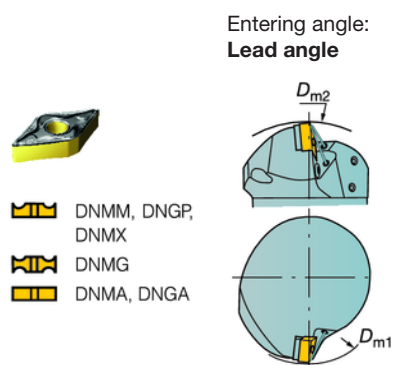


J2

CoroTurn® HP cutting units

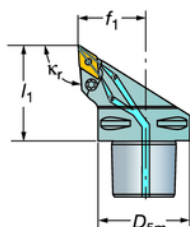
T-Max® P lever design

With high pressure coolant



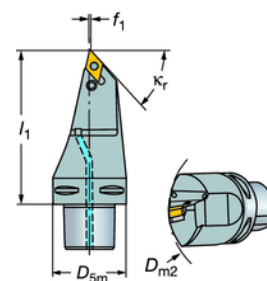
Cx-PDJNR/L-15HP

κ_r 93°
-3°





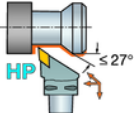
Cx-PDMNR/L-15HP

κ_r 48° (93°)
42° (-3°)



Coolant inlet: Axial through the center
Right hand style shown

Left hand style shown

Main application		iC	Ordering code ⁵⁾	Dimensions, mm, inch								Gauge inserts		
				D _{5m}	D _{m1} min ⁴⁾	D _{m2} min ⁴⁾	f ₁	l ₁	γ ¹⁾	λ _s ²⁾		ISO	ANSI	Nm ³⁾
	15	1/2	C5-PDJNR/L-35060-1504HP	50	70	165	35	60	-6°	-7°	0.7	DNMG 15 04 08	DNMG 432	5.0
			C6-PDJNR/L-45065-1504HP	63	2.756	6.496	1.378	2.362	-6°	-7°	1.2	DNMG 15 04 08	DNMG 432	5.0
			C8-PDJNR/L-55080-1504HP	80	3.740	7.677	1.772	2.559	-6°	-7°	4.3	DNMG 15 04 08	DNMG 432	5.0
					5.118	9.842	2.165	3.150						
	11	3/8	C4-PDJNR/L-27050-11HP	40	90	145	27	50	-6°	-7°	0.3	DNMG 11 04 08	DNMG 332	5.0
			C5-PDJNR/L-35060-11HP	50	3.543	5.709	1.063	1.968	-6°	-7°	0.6	DNMG 11 04 08	DNMG 332	5.0
					4.331	6.496	1.378	2.362						
	15	1/2	C4-PDJNR/L-27055-15HP	40	65	145	27	55	-6°	-7°	0.4	DNMG 15 06 08	DNMG 15 06	5.0
			C5-PDJNR/L-35060-15HP	50	2.559	5.709	1.063	2.165	-6°	-7°		DNMG 15 06 08	DNMG 442	5.0
			C6-PDJNR/L-45065-15HP	63	2.559	6.496	1.378	2.362	-6°	-7°		DNMG 15 06 08	DNMG 442	5.0
C8-PDJNR/L-55080-15HP			80	3.740	7.677	1.772	2.559	-6°	-7°		DNMG 15 06 08	DNMG 442	5.0	
				5.118	9.842	2.165	3.150							
C10-PDJNR/L-68110-15HP			100	180	280	68	110	-6°	-7°	5.2	DNMG 15 06 08	DNMG 442	5.0	
				7.087	11.024	2.677	4.331							

Main application	iC	Ordering code	Dimensions, mm, inch							Gauge insert	ISO	ANSI	Nm ³⁾
			dm _m	D _{5m}	f ₁	l ₁	γ ¹⁾	λ _s ²⁾	λ _s ²⁾				
	15	1/2	C6-PDMNR/L-00130-15HP	44	63	0.6	130	-5°	-15°	1.96	DNMG 15 06 08	DNMG 442	5.0
					2.480	.022	5.118						

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

5) -1504 in the end of the ordering code = For inserts with thickness 4.76 mm (1/4")

R = Right hand, L = Left hand

Main spare parts

Insert size	iC	Coupling size	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia mm.)
11 04	3/8 (DNMG 33)	C4-C5	5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01	5691 026-03 (1.0)
15 04	1/2 (DNMG 43)	C5	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-856	5691 026-03 (1.0)
15 04	1/2 (DNMG 43)	C6-C8	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5691 026-03 (1.0)
15 06	1/2 (DNMG 44)	C4-C8	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5691 026-03 (1.0)
15 06	1/2 (DNMG 44)	C10	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5691 034-03 (3.5) ¹⁾

¹⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04



CoroTurn® HP cutting units

T-Max® P lever design

With high pressure coolant

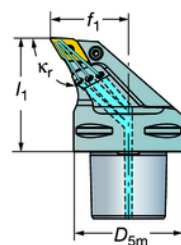
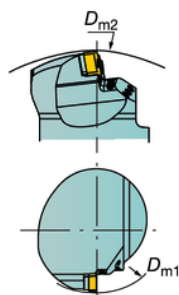
Cx-PDUNR/L-HP

κ_r 93°
-3°



DNMM, DNGP,
DNMX
DNMG
DNMA, DNGA

Entering angle:
Lead angle



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				D_{5m}	D_{m1} min ⁴⁾	D_{m2} min ⁴⁾	f_1	l_1	γ^1	λ_s^2	α_{KO}	ISO	ANSI	Nm ³⁾
	15	1/2	C6-PDUNR/L-45065-15HP	63	80	190	45	65	-6°	-7°	1.2	DNMG 15 06 08	DNMG 442	5.0
					3.150	7.480	1.772	2.559						
			C8-PDUNR/L-55080-15HP	80	100	250	55	80	-6°	-7°	2.6			
					3.937	9.842	2.165	3.150						

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

Insert size										
	iC	Coupling size	Lever	Screw	Key (mm)	Shim ¹⁾	Insert radius	Shim pin	Shim pin punch	Nozzle (hole dia. mm)
15	1/2	C6-C8	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M 171.35-850M	0.4-0.8 (.016-.031) 1.2 < (.047 <)	174.3-861	5681 002-01	5691 026-03 (1.0)

1) Shim for 3/16" thick insert = 171.35-856.

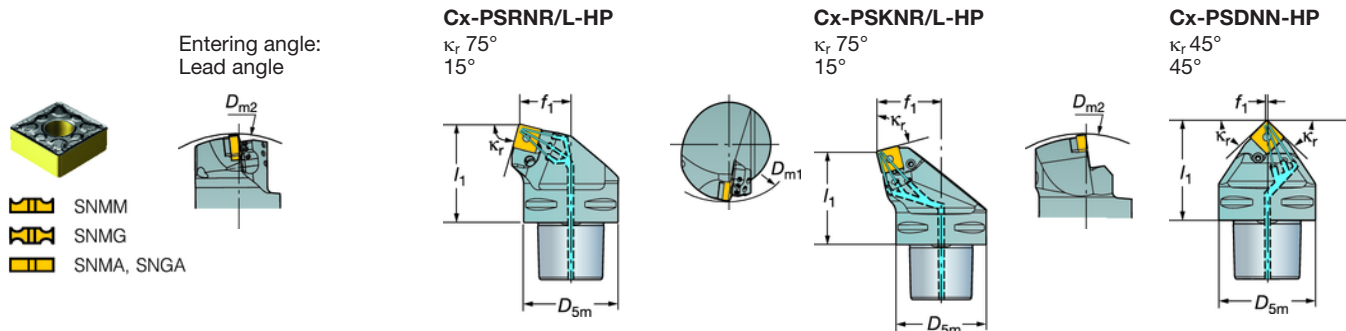
2) When changing nozzle use key 5680 019-01 and bits 5680 021-04



CoroTurn® HP cutting units

T-Max® P lever design



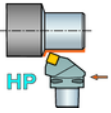
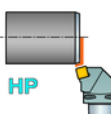
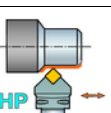
With high pressure coolant



Coolant inlet: Axial through the center

Neutral

Right hand style shown

Right hand style (turning)			Dimensions, millimeter, inch (mm, in.)												Gauge inserts			
Main application		iC	Ordering code	D _{5m}	D _{m1} min mm ⁴⁾	D _{m1} min in. ⁴⁾	D _{m2} min mm ⁴⁾	D _{m2} min in. ⁴⁾	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾	 kg	ISO	ANSI	Nm ³⁾
 HP	15	5/8	C6-PSRNR/L-35065-15HP	63			190	7.480	35.0	1.378	65.0	2.559	-6°	-6°	1.3	SNMG 15 06 12	SNMG 543	3.7
	19	3/4	C6-PSRNR/L-35065-19HP	63			190	7.480	35.0	1.378	65.0	2.559	-6°	-6°	1.3	SNMG 19 06 12	SNMG 643	8.8
			C8-PSRNR/L-45080-19HP	80			250	9.842	45.0	1.772	80.0	3.150	-6°	-6°	2.7	SNMG 19 06 12	SNMG 643	8.8
 HP	15	5/8	C6-PSKNR/L-45065-15HP	63	125	4.921			45.0	1.772	65.0	2.559	-6°	-6°	1.4	SNMG 15 06 12	SNMG 543	5.0
	19	3/4	C6-PSKNR/L-45065-19HP	63	125	4.921			45.0	1.772	65.0	2.559	-6°	-6°	1.5	SNMG 19 06 12	SNMG 643	10.0
			C8-PSKNR/L-55080-19HP	80	125	4.921			55.0	2.165	80.0	3.150	-6°	-6°	2.8	SNMG 19 06 12	SNMG 643	10.0
 HP	15	5/8	C6-PSDNN-00065-15HP	63			190	7.480	0.5	.020	65.0	2.559	-6°	-6°	1.1	SNMG 15 06 12	SNMG 543	5.0
	19	3/4	C6-PSDNN-00065-19HP	63			190	7.480	0.5	.020	65.0	2.559	-6°	-6°	1.2	SNMG 19 06 12	SNMG 643	10.0

1) γ = Rake angle (valid with flat insert).

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

2) λ = Angle of inclination

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

Main spare parts

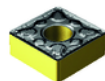
Insert size						
□	iC	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia. mm)
15	5/8	438.3-840	438.3-831	174.1-864 (3.0)	174.3-864	5691 026-03 (1.0)
19	3/4	174.3-842M	174.3-822M	3021 010-040 (4.0)	174.3-852M	5691 026-03 (1.0)



CoroTurn® HP cutting units

T-Max® P lever design

With high pressure coolant

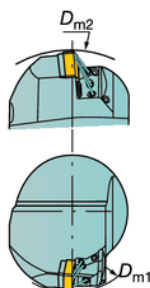


SNMM

SNMG

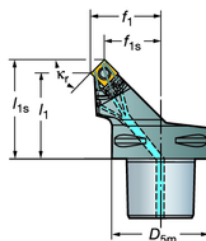
SNMA, SNGA

Entering angle:
Lead angle



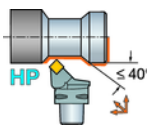
Cx-PSSNR/L-HP

$\kappa_r 45^\circ$
 45°



Coolant inlet: Axial through the center

Right hand style shown

Main application	□	iC	Ordering code	Dimensions, mm, inch										Gauge insert		
				D_{5m}	D_{m1} min ⁴⁾	D_{m2} min ⁴⁾	f_1	f_{1s}	l_1	l_{1s}	γ^1	λ_s^2	ρ_{kg}	ISO	ANSI	Nm ³⁾
	12	1/2	C4-PSSNR/L-27042-12HP	40	90		27.0	18.7	42	50.3	-8°	0°	0.39	SNMG 12 04 08	SNMG 432	5.0
					3.543		1.063	.736	1.654	1.980						
			C5-PSSNR/L-35052-12HP	50	110	165	35.0	26.9	52	60.3	-8°	0°	0.70	SNMG 12 04 08	SNMG 432	5.0
					4.331	6.496	1.378	1.059	2.047	2.374						
			C6-PSSNR/L-45056-12HP	63	110	200	45.0	36.7	56	64.3	-8°	0°	1.05	SNMG 12 04 08	SNMG 432	5.0
	15	5/8			4.331	7.874	1.772	1.445	2.205	2.532						
			C8-PSSNR/L-55080-12HP	80	200	260	55.0	46.7	80	88.3	-8°	0°	2.40	SNMG 12 04 08	SNMG 432	5.0
					7.874	10.23	2.165	1.839	3.150	3.476						
			C5-PSSNR/L-35050-15HP	50	110	165	35.0	25.5	50	60.2	-8°	0°	0.70	SNMG 15 06 12	SNMG 543	5.0
					4.331	6.496	1.378	1.004	1.968	2.370						
19	3/4	C6-PSSNR/L-45054-15HP			4.331	7.874	1.772	1.370	2.126	2.528						
					4.331	6.496	1.378	1.004	1.968	2.370						
			C6-PSSNR/L-45052-19HP	63	110	180	45.0	32.5	52	64.5	-8°	0°	1.07	SNMG 19 06 12	SNMG 643	5.0
					4.331	7.087	1.772	1.280	2.047	2.539						
			C8-PSSNR/L-55080-19HP	80	200	260	55.0	42.5	80	92.5	-8°	0°	2.55	SNMG 19 06 12	SNMG 643	5.0
C10-PSSNR/L-68092-19HP					7.874	10.23	2.165	1.673	3.150	3.642						
					10.23	12.40	2.677	2.166	3.622	4.114						

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

Insert size								
□	iC	Coupling size	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia. mm)	
12	1/2	C5-C8	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M	5691 026-03 (1.0)	
15	5/8	C5-C6	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857	5691 026-03 (1.0)	
19	3/4	C6-C8	174.3-842M	174.3-822M	3021 010-040 (4.0)	174.3-852M	5691 026-03 (1.0)	
19	3/4	C10	174.3-842M	174.3-822M	3021 010-040 (4.0)	174.3-852M	5691 034-03 (3.5) ¹⁾	

1) When changing nozzle use key 5680 019-01 and bits 5680 021-04.



A9



A464



G6



A2



J2

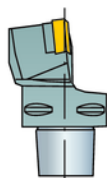
Coromant Capto® cutting units

T-Max® P lever design

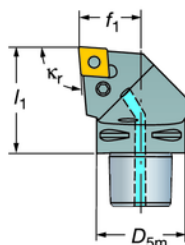


CNMM, CNGP
 CNMG
 CNMA, CNGA

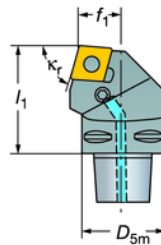
Entering angle:
Lead angle:



PCLNR/L
 $\kappa_r 95^\circ$
 -5°


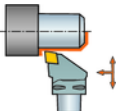
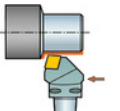


PCRNRL
 $\kappa_r 75^\circ$
 15°



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)						Gauge inserts		
				D_{5m}	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ^1	$\lambda_s^{2)}$	ISO	ANSI
	12	1/2	C3-PCLNR/L-22040-12	32	22.0	.866	40.0	1.575	-6°	-6°	CNMG 12 04 08	CNMG 432
			C4-PCLNR/L-27050-12	40	27.0	1.063	50.0	1.968	-6°	-6°	CNMG 12 04 08	CNMG 432
			C5-PCLNR/L-35060-12	50	35.0	1.378	60.0	2.362	-6°	-6°	CNMG 12 04 08	CNMG 432
			C6-PCLNR/L-45065-12	63	45.0	1.772	65.0	2.559	-6°	-6°	CNMG 12 04 08	CNMG 432
			C8-PCLNR/L-55080-12	80	55.0	2.165	80.0	3.150	-6°	-6°	CNMG 12 04 08	CNMG 432
	16	5/8	C4-PCLNR/L-27050-16	40	27.0	1.063	50.0	1.968	-6°	-6°	CNMG 16 06 12	CNMG 543
			C5-PCLNR/L-35060-16	50	35.0	1.378	60.0	2.362	-6°	-6°	CNMG 16 06 12	CNMG 543
			C6-PCLNR/L-45065-16	63	45.0	1.772	65.0	2.559	-6°	-6°	CNMG 16 06 12	CNMG 543
			C8-PCLNR/L-55080-16	80	55.0	2.165	80.0	3.150	-6°	-6°	CNMG 16 06 12	CNMG 543
	19	3/4	C5-PCLNR/L-35060-19	50	35.0	1.378	60.0	2.362	-6°	-6°	CNMG 19 06 12	CNMG 643
C6-PCLNR/L-45065-19			63	45.0	1.772	65.0	2.559	-6°	-6°	CNMG 19 06 12	CNMG 643	
C8-PCLNR/L-55080-19			80	55.0	2.165	80.0	3.150	-6°	-6°	CNMG 19 06 12	CNMG 643	
25	1	C8-PCLNR/L-55080-25	80	55.0	2.165	80.0	3.150	-6°	-6°	CNMG 25 09 24	CNMG 866	
		C10-PCLNR/L-68110-25	100	68.0	2.677	110.0	4.331	-6°	-6°	CNMG 25 09 24	CNMG 866	
	12	1/2	C5-PCRNRL/L-27060-12	50	27.0	1.063	60.0	2.362	-6°	-6°	CNMG 12 04 08	CNMG 432
			C6-PCRNRL/L-35065-12	63	35.0	1.378	65.0	2.559	-6°	-6°	CNMG 12 04 08	CNMG 432
	16	5/8	C5-PCRNRL/L-27060-16	50	27.0	1.063	60.0	2.362	-6°	-6°	CNMG 16 06 12	CNMG 543
			C6-PCRNRL/L-35065-16	63	35.0	1.378	65.0	2.559	-6°	-6°	CNMG 16 06 12	CNMG 543
	19	3/4	C5-PCRNRL/L-27060-19	50	27.0	1.063	60.0	2.362	-6°	-6°	CNMG 19 06 12	CNMG 643
			C6-PCRNRL/L-35065-19	63	35.0	1.378	65.0	2.559	-6°	-6°	CNMG 19 06 12	CNMG 643

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size					
	iC	Lever	Screw	Key (mm)	Shim
12	1/2	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M
16	5/8	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852
19	3/4	174.3-842M	174.3-822M	3021 010-040 (4.0)	171.31-851M
25	1	174.3-844M	174.3-827	3021 010-050 (5.0)	5322 230-01



A9



A152



A446



G6



A2



J2

Coromant Capto® cutting units

T-Max® P lever design

B

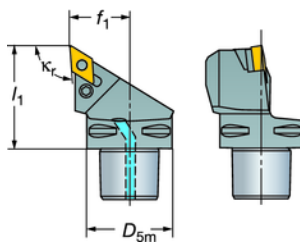


DNMM, DNGP, DNMX
 DNMG
 DNMA, DNGA

Entering angle:
Lead angle:

PDJNR/L

$\kappa_r 93^\circ$
 -3°



Coolant inlet: Radial through the taper

C

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)						Gauge inserts	
				D_{5m}	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^1)$ $\lambda_s^2)$	ISO	ANSI
 $\leq 27^\circ$	11	3/8	C3-PDJNR/L-22045-11	32	22.0	.866	45.0	1.772	-6° -7°	DNMG 11 04 08	DNMG 332
			C4-PDJNR/L-27050-11	40	27.0	1.063	50.0	1.968	-6° -7°	DNMG 11 04 08	DNMG 332
			C5-PDJNR/L-35060-11	50	35.0	1.378	60.0	2.362	-6° -7°	DNMG 11 04 08	DNMG 332
			C6-PDJNR/L-45065-11	63	45.0	1.772	65.0	2.559	-6° -7°	DNMG 11 04 08	DNMG 332
	15	1/2	C4-PDJNR/L-27055-15	40	27.0	1.063	55.0	2.165	-6° -7°	DNMG 15 06 08	DNMG 442
			C5-PDJNR/L-35060-15	50	35.0	1.378	60.0	2.362	-6° -7°	DNMG 15 06 08	DNMG 442

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC		Lever	Screw	Key (mm)	Shim
11	3/8		5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01
15	1/2		174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M

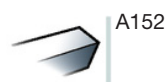
H

I

J



A9



A152



A446



G6



A2



J2

Coromant Capto® cutting units

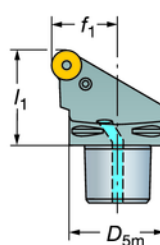
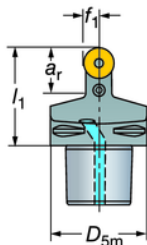
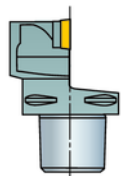
T-Max® P lever design



RCMX
RCMT
RCGX AL

PRDCN

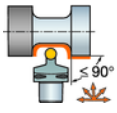
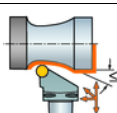
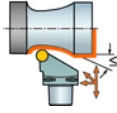
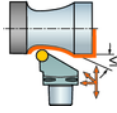
PRSCR/L



Neutral

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application	$\frac{\phi}{mm}$	iC	Ordering code	Dimensions, mm, inch						Gauge inserts	
				D_{5m}	a_r	f_1	l_1	γ^1	λ_s^2	ISO	ANSI
	25	.984	C6-PRDCN-00065-25A	63	40	12.5	65.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
					1.575	.492	2.559				
			C8-PRDCN-00080-25A	80	40	12.5	80.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
					1.575	.492	3.150				
			C10-PRDCN-00110-25	100	60	12.5	110.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
					2.362	.492	4.331				
	32	1.260	C8-PRDCN-00080-32A	80	45	16.0	80.0	0°	0°	RCMX 32 09 00	RCMX 32 09 00
					1.772	.630	3.150				
			C10-PRDCN-00110-32	100	65	16.0	110.0	0°	0°	RCMX 32 09 00	RCMX 32 09 00
					2.559	.630	4.331				
	20	.787	C8-PRSCR/L-55080-20	80		55.0	80.0	0°	0°	RCMX 20 06 00	RCMX 20 06 00
						2.165	3.150				
	25	.984	C6-PRSCR/L-45065-25	63		45.0	65.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
						1.772	2.559				
			C8-PRSCR/L-55080-25	80		55.0	80.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
						2.165	3.150				
	32	1.260	C8-PRSCR/L-55080-32	80		55.0	80.0	0°	0°	RCMX 32 09 00	RCMX 32 09 00
						2.165	3.150				
	25	.984	C10-PRSCR/L-68110-25	100		68.0	110.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
						2.677	4.331				
	32	1.260	C10-PRSCR/L-68110-32	100		68.0	110.0	0°	0°	RCMX 32 09 00	RCMX 32 09 00
						2.677	4.331				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

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

Main spare parts

Insert size					
$\frac{\phi}{mm}$	iC	Lever	Screw	Key (mm)	Shim
20	.787	176.39-843	174.3-825	174.1-864 (3.0)	176.39-853
25	.984	176.39-844	174.3-832	3021 010-040 (4.0)	176.39-854
32	1.260	176.39-845	174.3-827	3021 010-050 (5.0)	176.39-855

B

C

G

H

I

J



A9



A154



A446



G6



A2

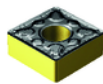


J2

Coromant Capto® cutting units

T-Max® P lever design

B

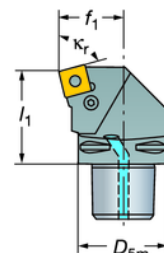
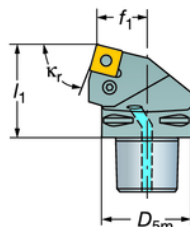
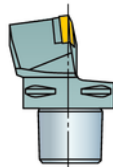


SNMM
SNMG
SNMA, SNGA

Entering angle:
Lead angle:

PSRNR/L
 $\kappa_r 75^\circ$
 15°

PSKNR/L
 $\kappa_r 75^\circ$
 15°



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

C

Main application		iC	Ordering code	Dimensions, mm, inch						Gauge inserts	
				D_{5m}	f_1	l_1	γ^1	λ_s^2		ISO	ANSI
	12	1/2	C4-PSRNR/L-22050-12	40	22	50	-6°	-6°		SNMG 12 04 08	SNMG 432
			C5-PSRNR/L-27060-12	50	27	60	-6°	-6°		SNMG 12 04 08	SNMG 432
			C6-PSRNR/L-35065-12	63	35	65	-6°	-6°		SNMG 12 04 08	SNMG 432
					1.063	2.362					
					1.378	2.559					
	15	5/8	C4-PSRNR/L-22050-15	40	22	50	-6°	-6°		SNMG 15 06 12	SNMG 543
			C5-PSRNR/L-27060-15	50	27	60	-6°	-6°		SNMG 15 06 12	SNMG 543
			C6-PSRNR/L-35065-15	63	35	65	-6°	-6°		SNMG 15 06 12	SNMG 543
					1.063	2.362					
					1.378	2.559					
	19	3/4	C5-PSRNR/L-27060-19	50	27	60	-6°	-6°		SNMG 19 06 12	SNMG 643
			C6-PSRNR/L-35065-19	63	35	65	-6°	-6°		SNMG 19 06 12	SNMG 643
			C8-PSRNR/L-45080-19	80	45	80	-6°	-6°		SNMG 19 06 12	SNMG 643
					1.063	2.362					
					1.378	2.559					
					1.772	3.150					
	25	1	C8-PSRNR/L-45080-25	80	45	80	-6°	-6°		SNMG 25 07 24	SNMG 856
			C10-PSRNR/L-58110-25	100	58	110	-6°	-6°		SNMG 25 07 24	SNMG 856
					1.772	3.150					
					2.284	4.331					
	12	1/2	C4-PSKNR/L-27050-12	40	27	50	-6°	-6°		SNMG 12 04 08	SNMG 432
			C5-PSKNR/L-35060-12	50	35	60	-6°	-6°		SNMG 12 04 08	SNMG 432
			C6-PSKNR/L-45065-12	63	45	65	-6°	-6°		SNMG 12 04 08	SNMG 432
					1.063	1.968					
					1.378	2.362					
					1.772	2.559					
	15	5/8	C4-PSKNR/L-27050-15	40	27	50	-6°	-6°		SNMG 15 06 12	SNMG 543
			C5-PSKNR/L-35060-15	50	35	60	-6°	-6°		SNMG 15 06 12	SNMG 543
			C6-PSKNR/L-45065-15	63	45	65	-6°	-6°		SNMG 15 06 12	SNMG 543
					1.063	1.968					
					1.378	2.362					
					1.772	2.559					
	19	3/4	C5-PSKNR/L-35060-19	50	35	60	-6°	-6°		SNMG 19 06 12	SNMG 643
			C6-PSKNR/L-45065-19	63	45	65	-6°	-6°		SNMG 19 06 12	SNMG 643
			C8-PSKNR/L-55080-19	80	55	80	-6°	-6°		SNMG 19 06 12	SNMG 643
					1.378	2.362					
					1.772	2.559					
					2.165	3.150					
	25	1	C8-PSKNR/L-55080-25	80	55	80	-6°	-6°		SNMG 25 07 24	SNMG 856
			C10-PSKNR/L-68110-25	100	68	110	-6°	-6°		SNMG 25 07 24	SNMG 856
					2.165	3.150					
					2.677	4.331					

1) γ = Rake angle (valid with flat insert).

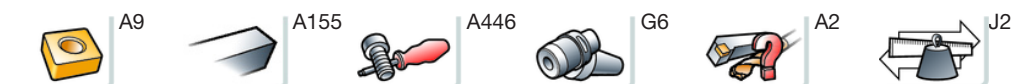
2) λ_s = Angle of inclination.

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

Main spare parts

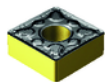
Insert size		Lever	Screw	Key (mm)	Shim
iC					
12 1/2		174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M
15 5/8		438.3-840	438.3-831	174.1-864 (3.0)	174.3-857
19 3/4		174.3-842M	174.3-822M	3021 010-040 (4.0)	174.3-852M
25 1		174.3-844M	174.3-827	3021 010-050 (5.0)	174.3-853M

J



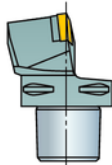
Coromant Capto® cutting units

T-Max® P lever design

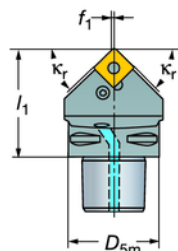


SNMM
SNMG
SNMA, SNGA

Entering angle:
Lead angle:

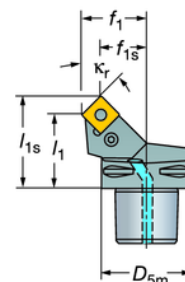


PSDNN
 $\kappa_r 45^\circ$
 45°


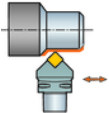
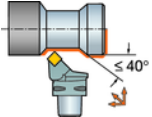


Neutral

PSSNR/L
 $\kappa_r 45^\circ$
 45°



Coolant inlet: Radial through the taper
Right hand style shown unless otherwise stated

Main application		i/C	Ordering code	Dimensions, mm, inch							Gauge inserts		
				D_{5m}	f_1	f_{1s}	l_1	l_{1s}	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO	ANSI	
	12	1/2	C4-PSDNN-00050-12	40	0.3		50			-6°	-6°	SNMG 12 04 08	SNMG 432
			C5-PSDNN-00060-12	50	.012		1.968			-6°	-6°	SNMG 12 04 08	SNMG 432
			C6-PSDNN-00065-12	63	.012		2.362			-6°	-6°	SNMG 12 04 08	SNMG 432
					.012		2.559			-6°	-6°		
	15	5/8	C4-PSDNN-00050-15	40	0.5		50			-6°	-6°	SNMG 15 06 12	SNMG 543
			C5-PSDNN-00060-15	50	.020		1.968			-6°	-6°	SNMG 15 06 12	SNMG 543
			C6-PSDNN-00065-15	63	.020		2.362			-6°	-6°	SNMG 15 06 12	SNMG 543
					.020		2.559			-6°	-6°		
	19	3/4	C5-PSDNN-00060-19	50	0.5		60			-6°	-6°	SNMG 19 06 12	SNMG 643
			C6-PSDNN-00065-19	63	.020		2.362			-6°	-6°	SNMG 19 06 12	SNMG 643
					.020		2.559			-6°	-6°		
			C10-PSDNN-00110-25	100	1		65			-6°	-6°	SNMG 25 07 24	SNMG 856
	15	5/8	C4-PSSNR/L-27040-15	40	.039		2.559			-6°	-6°	SNMG 25 07 24	SNMG 856
			C8-PSDNN-00080-25	80	.039		3.150			-6°	-6°	SNMG 25 07 24	SNMG 856
					.039		4.331			-6°	-6°	SNMG 25 07 24	SNMG 856
	25	1	C6-PSDNN-00065-25	63	1		65			-6°	-6°	SNMG 25 07 24	SNMG 856
					.039		4.331			-6°	-6°		
	15	5/8	C4-PSSNR/L-27040-15	40	27	16.8	40	50.2	-8°	0°	SNMG 15 06 12	SNMG 543	
			C5-PSSNR/L-35050-15	50	1.063	.661	1.575	1.976	-8°	0°	SNMG 15 06 12	SNMG 543	
					1.378	.976	1.968	2.370	-8°	0°			
	19	3/4	C5-PSSNR/L-35048-19	50	35	22.5	48	60.5	-8°	0°	SNMG 19 06 12	SNMG 643	
					1.378	.886	1.890	2.382	-8°	0°			
	25	1	C10-PSSNR/L-68092-25	100	68	51.0	92	108.0	-8°	0°	SNMG 25 07 24	SNMG 856	
					2.677	2.009	3.622	4.252	-8°	0°			
	12	1/2	C3-PSSNR/L-22032-12	32	22	13.7	32	40.3	-8°	0°	SNMG 12 04 08	SNMG 432	
					.866	.539	1.260	1.587	-8°	0°			
		C4-PSSNR/L-27042-12	40	27	18.7	42	50.3	-8°	0°	SNMG 12 04 08	SNMG 432		
				1.063	.736	1.654	1.980	-8°	0°				
		C5-PSSNR/L-35052-12	50	35	26.7	52	60.3	-8°	0°	SNMG 12 04 08	SNMG 432		
				1.378	1.051	2.047	2.374	-8°	0°				
		C6-PSSNR/L-45056-12	63	45	36.7	56	64.3	-8°	0°	SNMG 12 04 08	SNMG 432		
				1.772	1.445	2.205	2.532	-8°	0°				
15	5/8	C6-PSSNR/L-45054-15	63	45	34.8	54	64.2	-8°	0°	SNMG 15 06 12	SNMG 543		
				1.772	1.370	2.126	2.528	-8°	0°				
19	3/4	C6-PSSNR/L-45052-19	63	45	32.5	52	64.5	-8°	0°	SNMG 19 06 12	SNMG 643		
				1.772	1.280	2.047	2.539	-8°	0°				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

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

Main spare parts

Insert size					
iC		Lever	Screw	Key (mm)	Shim
12	1/2	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M
15	5/8	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857
19	3/4	174.3-842M	174.3-822M	3021 010-040 (4.0)	174.3-852M
25	1	174.3-844M	174.3-827	3021 010-050 (5.0)	174.3-853M



A9



A155



A446



G6



A2



J2

Coromant Capto® cutting units

T-Max P wedge clamp design

B

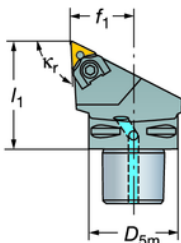
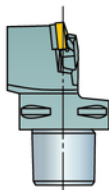


TNMM, TNMX
TNMG
TNMA, TNGA

Entering angle:
Lead angle:

MTJNR/L

$\kappa_r 93^\circ$
 -3°



C

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, mm, inch					Gauge inserts	
				D_{5m}	f_1	l_1	$\gamma^{(1)}$	$\lambda_s^{(2)}$	ISO	ANSI
	16	3/8	C3-MTJNR/L-22040-16	32	22	40	-6°	-6°	TNMG 16 04 08	TNMG 332
					.866	1.575				
			C4-MTJNR/L-27050-16	40	27	50	-6°	-6°	TNMG 16 04 08	TNMG 332
					1.063	1.968				
			C5-MTJNR/L-35060-16	50	35	60	-6°	-6°	TNMG 16 04 08	TNMG 332
					1.378	2.362				
	22	1/2	C4-MTJNR/L-27050-22	40	27	50	-6°	-6°	TNMG 22 04 08	TNMG 432
					1.063	1.968				
			C5-MTJNR/L-35060-22	50	35	60	-6°	-6°	TNMG 22 04 08	TNMG 432
					1.378	2.362				
			C6-MTJNR/L-45065-22	63	45	65	-6°	-6°	TNMG 22 04 08	TNMG 432
					1.772	2.559				
	27	5/8	C6-MTJNR/L-45065-27	63	45	65	-6°	-6°	TNMG 27 06 12	TNMG 543
					1.772	2.559				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

G

Main spare parts

H

Insert size							
	iC	Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm)
16	3/8	170.38-820-1	174.1-863 (2.5)	170.3-852	5313 021-02	3212 010-206	174.1-863 (2.5)
22	1/2	170.38-821-1	174.1-864 (3.0)	170.3-855	181.38-840	3212 010-255	174.1-864 (3.0)
27	5/8	170.38-822-1	174.1-864 (3.0)	170.3-854	5313 021-04	3212 100-307	3021 010-040 (4.0)

I

J



A9



A159



A454



G6



A2



J2

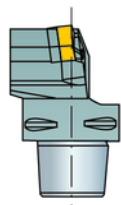
Coromant Capto® cutting units

T-Max P wedge clamp design



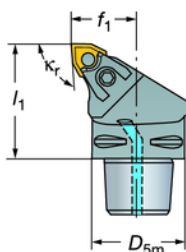
WNMM,
WNMG
WNGA, WNMA

Entering angle:
Lead angle:



MWLNRL/L

$\kappa_r 95^\circ$
 -5°



Coolant inlet: Radial through the taper

Right hand style shown when nothing else is stated

Main application		iC	Ordering code	Dimensions, mm, inch					Gauge inserts	
				D_{5m}	f_1	l_1	γ^1	λ_s^2	ISO	ANSI
	06	3/8	C3-MWLNRL/L-22040-06	32	22	40	-6°	-6°	WNMG 06 04 08	WNMG 332
			C4-MWLNRL/L-27050-06	40	.866	1.575	-6°	-6°	WNMG 06 04 08	WNMG 332
					1.063	1.968				
	08	1/2	C4-MWLNRL/L-27050-08	40	27	50	-6°	-6°	WNMG 08 04 08	WNMG 432
			C5-MWLNRL/L-35060-08	50	1.063	1.968	-6°	-6°	WNMG 08 04 08	WNMG 432
					1.378	2.362				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm)
06	5431 125-011	170.3-860 (2.5)	5322 331-06	5313 022-01	5512 030-03	170.3-864 (1.98)
08	5431 125-021	174.1-864 (3.0)	5322 331-07	5313 022-03	3212 010-255	174.1-864 (3.0)



A9



A151



A454



G6



A2



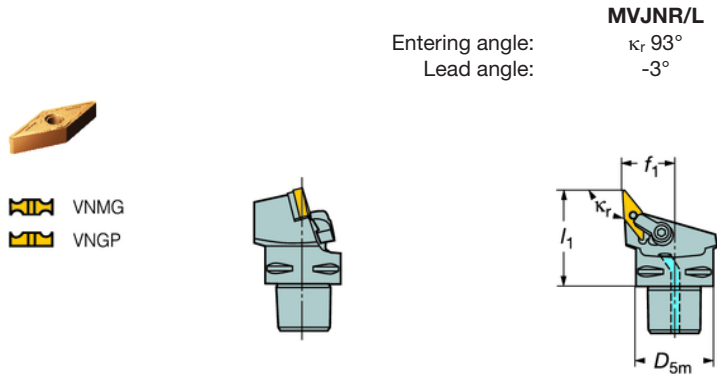
J2

A

Coromant Capto® cutting units

T-Max M top clamp design

B



C

Coolant inlet: Radial through the taper

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch					Gauge inserts	
				D _{5m}	f ₁	l ₁	γ ¹⁾	λ _s ²⁾	ISO	ANSI
	16	3/8	C4-MVJNR/L-27050-16	40	27	50	-4°	-13°	VNMG 16 04 08	VNMG 332
			C5-MVJNR/L-35060-16	50	1.063	1.968	-4°	-13°	VNMG 16 04 08	VNMG 332
					35	60				
					1.378	2.362				

1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.
R = Right hand, L = Left hand

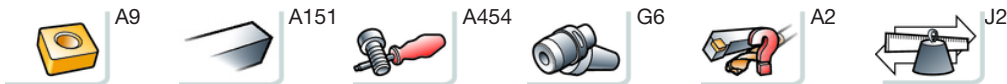
Main spare parts

Insert size							
	iC	Clamp	Clamp screw	Key (Size)	Lock pin	Key (Size)	Shim
16	3/8	MC-12	MS-510	3021 011-532 (5/32)	MN-34L	174.1-872 (5/64)	MVN-322

H

I

J



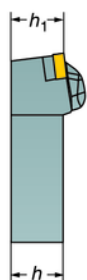
Shank tools

CoroTurn® RC rigid clamp design

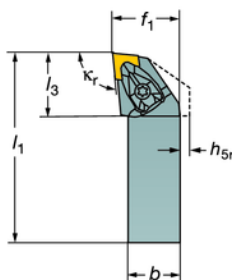


CNMM, CNGP
 CNMG
 CNMA, CNGA

Entering angle:
Lead angle:



DCLNR/L
 $\kappa_r 95^\circ$
 -5°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	09	DCLNR/L 1616H 09	16	20	16	16	100	24.8	-6°	-6°	CNMG 09 03 08	1.7
		DCLNR/L 2020K 09	20	25	20	20	125	24.8	-6°	-6°	CNMG 09 03 08	1.7
		DCLNR/L 2525M 09	25	32	25	25	150	24.8	-6°	-6°	CNMG 09 03 08	1.7
	12	DCLNR/L 1616H 12	16	20	16	16	100	32.2	-6°	-6°	CNMG 12 04 08	3.9
		DCLNR/L 2020K 12	20	25	20	20	125	32	-6°	-6°	CNMG 12 04 08	3.9
		DCLNR/L 2525M 12	25	32	25	25	150	32	-6°	-6°	CNMG 12 04 08	3.9
		DCLNR/L 3225P 12	25	32	32	32	170	32	-6°	-6°	CNMG 12 04 08	3.9
		DCLNR/L 3232P 12	32	40	32	32	170	32.2	-6°	-6°	CNMG 12 04 08	3.9
		DCLNR/L 4040S 12	40	50	40	40	250	32.2	-6°	-6°	CNMG 12 04 08	3.9
	16	DCLNR/L 2525M 16	25	32	25	25	150	39	-6°	-6°	CNMG 16 06 12	6.4
		DCLNR/L 3225P 16	25	32	32	32	170	39	-6°	-6°	CNMG 16 06 12	6.4
		DCLNR/L 3232P 16	32	40	32	32	170	39	-6°	-6°	CNMG 16 06 12	6.4
	19	DCLNR/L 2525M 19	25	32	25	25	150	43.7	-6°	-6°	CNMG 19 06 12	6.4
		DCLNR/L 3225P 19	25	32	32	32	170	43.7	-6°	-6°	CNMG 19 06 12	6.4
		DCLNR/L 3232P 19	32	40	32	32	170	43.2	-6°	-6°	CNMG 19 06 12	6.4
		DCLNR/L 4040S 19	40	50	40	40	250	43.4	-6°	-6°	CNMG 19 06 12	6.4
	25	DCLNR/L 4040S 25	40	50	40	40	250	53.2	-6°	-6°	CNMG 25 09 24	9.5
		DCLNR/L 5050T 25	50	60	50	50	300	53.2	-6°	-6°	CNMG 25 09 24	9.5

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	DCLNR/L 10 3A	.625	.875	.625	.625	4.000	.980	-6°	-6°	CNMG 322	1.3
		DCLNR/L 12 3C	.750	1.000	.750	.750	5.000	.980	-6°	-6°	CNMG 322	1.3
		DCLNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	.980	-6°	-6°	CNMG 322	1.3
	1/2	DCLNR/L 10 4A	.625	.867	.625	.625	4.000	1.260	-6°	-6°	CNMG 432	2.9
		DCLNR/L 12 4B	.750	1.000	.750	.750	4.500	1.260	-6°	-6°	CNMG 432	2.9
		DCLNR/L 16 4C	1.000	1.250	1.000	1.000	5.000	1.260	-6°	-6°	CNMG 432	2.1
		DCLNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.260	-6°	-6°	CNMG 432	2.1
		DCLNR/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.260	-6°	-6°	CNMG 432	2.1
		DCLNR/L 24 4D	1.500	2.000	1.500	1.500	6.000	1.260	-6°	-6°	CNMG 432	2.1
		DCLNR/L 85 4D	1.000	1.250	1.250	1.250	6.000	1.260	-6°	-6°	CNMG 432	2.1
	5/8	DCLNR/L 16 5D	1.000	1.250	1.000	1.000	6.000	1.540	-6°	-6°	CNMG 543	4.7
		DCLNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.540	-6°	-6°	CNMG 543	4.7
		DCLNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.540	-6°	-6°	CNMG 543	4.7
		DCLNR/L 85 5D	1.000	1.250	1.250	1.250	6.000	1.540	-6°	-6°	CNMG 543	4.7
	3/4	DCLNR 20 6D	1.250	1.500	1.250	1.250	6.000	1.700	-6°	-6°	CNMG 643	4.7
		DCLNR/L 16 6D	1.000	1.250	1.000	1.000	6.000	1.700	-6°	-6°	CNMG 643	4.7
		DCLNR/L 24 6D	1.500	2.000	1.500	1.500	6.000	1.700	-6°	-6°	CNMG 643	4.7
		DCLNR/L 85 6D	1.000	1.250	1.250	1.250	6.000	1.700	-6°	-6°	CNMG 643	4.7
		DCLNR/L 20 6D	1.250	1.500	1.250	1.250	6.000	1.700	-6°	-6°	CNMG 643	4.7
	1	DCLNR/L 24 8E	1.500	2.000	1.500	1.500	7.000	2.090	-6°	-6°	CNMG 866	7.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts (see next page)



A9



A115



A439



G6



A2



J2

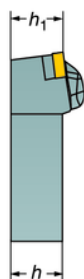
Shank tools

CoroTurn® RC rigid clamp design

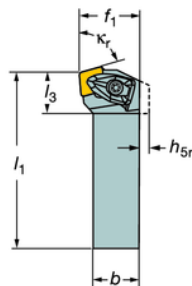
Entering angle:
Lead angle:



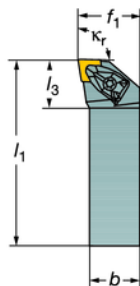
CNMM, CNGP
CNMG
CNMA, CNGA



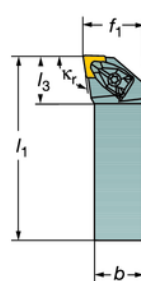
DCKNR/L
 $\kappa_r 75^\circ$
 15°



DCFNR/L
 $\kappa_r 91^\circ$
 -1°





DCGNR/L
 $\kappa_r 91^\circ$
 -1°

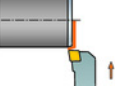
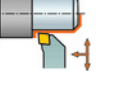



Right hand style shown unless otherwise stated

Metric version

			Dimensions, mm										
Main application		Ordering code	b	f ₁	h	h ₁	h _{5r}	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	Gauge inserts	Nm ³⁾
	12	DCKNR/L 2020K 12	20	25	20	20	4.5	125	21.2	-6°	-6°	CNMG 12 04 08	3.9
		DCKNR/L 2525M 12	25	32	25	25		150	21.1	-6°	-6°	CNMG 12 04 08	3.9
		DCKNR/L 3225P 12	25	32	32	32		170	21.1	-6°	-6°	CNMG 12 04 08	3.9
	16	DCKNR/L 3232P 16	32	40	32	32		170	26	-6°	-6°	CNMG 16 06 12	6.4
		DCKNR/L 4040S 16	40	50	40	40		250	23.1	-6°	-6°	CNMG 16 06 12	6.4

Inch version

Main application	iC	Ordering code	Dimensions, inch										Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	h _{5r}	l ₁	l ₃	γ ¹⁾	λ _s ²⁾			
	1/2	DCFNR/L 16 4D	1.000	1.250	1.000	1.000		6.000	1.070	-6°	-6°	CNMG 432	2.9	
	1/2	DCGNR/L 16 4D	1.000	1.250	1.000	1.000		6.000	1.300	-6°	-6°	CNMG 432	2.9	
		DCGNR/L 20 4D	1.250	1.500	1.250	1.250		6.000	1.300	-6°	-6°	CNMG 432	2.9	
	3/4	DCGNR/L 20 6D	1.250	1.500	1.250	1.250		6.000	1.770	-6°	-6°	CNMG 643	4.7	
	1/2	DCKNR/L 12 4B	.750	.855	.750	.750	.170	4.500	.830	-6°	-6°	CNMG 432	2.9	
		DCKNR/L 16 4D	1.000	1.250	1.000	1.000		6.000	.830	-6°	-6°	CNMG 432	2.9	
		DCKNR/L 85 4D	1.000	1.250	1.250	1.250		6.000	.830	-6°	-6°	CNMG 432	2.9	
	5/8	DCKNR/L 20 5D	1.250	1.500	1.250	1.250		6.000	1.020	-6°	-6°	CNMG 543	4.7	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size		Shim screw					Shim		Key (Torx Plus)		Complete clamp set		Key (Torx Plus)	
	iC													
09	3/8	5513 020-04					5322 236-04		5680 051-03 (9IP)		5412 028-011		5680 051-03 (9IP)	
12	1/2 ²⁾	5513 020-02					5322 234-01 ²⁾		5680 049-01 (15IP)		5412 028-021 ¹⁾		5680 049-01 (15IP)	
16	5/8	5513 020-07					5322 234-03		5680 043-14 (20IP)		5412 028-031 ¹⁾		5680 043-14 (20IP)	
19	3/4	5513 020-07					5322 236-01		5680 043-14 (20IP)		5412 028-041		5680 043-14 (20IP)	
25	1	5513 020-08					5322 234-05		5680 043-15 (25IP)		5412 028-051		5680 043-15 (25IP)	

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.

²⁾ Holders DCLNR/L 104A and DCLNR/L 1616H 12 use shim 5322 236-03.

A9

A115

A439

G6

A2

J2



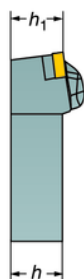
Shank tools

CoroTurn® RC rigid clamp design



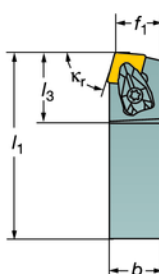
CNMM, CNGP
 CNMG
 CNMA, CNGA

Entering angle:
Lead angle:



DCBNR/L (Metric)
DCRNR/L (Inch)

κ_r 75°
15°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	12	DCBNR/L 2020K 12	20	17	20	20	125	34.2	-6°	-6°	CNMG 12 04 08	3.9
		DCBNR/L 2525M 12	25	22	25	25	150	34.6	-6°	-6°	CNMG 12 04 08	3.9
		DCBNR/L 3225P 12	25	22	32	32	170	34.6	-6°	-6°	CNMG 12 04 08	3.9
		DCBNR/L 3232P 12	32	27	32	32	170	34.2	-6°	-6°	CNMG 12 04 08	3.9
		DCBNR/L 4040S 12	40	35	40	40	250	34.8	-6°	-6°	CNMG 12 04 08	3.9
	16	DCBNR/L 2525M 16	25	22	25	25	150	41.5	-6°	-6°	CNMG 16 06 12	6.4
		DCBNR/L 3225P 16	25	22	32	32	170	32	-6°	-6°	CNMG 16 06 12	6.4
		DCBNR/L 3232P 16	32	27	32	32	170	41.6	-6°	-6°	CNMG 16 06 12	6.4
		DCBNR/L 4040S 16	40	35	40	40	250	42.3	-6°	-6°	CNMG 16 06 12	6.4
	19	DCBNR/L 3232P 19	32	27	32	32	170	46.1	-6°	-6°	CNMG 19 06 12	6.4
		DCBNR/L 4040S 19	40	35	40	40	250	46.7	-6°	-6°	CNMG 19 06 12	6.4

Inch version

Main application		Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/2	DCRNR/L 12 4BM1 ⁵⁾	.750	.855	.750	.750	4.500	1.350	-6°	-6°	CNMG 432	2.9
		DCRNR/L 16 4DM1 ⁵⁾	1.000	1.048	1.000	1.000	6.000	1.350	-6°	-6°	CNMG 432	2.9
		DCRNR/L 20 4DM1 ⁵⁾	1.250	1.292	1.250	1.250	6.000	1.350	-6°	-6°	CNMG 432	2.9
		DCRNR/L 24 4DM1 ⁵⁾	1.500	1.697	1.500	1.500	6.000	1.350	-6°	-6°	CNMG 432	2.9
		DCRNR/L 85 4D	1.000	1.047	1.250	1.250	6.000	1.360	-6°	-6°	CNMG 432	2.9
	5/8	DCRNR/L 16 5D	1.000	1.047	1.000	1.000	6.000	1.640	-6°	-6°	CNMG 543	4.7
		DCRNR/L 20 5D	1.250	1.291	1.250	1.250	6.000	1.640	-6°	-6°	CNMG 543	4.7
		DCRNR/L 24 5D	1.500	1.697	1.500	1.500	6.000	1.640	-6°	-6°	CNMG 543	4.7
		DCRNR/L 85 5D	1.000	1.047	1.250	1.250	6.000	1.640	-6°	-6°	CNMG 543	4.7
	3/4	DCRNR/L 20 6D	1.250	1.291	1.250	1.250	6.000	1.820	-6°	-6°	CNMG 643	4.7
		DCRNR/L 24 6D	1.500	1.697	1.500	1.500	6.000	1.820	-6°	-6°	CNMG 643	4.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) M1 in the end of the ordering code = Modified f₁-dimension to follow ANSI-standard.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
12	1/2	5513 020-02	5322 234-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
16	5/8	5513 020-07	5322 234-03	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
19	3/4	5513 020-07	5322 236-01	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A115



A439



G6



A2



J2

Shank tools

CoroTurn® RC rigid clamp design

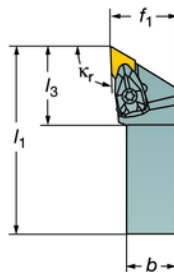
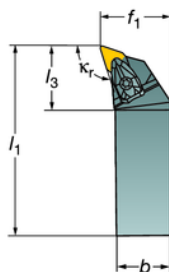
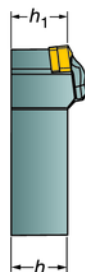


- DNMM, DNGP, DNMX
- DNMG
- DNMA, DNGA

Entering angle:
Lead angle:

DDHNR/L
DDQNR/L
 κ_r 107.5°
-17.5°

DDJNR/L
 κ_r 93°
-3°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	15	DDHNR/L 2020K 15	20	25	20	20	125	36.1	-6°	-7°	DNMG 15 06 08	3.9
		DDHNR/L 2525M 15	25	32	25	25	150	36.1	-6°	-7°	DNMG 15 06 08	3.9
		DDHNR/L 2525M 1504 ⁵⁾	25	32	25	25	150	36.1	-6°	-7°	DNMG 15 04 08	3.9
		DDHNR/L 3225P 15	25	32	32	32	170	36.1	-6°	-7°	DNMG 15 06 08	3.9
		DDHNR/L 3232P 15	32	40	32	32	170	36.1	-6°	-7°	DNMG 15 06 08	3.9
	11	DDJNR/L 1616H 11	16	20	16	16	100	30.1	-6°	-7°	DNMG 11 04 08	1.7
		DDJNR/L 2020K 11	20	25	20	20	125	30.2	-6°	-7°	DNMG 11 04 08	1.7
		DDJNR/L 2525M 11	25	32	25	25	150	30.2	-6°	-7°	DNMG 11 04 08	1.7
		DDJNR/L 3225P 11	25	32	32	32	170	30.2	-6°	-7°	DNMG 11 04 08	1.7
		DDJNR/L 3232P 11	32	40	32	32	170	30.1	-6°	-7°	DNMG 11 04 08	1.7
	15	DDJNR/L 2020K 15	20	25	20	20	125	39.4	-6°	-7°	DNMG 15 06 08	3.9
		DDJNR/L 2020K 1504 ⁵⁾	20	25	20	20	125	39.4	-6°	-7°	DNMG 15 04 08	3.9
		DDJNR/L 2525M 15	25	32	25	25	150	39.4	-6°	-7°	DNMG 15 06 08	3.9
		DDJNR/L 2525M 1504 ⁵⁾	25	32	25	25	150	39.4	-6°	-7°	DNMG 15 04 08	3.9
		DDJNR/L 3225P 15	25	32	32	32	170	39.4	-6°	-7°	DNMG 15 06 08	3.9
		DDJNR/L 3225P 1504 ⁵⁾	25	32	32	32	170	39.4	-6°	-7°	DNMG 15 04 08	3.9
		DDJNR/L 3232P 15	32	40	32	32	170	39.4	-6°	-7°	DNMG 15 06 08	3.9
		DDJNR/L 4040S 15	40	50	40	40	250	39.6	-6°	-7°	DNMG 15 06 08	3.9

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	DDQNR/L 12 3B	.750	1.000	.750	.750	4.500	1.090	-6°	-7°	DNMG 332	1.3
	1/2	DDQNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.420	-6°	-7°	DNMG 432	2.9
		DDQNR/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.420	-6°	-7°	DNMG 432	2.9
		DDQNR/L 24 4D	1.500	2.000	1.500	1.500	6.000	1.420	-6°	-7°	DNMG 432	2.9
	3/8	DDJNR/L 10 3A	.625	.875	.625	.625	4.000	1.200	-6°	-7°	DNMG 332	1.3
		DDJNR/L 12 3C	.750	1.000	.750	.750	5.000	1.190	-6°	-7°	DNMG 332	1.3
		DDJNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.190	-6°	-7°	DNMG 332	1.3
		DDJNR/L 20 3D	1.250	1.500	1.250	1.250	6.000	1.190	-6°	-7°	DNMG 332	1.3
		DDJNR/L 24 3D	1.500	2.000	1.500	1.500	6.000	1.190	-6°	-7°	DNMG 332	1.3
		DDJNR/L 85 3D	1.000	1.250	1.250	1.250	6.000	1.200	-6°	-7°	DNMG 332	1.3
	1/2	DDJNR/L 12 4B	.750	1.000	.750	.750	4.500	1.450	-6°	-7°	DNMG 432	2.9
		DDJNR/L 16 4C	1.000	1.250	1.000	1.000	5.000	1.550	-6°	-7°	DNMG 432	2.9
		DDJNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.250	-6°	-7°	DNMG 432	2.9
		DDJNR/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.550	-6°	-7°	DNMG 432	2.9
		DDJNR/L 24 4D	1.500	2.000	1.500	1.500	6.000	1.550	-6°	-7°	DNMG 432	2.9
		DDJNR/L 85 4D	1.000	1.250	1.250	1.250	6.000	1.550	-6°	-7°	DNMG 432	2.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

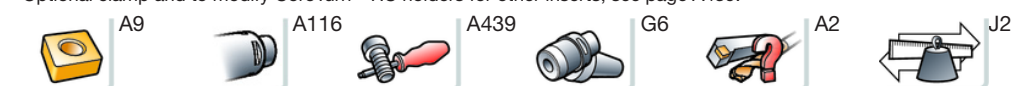
5) -1504 in the end of the ordering code = For inserts with thickness 4.76 mm (3/16")

R = Right hand, L = Left hand

Main spare parts

Insert size		Shim screw					Shim		Key (Torx Plus)		Complete clamp set		Key (Torx Plus)	
11	3/8	5513 020-04	5322 267-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)								
1504	-	5513 020-02	5322 266-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)								
1506	-	5513 020-02	5322 266-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)								
-	1/2	5513 020-02	5322 266-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)								

1) Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



Shank tools

CoroTurn® RC rigid clamp design



DNMM, DNGP,
DNMX
DNMG
DNMA, DNGA

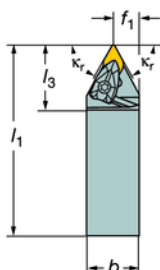
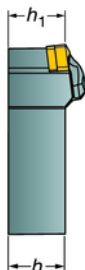
Entering angle:
Lead angle:

DDNNN

DDPNN

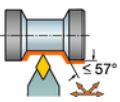
κ_r 62.5°

27.5°

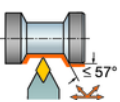


Neutral style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	11	DDNNN 2020K 11	20	10.5	20	20	125	31.2	-5°	-9°	DNMG 11 04 08	1.7
		DDNNN 2525M 11	25	13	25	25	150	31.2	-5°	-9°	DNMG 11 04 08	1.7
	15	DDNNN 2525M 15	25	13	25	25	150	40.8	-5°	-9°	DNMG 15 06 08	3.9
		DDNNN 2525M 1504 ⁵⁾	25	13	25	25	150	40.8	-5°	-9°	DNMG 15 04 08	3.9
		DDNNN 3225P 15	25	13	32	32	170	40.8	-5°	-9°	DNMG 15 06 08	3.9
		DDNNN 3225P 1504 ⁵⁾	25	13	32	32	170	40.8	-5°	-9°	DNMG 15 04 08	3.9
		DDNNN 3232P 15	32	16.5	32	32	170	40.8	-5°	-9°	DNMG 15 06 08	3.9
		DDNNN 4040S 15	40	20.5	40	40	250	40.8	-5°	-9°	DNMG 15 06 08	3.9

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	DDPNN 12 3B	.750	.375	.750	.750	4.500	1.230	-5°	-9°	DNMG 332	1.3
		DDPNN 16 3C	1.000	.500	1.000	1.000	5.000	1.230	-5°	-9°	DNMG 332	1.3
	1/2	DDPNN 12 4B	.750	.375	.750	.750	4.500	1.610	-5°	-9°	DNMG 432	2.9
		DDPNN 16 4D	1.000	.500	1.000	1.000	6.000	1.610	-5°	-9°	DNMG 432	2.9
		DDPNN 20 4D	1.250	.625	1.250	1.250	6.000	1.610	-5°	-9°	DNMG 432	2.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) -1504 in the end of the ordering code = For inserts with thickness 4.76 mm (3/16")

N = Neutral

Main spare parts

Insert size

	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
11	3/8	5513 020-04	5322 267-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
1504	1/2	5513 020-02	5322 266-01	5680 049-01 (15IP)	5412 028-0211)	5680 049-01 (15IP)
1506	1/2	5513 020-02	5322 266-02	5680 049-01 (15IP)	5412 028-0211)	5680 049-01 (15IP)

1) Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A116



A439



G6



A2



J2

Shank tools

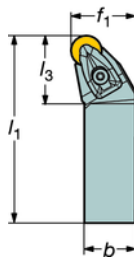
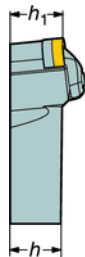
CoroTurn® RC rigid clamp design

Neg.

DRSNR/L



RNMG
RNGA



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	09	DRSNR/L 2020K 09	20	25	20	20	125	24.4	-6°	-6°	RNMG 09 03 00	1.7
	12	DRSNR/L 2525M 12	25	32	25	25	150	31.6	-6°	-6°	RNMG 12 04 00	3.9
	15	DRSNR/L 3225P 15	25	32	32	32	170	38.5	-6°	-6°	RNMG 15 06 00	6.4
	19	DRSNR/L 3232P 19	32	40	32	32	170	42.6	-6°	-6°	RNMG 19 06 00	6.4
	25	DRSNR/L 4040S 25	40	50	40	40	250	50.5	-6°	-6°	RNMG 25 09 00	9.5

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	DRSNR/L 12 3B	.750	1.000	.750	.750	4.500	.984	-6°	-6°	RNMG 32	1.3
	1/2	DRSNR/L 16 4D	1.000	1.252	1.000	1.000	6.000	1.244	-6°	-6°	RNMG 43	2.9
		DRSNR/L 20 4D	1.250	1.500	1.250	1.252	6.000	1.244	-6°	-6°	RNMG 43	2.9

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
09	3/8	5513 020-04	5322 156-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
12	1/2	5513 020-02	5322 155-02	5680 049-01 (15IP)	5412 028-021	5680 049-01 (15IP)
15		5513 020-07	5322 155-04	5680 043-14 (20IP)	5412 028-031	5680 043-14 (20IP)
19		5513 020-07	5322 155-06	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)
25		5513 020-08	5322 155-07	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)



A9



A117



A439



G6



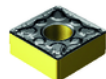
A2



J2

Shank tools

CoroTurn® RC rigid clamp design

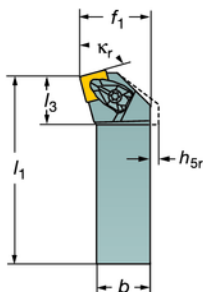
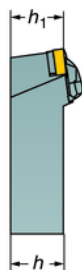


SNMM
 SNMG
 SNMA, SNGA

Entering angle:
 Lead angle:



DSKNR/L

κ_r 75°
 15°




Right hand style shown unless otherwise stated

Metric version

			Dimensions, mm											
Main application		Ordering code	<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>h</i> _{5r}	<i>l</i> ₁	<i>l</i> ₃	<i>γ</i> ¹⁾	<i>λ</i> _s ²⁾	Gauge inserts	Nm ³⁾	
	09	DSKNR/L 2020K 09	20	25	20	20		125	18.2	-6°	-6°	SNMG 09 03 08	1.7	
	12	DSKNR/L 2020K 12	20	25	20	20	4.5	125	23.6	-6°	-6°	SNMG 12 04 08	3.9	
		DSKNR/L 2525M 12	25	32	25	25		150	23.6	-6°	-6°	SNMG 12 04 08	3.9	
		DSKNR/L 3225P 12	25	32	32	32		170	23.5	-6°	-6°	SNMG 12 04 08	3.9	
	15	DSKNR/L 3232P 15	32	40	32	32		170	28.9	-6°	-6°	SNMG 15 06 12	6.4	
	19	DSKNR/L 3232P 19	32	40	32	32		170	32.1	-6°	-6°	SNMG 19 06 12	6.4	
		DSKNR/L 4040S 19	40	50	40	40		250	29.6	-6°	-6°	SNMG 19 06 12	6.4	
	25	DSKNR/L 5050T 25	50	60	50	50		300	35.2	-6°	-6°	SNMG 25 07 24	9.5	

Inch version

			Dimensions, inch										
Main application	iC	Ordering code	b	f ₁	h	h ₁	h _{5r}	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	Gauge inserts	ft-lbs ⁴⁾
	3/8	DSKNR/L 12 3B	.750	1.000	.750	.750		4.500	.670	-6°	-6°	SNMG 322	1.3
	1/2	DSKNR/L 12 4B	.750	1.000	.750	.750	.180	4.500	.930	-6°	-6°	SNMG 432	2.1
		DSKNR/L 16 4D	1.000	1.250	1.000	1.000		6.000	.930	-6°	-6°	SNMG 432	2.1
		DSKNR/L 85 4D	1.000	1.250	1.250	1.250		6.000	.930	-6°	-6°	SNMG 432	2.9
	5/8	DSKNR/L 20 5D	1.250	1.500	1.250	1.250		6.000	1.140	-6°	-6°	SNMG 543	4.7
	3/4	DSKNR/L 20 6D	1.250	1.500	1.250	1.250	.100	6.000	1.170	-6°	-6°	SNMG 643	4.7
		DSKNR/L 24 6D	1.500	2.000	1.500	1.500		6.000	1.170	-6°	-6°	SNMG 643	4.7
	1	DSKNR/L 32 8F	2.000	2.500	2.000	2.000		8.000	1.390	-6°	-6°	SNMG 856	7.0

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	
09	3/8	5513 020-04	5322 426-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)	
12	1/2	5513 020-02	5322 425-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)	
15	5/8	5513 020-07	5322 425-03	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)	
19	3/4	5513 020-07	5322 425-04	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)	
25	1	5513 020-08	5322 425-07	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)	

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A118



A439



G6



A2



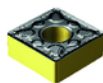
J2

Shank tools

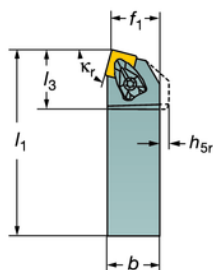
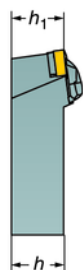
CoroTurn® RC rigid clamp design

DSBNR/L
DSRNR/L
 κ_r 75°
15°

Entering angle:
Lead angle:





SNMM
SNMG
SNMA, SNGA



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm									Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	h _{5r}	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	09	DSBNR/L 1616H 09	16	13	16	16	1	100	26.7	-6°	-6°	SNMG 09 03 08	1.7
		DSBNR/L 2020K 09	20	17	20	20		125	26.7	-6°	-6°	SNMG 09 03 08	1.7
		DSBNR/L 2525M 09	25	22	25	25		150	26.7	-6°	-6°	SNMG 09 03 08	1.7
	12	DSBNR/L 2020K 12	20	17	20	20	2.5	125	34.2	-6°	-6°	SNMG 12 04 08	3.9
		DSBNR/L 2525M 12	25	22	25	25		150	34.3	-6°	-6°	SNMG 12 04 08	3.9
		DSBNR/L 3225P 12	25	22	32	32		170	34.3	-6°	-6°	SNMG 12 04 08	3.9
		DSBNR/L 3232P 12	32	27	32	32		170	34.2	-6°	-6°	SNMG 12 04 08	3.9
		DSBNR/L 4040S 12	40	35	40	40		250	34.5	-6°	-6°	SNMG 12 04 08	3.9
		15	DSBNR/L 2525M 15	25	22	25	25	2	150	41.6	-6°	-6°	SNMG 15 06 12
	DSBNR/L 3225P 15		25	22	32	32	2	170	41.7	-6°	-6°	SNMG 15 06 12	6.4
	DSBNR/L 3232P 15		32	27	32	32		170	41.5	-6°	-6°	SNMG 15 06 12	6.4
	19	DSBNR/L 3232P 19	32	27	32	32		170	46.4	-6°	-6°	SNMG 19 06 12	6.4
		DSBNR/L 4040S 19	40	35	40	40		250	46.5	-6°	-6°	SNMG 19 06 12	6.4
	25	DSBNR/L 4040S 25	40	35	40	40		250	56.6	-6°	-6°	SNMG 25 07 24	9.5
		DSBNR/L 5050T 25	50	43	50	50		300	56.6	-6°	-6°	SNMG 25 07 24	9.5

Inch version

			Dimensions, inch										
Main application	iC	Ordering code	b	f ₁	h	h ₁	h _{5r}	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	Gauge inserts	ft-lbs ⁴⁾
	3/8	DSRNR/L 10 3B	.625	.783	.625	.625		4.500	1.050	-6°	-6°	SNMG 322	1.3
		DSRNR/L 12 3B	.750	.855	.750	.750		4.500	1.050	-6°	-6°	SNMG 322	1.3
		DSRNR/L 16 3C	1.000	1.048	1.000	1.000		5.000	1.050	-6°	-6°	SNMG 322	1.3
	1/2	DSRNR/L 12 4BM1 ⁵⁾	.750	.855	.750	.750		4.500	1.350	-6°	-6°	SNMG 432	2.9
		DSRNR/L 16 4DM1 ⁵⁾	1.000	1.048	1.000	1.000		6.000	1.350	-6°	-6°	SNMG 432	2.9
		DSRNR/L 20 4DM1 ⁵⁾	1.250	1.292	1.250	1.250		6.000	1.350	-6°	-6°	SNMG 432	2.9
		DSRNR/L 24 4DM1 ⁵⁾	1.500	1.697	1.500	1.500		6.000	1.350	-6°	-6°	SNMG 432	2.9
		DSRNR/L 85 4D	1.000	1.047	1.250	1.250		6.000	1.350	-6°	-6°	SNMG 432	2.9
	5/8	DSRNR/L 16 5D	1.000	1.047	1.000	1.000		6.000	1.640	-6°	-6°	SNMG 543	4.7
		DSRNR/L 20 5D	1.250	1.291	1.250	1.250		6.000	1.640	-6°	-6°	SNMG 543	4.7
		DSRNR/L 85 5D	1.000	1.047	1.250	1.250		6.000	1.640	-6°	-6°	SNMG 543	4.7
	3/4	DSRNR/L 16 6DM1 ⁵⁾	1.000	1.048	1.000	1.000		6.000	1.830	-6°	-6°	SNMG 643	4.7
		DSRNR/L 20 6DM1 ⁵⁾	1.250	1.292	1.250	1.250		6.000	1.830	-6°	-6°	SNMG 643	4.7
		DSRNR/L 24 6D	1.500	1.697	1.500	1.500		6.000	1.830	-6°	-6°	SNMG 643	4.7
	1	DSRNR/L 24 8E	1.500	1.697	1.500	1.500		7.000	2.220	-6°	-6°	SNMG 856	7.0
		DSRNR/L 32 8F	2.000	2.268	2.000	2.000		8.000	2.230	-6°	-6°	SNMG 856	7.0

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) M1 in the end of the ordering code = Modified f_1 -dimension to follow ANSI-standard.

R = Right hand, L = Left hand

Main spare parts

Insert size		Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
09	3/8	5513 020-04	5322 426-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
12	1/2	5513 020-02	5322 425-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
15	5/8	5513 020-07	5322 425-03	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
19	3/4	5513 020-07	5322 425-04	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)
25	1	5513 020-08	5322 425-07	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.

A9



A118



A439



G6



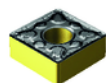
A2



J2

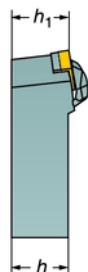
Shank tools

CoroTurn® RC rigid clamp design



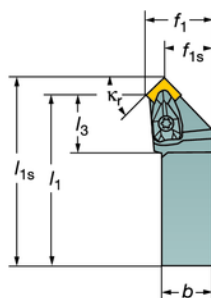
SNMM
 SNMG
 SNMA, SNGA

Entering angle:
Lead angle:



DSSNR/L

$\kappa_r 45^\circ$
 45°



Right hand style shown unless otherwise stated

Metric version

Main application	□ iC	Ordering code	Dimensions, mm										Gauge inserts	Nm ³⁾
			b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾		
	09	DSSNR/L 1616H 09	16	20	13.9	16	16	100	21.3	106.1	-8°	0°	SNMG 09 03 08	1.7
		DSSNR/L 2020K 09	20	25	18.9	20	20	125	21.3	131.1	-8°	0°	SNMG 09 03 08	1.7
		DSSNR/L 2525M 09	25	32	25.9	25	25	150	21.3	156.1	-8°	0°	SNMG 09 03 08	1.7
	12	DSSNR/L 2020K 12	20	25	16.7	20	20	125	27.5	133.3	-8°	0°	SNMG 12 04 08	3.9
		DSSNR/L 2525M 12	25	32	23.7	25	25	150	27.5	158.3	-8°	0°	SNMG 12 04 08	3.9
		DSSNR/L 3225P 12	25	32	23.7	32	32	170	28.8	178.3	-8°	0°	SNMG 12 04 08	3.9
		DSSNR/L 3232P 12	32	40	31.7	32	32	170	27.4	178.3	-8°	0°	SNMG 12 04 08	3.9
	15	DSSNR/L 2525M 15	25	32	21.8	25	25	150	32	160.2	-8°	0°	SNMG 15 06 12	6.4
		DSSNR/L 3225P 15	25	32	21.8	32	32	170	34.9	180.2	-8°	0°	SNMG 15 06 12	6.4
		DSSNR/L 3232P 15	32	40	29.8	32	32	170	34.9	180.2	-8°	0°	SNMG 15 06 12	6.4
	19	DSSNR/L 3232P 19	32	40	27.5	32	32	170	37	182.5	-8°	0°	SNMG 19 06 12	6.4
		DSSNR/L 4040S 19	40	50	37.5	40	40	250	37.7	262.5	-8°	0°	SNMG 19 06 12	6.4
	25	DSSNR/L 4040S 25	40	50	34.0	40	40	250	41.1	266.0	-8°	0°	SNMG 25 07 24	9.5

Inch version

Main application	iC	Ordering code	Dimensions, inch										Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾		
	3/8	DSSNR/L 10 3B	.625	.875	.630	.625	.625	4.500	4.740	.890	-8°	0°	SNMG 322	1.3
		DSSNR/L 12 3B	.750	1.000	.770	.750	.750	4.500	4.740	.890	-8°	0°	SNMG 322	1.3
		DSSNR/L 16 3D	1.000	1.250	1.010	1.000	1.000	6.000	6.240	.840	-8°	0°	SNMG 322	1.3
	1/2	DSSNR/L 12 4B	.750	1.000	.740	.750	.750	4.500	4.880	1.130	-8°	0°	SNMG 432	2.9
		DSSNR/L 16 4D	1.000	1.250	.925	1.000	1.000	6.000	6.327	1.172	-8°	0°	SNMG 432	2.9
		DSSNR/L 85 4D	1.000	1.250	.921	1.250	1.250	6.000	6.327	1.075	-8°	0°	SNMG 432	2.9
	5/8	DSSNR/L 16 5D	1.000	1.250	.846	1.000	1.000	6.000	6.402	1.303	-8°	0°	SNMG 543	4.7
		DSSNR/L 20 5D	1.250	1.500	1.098	1.250	1.250	6.000	6.413	1.303	-8°	0°	SNMG 543	4.7
	3/4	DSSNR/L 20 6D	1.250	1.500	1.008	1.250	1.250	6.000	6.492	1.413	-8°	0°	SNMG 643	4.7
		DSSNR/L 24 6E	1.500	2.000	1.508	1.500	1.500	7.000	7.492	1.484	-8°	0°	SNMG 643	4.7
		DSSNR/L 86 6D	1.000	1.250	.760	1.500	1.500	6.000	6.492	1.413	-8°	0°	SNMG 643	4.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size						
□	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
09	3/8	5513 020-04	5322 426-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
12	1/2	5513 020-02	5322 425-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
15	5/8	5513 020-07	5322 425-03	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
19	3/4	5513 020-07	5322 425-04	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)
25	1	5513 020-08	5322 425-07	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A118



A439



G6



A2



J2

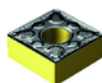
Shank tools

CoroTurn® RC rigid clamp design

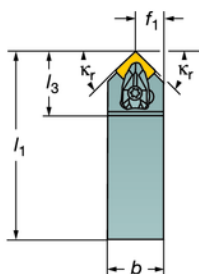
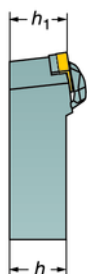
DSDNN

$\kappa_r 45^\circ$
45°

Entering angle:
Lead angle:





SNMM
SNMG
SNMA, SNGA




Neutral style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	γ ¹⁾	λ _s ²⁾		
	09	DSDNN 1616H 09	16	8.3	16	16	100	28.1	-6°	-6°	SNMG 09 03 08	1.7
	12	DSDNN 2020K 12	20	10.3	20	20	125	36.5	-6°	-6°	SNMG 12 04 08	3.9
		DSDNN 2525M 12	25	12.8	25	25	150	36.5	-6°	-6°	SNMG 12 04 08	3.9
		DSDNN 3225P 12	25	12.8	32	32	170	36.5	-6°	-6°	SNMG 12 04 08	3.9
		DSDNN 3232P 12	32	16.3	32	32	170	36.8	-6°	-6°	SNMG 12 04 08	3.9
	15	DSDNN 2525M 15	25	12.8	25	25	150	44.8	-6°	-6°	SNMG 15 06 12	6.4
	19	DSDNN 3225P 19	25	13	32	32	170	49.5	-6°	-6°	SNMG 19 06 12	6.4
		DSDNN 3232P 19	32	16.5	32	32	170	49.5	-6°	-6°	SNMG 19 06 12	6.4
	25	DSDNN 4040S 25	40	21	40	40	250	57.2	-6°	-6°	SNMG 25 07 24	9.5

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	3/8	DSDNN 10 3A	.625	.330	.625	.625	4.000	1.110	-6°	-6°	SNMG 322	1.3
	1/2	DSDNN 12 4B	.750	.386	.750	.750	4.500	1.450	-6°	-6°	SNMG 432	2.9
		DSDNN 16 4D	1.000	.512	1.000	1.000	6.000	1.450	-6°	-6°	SNMG 432	2.9
		DSDNN 20 4D	1.250	.638	1.250	1.250	6.000	1.450	-6°	-6°	SNMG 432	2.9
		DSDNN 24 4D	1.500	.764	1.500	1.500	6.000	1.450	-6°	-6°	SNMG 432	2.9
		DSDNN 85 4D	1.000	.512	1.250	1.250	6.000	1.450	-6°	-6°	SNMG 432	2.1
	5/8	DSDNN 16 5D	1.000	.520	1.000	1.000	6.000	1.760	-6°	-6°	SNMG 543	4.7
		DSDNN 20 5D	1.250	.646	1.250	1.250	6.000	1.760	-6°	-6°	SNMG 543	4.7
		DSDNN 24 5D	1.500	.772	1.500	1.500	6.000	1.760	-6°	-6°	SNMG 543	4.7
	3/4	DSDNN 20 6D	1.250	.646	1.250	1.250	6.000	1.970	-6°	-6°	SNMG 643	4.7
		DSDNN 85 6D	1.000	.520	1.250	1.250	6.000	1.970	-6°	-6°	SNMG 643	4.7
	1	DSDNN 24 8D	1.500	.791	1.500	1.500	6.000	2.260	-6°	-6°	SNMG 856	7.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

N = Neutral

Main spare parts

Insert size						
	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
09	3/8	5513 020-04	5322 426-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
12	1/2	5513 020-02	5322 425-01	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
15	5/8	5513 020-07	5322 425-03	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
19	3/4	5513 020-07	5322 425-04	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)
25	1	5513 020-08	5322 425-07	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A118



A439



G6



A2



J2

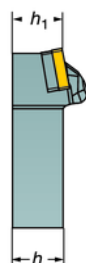
Shank tools

CoroTurn® RC rigid clamp design



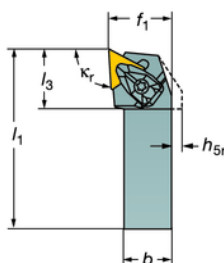
TNMM, TNMX
TNMG
TNMA, TNGA

Entering angle:
Lead angle:



DTJNR/L

$\kappa_r 93^\circ$
 -3°

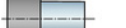


Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm									Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	h _{5r}	l ₁	l ₃	$\gamma^1)$	$\lambda_s^{2)}$		
	16	DTJNR/L 1616H 16	16	20	16	16	1	100	24.9	-6°	-6°	TNMG 16 04 08	1.7
		DTJNR/L 2020K 16	20	25	20	20		125	24.9	-6°	-6°	TNMG 16 04 08	1.7
		DTJNR/L 2525M 16	25	32	25	25		150	24.9	-6°	-6°	TNMG 16 04 08	1.7
		DTJNR/L 3225P 16	25	32	32	32		170	25.3	-6°	-6°	TNMG 16 04 08	1.7
	22	DTJNR/L 2525M 22	25	32	25	25		150	32.6	-6°	-6°	TNMG 22 04 08	3.9
		DTJNR/L 3225P 22	25	32	32	32		170	32.6	-6°	-6°	TNMG 22 04 08	3.9
		DTJNR/L 3232P 22	32	40	32	32		170	32.6	-6°	-6°	TNMG 22 04 08	3.9
	27	DTJNR/L 3232P 27	32	40	32	32		170	49.8	-6°	-6°	TNMG 27 06 12	6.4
		DTJNR/L 4040S 27	40	50	40	40		250	38.4	-6°	-6°	TNMG 27 06 12	6.4

Inch version

			Dimensions, inch										
Main application	iC	Ordering code	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	Gauge inserts	ft-lbs ⁴⁾	
	3/8	DTJNR/L 12 3B	.750	1.000	.750	.750	4.500	.953	-6°	-6°	TNMG 332	1.3	
		DTJNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	.980	-6°	-6°	TNMG 332	1.3	
		DTJNR/L 20 3D	1.250	1.500	1.250	1.250	6.000	.980	-6°	-6°	TNMG 332	1.3	
	1/2	DTJNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.283	-6°	-6°	TNMG 432	2.9	
		DTJNR/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.283	-6°	-6°	TNMG 432	2.9	
		DTJNR/L 85 4D	1.000	1.250	1.250	1.200	6.000	1.283	-6°	-6°	TNMG 432	2.9	
	5/8	DTJNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.570	-6°	-6°	TNMG 543	4.7	
		DTJNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.520	-6°	-6°	TNMG 543	4.7	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size		Shank size					
	iC	mm	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
16	3/8	1616	5513 020-04	5322 316-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
16	3/8		5513 020-04	5322 315-02	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
22	1/2		5513 020-02	5322 315-04	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
27	5/8		5513 020-07	5322 315-05	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A120



A439



G6



A2



J2

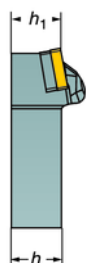
Shank tools

CoroTurn® RC rigid clamp design



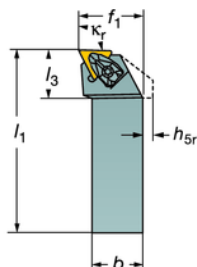
TNMM, TNMX
TNMG
TNMA, TNGA

Entering angle:
Lead angle:




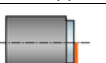
DTFNR/L

$\kappa_r 91^\circ$
 -1°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm									Gauge inserts	Nm ³⁾
			<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>h</i> _{5r}	<i>l</i> ₁	<i>l</i> ₃	γ ¹⁾	λ _s ²⁾		
	16	DTFNR/L 1616H 16	16	20	16	16	2	100	24	-6°	-6°	TNMG 16 04 08	1.7
		DTFNR/L 2020K 16	20	25	20	20		125	23.6	-6°	-6°	TNMG 16 04 08	1.7
		DTFNR/L 2525M 16	25	32	25	25		150	23.6	-6°	-6°	TNMG 16 04 08	1.7
		DTFNR/L 3225P 16	25	32	32	32		170	24.1	-6°	-6°	TNMG 16 04 08	1.7
	22	DTFNR/L 2525M 22	25	32	25	25		150	30.5	-6°	-6°	TNMG 22 04 08	3.9
		DTFNR/L 3225P 22	25	32	32	32		170	31.1	-6°	-6°	TNMG 22 04 08	3.9
		DTFNR/L 3232P 22	32	40	32	32		170	31.1	-6°	-6°	TNMG 22 04 08	3.9
	27	DTFNR/L 3232P 27	32	40	32	32		170	38.1	-6°	-6°	TNMG 27 06 12	6.4
		DTFNR/L 4040S 27	40	50	40	40		250	37.4	-6°	-6°	TNMG 27 06 12	6.4
	33	DTFNR/L 4040S 33	40	50	40	40		250	41.4	-6°	-6°	TNMG 33 07 12	6.4

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	$\gamma^{1)}$	$\lambda_s^{2)}$		
	3/8	DTFNR/L 10 3A	.625	.875	.625	.625	4.000	.933	-6°	-6°	TNMG 332	1.3
		DTFNR/L 12 3B	.750	1.000	.750	.750	4.500	.933	-6°	-6°	TNMG 332	1.3
		DTFNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.000	-6°	-6°	TNMG 332	1.3
	1/2	DTFNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.228	-6°	-6°	TNMG 432	2.9
		DTFNR/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.228	-6°	-6°	TNMG 432	2.9
		DTFNR/L 24 4D	1.500	2.000	1.500	1.500	6.000	1.210	-6°	-6°	TNMG 432	2.9
		DTFNR/L 85 4D	1.000	1.250	1.250	1.250	6.000	1.228	-6°	-6°	TNMG 432	2.9
	5/8	DTFNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.500	-6°	-6°	TNMG 543	4.7
		DTFNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.470	-6°	-6°	TNMG 543	4.7
	3/4	DTFNR/L 24 6D	1.500	2.000	1.500	1.500	6.000	1.630	-6°	-6°	TNMG 653	4.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size

	iC	Shank size		Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
		mm	inch					
16	3/8	1616	103A	5513 020-04	5322 316-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
16	3/8			5513 020-04	5322 315-02	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
22	1/2			5513 020-02	5322 315-04	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
27	5/8			5513 020-07	5322 315-05	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
33	3/4			5513 020-07	5322 315-06	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



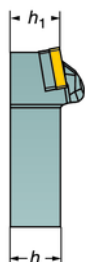
Shank tools

CoroTurn® RC rigid clamp design

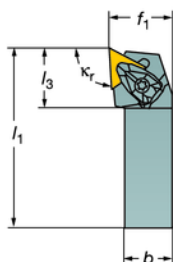


TNMM, TNMX
TNMG
TNMA, TNGA

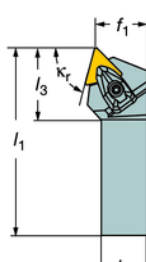
Entering angle:
Lead angle:



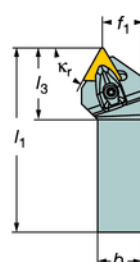
DTGNR/L
 $\kappa_r 91^\circ$
 -1°



DTRNR/L
 $\kappa_r 75^\circ$
 15°



DTTNR/L
 $\kappa_r 60^\circ$
 30°



Metric version

Right hand style shown unless otherwise stated

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	16	DTGNR/L 1616H 16	16	20	16	16	100	25.4	-6°	-6°	TNMG 16 04 08	1.7
		DTGNR/L 2020K 16	20	25	20	20	125	25.4	-6°	-6°	TNMG 16 04 08	1.7
		DTGNR/L 2525M 16	25	32	25	25	150	24.6	-6°	-6°	TNMG 16 04 08	1.7
		DTGNR/L 3225P 16	25	32	32	32	170	25.3	-6°	-6°	TNMG 16 04 08	1.7
	22	DTGNR/L 2525M 22	25	32	25	25	150	32.1	-6°	-6°	TNMG 22 04 08	3.9
		DTGNR/L 3225P 22	25	32	32	32	170	33.1	-6°	-6°	TNMG 22 04 08	3.9
	27	DTGNR/L 3232P 22	32	40	32	32	170	33.1	-6°	-6°	TNMG 22 04 08	3.9
		DTGNR/L 3232P 27	32	40	32	32	170	40.6	-6°	-6°	TNMG 27 06 12	6.4
	16	DTTNR/L 1616H 16	16	13	16	16	100	30.3	-6°	-6°	TNMG 16 04 08	1.7
		DTTNR/L 2020K 16	20	17	20	20	125	30.2	-6°	-6°	TNMG 16 04 08	1.7
	22	DTTNR/L 2525M 22	25	22	25	25	150	39.6	-6°	-6°	TNMG 22 04 08	3.9
		DTTNR/L 3225P 22	25	22	32	32	170	39.6	-6°	-6°	TNMG 22 04 08	3.9

Inch version

Main application		iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8		DTGNR/L 10 3A	.625	.875	.625	.625	4.000	.970	-6°	-6°	TNMG 332	1.3
			DTGNR/L 12 3B	.750	1.000	.750	.750	4.500	.970	-6°	-6°	TNMG 332	1.3
			DTGNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	.970	-6°	-6°	TNMG 332	1.3
			DTGNR/L 85 3D	1.000	1.250	1.250	1.250	6.000	1.000	-6°	-6°	TNMG 332	1.3
	1/2		DTGNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.260	-6°	-6°	TNMG 432	2.9
			DTGNR/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.310	-6°	-6°	TNMG 432	2.9
			DTGNR/L 85 4D	1.000	1.250	1.250	1.250	6.000	1.310	-6°	-6°	TNMG 432	2.9
			DTGNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.590	-6°	-6°	TNMG 543	4.7
	3/8		DTGNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.550	-6°	-6°	TNMG 543	4.7
			DTGNR/L 24 6D	1.500	2.000	1.500	1.500	6.000	1.740	-6°	-6°	TNMG 653	4.7
	1/2		DTRNR/L 12 3B	.750	.854	.750	.750	4.500	1.122	-6°	-6°	TNMG 332	1.3
			DTRNR/L 16 3D	1.000	1.047	1.000	1.000	6.000	1.122	-6°	-6°	TNMG 332	1.3
	3/8		DTRNR/L 16 4D	1.000	1.047	1.000	1.000	6.000	1.472	-6°	-6°	TNMG 432	2.9
	1/2		DTTNR/L 10 3B	.625	.590	.625	.625	4.500	1.190	-6°	-6°	TNMG 332	1.3
			DTTNR/L 12 3B	.750	.598	.750	.750	4.500	1.190	-6°	-6°	TNMG 332	1.3
	1/2		DTTNR/L 16 4D	1.000	.791	1.000	1.000	6.000	1.560	-6°	-6°	TNMG 432	2.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size

	iC	Shank size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
16	3/8	1616	5513 020-04	5322 316-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
16	3/8	103A	5513 020-04	5322 315-02	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
22	1/2		5513 020-02	5322 315-04	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
27	5/8		5513 020-07	5322 315-05	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
33	3/4		5513 020-07	5322 315-06	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A120



A439



G6



A2



J2

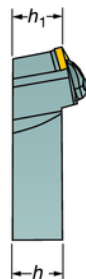
Shank tools

CoroTurn® RC rigid clamp design

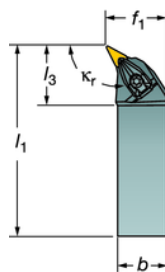


VNMG
VNGP

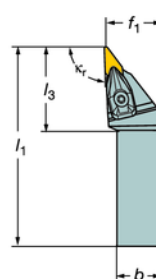
Entering angle:
Lead angle:



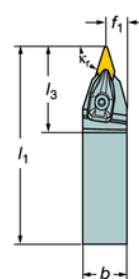
DVPCR/L
DVTNR/L
 κ_r 117.5°
-27.5°



DVJNR/L
 κ_r 93°
-3°



DVVNN
 κ_r 72.5°
17.5°



Right hand style shown unless otherwise stated

Neutral

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	16	DVPCR/L 2525M 16	25	32	25	25	150	39.2	-4°	-13°	VNMG 16 04 08	3.0
		DVPCR/L 3225P 16	25	32	32	32	170	39.2	-4°	-13°	VNMG 16 04 08	3.0
		DVPCR/L 3232P 16	32	40	32	32	170	39.2	-4°	-13°	VNMG 16 04 08	3.0
		DVPCR/L 4040S 16	40	50	40	40	250	39.2	-4°	-13°	VNMG 16 04 08	3.0
	16	DVJNR/L 2020K 16	20	25	20	20	125	46.6	-4°	-13°	VNMG 16 04 08	3.0
		DVJNR/L 2525M 16	25	32	25	25	150	46.6	-4°	-13°	VNMG 16 04 08	3.0
		DVJNR/L 3225P 16	25	32	32	32	170	46.6	-4°	-13°	VNMG 16 04 08	3.0
		DVJNR/L 3232P 16	32	40	32	32	170	46.6	-4°	-13°	VNMG 16 04 08	3.0
	16	DVVNN 2020K 16	20	10.6	20	20	125	47.8	-4°	-13°	VNMG 16 04 08	3.0
		DVVNN 2525M 16	25	13.1	25	25	150	47.8	-4°	-13°	VNMG 16 04 08	3.0
		DVVNN 3225P 16	25	13.1	32	32	170	47.8	-4°	-13°	VNMG 16 04 08	3.0
		DVVNN 3232P 16	32	16.6	32	32	170	47.8	-4°	-13°	VNMG 16 04 08	3.0
		DVVNN 4040S 16	40	20.6	40	40	250	47.8	-4°	-13°	VNMG 16 04 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	DVTNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.540	-4°	-13°	VNMG 332	2.2
		DVTNR/L 20 3D	1.250	1.500	1.250	1.250	6.000	1.540	-4°	-13°	VNMG 332	2.2
		DVTNR/L 24 3D	1.500	2.000	1.500	1.500	6.000	1.520	-4°	-13°	VNMG 332	2.2
	3/8	DVJNR/L 12 3B	.750	1.000	.750	.750	4.500	1.830	-4°	-13°	VNMG 332	2.2
		DVJNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.830	-4°	-13°	VNMG 332	2.2
		DVJNR/L 20 3D	1.250	1.500	1.250	1.250	6.000	1.830	-4°	-13°	VNMG 332	2.2
		DVJNR/L 24 3D	1.500	2.000	1.500	1.500	6.000	1.830	-4°	-13°	VNMG 332	2.2
	3/8	DVVNN 12 3B	.750	.398	.750	.750	4.500	1.880	-4°	-13°	VNMG 332	2.2
		DVVNN 16 3D	1.000	.524	1.000	1.000	6.000	1.880	-4°	-13°	VNMG 332	2.2
		DVVNN 20 3D	1.250	.650	1.250	1.250	6.000	1.880	-4°	-13°	VNMG 332	2.2
		DVVNN 24 3D	1.500	.770	1.500	1.500	6.000	1.880	-4°	-13°	VNMG 332	2.2

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Insert size						
iC		Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
16	3/8	5513 020-09	5322 269-01	5680 049-01 (15IP)	5412 028-061	5680 049-01 (15IP)



A9



A121



A439



G6



A2



J2

Shank tools

CoroTurn® RC rigid clamp design

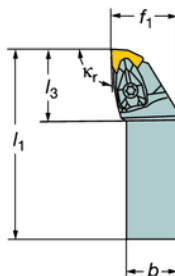
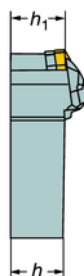


WNMM,
WNMG
WNGA, WNMA

Entering angle:
Lead angle:



DWLNRL

$\kappa_r 95^\circ$
 -5°




Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	γ ¹⁾	λ _s ²⁾		
	06	DWLNRL/L 1616H 06	16	20	16	16	100	26.4	-6°	-6°	WNMG 06 04 08	1.7
		DWLNRL/L 2020K 06	20	25	20	20	125	27.1	-6°	-6°	WNMG 06 04 08	1.7
		DWLNRL/L 2525M 06	25	32	25	25	150	27.1	-6°	-6°	WNMG 06 04 08	1.7
		DWLNRL/L 3225P 06	25	32	32	32	170	27.1	-6°	-6°	WNMG 06 04 08	1.7
	08	DWLNRL/L 2020K 08	20	25	20	20	125	34.3	-6°	-6°	WNMG 08 04 08	3.9
		DWLNRL/L 2525M 08	25	32	25	25	150	35	-6°	-6°	WNMG 08 04 08	3.9
		DWLNRL/L 3225P 08	25	32	32	32	170	35	-6°	-6°	WNMG 08 04 08	3.9
		DWLNRL/L 3232P 08	32	40	32	32	170	34.3	-6°	-6°	WNMG 08 04 08	3.9
		DWLNRL/L 4040S 08	40	50	40	40	250	35	-6°	-6°	WNMG 08 04 08	3.9

Inch version

			Dimensions, inch									
Main application	iC	Ordering code	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	Gauge inserts	ft-lbs ⁴⁾
	3/8	DWLNRL/L 10 3B	.625	.875	.625	.625	4.500	1.070	-6°	-6°	WNMG 332	1.3
		DWLNRL/L 12 3C	.750	1.000	.750	.750	5.000	1.950	-6°	-6°	WNMG 332	1.3
		DWLNRL/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.950	-6°	-6°	WNMG 332	1.3
		DWLNRL/L 20 3D	1.250	1.500	1.250	1.250	6.000	1.950	-6°	-6°	WNMG 332	1.3
		DWLNRL/L 24 3D	1.500	2.000	1.500	1.500	6.000	1.070	-6°	-6°	WNMG 332	1.3
	1/2	DWLNRL/L 12 4C	.750	1.000	.750	.750	5.000	1.378	-6°	-6°	WNMG 432	2.9
		DWLNRL/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.350	-6°	-6°	WNMG 432	2.9
		DWLNRL/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.378	-6°	-6°	WNMG 432	2.9
		DWLNRL/L 24 4D	1.500	2.000	1.500	1.500	6.000	1.350	-6°	-6°	WNMG 432	2.9

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
06	3/8	5513 020-04	5322 328-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)
08	1/2	5513 020-02	5322 331-12	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)

¹⁾ Optional clamp and to modify CoroTurn® RC holders for other inserts, see page A439.



A9



A122



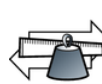
A439



G6



A2



J2

Shank tools

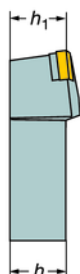
T-Max® P lever design

B

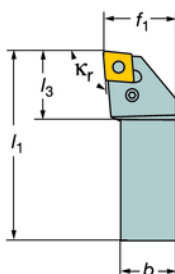


CNMM, CNGP
 CNMG
 CNMA, CNGA

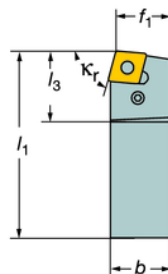
Entering angle:
Lead angle:



PCLNR/L

 $\kappa_r 95^\circ$
 -5°



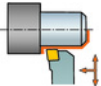

PCBNR/L

 $\kappa_r 75^\circ$
 15°


C

Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm								Gauge inserts
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	
	09	3/8	PCLNR/L 1616H 09	16	20	16	16	100	24.2	-6°	-6°	CNMG 09 03 08
			PCLNR/L 2020K 09	20	25	20	20	125	24.2	-6°	-6°	CNMG 09 03 08
			PCLNR/L 2525M 09	25	32	25	25	150	24.2	-6°	-6°	CNMG 09 03 08
	12	1/2	PCLNR/L 1616H 12-M	16	20	16	16	100	27.2	-6°	-6°	CNMG 12 04 08
			PCLNR/L 2020K 12	20	25	20	20	125	27.2	-6°	-6°	CNMG 12 04 08
			PCLNR/L 2525M 12	25	32	25	25	150	27.2	-6°	-6°	CNMG 12 04 08
			PCLNR/L 3225P 12	25	32	32	32	170	27.2	-6°	-6°	CNMG 12 04 08
	16	5/8	PCLNR/L 2525M 16	25	32	25	25	150	33.9	-6°	-6°	CNMG 16 06 12
			PCLNR/L 3225P 16	25	32	32	32	170	33.9	-6°	-6°	CNMG 16 06 12
			PCLNR/L 3232P 16	32	40	32	32	170	33.9	-6°	-6°	CNMG 16 06 12
19	3/4	PCLNR/L 2525M 19	25	32	25	25	150	37.9	-6°	-6°	CNMG 19 06 12	
		PCLNR/L 3225P 19	25	32	32	32	170	37.9	-6°	-6°	CNMG 19 06 12	
		PCLNR/L 3232P 19	32	40	32	32	170	37.9	-6°	-6°	CNMG 19 06 12	
		PCLNR/L 4040S 19	40	50	40	40	250	37.9	-6°	-6°	CNMG 19 06 12	
25	1	PCLNR/L 4040S 25	40	50	40	40	250	50	-6°	-6°	CNMG 25 09 24	
		PCLNR/L 5050T 25	50	60	50	50	300	50	-6°	-6°	CNMG 25 09 24	
	12	1/2	PCBNR/L 2525M 12	25	22	25	25	150	26.9	-6°	-6°	CNMG 12 04 08
	16	5/8	PCBNR/L 2525M 16	25	22	25	25	150	33.6	-6°	-6°	CNMG 16 06 12
			PCBNR/L 3225P 16	25	22	32	32	170	33.6	-6°	-6°	CNMG 16 06 12
			PCBNR/L 3232P 16	32	27	32	32	170	33.6	-6°	-6°	CNMG 16 06 12
	19	3/4	PCBNR/L 3232P 19	32	27	32	32	170	37.5	-6°	-6°	CNMG 19 06 12
			PCBNR/L 4040S 19	40	35	40	40	250	37.5	-6°	-6°	CNMG 19 06 12

1) γ = Rake angle (valid with flat insert).

R = Right hand, L = Left hand

2) λ_s = Angle of inclination.

Main spare parts

Insert size					
	iC	Lever	Screw	Key (mm)	Shim
09	3/8	174.3-840M	174.3-820M	170.3-860 (2.5)	5322 230-02
12-M	1/2 ¹⁾	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M
12	1/2	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M
16	5/8	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852
19	3/4	174.3-842M	174.3-822M	3021 010-040 (4.0)	171.31-851M
25	1	174.3-844M	174.3-827	3021 010-050 (5.0)	5322 230-01

1) For PCLNR/L 1616H12-M

J



A9



A129



A446



G6



A2





J2

Shank tools

T-Max® P lever design

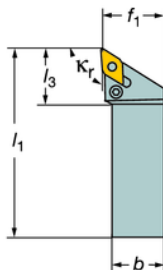
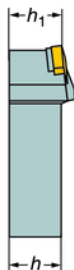


 DNMM, DNGP, DNMX
 DNMG
 DNMA, DNGA

Entering angle:
Lead angle:


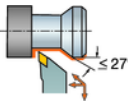
PDJNR/L
R/L 171.35

κ_r 93°
-3°



Right hand style shown unless otherwise stated

Metric version


Main application		iC	Ordering code	Dimensions, mm								Gauge inserts
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	
	11	3/8	PDJNR/L 1616H 11	16	20	16	16	100	29.7	-6°	-7°	DNMG 11 04 08
			PDJNR/L 2020K 11	20	25	20	20	125	29.7	-6°	-7°	DNMG 11 04 08
			PDJNR/L 2525M 11	25	32	25	25	150	29.7	-6°	-7°	DNMG 11 04 08
			PDJNR/L 3225P 11	25	32	32	32	170	29.7	-6°	-7°	DNMG 11 04 08
	15	1/2	PDJNR/L 2020K 15	20	25	20	20	125	36.2	-6°	-7°	DNMG 15 06 08
			PDJNR/L 2525M 15	25	32	25	25	150	36.2	-6°	-7°	DNMG 15 06 08
			PDJNR/L 3225P 15	25	32	32	32	170	36.2	-6°	-7°	DNMG 15 06 08
			PDJNR/L 3232P 15	32	40	32	32	170	36.2	-6°	-7°	DNMG 15 06 08
			R/L171.35-4025-15	25	28.7	40	40	200	38	-6°	-7°	DNMG 15 06 08
			R/L171.35-5032-15	32	35	50	50	225	38	-6°	-7°	DNMG 15 06 08

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size					
	iC	Lever	Screw	Key (mm)	Shim
11	3/8	5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01
15	1/2	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M



A9



A446



G6



A2



J2

Shank tools

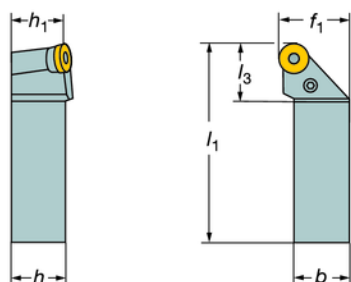
T-Max® P lever design

Neg.



RNMG
RNGA

PRGNR/L

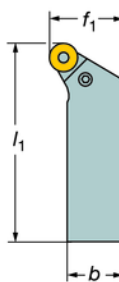


Pos.

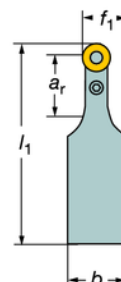


RCMX
RCMT
RCGX AL

PRGCR/L




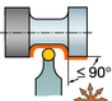

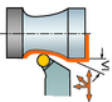
PRDCN



Neutral

Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm										Gauge inserts	
			a_r	b	f_1	h	h_1	l_1	l_3	$\gamma^{(1)}$	$\lambda_s^{(2)}$			
	10	PRDCN 2020K 10	25	20	15	20	20	125			0°	0°	RCMX 10 03 00	
	12	PRDCN 2525M 12	28	25	18.5	25	25	150			0°	0°	RCMX 12 04 00	
		PRDCN 3225P 12	28	25	18.5	32	32	170			0°	0°	RCMX 12 04 00	
	16	PRDCN 3225P 16	35	25	20.5	32	32	170			0°	0°	RCMX 16 06 00	
	20	PRDCN 3232P 20	40	32	26	32	32	170			0°	0°	RCMX 20 06 00	
	25	PRDCN 4040S 25	50	40	32.5	40	40	250			0°	0°	RCMX 25 07 00	
	32	PRDCN 5050U 32	55	50	41	50	50	350			0°	0°	RCMX 32 09 00	
	09	PRGNR/L 2020K 09		20	25	20	20	125	20.8		-6°	-6°	RNMG 09 03 00	
	12	PRGNR/L 2525M 12		25	32	25	25	150	27.2		-6°	-6°	RNMG 12 04 00	
	15	PRGNR/L 3225P 15		25	32	32	32	170	33.2		-6°	-6°	RNMG 15 06 00	
	19	PRGNR/L 3232P 19		32	40	32	32	170	38		-6°	-6°	RNMG 19 06 00	
	25	PRGNR/L 4040S 25		40	50	40	40	250	41.9		-6°	-6°	RNMG 25 09 00	
	10	PRGCR/L 2020K 10		20	25	20	20	125			0°	0°	RCMX 10 03 00	
		PRGCR/L 2525M 10		25	32	25	25	150			0°	0°	RCMX 10 03 00	
	12	PRGCR/L 2020K 12		20	25	20	20	125			0°	0°	RCMX 12 04 00	
		PRGCR/L 2525M 12		25	32	25	25	150			0°	0°	RCMX 12 04 00	
		PRGCR/L 3225P 12		25	32	32	32	170			0°	0°	RCMX 12 04 00	
	16	PRGCR/L 2525M 16		25	32	25	25	150			0°	0°	RCMX 16 06 00	
		PRGCR/L 3225P 16		25	32	32	32	170			0°	0°	RCMX 16 06 00	
	20	PRGCR/L 3232P 20		32	40	32	32	170			0°	0°	RCMX 20 06 00	
	25	PRGCR/L 4040S 25		40	50	40	40	250			0°	0°	RCMX 25 07 00	
	32	PRGCR/L 5050T 32		50	63	50	50	300			0°	0°	RCMX 32 09 00	

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Insert size					
Neg	Pos				
		Lever	Screw	Key (mm)	Shim
09		174.3-840M	174.3-820M	170.3-860 (2.5)	176.3-850
12		174.3-841M	174.3-821	174.1-864 (3.0)	176.3-851M
15		174.3-843M	174.3-825	174.1-864 (3.0)	176.3-854M
19		174.3-842M	174.3-822M	3021 010-040 (4.0)	176.3-852M
25		174.3-844M	174.3-827	3021 010-050 (5.0)	176.3-853M
	10	176.39-840	174.3-834	170.3-864 (1.98)	176.39-850
	12	5432 005-01	174.3-820M	170.3-860 (2.5)	176.39-851
	16	176.39-842	174.3-833	170.3-860 (2.5)	176.39-852
	20	176.39-843	174.3-825	174.1-864 (3.0)	176.39-853
	25	176.39-844	174.3-832	3021 010-040 (4.0)	176.39-854
	32	176.39-845	174.3-827	3021 010-050 (5.0)	176.39-855



A9



A131



A446



G6



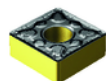
A2



J2

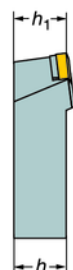
Shank tools

T-Max® P lever design



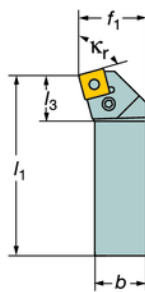
SNMM
 SNMG
 SNMA, SNGA

Entering angle:
Lead angle:



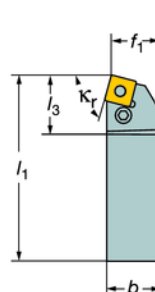
PSKNR/L

κ_r 75°
15°



PSBNR/L
PSRNR/L

κ_r 75°
15°



Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm								Gauge inserts
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	
	09	3/8	PSKNR/L 1616H 09	16	20	16	16	100	16.5	-6°	-6°	SNMG 09 03 08
			PSKNR/L 2020K 09	20	25	20	20	125	17.4	-6°	-6°	SNMG 09 03 08
	12	1/2	PSKNR/L 2020K 12	20	25	20	20	125	22.7	-6°	-6°	SNMG 12 04 08
			PSKNR/L 2525M 12	25	32	25	25	150	22.7	-6°	-6°	SNMG 12 04 08
			PSKNR/L 3225P 12	25	32	32	32	170	22.7	-6°	-6°	SNMG 12 04 08
	15	5/8	PSKNR/L 2525M 15	25	32	25	25	150	28.2	-6°	-6°	SNMG 15 06 12
	19	3/4	PSKNR/L 3232P 19	32	40	32	32	170	37.5	-6°	-6°	SNMG 19 06 12
			PSKNR/L 4040S 19	40	50	40	40	250	32.9	-6°	-6°	SNMG 19 06 12
	25	1	PSKNR/L 5050T 25	50	60	50	50	300	37.5	-6°	-6°	SNMG 25 07 24
	09	3/8	PSBNR/L 1616H 09	16	13	16	16	100	20.8	-6°	-6°	SNMG 09 03 08
			PSRNR/L 1212F 09	12	13	12	12	80	21	-6°	-6°	SNMG 09 03 08
	12	1/2	PSBNR/L 2020K 12	20	17	20	20	125	27.5	-6°	-6°	SNMG 12 04 08
			PSBNR/L 2525M 12	25	22	25	25	150	27.5	-6°	-6°	SNMG 12 04 08
			PSBNR/L 3225P 12	25	22	32	32	170	27.5	-6°	-6°	SNMG 12 04 08
	15	5/8	PSBNR/L 2525M 15	25	22	25	25	150	32	-6°	-6°	SNMG 15 06 12
			PSBNR/L 3225P 15	25	22	32	32	170	32	-6°	-6°	SNMG 15 06 12
			PSBNR/L 3232P 15	32	27	32	32	170	32	-6°	-6°	SNMG 15 06 12
	19	3/4	PSBNR/L 3232P 19	32	27	32	32	170	39.2	-6°	-6°	SNMG 19 06 12
			PSBNR/L 4040S 19	40	35	40	40	250	41.5	-6°	-6°	SNMG 19 06 12
	25	1	PSBNR/L 4040S 25 ³⁾	40	35	40	40	250	47.5	-6°	-6°	SNMG 25 07 24
			PSBNR/L 5050T 25	50	43	50	50	300	47.5	-6°	-6°	SNMG 25 07 24

¹⁾ γ = Rake angle (valid with flat insert).

R = Right hand, L = Left hand

²⁾ λ_s = Angle of inclination.

³⁾ With insert 7.94 mm thick. With insert 9.52 mm thick: h₁ = 41.56 and 51.56 mm

Main spare parts

Insert size					
	iC	Lever	Screw	Key (mm)	Shim
09 ¹⁾	3/8 ¹⁾	174.3-840-1	174.3-829	174.1-870 (1.98)	-
09	3/8	174.3-840M	174.3-820M	170.3-860 (2.5)	174.3-850
12	1/2	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M
15	5/8	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857
19	3/4	174.3-842M	174.3-822M	3021 010-040 (4.0)	174.3-852M
25	1	174.3-844M	174.3-827	3021 010-050 (5.0)	174.3-853M

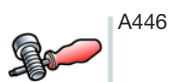
¹⁾ Only for PSRNR/L 1212F09



A9



A131



A446



G6



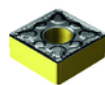
A2



J2

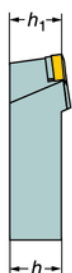
Shank tools

T-Max® P lever design

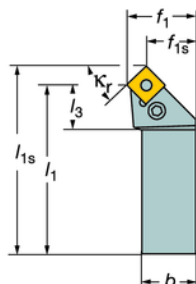


SNMM
SNMG
SNMA, SNGA

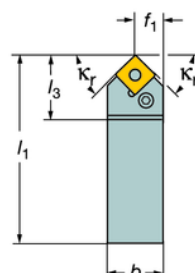
Entering angle:
Lead angle:



PSSNR/L

 $\kappa_r 45^\circ$
45°


PSDNN

 $\kappa_r 45^\circ$
45°


Neutral

Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm										Gauge inserts
	09	3/8	PSSNR/L 1616H 09	16	20	13.9	16	16	100	22	106.1	-8°	0°	SNMG 09 03 08
			PSSNR/L 2020K 09	20	25	18.9	20	20	125	21.9	131.1	-8°	0°	SNMG 09 03 08
			PSSNR/L 2525M 09	25	32	25.9	25	25	150	23	156.1	-8°	0°	SNMG 09 03 08
	12	1/2	PSSNR/L 2020K 12	20	25	16.7	20	20	125	29.3	133.3	-8°	0°	SNMG 12 04 08
			PSSNR/L 2525M 12	25	32	23.7	25	25	150	29.3	158.3	-8°	0°	SNMG 12 04 08
			PSSNR/L 3225P 12	25	32	23.7	32	32	170	29.3	178.3	-8°	0°	SNMG 12 04 08
	15	5/8	PSSNR/L 2525M 15	25	32	21.8	25	25	150	34	160.2	-8°	0°	SNMG 15 06 12
			PSSNR/L 3225P 15	25	32	21.8	32	32	170	34	180.2	-8°	0°	SNMG 15 06 12
			PSSNR/L 3232P 15	32	40	29.8	32	32	170	34	180.2	-8°	0°	SNMG 15 06 12
	19	3/4	PSSNR/L 3232P 19	32	40	27.5	32	32	170	41.3	182.5	-8°	0°	SNMG 19 06 12
			PSSNR/L 4040S 19	40	50	37.5	40	40	250	41.5	262.5	-8°	0°	SNMG 19 06 12
	25	1	PSSNR/L 4040S 25	40	50	34.4	40	40	250	48.8	266.0	-8°	0°	SNMG 25 07 24
	09	3/8	PSDNN 1010E 09	10	5.3		10	10	70	20		-6°	-6°	SNMG 09 03 08
			PSDNN 1212F 09	12	6.3		12	12	80	20		-6°	-6°	SNMG 09 03 08
			PSDNN 1616H 09	16	8.3		16	16	100	21		-6°	-6°	SNMG 09 03 08
	12	1/2	PSDNN 2020K 12	20	10.3		20	20	125	27.6		-6°	-6°	SNMG 12 04 08
			PSDNN 2525M 12	25	12.8		25	25	150	27.6		-6°	-6°	SNMG 12 04 08
			PSDNN 3225P 12	25	12.8		32	32	170	27.6		-6°	-6°	SNMG 12 04 08
	19	3/4	PSDNN 3225P 19	25	13		32	32	170	40.4		-6°	-6°	SNMG 19 06 12
			PSDNN 3232P 19	32	16.3		32	32	170	40.4		-6°	-6°	SNMG 19 06 12
	25	1	PSDNN 4040S 25	40	21		40	40	250	48.8		-6°	-6°	SNMG 25 07 24

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Insert size						
	iC	Shank size, mm	Lever	Screw	Key (mm)	Shim
09	3/8	1010-1212	174.3-845-1	174.3-829	174.3-870 (1.98)	-
09	3/8	1616-2525	174.3-840M	174.3-820M	170.3-860 (2.5)	174.3-850
12	1/2		174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M
15	5/8		438.3-840	438.3-831	174.1-864 (3.0)	174.3-857
19	3/4		174.3-842M	174.3-822M	3021 010-040 (4.0)	174.3-852M
25	1		174.3-844M	174.3-827	3021 010-050 (5.0)	174.3-853M

A9

A132

A446

G6

A2

J2



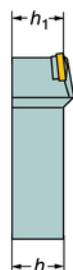
Shank tools

T-Max® P lever design



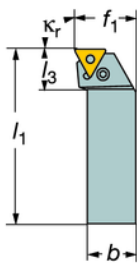
TNMM, TNMX
TNMG
TNMA, TNGA

Entering angle:
Lead angle:



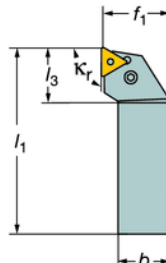
PTFNR/L

$\kappa_r 91^\circ$
-1°



PTGNR/L

$\kappa_r 91^\circ$
-1°



Right hand style shown unless otherwise stated

Metric version

Main application		i/C	Ordering code	Dimensions, mm								Gauge inserts
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	
	11	1/4	PTFNR/L 1212F 11	12	16	12	12	80	15	-6°	-6°	TNMG 11 03 04
	16	3/8	PTFNR/L 1616H 16	16	20	16	16	100	19.7	-6°	-6°	TNMG 16 04 08
			PTFNR/L 2020K 16	20	25	20	20	125	20.2	-6°	-6°	TNMG 16 04 08
			PTFNR/L 2525M 16	25	32	25	25	150	20.2	-6°	-6°	TNMG 16 04 08
	22	1/2	PTFNR/L 2525M 22	25	32	25	25	150	25.2	-6°	-6°	TNMG 22 04 08
			PTFNR/L 3225P 22	25	32	32	32	170	25.2	-6°	-6°	TNMG 22 04 08
			PTFNR/L 3232P 22	32	40	32	32	170	25.2	-6°	-6°	TNMG 22 04 08
	27	5/8	PTFNR/L 3232P 27	32	40	32	32	170	34.4	-6°	-6°	TNMG 27 06 12
			PTFNR/L 4040S 27	40	50	40	40	250	33.2	-6°	-6°	TNMG 27 06 12
	33	3/4	PTFNR/L 4040S 33	40	50	40	40	250	38.2	-6°	-6°	TNMG 33 07 12
	11	1/4	PTGNR/L 1212K11-S	12	12	12	12	125	15.8	-6°	-6°	TNMG 11 03 04
			PTGNR/L 1616K11-S	16	16	16	16	125	15.8	-6°	-6°	TNMG 11 03 04
			PTGNR/L 1010E 11	10	12	10	10	70	15.6	-6°	-6°	TNMG 11 03 04
			PTGNR/L 1212F 11	12	16	12	12	80	15.6	-6°	-6°	TNMG 11 03 04
			PTGNR/L 1616H 11	16	20	16	16	100	18	-6°	-6°	TNMG 11 03 04
			PTGNR/L 2020K 11	20	25	20	20	125	19	-6°	-6°	TNMG 11 03 04
			PTGNR/L 2525M 11	25	32	25	25	150	20	-6°	-6°	TNMG 11 03 04
	16	3/8	PTGNR/L 1616H 16	16	20	16	16	100	20.2	-6°	-6°	TNMG 16 04 08
			PTGNR/L 2020K 16	20	25	20	20	125	20.2	-6°	-6°	TNMG 16 04 08
			PTGNR/L 2525M 16	25	32	25	25	150	22.2	-6°	-6°	TNMG 16 04 08
			PTGNR/L 3225P 16	25	32	32	32	170	22.2	-6°	-6°	TNMG 16 04 08
	22	1/2	PTGNR/L 2525M 22	25	32	25	25	150	28.7	-6°	-6°	TNMG 22 04 08
			PTGNR/L 3225P 22	25	32	32	32	170	28.7	-6°	-6°	TNMG 22 04 08
			PTGNR/L 3232P 22	32	40	32	32	170	28.7	-6°	-6°	TNMG 22 04 08
	27	5/8	PTGNR/L 3232P 27	32	40	32	32	170	35.2	-6°	-6°	TNMG 27 06 12
			PTGNR/L 4040S 27	40	50	40	40	250	34	-6°	-6°	TNMG 27 06 12

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size					
	i/C	Lever	Screw	Key (mm)	Shim
11	1/4	174.3-846-1	174.3-829	170.3-864 (1.98)	-
16	3/8	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M
22	1/2	174.3-841M	174.3-821	174.1-864 (3.0)	179.3-852M
27	5/8	174.3-843M	174.3-825	174.1-864 (3.0)	179.3-854M
33	3/4	174.3-842M	174.3-822M	3021 010 040 (4.0)	179.3-855M



A9



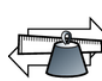
A446



G6



A2



J2

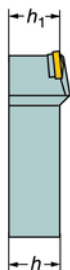
Shank tools

T-Max® P lever design

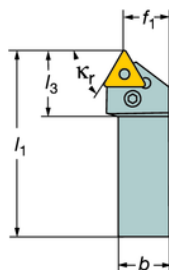


TNMM, TNMX
TNMG
TNMA, TNGA

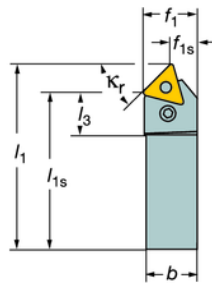
Entering angle:
Lead angle:



PTTNR/L

 $\kappa_r 60^\circ$
 30°


PTDNR/L

 $\kappa_r 45^\circ$
 45°


Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm										Gauge inserts
				b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾	
	11	1/4	PTTNR/L 1010E 11	10	9		10	10	70	19.1		-6°	-6°	TNMG 11 03 04
			PTTNR/L 1212F 11	12	11		12	12	80	19.1		-6°	-6°	TNMG 11 03 04
	16	3/8	PTTNR/L 1616H 16	16	13		16	16	100	23.4		-6°	-6°	TNMG 16 04 08
			PTTNR/L 2020K 16	20	17		20	20	125	25.9		-6°	-6°	TNMG 16 04 08
	22	1/2	PTTNR/L 2525M 22	25	22		25	25	150	31.9		-6°	-6°	TNMG 22 04 08
			PTTNR/L 3225P 22	25	22		32	32	170	31.9		-6°	-6°	TNMG 22 04 08
	22	1/2	PTDNR/L 2525M 22	25	12.97	27.0	25	25	150	19.5	135.9	-7°	0°	TNMG 22 04 08

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size					
	iC	Lever	Screw	Key (mm)	Shim
11	1/4	174.3-846-1	174.3-829	170.3-864 (1.98)	-
16	3/8	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M
22	1/2	174.3-841M	174.3-821	174.1-864 (3.0)	179.3-852M



A9



A446



G6



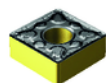
A2



J2

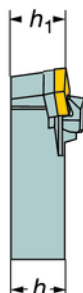
Shank tools

T-Max P wedge clamp design



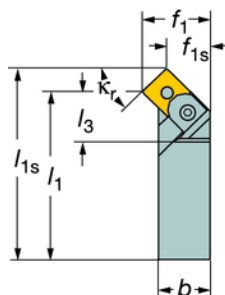
-  SNMM
-  SNMG
-  SNMA, SNGA

Entering angle:
Lead angle:





MSSNR/L

$\kappa_r 45^\circ$
 45°



Right hand style shown unless otherwise stated

Metric version


Main application		iC	Ordering code	Dimensions, mm										Gauge inserts
				b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	$\gamma^{1)}$	$\lambda_s^{2)}$	
	12	1/2	MSSNR/L 2525M 12	25	32	23.7	25	25	150	23	158.3	-8°	0°	SNMG 12 04 08
	19	3/4	MSSNR/L 3232P 19	32	40	27.5	32	32	170	31.3	182.5	-8°	0°	SNMG 19 06 12
	25	1	MSSNR/L 4040S 25	40	50	34.0	40	40	250	34	266.0	-8°	0°	SNMG 25 07 24

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm)
12	1/2	181.38-824-1	174.1-864 (3.0)	181.38-850	181.38-840	3212 010-255	174.1-864 (3.0)
19	3/4	181.38-825-1	3021 010-040 (4.0)	181.38-851	181.38-841	3212 010-306	174.1-864 (3.0)
25	1	181.38-826-1	3021 010-050 (5.0)	181.38-852	181.38-842	3212 100-357	3021 010-040 (4.0)



A9



A134



A454



G6



A2



J2

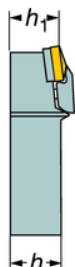
Shank tools

T-Max P wedge clamp design

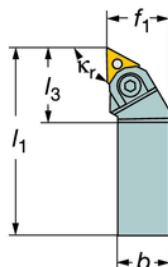


TNMM, TNMX
TNMG
TNMA, TNGA

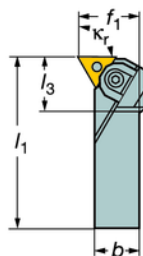
Entering angle:
Lead angle:



MTJNR/L
WTJNR/L
 $\kappa_r 93^\circ$
 -3°



WTFNR/L
 $\kappa_r 91^\circ$
 -1°



Right hand style shown unless otherwise stated

Metric version

Main application	\triangle	iC	Ordering code	Dimensions, mm								Gauge inserts
	16	3/8	MTJNR/L 2020K 16M1	b	f ₁	h	h ₁	l ₁	l ₃	γ^1	λ_s^2	TNMG 16 04 08
			MTJNR/L 2525M 16M1	20	25	20	20	125	30.8	-6°	-6°	TNMG 16 04 08
			MTJNR/L 3225P 16M1	25	32	25	25	150	30.8	-6°	-6°	TNMG 16 04 08
	22	1/2	MTJNR/L 2525M 22M1	25	32	32	32	170	30.8	-6°	-6°	TNMG 16 04 08
			MTJNR/L 3225P 22M1	25	32	25	25	150	34.8	-6°	-6°	TNMG 22 04 08

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts
	3/8	WTJNR 20 3D	1.250	1.500	1.250	1.250	6.000	1.540	-4°	-13°	TNMG 332
		WTJNR/L 12 3B	.750	1.000	.750	.750	4.500	1.250	-4°	-13°	TNMG 332
		WTJNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.540	-4°	-13°	TNMG 332
	1/2	WTJNR/L 16 4C	1.000	1.250	1.000	1.000	5.000	1.540	-4°	-13°	TNMG 432
		WTJNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.540	-4°	-13°	TNMG 432
		WTJNR/L 20 4D	1.250	1.500	1.250	1.250	6.000	1.540	-4°	-13°	TNMG 432
		WTJNR/L 85 4D	1.000	1.250	1.250	1.250	6.000	1.540	-4°	-13°	TNMG 432
	5/8	WTJNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.750	-4°	-13°	TNMG 543
		WTJNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.750	-4°	-13°	TNMG 543
	1/2	WTFNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.190	-6°	-6°	TNMG 432

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size								
\triangle	iC	Wedge clamp set	Key (mm/inch)	Shim	Pin	Screw	Key (mm/inch)	
MTJNR/L	16	170.38-820-1	174.1-863 (2.5)	170.3-852	5313 021-02	3212 010-206	174.1-863 (2.5)	
	22	170.38-821-1	174.1-864 (3.0)	170.3-855	181.38-840	3212 010-255	174.1-864 (3.0)	
WTJNR/L	16	A170.38-820-1	265.2-818 (3/32)	170.3-852	5313 021-02	3212 010-206	174.1-863 (2.5)	
	16	A170.38-820-1	265.2-818 (3/32)	170.3-852	5313 021-02	3212 010-206	174.1-863 (2.5)	
	22	A170.38-821-1	174.1-871 (1/8)	170.3-859	170.3-836M-1 ²⁾	-	174.1-871 (1/8)	
	27	A170.38-822-1	174.1-871 (1/8)	170.3-858	170.3-848M-1 ²⁾	-	3021 010-040 (5/32)	
WTFNR/L	22	A170.38-821-1	174.1-871 (1/8)	170.3-859	170.3-836M-1 ²⁾	-	174.1-871 (1/8)	

¹⁾ Only for WTJNR/L 123B.

²⁾ Shim pin and screw.



A9



A134



A454



G6



A2



J2

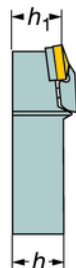
Shank tools

T-Max P wedge clamp design

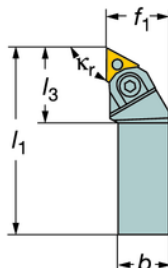


TNMM, TNMX
TNMG
TNMA, TNGA

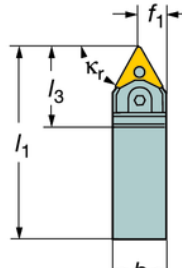
Entering angle:
Lead angle:



**MTGNR/L
WTGNR/L**
 $\kappa_r 91^\circ$
-1°



**MTENN
WTENN**
 $\kappa_r 60^\circ$
30°



Neutral

Right hand style shown unless otherwise stated

Metric version

Main application	\triangle	iC	Ordering code	Dimensions, mm								Gauge inserts
 $\leq 25^\circ$	22	1/2	MTGNR/L 2525M 22M1	25	32	25	25	150	34.8	-6°	-6°	TNMG 22 04 08
			MTGNR/L 3225P 22M1	25	32	32	32	170	34.8	-6°	-6°	TNMG 22 04 08
			MTGNR/L 3232P 22M1	32	40	32	32	170	34.8	-6°	-6°	TNMG 22 04 08
 $\leq 55^\circ$	22	1/2	MTENN 2525M 22M1	25	13	25	25	150	35.7	-8°	0°	TNMG 22 04 08
			MTENN 3225P 22M1	25	13	32	32	170	35.7	-8°	0°	TNMG 22 04 08
			MTENN 3232P 22M1	32	16.5	32	32	170	35.7	-8°	0°	TNMG 22 04 08

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts
 $\leq 25^\circ$	1/2	WTGNR/L 16 4D	1.000	1.250	1.000	1.000	6.000	1.540	-6°	-6°	TNMG 432
		WTGNR/L 85 4D	1.000	1.250	1.250	1.250	6.000	1.540	-6°	-6°	TNMG 432
 $\leq 55^\circ$	1/2	WTENN 16 4C	1.000	.500	1.000	1.000	5.000	1.540	-8°	0°	TNMG 432
		WTENN 16 4D	1.000	.500	1.000	1.000	6.000	1.540	-8°	0°	TNMG 432
		WTENN 85 4D	1.000	.500	1.250	1.250	6.000	1.540	-8°	0°	TNMG 432
	5/8	WTENN 20 5D	1.250	.625	1.250	1.250	6.000	1.750	-8°	0°	TNMG 543

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

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

Main spare parts

Insert size								
\triangle	iC	Wedge clamp set	Key (mm/inch)	Shim	Pin	Screw	Key (mm/inch)	
MTGNR/L	22	1/2	170.38-821-1	174.1-864 (3.0)	170.3-855	181.38-840	3212 010-255	174.1-864 (3.0)
WTGNR/L	22	1/2	A170.38-821-1	174.1-871 (1/8)	170.3-859	170.3-836M-1 ¹⁾	-	174.1-871 (1/8)
WTENN	22	1/2	A170.38-821-1	174.1-871 (1/8)	170.3-859	170.3-836M-1 ¹⁾	-	174.1-871 (1/8)
MTENN	22	1/2	170.38-821-1	174.1-864 (3.0)	170.3-855	181.38-840	3212 010-255	174.1-864 (3.0)
WTENN	27	5/8	A170.38-822-1	174.1-871 (1/8)	170.3-858	170.3-848M-1	-	174.1-871 (1/8)

¹⁾ Shim pin and screw.



A9



A134



A454



G6



A2



J2

Shank tools

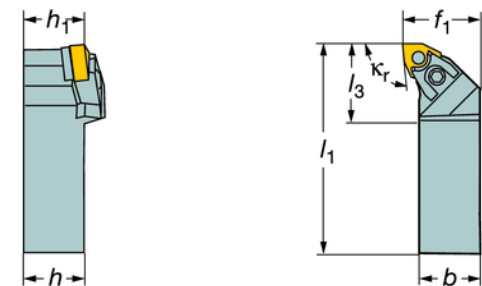
T-Max P wedge clamp design



- WNMM,
- WNMG
- WNGA, WNMA

Entering angle:

MWLNRL
 $\kappa_r 95^\circ (-5^\circ)$



Right hand style shown when nothing else is stated

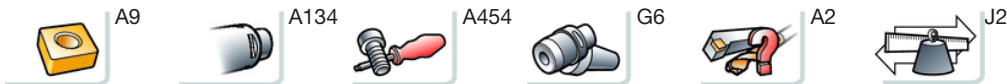
Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts
			b	f ₁	h	h ₁	l ₁	l ₃	$\gamma^{1)}$	$\lambda_s^{2)}$	
	06	MWLNRL 2020K 06	20	25	20	20	125	26	-6°	-6°	WNMG 06 04 08
		MWLNRL 2525M 06	25	32	25	25	150	26	-6°	-6°	WNMG 06 04 08
	08	MWLNRL 2020K 08	20	27	20	20	125	34	-6°	-6°	WNMG 08 04 08
		MWLNRL 2525M 08	25	32	25	25	150	35	-6°	-6°	WNMG 08 04 08
		MWLNRL 3225P 08	25	32	32	32	170	35	-6°	-6°	WNMG 08 04 08

1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.
R = Right hand, L = Left hand

Main spare parts

Insert size						
	Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm)
06	5431 125-011	170.3-860 (2.5)	5322 331-06	5313 022-01	5512 030-03	170.3-864 (1.98)
08	5431 125-021	174.1-864 (3.0)	5322 331-07	5313 022-03	3212 010-255	174.1-864 (3.0)



Shank tools

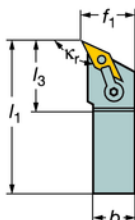
T-Max M top clamp design



Entering angle:
Lead angle:

MVTNR/L

κ_r 117°30'
-27.5°



Right hand style shown unless otherwise stated

Inch version

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts	
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI
	16	3/8	MVTNR/L 12 3B	19.05	25.4	19.05	19.05	114.3	38.1	-10°	-10°	VNMG 16 04 08	VNMG 332
				.750	1.000	.750	.750	4.500	1.500				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Clamp	Clamp screw	Key (inch)	Lock pin	Key (inch)	Shim
16	3/8	MC-12	MS-510	3021 011-532 (5/32)	MN-34L	174.1-870 (5/64)	MVN-322



A9



A122



A439



G6



A2



J2

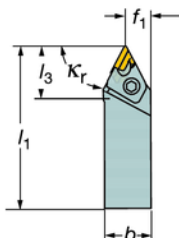
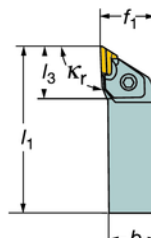
Shank tools for copying

T-Max® top clamp design



KNUX, KNMX

Entering angle
Lead angle:

**R/L170.5**
 $\kappa_r 62.5^\circ$
 27.5°
**CKJNR/L**
 $\kappa_r 93^\circ$
 -3°


Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts
	16	CKJNR/L 2525M 16	25	32	25	25	150	32	-6°	0°	KNUX 16 04 05L
		CKJNR/L 3225P 16	25	32	32	32	170	32	-6°	0°	KNUX 16 04 05L
		CKJNR/L 4025R 16	25	32	40	40	200	32	-6°	0°	KNUX 16 04 05L
	16	R/L170.5-4025M-16	25	14.3	40	40	145	37	-6°	0°	KNUX 16 04 05L

Inch version

Main application	i/C	Ordering code	Dimensions, inch								Gauge inserts
	3/8	CKJNR/L 12 3	.750	1.125	.750	.750	5.000	1.260	-6°	0°	KNUX 16 04 05L
		CKJNR/L 16 3C	1.000	1.250	1.000	1.000	5.000	1.260	-6°	0°	KNUX 16 04 05L
		CKJNR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.260	-6°	0°	KNUX 16 04 05L
		CKJNR/L 20 3D	1.250	1.500	1.250	1.250	6.000	1.260	-6°	0°	KNUX 16 04 05L

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Clamp				Shim	
R	L	Screw	Key (mm)	R	L
170.5-824	170.5-825	170.5-865	3021 010-040 (4.0)	R170.5-851 ¹⁾ R170.5-852 ²⁾ R170.5-850 ³⁾	L170.5-851 ¹⁾ L170.5-852 ²⁾ L170.5-850 ³⁾

1) Fitted as standard: For inserts with $r_c = 1.0$ mm.2) Optional shim delivered to separate order, for inserts with $r_c = 0.5$ mm3) Optional shim delivered to separate order, for inserts with $r_c = 1.5$ mm

A44



G6



A2



J2

CoroTurn® 107 screw clamping

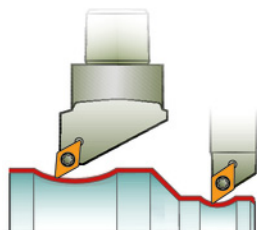
External tools for positive basic-shape inserts with 7° clearance angle

For light roughing to finishing of small, long and slender components, ideal for copy machining

CoroTurn® 107 system is available in Coromant Capto® cutting units and conventional steel shank design for all insert shapes and in different entering angles

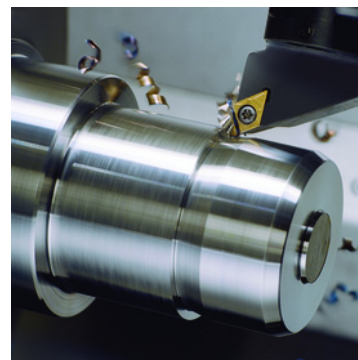
Coromant Capto cutting unit

Available in CoroTurn HP design, see page A166.



A screw clamping system, giving:

- Secure insert clamping
- Excellent repeatability
- Unhampered chip flow
- Few spare parts



Safe and productive machining process

CoroTurn® 107 gives:

- Excellent chip control
- Soft cutting action
- Low cutting forces
- Very good surface finish on the component

Versatile clamping system

With many features, the CoroTurn® 107 can be used for a large number of applications:

- Tools for multi-task machining
- Tools with small insert shanks for small part machining
- QS™ holding system, see page
- Different special solutions



CoroTurn® HP cutting units

CoroTurn® 107 screw clamp design

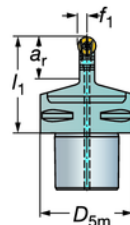
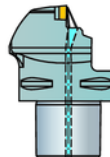
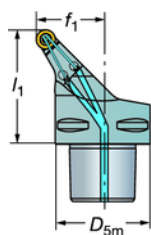
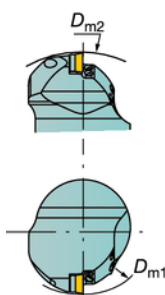
With high pressure coolant

Cx-SRSCR/L-HP

Cx-SRDCN-HP


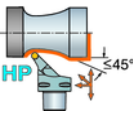



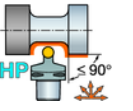
RCMT
RCGX-AL



Neutral

Right hand style shown

				Dimensions, mm, inch									
Main application		iC	Ordering code	D _{5m}	a _r	D _{m1} min ⁴⁾	D _{m2} min ⁴⁾	f ₁	l ₁	γ ¹⁾	λ _s ²⁾	Gauge inserts	Nm ³⁾
		10	C5-SRSCR/L-35060-10HP	50		130	270	35.0	60.0	0°	0°	RCMT 10 T3 M0	3.0
			C6-SRSCR/L-45065-10HP ⁵⁾	63		5.118	10.630	1.378	2.362			RCMT 10 T3 M0	3.0
		12	C5-SRSCR/L-35060-12HP	50		130	270	35.0	60.0	0°	0°	RCMT 12 04 M0	3.0
			C6-SRSCR/L-45065-12HP ⁵⁾	63		5.118	10.630	1.378	2.362			RCMT 12 04 M0	3.0

				Dimensions, mm, inch										
Main application		iC	Ordering code	D _{5m}	a _r	D _{m1} min ⁴⁾	D _{m2} min ⁴⁾	f ₁	l ₁	γ ¹⁾	λ _s ²⁾	Gauge inserts	Nm ³⁾	
		12	C6-SRDCN-00065-12HP	63		28	300	200	6.0	65.0	0°	0°	RCMT 12 04 M0	3.0
						1.102	11.811	7.874	.236	2.559				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

5) Max incopying angle 27°

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

Main spare parts

Insert size							
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	Nozzle (hole dia. mm)
10	.394	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 049-01 (3.5)	5691 026-03 (1.0)
12	.472	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 110-02	5512 090-01	5680 049-01 (3.5)	5691 026-03 (1.0)



A9



A464



G6



A2

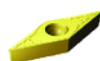


J2

CoroTurn® HP cutting units

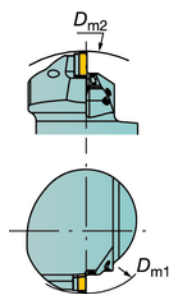
CoroTurn 107 – Screw clamp design

With high pressure coolant



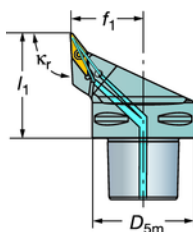
VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW

Entering angle
Lead angle

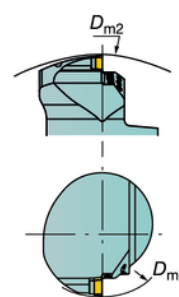


Cx-SVJBR/L-HP

κ_r 93°
-3°

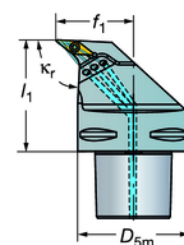


Entering angle
Lead angle



Cx-SVUBR/L-HP

κ_r 93°
-3°



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				dm_m	D_{5m}	D_{m1} min ⁴⁾	D_{m2} min ⁴⁾	f_1	l_1	$\gamma^1)$	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾
	16	3/8	C4-SVJBR/L-27050-16HP	28	40	155	140	27.0	50	0°	0°	VBMT 16 04 08	VBMT 332	3.0
			C5-SVJBR/L-35060-16HP	35	50	180	200	35.0	60	0°	0°			
			C6-SVJBR/L-45065-16HP	44	63	200	200	45.0	65	0°	0°			
			C7-SVJBR/L-55080-16HP	55	80	240	240	55.0	80	0°	0°			
			C8-SVJBR/L-55080-16HP	55	80	240	240	55.0	80	0°	0°			

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				dm_m	D_{5m}	D_{m1} min ⁴⁾	D_{m2} min ⁴⁾	f_1	l_1	$\gamma^1)$	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾
	16	3/8	C6-SVUBR/L-45065-16HP	44	63	85	190	45.0	65	0°	0°	VBMT 16 04 08	VBMT 332	3.0
			C7-SVUBR/L-55080-16HP	55	80	100	250	55.0	80	0°	0°			
			C8-SVUBR/L-55080-16HP	55	80	100	250	55.0	80	0°	0°			

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	Nozzle (hole dia. mm)
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)	5691 026-13 (1.0)



A9



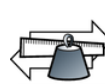
A464



G6



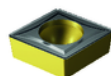
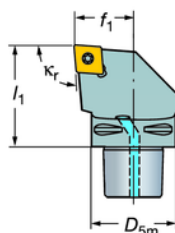
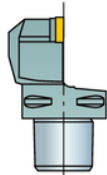
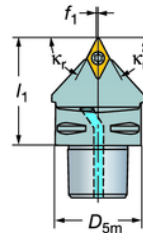
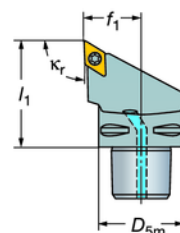
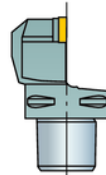
A2



J2

Coromant Capto® cutting units


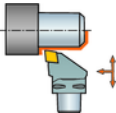
CoroTurn® 107 screw clamp design


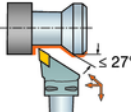
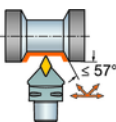
Entering angle:
Lead angle:**SCLCR/L** $\kappa_r 95^\circ$
 -5° **SDJCR/L** $\kappa_r 93^\circ$
 -3° **SDNCN** $\kappa_r 62.5^\circ$
 27.5° CCMT, CCGT
CCGX, CCET
CCMWDCMT, DCMX
DCGT, DCGX, DCI
DCMW

Neutral

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)						Gauge inserts		Nm ³⁾	
				D _{5m}	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾	ISO		ANSI
	09	3/8	C3-SCLCR/L-22040-09	32	22.0	.866	40.0	1.575	0°	0°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0
			C4-SCLCR/L-27050-09	40	27.0	1.063	50.0	1.968	0°	0°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0
			C5-SCLCR/L-35060-09	50	35.0	1.378	60.0	2.362	0°	0°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0
			C6-SCLCR/L-45065-09	63	45.0	1.772	65.0	2.559	0°	0°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0
	12	1/2	C3-SCLCR/L-22040-12	32	22.0	.866	40.0	1.575	0°	0°	CCMT 12 04 08	CCMT 432	3.0
			C4-SCLCR/L-27050-12	40	27.0	1.063	50.0	1.968	0°	0°	CCMT 12 04 08	CCMT 432	3.0
			C5-SCLCR/L-35060-12	50	35.0	1.378	60.0	2.362	0°	0°	CCMT 12 04 08	CCMT 432	3.0
			C6-SCLCR/L-45065-12	63	45.0	1.772	65.0	2.559	0°	0°	CCMT 12 04 08	CCMT 432	3.0
38	1 1/2	C10-SCLCR/L-68110-38	100	68	2.677	110	4.331	0°	0°	CCMT380932		3.0	

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)						Gauge inserts		Nm ³⁾	
				D _{5m}	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾	ISO		ANSI
	07	1/4	C3-SDJCR/L-22040-07	32	22.0	.866	40.0	1.575	0°	0°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
			C4-SDJCR/L-27050-07	40	27.0	1.063	50.0	1.968	0°	0°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
	11	3/8	C3-SDJCR/L-22040-11	32	22.0	.866	40.0	1.575	0°	0°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
			C4-SDJCR/L-27050-11	40	27.0	1.063	50.0	1.968	0°	0°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
			C5-SDJCR/L-35060-11	50	35.0	1.378	60.0	2.362	0°	0°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
			C6-SDJCR/L-45065-11	63	45.0	1.772	65.0	2.559	0°	0°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
	11	3/8	C3-SDNCN-00040-11	32	0.5	.020	40.0	1.575	0°	0°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
			C4-SDNCN-00050-11	40	0.5	.020	50.0	1.968	0°	0°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
			C5-SDNCN-00060-11	50	0.5	.020	60.0	2.362	0°	0°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

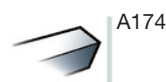
N = Neutral, R = Right hand, L = Left hand

Main spare parts

Insert size								
		iC	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
09		3/8		5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 232-01	5512 090-01	5680 049-01 (3.5)
12		1/2		5513 020-18 (M4x0.5)	5680 049-02 (15IP)	5322 232-02	5512 090-03	5680 016-02 (4.0)
38		1 1/2		5513 028-01	5680 042-03 (T30)	5322 232-03	5512 089-01	5680 042-03 (6.0)
	07		1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
	11		3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 263-01	5512 090-01	5680 049-01 (3.5)



A9



A174



A456



G6



A2



J2

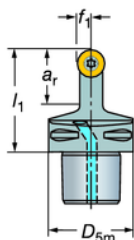
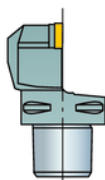
Coromant Capto® cutting units

CoroTurn® 107 screw clamp design

SRDCN



RCMT
RCGX-AL



Coolant inlet: Radial through the taper

Neutral style shown

Main application	O	iC	Ordering code	Dimensions, millimeter, inch (mm, in.)										Gauge inserts		Nm ³⁾
				D _{5m}	a _r mm	a _r in.	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾	ρ _{kg}	ISO	ANSI	
	05	.19	C3-SRDCN-00040-05A	32	10	.394	2.5	.0984	40.0	1.5748	0°	0°	0.2	RCMT 05 02 M0	RCMT 05 02 M0	0.9
			C4-SRDCN-00050-05A	40	10	.394	2.5	.0984	50.0	1.9685	0°	0°	0.4	RCMT 05 02 M0	RCMT 05 02 M0	0.9
			C5-SRDCN-00060-05A	50	10	.394	2.5	.0984	60.0	2.3622	0°	0°	0.7	RCMT 05 02 M0	RCMT 05 02 M0	0.9
	06	.23	C3-SRDCN-00040-06A	32	12	.472	3.0	.1181	40.0	1.5748	0°	0°	0.2	RCMT 06 02 M0	RCMT 06 02 M0	0.9
			C4-SRDCN-00050-06A	40	12	.472	3.0	.1181	50.0	1.9685	0°	0°	0.4	RCMT 06 02 M0	RCMT 06 02 M0	0.9
			C5-SRDCN-00060-06A	50	12	.472	3.0	.1181	60.0	2.3622	0°	0°	0.7	RCMT 06 02 M0	RCMT 06 02 M0	0.9
	08	.31	C3-SRDCN-00040-08A	32	16	.630	4.0	.1575	40.0	1.5748	0°	0°	0.2	RCMT 08 03 M0	RCMT 08 03 M0	1.4
			C4-SRDCN-00050-08A	40	16	.630	4.0	.1575	50.0	1.9685	0°	0°	0.3	RCMT 08 03 M0	RCMT 08 03 M0	1.4
			C5-SRDCN-00060-08A	50	16	.630	4.0	.1575	60.0	2.3622	0°	0°	0.7	RCMT 08 03 M0	RCMT 08 03 M0	1.4
	10	.39	C3-SRDCN-00040-10A	32	20	.787	5.0	.1969	40.0	1.5748	0°	0°	0.2	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0
			C4-SRDCN-00050-10A	40	25	.984	5.0	.1969	50.0	1.9685	0°	0°	0.3	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0
			C5-SRDCN-00060-10A	50	25	.984	5.0	.1969	60.0	2.3622	0°	0°	0.6	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0
	12	.47	C4-SRDCN-00050-12A	40	28	1.102	6.0	.2362	50.0	1.9685	0°	0°	0.3	RCMT 12 04 M0	RCMT 12 04 M0	3.0
			C5-SRDCN-00060-12A	50	28	1.102	6.0	.2362	60.0	2.3622	0°	0°	0.6	RCMT 12 04 M0	RCMT 12 04 M0	3.0
			C6-SRDCN-00065-12A	63	28	1.102	6.0	.2362	65.0	2.5591	0°	0°	1.1	RCMT 12 04 M0	RCMT 12 04 M0	3.0
	16	.63	C5-SRDCN-00060-16A	50	35	1.378	8.0	.315	60.0	2.3622	0°	0°	0.6	RCMT 16 06 M0	RCMT 16 06 M0	6.4
			C6-SRDCN-00065-16A	63	35	1.378	8.0	.315	65.0	2.5591	0°	0°	1.0	RCMT 16 06 M0	RCMT 16 06 M0	6.4
	20	.78	C5-SRDCN-00060-20A	50	40	1.575	10.0	.3937	60.0	2.3622	0°	0°	0.6	RCMT 20 06 M0	RCMT 20 06 M0	9.5
			C6-SRDCN-00065-20A	63	40	1.575	10.0	.3937	65.0	2.5591	0°	0°	1.0	RCMT 20 06 M0	RCMT 20 06 M0	9.5

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

N = Neutral

Main spare parts

Insert size

O	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
05	.197	5513 020-05 (M2.2)	5680 051-02 (7IP)	-	-	-
06	.236	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
08	.315	5513 020-04 (M3.0)	5680 051-03 (9IP)	-	-	-
10	.394	5513 020-10 (M3.5)	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 049-01 (3.5)
12	.472	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 110-02	5512 090-01	5680 049-01 (3.5)
16	.630	5513 020-26 (M5.0)	5680 043-14 (20IP)	5322 110-03	5512 090-06	3021 010-050 (5.0)
20	.787	5513 020-14 (M6.0)	5680 043-15 (25IP)	5322 110-04	5512 090-08	3021 010-060 (6.0)



A9



A178



A456



G6



A2

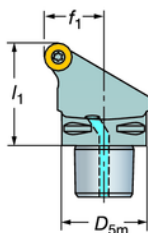
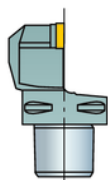


J2

Coromant Capto® cutting units


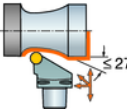
CoroTurn® 107 screw clamp design

SRSCR/L

RCMT
RCGX-AL

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application	$\frac{\phi}{mm}$	iC	Ordering code	Dimensions, millimeter, inch (mm, in.)							Gauge inserts			Nm ³⁾
				D_{5m}	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_s^{2)}$		ISO	ANSI	
	06	.236	C3-SRSCR/L-22040-06	32	22.0	.866	40.0	1.575	0°	0°	0.2	RCMT 06 02 M0	RCMT 06 02 M0	0.9
			C4-SRSCR/L-27050-06	40	27.0	1.063	50.0	1.968	0°	0°	0.4	RCMT 06 02 M0	RCMT 06 02 M0	0.9
			C5-SRSCR/L-35060-06	50	35.0	1.378	60.0	2.362	0°	0°	0.7	RCMT 06 02 M0	RCMT 06 02 M0	0.9
	08	.315	C3-SRSCR/L-22040-08	32	22.0	.866	40.0	1.575	0°	0°	0.2	RCMT 08 03 M0	RCMT 08 03 M0	1.4
			C4-SRSCR/L-27050-08	40	27.0	1.063	50.0	1.968	0°	0°	0.4	RCMT 08 03 M0	RCMT 08 03 M0	1.4
			C5-SRSCR/L-35060-08	50	35.0	1.378	60.0	2.362	0°	0°	0.7	RCMT 08 03 M0	RCMT 08 03 M0	1.4
	10	.394	C3-SRSCR/L-22040-10	32	22.0	.866	40.0	1.575	0°	0°	0.2	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0
			C4-SRSCR/L-27050-10	40	27.0	1.063	50.0	1.968	0°	0°	0.4	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0
			C5-SRSCR/L-35060-10	50	35.0	1.378	60.0	2.362	0°	0°	0.7	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0
			C6-SRSCR/L-45065-10	63	45.0	1.772	65.0	2.559	0°	0°	1.2	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0
	12	.472	C4-SRSCR/L-27050-12	40	27.0	1.063	50.0	1.968	0°	0°	0.4	RCMT 12 04 M0	RCMT 12 04 M0	3.0
			C5-SRSCR/L-35060-12	50	35.0	1.378	60.0	2.362	0°	0°	0.8	RCMT 12 04 M0	RCMT 12 04 M0	3.0
		C6-SRSCR/L-45065-12	63	45.0	1.772	65.0	2.559	0°	0°	1.2	RCMT 12 04 M0	RCMT 12 04 M0	3.0	
16	.630	C5-SRSCR/L-35060-16	50	35.0	1.378	60.0	2.362	0°	0°	0.8	RCMT 16 06 M0	RCMT 16 06 M0	6.4	
		C6-SRSCR/L-45065-16	63	45.0	1.772	65.0	2.559	0°	0°	1.3	RCMT 16 06 M0	RCMT 16 06 M0	6.4	
20	.787	C5-SRSCR/L-35060-20	50	35.0	1.378	60.0	2.362	0°	0°	0.8	RCMT 20 06 M0	RCMT 20 06 M0	9.5	
		C6-SRSCR/L-45065-20	63	45.0	1.772	65.0	2.559	0°	0°	1.3	RCMT 20 06 M0	RCMT 20 06 M0	9.5	

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size						
$\frac{\phi}{mm}$	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
06	.236	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
08	.315	5513 020-04 (M3.0)	5680 051-03 (9IP)	-	-	-
10	.394	5513 020-10 (M3.5)	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 049-01 (3.5)
12	.472	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 110-02	5512 090-01	5680 049-01 (3.5)
16	.630	5513 020-26 (M5.0)	5680 043-14 (20IP)	5322 110-03	5512 090-06	3021 010-050 (5.0)
20	.787	5513 020-14 (M6.0)	5680 043-15 (25IP)	5322 110-04	5512 090-08	3021 010-060 (6.0)



A9



A179



A456



G6



A2



J2

Coromant Capto® cutting units

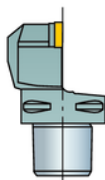
CoroTurn® 107 screw clamp design



SCMT, SCGX

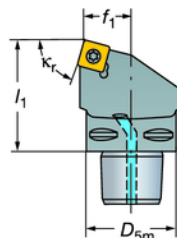
SCMW

Entering angle:
Lead angle:



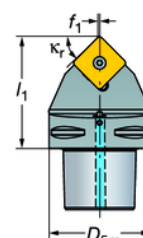
SSRCR/L

κ_r 75°
15°



SSDCN



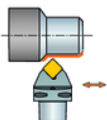
κ_r 45°
45°



Coolant inlet: Radial through the taper

Neutral

Right hand style shown unless otherwise stated

			Dimensions, millimeter, inch (mm, in.)						Gauge inserts				
Main application		iC	Ordering code	D _{5m}	f ₁	f ₁	l ₁	l ₁	γ ¹⁾	λ _{sg} ²⁾	ISO	ANSI	Nm ³⁾
					mm	in.	mm	in.					
	09	3/8	C3-SSRCR/L-17040-09	32	17.0	.6693	40.0	1.5748	0°	0°	SCMT 09 T3 08	SCMT 3(2.5)2	3.0
	12	1/2	C4-SSRCR/L-22050-12	40	22.0	.8661	50.0	1.9685	0°	0°	SCMT 12 04 08	SCMT 432	3.0
			C5-SSRCR/L-27060-12	50	27.0	1.063	60.0	2.3622	0°	0°	SCMT 12 04 08	SCMT 432	3.0
	38	1 1/2	C10-SSRCR/L-58110-38	100	58	2.283	110	4.331	0°	0°	SCMT380932		3.0
	38	1 1/2	C10-SSDCN-00110-38	100	0	0	110	4.331	0°	0°	SCMT380932		3.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size						
□ iC		Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
09	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 420-01	5512 090-01	5680 049-01 (3.5)
12	1/2	5513 020-18 (M4x0.5)	5680 049-02 (15IP)	5322 420-02	5512 090-03	5680 049-02 (4.0)
38	1 1/2	5513 028-01	5680 042-03 (T30)	5322 232-03	5512 089-01	5680 042-03 (6.0)



A9



A180



A456



G6



A2



J2

Coromant Capto® cutting units

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

STJCR/L

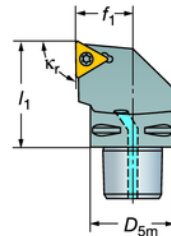
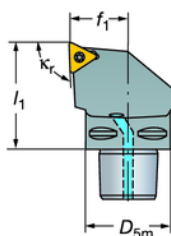
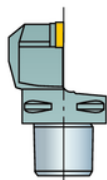
$\kappa_r 93^\circ$
 -3°

STGCR/L

$\kappa_r 91^\circ$
 -1°



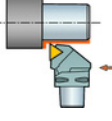


TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

				Dimensions, millimeter, inch (mm, in.)							Gauge inserts			
		iC	Ordering code ⁴⁾	D _{5m}	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾		ISO	ANSI	Nm ³⁾
	11	1/4	C3-STJCR/L-22040-11-B1	32	22.0	.866	40.0	1.575	0°	0°	0.2	TCMT 11 03 04	TCMT 221	0.9
			C4-STJCR/L-27050-11-B1	40	27.0	1.063	50.0	1.968	0°	0°	0.4	TCMT 11 03 04	TCMT 221	0.9
	16	3/8	C3-STJCR/L-22040-16	32	22.0	.866	40.0	1.575	0°	0°	0.2	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
			C4-STJCR/L-27050-16	40	27.0	1.063	50.0	1.968	0°	0°	0.4	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
			C5-STJCR/L-35060-16	50	35.0	1.378	60.0	2.362	0°	0°	0.6	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
	11	1/4	C3-STGCR/L-22040-11-B1	32	22.0	.866	40.0	1.575	0°	0°	0.2	TCMT 11 03 04	TCMT 221	0.9
			C4-STGCR/L-27050-11-B1	40	27.0	1.063	50.0	1.968	0°	0°	0.4	TCMT 11 03 04	TCMT 221	0.9
	16	3/8	C3-STGCR/L-22040-16	32	22.0	.866	40.0	1.575	0°	0°	0.2	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
			C4-STGCR/L-27050-16	40	27.0	1.063	50.0	1.968	0°	0°	0.4	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
			C5-STGCR/L-35060-16	50	35.0	1.378	60.0	2.362	0°	0°	0.6	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
			C6-STGCR/L-45065-16	63	45.0	1.772	65.0	2.559	0°	0°	1.2	TCMT 16 T3 08	TCMT 3(2.5)2	3.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

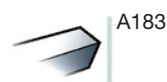
R = Right hand, L = Left hand

Main spare parts

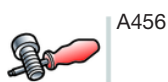
Insert size							
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-	
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 320-01	5512 090-01	5680 049-01 (3.5)	



A9



A183



A456



G6



A2



J2

Coromant Capto® cutting units

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

SVHBR/L

κ_r 107.5°
-17.5°

SVJBR/L

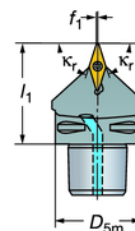
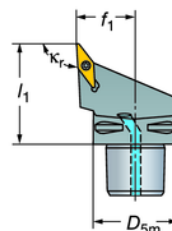
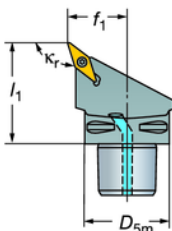
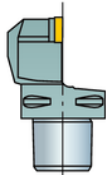
κ_r 93°
-3°

SVVBN

κ_r 72.5°
17.5°



VBMT, VBG
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW



Neutral

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application	iC	Ordering code ⁴⁾	Dimensions, millimeter, inch (mm, in.)					Gauge inserts		Nm ³⁾ Nm ³⁾
			D _{5m}	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ_s ²⁾	
	11	C3-SVHBR/L-22040-11	32	22.0	.866	40.0	1.575	0°	0°	0.1
		C3-SVHBR/L-22040-11-B1	32	22.0	.866	40.0	1.575	0°	0°	0.1
		C4-SVHBR/L-27050-11	40	27.0	1.063	50.0	1.968	0°	0°	0.3
		C4-SVHBR/L-27050-11-B1	40	27.0	1.063	50.0	1.968	0°	0°	0.3
		C5-SVHBR/L-35060-11	50	35.0	1.378	60.0	2.362	0°	0°	0.7
	16	C4-SVHBR/L-27050-16	40	27.0	1.063	50.0	1.968	0°	0°	0.3
	11	C3-SVJBR/L-22040-11	32	22.0	.866	40.0	1.575	0°	0°	0.1
		C3-SVJBR/L-22040-11-B1	32	22.0	.866	40.0	1.575	0°	0°	0.1
		C4-SVJBR/L-27050-11	40	27.0	1.063	50.0	1.968	0°	0°	0.3
		C4-SVJBR/L-27050-11-B1	40	27.0	1.063	50.0	1.968	0°	0°	0.3
		C5-SVJBR/L-35060-11	50	35.0	1.378	60.0	2.362	0°	0°	0.7
	16	C4-SVJBR/L-27050-16	40	27.0	1.063	50.0	1.968	0°	0°	0.3
	11	C3-SVVBN-00040-11	32	0.3	.012	40.0	1.575	0°	0°	0.1
		C3-SVVBN-00040-11-B1	32	0.3	.012	40.0	1.575	0°	0°	0.1
		C4-SVVBN-00050-11	40	0.3	.012	50.0	1.968	0°	0°	0.3
		C4-SVVBN-00050-11-B1	40	0.3	.012	50.0	1.968	0°	0°	0.3
		C5-SVVBN-00060-11	50	0.6	.024	60.0	2.362	0°	0°	0.5
	16	C4-SVVBN-00050-16	40	0.6	.024	50.0	1.968	0°	0°	0.3
	11	C3-SVVBN-00060-11	50	0.6	.024	60.0	2.362	0°	0°	0.5
		C6-SVVBN-00065-11	63	0.6	.024	65.0	2.559	0°	0°	0.9
		C3-SVVBN-00040-11	32	0.3	.012	40.0	1.575	0°	0°	0.1
		C3-SVVBN-00040-11-B1	32	0.3	.012	40.0	1.575	0°	0°	0.1
		C4-SVVBN-00050-11	40	0.3	.012	50.0	1.968	0°	0°	0.3
		C4-SVVBN-00050-11-B1	40	0.3	.012	50.0	1.968	0°	0°	0.3

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

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

Main spare parts

Insert size						
iC		Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)



A9



A184



A456



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

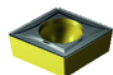
Entering angle:
Lead angle:

SCLCR/L-S

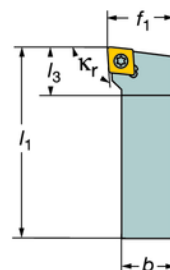
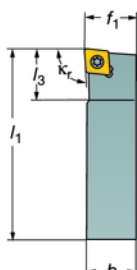
$\kappa_r 95^\circ$
 -5°
Dedicated for small part
machining

SCLCR/L

$\kappa_r 95^\circ$
 -5°



CCMT, CCGT
CCGX, CCET
CCMW



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	06	SCLCR/L 0808K 06-S	8	8	8	8	125	8	0°	0°	CCMT 06 02 04	0.9
		SCLCR/L 1010K 06-S	10	10	10	10	125	10	0°	0°	CCMT 06 02 04	0.9
		SCLCR/L 1212K 06-S	12	12	12	12	125	12	0°	0°	CCMT 06 02 04	0.9
		SCLCR/L 1616K 06-S	16	16	16	16	125	16	0°	0°	CCMT 06 02 04	0.9
	09	SCLCR/L 1212K 09-S	12	12	12	12	125	12	0°	0°	CCMT 09 T3 08	3.0
		SCLCR/L 1616K 09-S	16	16	16	16	125	16	0°	0°	CCMT 09 T3 08	3.0
	06	SCLCR/L 0808D 06	8	10	8	8	60	11	0°	0°	CCMT 06 02 04	0.9
		SCLCR/L 1010E 06	10	12	10	10	70	11	0°	0°	CCMT 06 02 04	0.9
	09	SCLCR/L 1212F 09-M	12	16	12	12	80	15.6	0°	0°	CCMT 09 T3 08	3.0
		SCLCR/L 1616H 09	16	20	16	16	100	16.8	0°	0°	CCMT 09 T3 08	3.0
		SCLCR/L 2020K 09	20	25	20	20	125	17.8	0°	0°	CCMT 09 T3 08	3.0
	12	SCLCR/L 2020K 12	20	25	20	20	125	21.7	0°	0°	CCMT 12 04 08	3.0
		SCLCR/L 2525M 12	25	32	25	25	150	23.7	0°	0°	CCMT 12 04 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/4	SCLCR/L 062C-S	.375	.375	.375	.375	5.000	.375	0°	0°	CCMT 2(1.5)1	0.7
		SCLCR/L 082C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 2(1.5)1	0.7
		SCLCR/L 102C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 2(1.5)1	0.7
		SCLCR/L 123C-S	.750	.750	.750	.750	5.000	.750	0°	0°	CCMT 2(1.5)1	0.7
	3/8	SCLCR/L 083C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 3(2.5)2	2.2
		SCLCR/L 103C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 3(2.5)2	2.2
	1/4	SCLCR/L 123C-S	.750	.750	.750	.750	5.000	.750	0°	0°	CCMT 3(2.5)2	2.2
		SCLCR/L 06 2	.375	.500	.375	.375	2.500	.390	0°	0°	CCMT 2(1.5)1	0.7
		SCLCR/L 08 3	.500	.625	.500	.500	3.500	.390	0°	0°	CCMT 3(2.5)2	2.2
		SCLCR/L 10 3	.625	.750	.625	.625	4.000	.630	0°	0°	CCMT 3(2.5)2	2.2
	1/2	SCLCR/L 12 3B	.750	1.000	.750	.750	4.500	.630	0°	0°	CCMT 3(2.5)2	2.2
		SCLCR/L 16 3D	1.000	1.250	1.000	1.000	6.000	.630	0°	0°	CCMT 3(2.5)2	2.2
		SCLCR/L 12 4D	.750	1.000	.750	.750	4.500	.830	0°	0°	CCMT 432	2.2
		SCLCR/L 16 4D	1.000	1.250	1.000	1.000	6.000	.830	0°	0°	CCMT 432	2.2
		SCLCR/L 20 4D	1.250	1.500	1.250	1.250	6.000	.830	0°	0°	CCMT 432	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

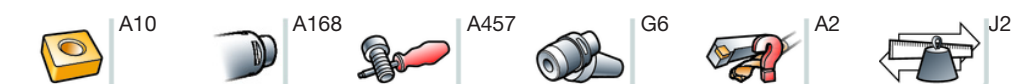
R = Right hand, L = Left hand

Main spare parts

Insert size							
iC		Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	
06	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-	
09 ¹⁾	3/8 ¹⁾	5513 020-10 (M3.5)	5680 049-01 (15IP)	-	-	-	
09 ²⁾	3/8 ²⁾	5513 020-09 (M3.5)	5680 049-01 (15IP)	-	-	-	
09	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 232-01	5512 090-01	5680 049-01 (3.5)	
12	1/2	5513 020-18 (M4.0)	5680 049-02 (15IP)	5322 232-02	5512 090-03	5680 049-02 (4.0)	

¹⁾ Only for SCLCR/L1212F09-M.

²⁾ Only for tools with -S in the end of the ordering code



Shank tools

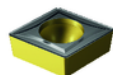
CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

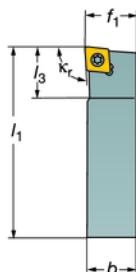
SCACR/L-S

κ_r 90°
0°

Dedicated for small part machining



CCMT, CCGT
CCGX, CCET
CCMW



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	06	SCACR/L 0808K 06-S	8	8	8	8	125	8	0°	0°	CCMT 06 02 04	0.9
		SCACR/L 1010K 06-S	10	10	10	10	125	10	0°	0°	CCMT 06 02 04	0.9
		SCACR/L 1212K 06-S	12	12	12	12	125	12	0°	0°	CCMT 06 02 04	0.9
	09	SCACR/L 1212K 09-S	12	12	12	12	125	12	0°	0°	CCMT 09 T3 08	3.0
		SCACR/L 1616K 09-S	16	16	16	16	125	16	0°	0°	CCMT 09 T3 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	SCACR/L 062C-S	.375	.375	.375	.375	5.000	.375	0°	0°	CCMT 2(1.5)1	0.7
		SCACR/L 082C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 2(1.5)1	0.7
		SCACR/L 102C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 2(1.5)1	0.7
	3/8	SCACR/L 083C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 3(2.5)2	2.2
		SCACR/L 103C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 3(2.5)2	2.2
		SCACR/L 123C-S	.750	.750	.750	.750	5.000	.750	0°	0°	CCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

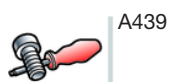
Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
06	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
09	3/8	5513 020-09 (M3.5)	5680 049-01 (15IP)	-	-	-



A10



A121



A439



v



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

SDJCR/L-S

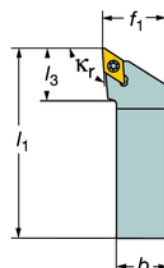
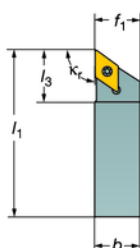
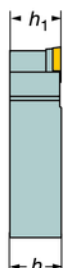
$\kappa_r 93^\circ$
 -3°
Dedicated for small part
machining

SDJCR/L

$\kappa_r 93^\circ$
 -3°

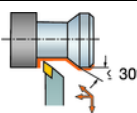
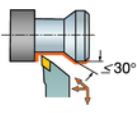


DCMT, DCMX
DCGT, DCGX, DCET
DCMW

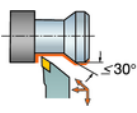
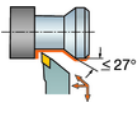


Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	07	SDJCR/L 0808K 07-S	8	8	8	8	125	12.7	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1010K 07-S	10	10	10	10	125	15	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1212K 07-S	12	12	12	12	125	15	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1616K 07-S	16	16	16	16	125	16	0°	0°	DCMT 07 02 04	0.9
	11	QS-SDJCR1212E11	12	12	12	12	70	18	0°	0°	DCMT 11 T3 08	3.0
		QS-SDJCR1616E11	16	16	16	16	70	20	0°	0°	DCMT 11 T3 08	3.0
		SDJCR/L 1212K 11-S	12	12	12	12	125	18	0°	0°	DCMT 11 T3 08	3.0
		SDJCR/L 1616K 11-S	16	16	16	16	125	20	0°	0°	DCMT 11 T3 08	3.0
	07	SDJCR/L 1010E 07	10	12	10	10	70	15.7	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1212F 07	12	16	12	12	80	15.5	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1616H 07	16	20	16	16	100	16	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 2020K 07	20	25	20	20	125	17.4	0°	0°	DCMT 07 02 04	0.9
	11	SDJCR/L 1616H 11	16	20	16	16	100	20.3	0°	0°	DCMT 11 T3 08	3.0
		SDJCR/L 2020K 11	20	25	20	20	125	21.9	0°	0°	DCMT 11 T3 08	3.0
		SDJCR/L 2525M 11	25	32	25	25	150	24.4	0°	0°	DCMT 11 T3 08	3.0

Inch version

Main application	i/C	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	SDJCR/L 062C-S	.375	.375	.375	.375	5.000	.590	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 082C-S	.500	.500	.500	.500	5.000	.670	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 102C-S	.625	.625	.625	.625	5.000	.670	0°	0°	DCMT 2(1.5)1	0.7
	3/8	SDJCR/L 083C-S	.500	.500	.500	.500	5.000	.940	0°	0°	DCMT 3(2.5)2	2.2
		SDJCR/L 103C-S	.625	.625	.625	.625	5.000	.940	0°	0°	DCMT 3(2.5)2	2.2
		SDJCR/L 123C-S	.750	.750	.750	.750	5.000	.940	0°	0°	DCMT 3(2.5)2	2.2
	1/4	SDJCR/L 06 2	.375	.500	.375	.375	2.500	.590	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 08 2	.500	.625	.500	.500	3.500	.670	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 10 2	.625	.750	.625	.625	4.000	.670	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 12 2B	.750	1.000	.750	.750	4.500	.710	0°	0°	DCMT 2(1.5)1	0.7
	3/8	SDJCR/L 12 3B	.750	1.000	.750	.750	4.500	.940	0°	0°	DCMT 3(2.5)2	2.2
		SDJCR/L 16 3C	1.000	1.250	1.000	1.000	5.000	1.100	0°	0°	DCMT 3(2.5)2	2.2
		SDJCR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.100	0°	0°	DCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

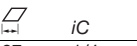
2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

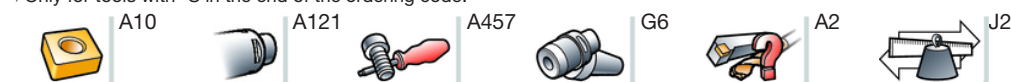
4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size		Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
	i/C					
07	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
11	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 263-01	5512 090-01	5680 049-01 (3.5)
11 ¹⁾	3/8 ¹⁾	5513 020-09 (M3.5)	5680 049-01 (15IP)	-	-	-

1) Only for tools with -S in the end of the ordering code.



Shank tools

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

SDACR/L-S

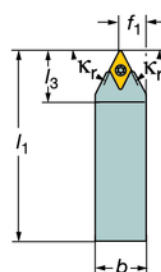
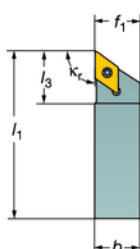
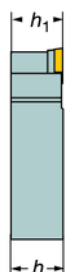
κ_r 90°
0°
Dedicated for small part
machining

SDPCN, SDPCN-S SDNCN, SDNCN-S

κ_r 62.5°
27.5°
-S = Dedicated for small part
machining



DCMT, DCMX
DCGT, DCGX, DCET
DCMW



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	07	SDACR/L 0808K 07-S	8	8	8	8	125	12.7	0°	0°	DCMT 07 02 04	0.9
		SDACR/L 1010K 07-S	10	10	10	10	125	15	0°	0°	DCMT 07 02 04	0.9
		SDACR/L 1212K 07-S	12	12	12	12	125	15	0°	0°	DCMT 07 02 04	0.9
	11	SDACR/L 1212K 11-S	12	12	12	12	125	18	0°	0°	DCMT 11 T3 08	3.0
		SDACR/L 1616K 11-S	16	16	16	16	125	20	0°	0°	DCMT 11 T3 08	3.0
	07	SDNCN 1010E 07	10	5.2	10	10	70	14.5	0°	0°	DCMT 07 02 04	0.9
		SDNCN 1212F 07	12	6.2	12	12	80	14.5	0°	0°	DCMT 07 02 04	0.9
	11	SDNCN 1616H 11	16	8.5	16	16	100	21.9	0°	0°	DCMT 11 T3 08	3.0
		SDNCN 2020K 11	20	10.5	20	20	125	21.9	0°	0°	DCMT 11 T3 08	3.0
		SDNCN 2525M 11	25	13	25	25	150	22.2	0°	0°	DCMT 11 T3 08	3.0
	07	SDNCN 1010K 07-S	10	5.2	10	10	125	15	0°	0°	DCMT 07 02 04	0.9
	11	SDNCN 1212K 11-S	12	6.2	12	12	125	21	0°	0°	DCMT 11 T3 08	3.0
		SDNCN 1616K 11-S	16	8.5	16	16	125	21	0°	0°	DCMT 11 T3 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	SDACR/L 062C-S	.375	.375	.375	.375	5.000	.500	0°	0°	DCMT 2(1.5)1	0.7
		SDACR/L 082C-S	.500	.500	.500	.500	5.000	.500	0°	0°	DCMT 2(1.5)1	0.7
		SDACR/L 102C-S	.625	.625	.625	.625	5.000	.625	0°	0°	DCMT 2(1.5)1	0.7
	3/8	SDACR/L 083C-S	.500	.500	.500	.500	5.000	.750	0°	0°	DCMT 3(2.5)2	2.2
		SDACR/L 103C-S	.625	.625	.625	.625	5.000	.750	0°	0°	DCMT 3(2.5)2	2.2
		SDACR/L 123C-S	.750	.750	.750	.750	5.000	.750	0°	0°	DCMT 3(2.5)2	2.2
	1/4	SDPCN 06 2	.375	.216	.375	.375	2.500	.571	0°	0°	DCMT 2(1.5)1	0.7
		SDPCN 08 2	.500	.279	.500	.500	3.482	.571	0°	0°	DCMT 2(1.5)1	0.7
	3/8	QS-SDPCN 083X	.500	.280	.500	.500	2.756	.827	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 10 3	.625	.341	.625	.625	4.000	.862	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 12 3B	.750	.404	.750	.750	4.500	.862	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 16 3C	1.000	.529	1.000	1.000	5.000	.890	0°	0°	DCMT 3(2.5)2	2.2
	3/8	SDPCN 083C-S	.500	.251	.500	.500	5.000	.830	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 103C-S	.625	.331	.625	.625	5.000	.830	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 123C-S	.750	.394	.750	.750	5.000	.830	0°	0°	DCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

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

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
07	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
11	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 263-01	5512 090-01	5680 049-01 (3.5)
11 ¹⁾	3/8 ¹⁾	5513 020-09 (M3.5)	5680 049-01 (15IP)	-	-	-

¹⁾ Only for tools with -S in the end of the ordering code.



A10



A121



A455



G6



A2



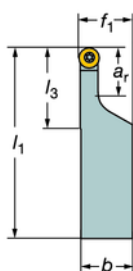
V

Shank tools

CoroTurn® 107 screw clamp design

RCMT
RCGX-ALSRACR/L
SRDCR/L

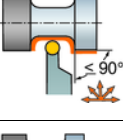

SRDCN



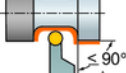

Neutral

Right hand style shown unless otherwise stated

Metric version

			Dimensions, mm											
Main application		Ordering code	a_r	b	f_1	h	h_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts	Nm ³⁾	
	05	SRDCR/L 3225P 05-A	20	25	25.5	32	32	170	35	0°	0°	RCMT 05 02 M0	0.9	
	06	SRDCR/L 2020K 06-A	20	20	20.5	20	20	125	32	0°	0°	RCMT 06 02 M0	0.9	
		SRDCR/L 3225P 06-A	20	25	25.5	32	32	170	35	0°	0°	RCMT 06 02 M0	0.9	
	08	SRDCR/L 2020K 08-A	20	20	20.5	20	20	125	32	0°	0°	RCMT 08 03 M0	1.4	
		SRDCR/L 2525M 08-A	20	25	25.5	25	25	150	35	0°	0°	RCMT 08 03 M0	1.4	
		SRDCR/L 3225P 08-A	20	25	25.5	32	32	170	35	0°	0°	RCMT 08 03 M0	1.4	
	05	SRDCN 1010E 05	10	10	7.5	10	10	70		0°	0°	RCMT 05 02 M0	0.9	
	06	SRDCN 1212F 06	12	12	9	12	12	80		0°	0°	RCMT 06 02 M0	0.9	
	08	SRDCN 1616H 08	16	16	12	16	16	100		0°	0°	RCMT 08 03 M0	1.4	
	10	SRDCN 2020K 10-A	25	20	15	20	20	125		0°	0°	RCMT 10 T3 M0	3.0	
		SRDCN 2525M 10-A	25	25	17.5	25	25	150		0°	0°	RCMT 10 T3 M0	3.0	
		SRDCN 3225P 10-A	28	25	17.5	32	32	170		0°	0°	RCMT 10 T3 M0	3.0	
	12	SRDCN 2020K 12-A	25	20	16	20	20	125		0°	0°	RCMT 12 04 M0	3.0	
		SRDCN 2525M 12-A	28	25	18.5	25	25	150		0°	0°	RCMT 12 04 M0	3.0	
		SRDCN 3225P 12-A	28	25	18.5	32	32	170		0°	0°	RCMT 12 04 M0	3.0	
	16	SRDCN 2525M 16-A	35	25	20.5	25	32	150		0°	0°	RCMT 16 06 M0	6.4	
		SRDCN 3225P 16-A	35	25	20.5	32	32	170		0°	0°	RCMT 16 06 M0	6.4	
	20	SRDCN 3232P 20-A	40	32	26	32	32	170		0°	0°	RCMT 20 06 M0	9.5	

Inch version

			Dimensions, inch											
Main application	iC	Ordering code	a_r	b	f_1	h	h_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts	ft-lbs ⁴⁾	
	1/4	SRACR/L 16 2D	1.000	1.000	1.015	1.000	1.000	6.000		0°	0°	RCMT 22	0.7	
		SRACR/L 20 2D	1.000	1.250	1.265	1.250	1.250	6.000		0°	0°	RCMT 22	0.7	
	3/8	SRACR/L 16 3D	1.000	1.000	1.015	1.000	1.000	6.000		0°	0°	RCMT 3(2.5)	1.0	
		SRACR/L 20 3D	1.000	1.250	1.325	1.250	1.250	6.000		0°	0°	RCMT 3(2.5)	1.0	
	1/2	SRACR/L 16 4D	1.000	1.000	1.015	1.000	1.000	6.000	1.000	0°	0°	RCMT 43	2.1	
		SRACR/L 20 4D	1.000	1.250	1.265	1.250	1.250	6.000		0°	0°	RCMT 43	2.1	
	1/4	SRDCN 08 2	.500	.500	.372	.500	.500	3.500		0°	0°	RCMT 22	0.7	
	3/8	SRDCN 10 3	.625	.625	.497	.625	.625	4.000		0°	0°	RCMT 3(2.5)	1.0	

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

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

Main spare parts

Insert size

Insert size	i/C	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
06	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
	3/8	5513 020-12 (M3.5)	5680 051-03 (9IP)	5322 120-01	-	-
	1/2	5513 020-13 (M4)	5680 049-01 (15IP)	5322 120-02	-	-
05	.197	5513 020-05 (M2.2)	5680 051-02 (7IP)	-	-	-
06	.236	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
08	.315	5513 020-04 (M3.0)	5680 051-03 (9IP)	-	-	-
10	.394	5513 020-10 (M3.5)	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 049-01 (3.5)
12	.472	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 110-02	5512 090-01	5680 049-01 (3.5)
16	.630	5513 020-26 (M5.0)	5680 043-14 (20IP)	5322 110-03	5512 090-06	3021 010-050 (5.0)
20	.787	5513 020-14 (M6.0)	5680 043-15 (25IP)	5322 110-04	5512 090-08	3021 010-060 (6.0)



A10



A169



A456



G6



A2



J2

Shank tools

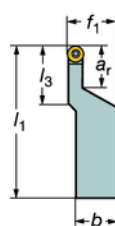
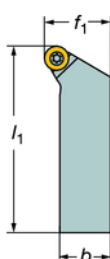
CoroTurn® 107 screw clamp design



RCMT
RCGX-AL

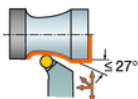
SRGCR/L
SRSCR/L
(Metric)

SRSCR/L
(Inch)

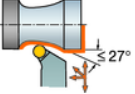
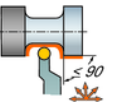


Right hand style shown unless otherwise stated

Metric version

Main application	iC	Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	05	SRSCR/L 3225P 05	25	32	32	32	170		0°	0°	RCMT 05 02 M0	0.9
	06	SRSCR/L 3225P 06	25	32	32	32	170		0°	0°	RCMT 06 02 M0	0.9
	08	SRSCR/L 3225P 08	25	32	32	32	170		0°	0°	RCMT 08 03 M0	1.4
	10	SRSCR/L 2020K 10	20	25	20	20	125		0°	0°	RCMT 10 T3 M0	3.0
		SRSCR/L 2525M 10	25	32	25	25	150		0°	0°	RCMT 10 T3 M0	3.0
	12	SRSCR/L 2525M 12	25	32	25	25	150		0°	0°	RCMT 12 04 M0	3.0
		SRSCR/L 3225P 12	25	32	32	32	170		0°	0°	RCMT 12 04 M0	3.0
	16	SRSCR/L 3225P 16	25	32	32	32	170		0°	0°	RCMT 16 06 M0	6.4
	20	SRSCR/L 3232P 20	32	40	32	32	170		0°	0°	RCMT 20 06 M0	9.5

Inch version

Main application	iC	Ordering code	Dimensions, inch									Gauge inserts	ft-lbs ⁴⁾
			a _r	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	3/8	SRGCR/L 12 3B		.750	1.000	.750	.750	4.500		0°	0°	RCMT 3(2.5)	1.0
		SRGCR/L 16 3D		1.000	1.250	1.000	1.000	6.000		0°	0°	RCMT 3(2.5)	1.0
	1/2	SRGCR/L 16 4C		1.000	1.250	1.000	1.000	5.000		0°	0°	RCMT 43	2.1
		SRGCR/L 16 4D		1.000	1.250	1.000	1.000	6.000		0°	0°	RCMT 43	2.1
		SRGCR/L 20 4D		1.250	1.500	1.250	1.250	6.000		0°	0°	RCMT 43	2.1
	3/4	SRGCR/L 20 6D		1.250	1.500	1.250	1.250	6.000		0°	0°	RCMT 64	5.2
	1/4	SRSCR/L 16 2D	.750	1.000	1.250	1.000	1.000	6.000	1.113	0°	0°	RCMT 22	0.7
		SRSCR/L 20 2D	.750	1.250	1.500	1.250	1.250	6.000	1.113	0°	0°	RCMT 22	0.7
	3/8	SRSCR/L 12 3B	.750	.750	1.000	.750	.750	4.500	1.082	0°	0°	RCMT 3(2.5)	1.0
		SRSCR/L 16 3C	1.000	1.000	1.250	1.000	1.000	5.000	1.332	0°	0°	RCMT 3(2.5)	1.0
		SRSCR/L 16 3D	1.000	1.000	1.250	1.000	1.000	6.000	1.332	0°	0°	RCMT 3(2.5)	1.0
		SRSCR/L 20 3D	1.000	1.250	1.500	1.250	1.250	6.000	1.332	0°	0°	RCMT 3(2.5)	1.0
	1/2	SRSCR/L 16 4D	1.000	1.000	1.250	1.000	1.000	6.000	1.446	0°	0°	RCMT 43	2.1
		SRSCR/L 20 4D	1.000	1.250	1.500	1.250	1.250	6.000	1.446	0°	0°	RCMT 43	2.1
		SRSCR/L 24 4D	1.000	1.500	2.000	1.500	1.500	6.000	1.446	0°	0°	RCMT 43	2.1
		SRSCR/L 24 4E	1.000	1.500	2.000	1.500	1.500	7.000	1.446	0°	0°	RCMT 43	2.1
	3/4	SRSCR/L 20 6D	1.000	1.250	1.500	1.250	1.250	6.000	1.663	0°	0°	RCMT 64	5.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size							
iC		Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	
3/8		5513 020-12 (M3.5)	5680 051-03 (9IP)	5322 120-01	-	-	
1/2		5513 020-13 (M4)	5680 049-01 (15IP)	5322 120-02	-	-	
3/4		5513 020-14 (M6)	5680 043-15 (25IP)	5322 120-03	-	-	
1		5513 020-15 (M7)	5680 043-17 (30IP)	5322 120-04	-	-	
05	.197	5513 020-05 (M2.2)	5680 051-02 (7IP)	-	-	-	
06	.236	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-	
08	.315	5513 020-04 (M3.0)	5680 051-03 (9IP)	-	-	-	
10	.394	5513 020-10 (M3.5)	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 049-01 (3.5)	
12	.472	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 110-02	5512 090-01	5680 049-01 (3.5)	
16	.630	5513 020-26 (M5.0)	5680 043-14 (20IP)	5322 110-03	5512 090-06	3021 010-050 (5.0)	
20	.787	5513 020-14 (M6.0)	5680 043-15 (25IP)	5322 110-04	5512 090-08	3021 010-060 (6.0)	



A10



A129



A456



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

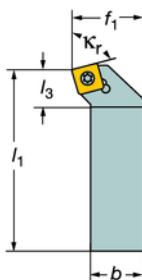


SCMT, SCGX
SCMW

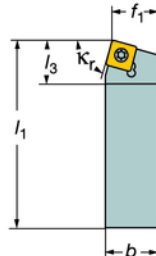
Entering angle:
Lead angle:



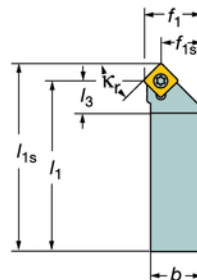
SSKCR/L
 $\kappa_r 75^\circ$
15°



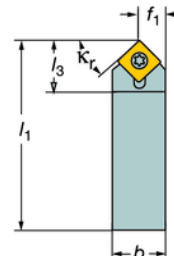
SSBCR/L
 $\kappa_r 75^\circ$
15°



SSDCR/L
 $\kappa_r 45^\circ$
45°



SSDCN
 $\kappa_r 45^\circ$
45°



Right hand style shown unless otherwise stated

Neutral

Metric version

Main application		Ordering code	Dimensions, mm										Gauge inserts	Nm ³⁾
	09	SSKCR/L 1616H 09	b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾	SCMT 09 T3 08	3.0
			16	20		16	16	100	12.8		0°	0°		
	09	SSBCR/L 1616H 09	b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃		γ ¹⁾	λ _s ²⁾	SCMT 09 T3 08	3.0
	12	SSBCR/L 2020K 12	20	17		20	20	125	20.1		0°	0°	SCMT 12 04 08	3.0
		SSBCR/L 2525M 12	25	22		25	25	150	20.1		0°	0°	SCMT 12 04 08	3.0
	09	SSDCR/L 1616H 09	b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾	SCMT 09 T3 08	3.0
		SSDCR/L 2020K 09	20	22	10.9	20	20	118.9	18	125.0	0°	0°	SCMT 09 T3 08	3.0
	12	SSDCR/L 2020K 12	20	22	13.7	20	20	116.7	21.7	125.0	0°	0°	SCMT 12 04 08	3.0
		SSDCR/L 2525M 12	25	27	18.7	25	25	141.7	21.7	150.0	0°	0°	SCMT 12 04 08	3.0
	09	SSDCN 1212F 09-M	b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃		γ ¹⁾	λ _s ²⁾	SCMT 09 T3 08	3.0
		SSDCN 1616H 09	16	8		16	16	100	15.1		0°	0°	SCMT 09 T3 08	3.0

Inch version

Main application		Ordering code	Dimensions, inch										Gauge inserts	ft-lbs ⁴⁾
	3/8	SSKCR 10 3	b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾	SCMT 3(2.5)2	2.2
			.625	.875		.625	.625	4.000	.583		0°	0°		
	3/8	SSDCR 10 3	b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾	SCMT 3(2.5)2	2.2
	1/2	SSDCR 16 4D	1.000	1.141	.813	1.000	1.000	5.653	.894	6.000	0°	0°	SCMT 432	2.2
	3/8	SSDCN 08 3	b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾	SCMT 3(2.5)2	2.2
		SSDCN 10 3	.625	.323		.625	.625	4.000	.594		0°	0°	SCMT 3(2.5)2	2.2
		SSDCN 12 3B	.750	.385		.750	.750	4.500	.594		0°	0°	SCMT 3(2.5)2	2.2
		SSDCN 16 3D	1.000	.511		1.000	1.000	6.000	.594		0°	0°	SCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

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

Main spare parts

Insert size	Ordering code	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
09	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 420-01	5512 090-01	5680 049-01 (3.5)
09 ¹⁾	3/8 ¹⁾	5513 020-10 (M3.5)	5680 049-01 (15IP)	-	-	-
12	1/2	5513 020-18 (M4x0.5)	5680 049-02 (15IP)	5322 420-02	5512 090-03	5680 049-02 (4.0)

¹⁾ Only for SSDCN1212F09-M.



A10



A132



A457



v



A2



J2

Shank tools

CoroTurn® 107 screw clamp design



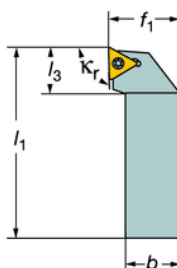
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TCGT, TCGX
TC EX
TCMW

Entering angle:
Lead angle:



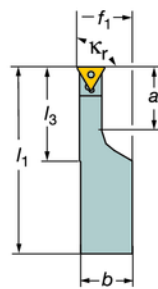
STGCR/L

$\kappa_r 91^\circ$
 -1°








STFCR/L-A

$\kappa_r 90^\circ$
 0°




Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm									Gauge inserts	Nm ³⁾
			a_r	b	f_1	h	h_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$		
		09 STGCR/L 0808D 09	8	10	8	8	60	13	0°	0°	TCMT 09 02 04	0.9	
		STGCR/L 1010E 09	10	12	10	10	70	13.9	0°	0°	TCMT 09 02 04	0.9	
		11 STGCR/L 1212F 11	12	16	12	12	80	14.1	0°	0°	TCMT 11 02 04	0.9	
		STGCR/L 1616H 11	16	20	16	16	100	14.1	0°	0°	TCMT 11 02 04	0.9	
		16 STGCR/L 1616H 16	16	20	16	16	100	20.1	0°	0°	TCMT 16 T3 08	3.0	
		STGCR/L 2020K 16	20	25	20	20	125	20.4	0°	0°	TCMT 16 T3 08	3.0	
		STGCR/L 2525M 16	25	32	25	25	150	20.9	0°	0°	TCMT 16 T3 08	3.0	
		11 STGCR/L 1212F 11-B1	12	16	12	12	80	14.1	0°	0°	TCMT 11 03 04	0.9	
		STGCR/L 1616H 11-B1	16	20	16	16	100	14.1	0°	0°	TCMT 11 03 04	0.9	
		11 STFCR/L 2020K 11-A	25	20	20.8	20	20	125	37	0°	0°	TCMT 11 02 04	0.9
		16 STFCR/L 2525M 16-A	35	25	25.9	25	25	150	47	0°	0°	TCMT 16 T3 08	3.0
		11 STFCR/L 2020K 11-AB1	25	20	20.8	20	20	125	37	0°	0°	TCMT 11 03 04	0.9

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch									Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾			
	1/4	STGCR/L 06 2	.375	.500	.375	.375	2.500	.543	0°	0°	TCMT 2(1.5)1	0.7	
		STGCR/L 08 2	.500	.625	.500	.500	3.500	.543	0°	0°	TCMT 2(1.5)1	0.7	
	3/8	STGCR/L 10 3	.625	.750	.625	.625	4.000	.823	0°	0°	TCMT 3(2.5)2	2.2	
		STGCR/L 12 3B	.750	1.000	.750	.750	4.500	.815	0°	0°	TCMT 3(2.5)2	2.2	
		STGCR/L 16 3C	1.000	1.250	1.000	1.000	5.000	.815	0°	0°	TCMT 3(2.5)2	2.2	
		STGCR/L 16 3D	1.000	1.250	1.000	1.000	6.000	.815	0°	0°	TCMT 3(2.5)2	2.2	
	1/4	STGCR/L 062-B1	.375	.500	.375	.375	2.500	.543	0°	0°	TCMT 221	0.7	
		STGCR/L 082-B1	.500	.625	.500	.500	3.500	.598	0°	0°	TCMT 221	0.7	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
09	7/32	5513 020-05 (M2.2)	5680 051-02 (7IP)	-	-	-
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 320-01	5512 090-01	5680 049-01 (3.5)



A10



A134



A457



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design



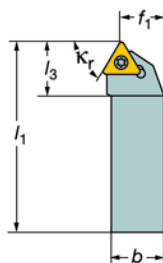
TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Entering angle:
Lead angle:



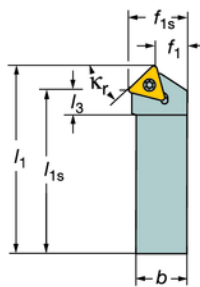
STTCR/L

$\kappa_r 60^\circ$
 30°



STDCR/L

$\kappa_r 45^\circ$
 45°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm										Gauge inserts	Nm ³⁾
	11	STTCR/L 1616H 11	16	13	f_{1s}	16	16	100	l_3	l_{1s}	$\gamma^{1)}$	$\lambda_s^{2)}$	TCMT 11 02 04	0.9
	16	STTCR/L 1616H 16	16	13		16	16	100	21.2		0°	0°	TCMT 16 T3 08	3.0
		STTCR/L 2020K 16	20	17		20	20	125	21.2		0°	0°	TCMT 16 T3 08	3.0
		STTCR/L 2525M 16	25	22		25	25	150	21.2		0°	0°	TCMT 16 T3 08	3.0
	11	STTCR/L 1616H 11-B1	16	13		16	16	100	12.9		0°	0°	TCMT 11 03 04	0.9
	09	STDCR/L 1010E 09	10	4.9	11.0	10	10	70	11.2	63.9	0°	0°	TCMT 09 02 04	0.9
	11	STDCR/L 1212F 11	12	6	13.0	12	12	80	13.2	73.0	0°	0°	TCMT 11 02 04	0.9
		STDCR/L 1616H 11	16	10	17.0	16	16	100	13.7	93.0	0°	0°	TCMT 11 02 04	0.9
	16	STDCR/L 1616H 16	16	6.8	17.0	16	16	100	21	89.8	0°	0°	TCMT 16 T3 08	3.0
		STDCR/L 2020K 16	20	11.8	22.0	20	20	125	21	114.8	0°	0°	TCMT 16 T3 08	3.0
		STDCR/L 2525M 16	25	16.8	27.0	25	25	150	22.9	139.8	0°	0°	TCMT 16 T3 08	3.0
	11	STDCR/L 1212F 11-B1	12	6	13.0	12	12	80	13.2	73.0	0°	0°	TCMT 11 03 04	0.9
		STDCR/L 1616H 11-B1	16	10	17.0	16	16	100	13.6	93.0	0°	0°	TCMT 11 03 04	0.9

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch										Gauge inserts	ft-lbs ⁴⁾
	3/8	STTCR/L 12 3B	.750	.718	f_{1s}	.750	.750	4.500		.835	0°	0°	TCMT 3(2.5)2	2.2
		STTCR/L 16 3D	1.000	.860		1.000	1.000	6.000		.835	0°	0°	TCMT 3(2.5)2	2.2
	1/4	STDCR/L 06 2	.375	.223	.500	.375	.375	2.500	2.223	.242	0°	0°	TCMT 2(1.5)1	0.7
		STDCR/L 08 2	.500	.348	.625	.500	.500	3.500	3.223	.242	0°	0°	TCMT 2(1.5)1	0.7
	3/8	STDCR/L 10 3	.625	.349	.750	.625	.625	4.000	3.599	.426	0°	0°	TCMT 3(2.5)2	2.2
		STDCR/L 12 3B	.750	.599	1.000	.750	.750	4.500	4.099	.426	0°	0°	TCMT 3(2.5)2	2.2
	1/4	STDCR/L 062-B1	.375	.223	.500	.375	.375	2.500	2.223	.242	0°	0°	TCMT 221	0.7
		STDCR/L 082-B1	.500	.348	.625	.500	.500	3.500	3.223	.242	0°	0°	TCMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
09	7/32	5513 020-05 (M2.2)	5680 051-02 (7IP)	-	-	-
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 320-01	5512 090-01	5680 049-01 (3.5)



A10



A134



A457



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

STJCR/L-S

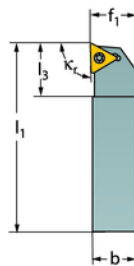
$\kappa_r 93^\circ$
 -3°
Dedicated for small part
machining

STFCR/L

$\kappa_r 91^\circ$
 -1°






TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW





Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm								Gauge inserts	Nm ³⁾
			<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	$\gamma^{1)}$	$\lambda_{S2)}$		
	11	STJCR/L 1010K 11-S	10	10	10	10	125	16	0°	0°	TCMT 11 02 04	0.9
		STJCR/L 1212K 11-S	12	12	12	12	125	16	0°	0°	TCMT 11 02 04	0.9
		STJCR/L 1616K 11-S	16	16	16	16	125	16	0°	0°	TCMT 11 02 04	0.9
	09	STFCR/L 1010E 09	10	12	10	10	70	13.2	0°	0°	TCMT 09 02 04	0.9
	11	STFCR/L 1212F 11	12	16	12	12	80	13.8	0°	0°	TCMT 11 02 04	0.9
		STFCR/L 1616H 11	16	20	16	16	100	14.9	0°	0°	TCMT 11 02 04	0.9
	16	STFCR/L 1616H 16	16	20	16	16	100	19.9	0°	0°	TCMT 16 T3 08	3.0
		STFCR/L 2020K 16	20	25	20	20	125	21.3	0°	0°	TCMT 16 T3 08	3.0
		STFCR/L 2525M 16	25	32	25	25	150	22.8	0°	0°	TCMT 16 T3 08	3.0
	11	STFCR/L 1212F 11-B1	12	16	12	12	80	13.8	0°	0°	TCMT 11 03 04	0.9
		STFCR/L 1616H 11-B1	16	20	16	16	100	14.9	0°	0°	TCMT 11 03 04	0.9

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/4	STJCR/L 062C-S	.375	.375	.375	.375	5.000	.630	0°	0°	TCMT 2(1.5)1	0.7
		STJCR/L 082C-S	.500	.500	.500	.500	5.000	.630	0°	0°	TCMT 2(1.5)1	0.7
		STJCR/L 102C-S	.625	.625	.625	.625	5.000	.630	0°	0°	TCMT 2(1.5)1	0.7
	1/4	STFCR/L 06 2	.375	.500	.375	.375	2.500	.543	0°	0°	TCMT 2(1.5)1	0.7
		STFCR/L 08 2	.500	.625	.500	.500	3.500	.543	0°	0°	TCMT 2(1.5)1	0.7
	3/8	STFCR/L 10 3	.625	.750	.625	.625	4.000	.823	0°	0°	TCMT 3(2.5)2	2.2
		STFCR/L 12 3B	.750	1.000	.750	.750	4.500	.815	0°	0°	TCMT 3(2.5)2	2.2
		STFCR/L 16 3D	1.000	1.250	1.000	1.000	6.000	.815	0°	0°	TCMT 3(2.5)2	2.2
	1/4	STFCR/L 062-B1	.375	.500	.375	.375	2.500	.543	0°	0°	TCMT 221	0.7
		STFCR/L 082-B1	.500	.625	.500	.500	3.500	.598	0°	0°	TCMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
09	7/32	5513 020-05 (M2.2)	5680 051-02 (7IP)	-	-	-
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 320-01	5512 090-01	5680 049-01 (3.5)



A10



A134



A457



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

**SVHBR/L
SVHCR/L**
 κ_r 107.5°
-17.5°

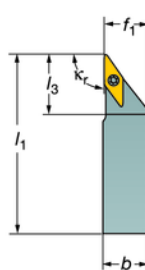
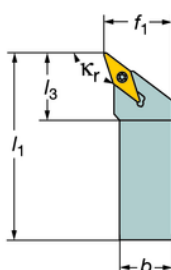
SVABR/L-S

κ_r 90°
0°

Dedicated for small part
machining



VBMT, VBGT
VCGX,
VCGT, VCET
VBMW, VCMW



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm								Gauge inserts	Nm ³⁾
	16	SVHBR/L 2020K 16	20	25	20	20	125	27.6	0°	0°	VBMT 16 04 08	3.0
		SVHBR/L 2525M 16	25	32	25	25	150	27.6	0°	0°	VBMT 16 04 08	3.0
		SVHBR/L 3225P 16	25	32	32	32	170	27.6	0°	0°	VBMT 16 04 08	3.0
	22	SVHCR/L 2525M 22-R2 ⁶⁾	25	32	25	25	150	35.2	0°	0°	VCMT 22 05 20	3.0

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	SVHBR/L 12 3B	.750	1.000	.750	.750	4.500	1.087	0°	0°	VBMT 332	2.2
		SVHBR/L 16 3C	1.000	1.250	1.000	1.000	5.000	1.087	0°	0°	VBMT 332	2.2
		SVHBR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.087	0°	0°	VBMT 332	2.2
	1/4	SVABR/L 062C-S	.375	.375	.375	.375	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVABR/L 082C-S	.500	.500	.500	.500	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVABR/L 102C-S	.625	.625	.625	.625	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
	3/8	SVABR/L 083C-S	.500	.500	.500	.500	5.000	1.610	0°	0°	VBMT 332	2.2
		SVABR/L 103C-S	.625	.625	.625	.625	5.000	1.610	0°	0°	VBMT 332	2.2
		SVABR/L 123C-S	.750	.750	.750	.750	5.000	1.610	0°	0°	VBMT 332	2.2
	1/4	SVABR/L 062C-S-B1	.375	.375	.375	.375	5.000	.790	0°	0°	VBMT 221	0.7
		SVABR/L 082C-S-B1	.500	.500	.500	.500	5.000	.790	0°	0°	VBMT 221	0.7
		SVABR/L 102C-S-B1	.625	.625	.625	.625	5.000	.790	0°	0°	VBMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

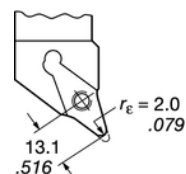
4) Insert tightening torque ft-lbs.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

6) When using insert VCGX 22 05 30-AL with radius 3.0 mm, together with shim 5322 270-04, the tool holder has to be modified. See picture.

R = Right hand, L = Left hand

Main spare parts (see next page)



A10



A173



A457



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

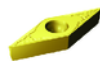
SVJBR/L-S

$\kappa_r 93^\circ$
 -3°

Dedicated for small part
machining

SVJBR/L

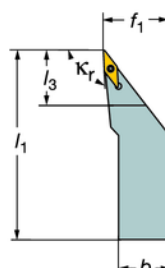
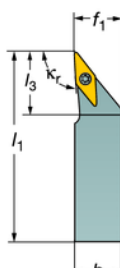
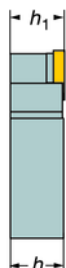
$\kappa_r 93^\circ$
 -3°



VBMT, VBGT
VCGX, VCEX,
VCGT, VCET


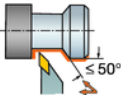
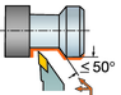


VBMW, VCMW



Right hand style shown unless otherwise stated

Metric version

			Dimensions, mm									
Main application		Ordering code ⁴⁾	<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	γ ¹⁾	λ _s ²⁾	Gauge inserts	Nm ³⁾
	11	SVJBR/L 1010K 11-S	10	10	10	10	125	26	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 1212K 11-S	12	12	12	12	125	26	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 1616K 11-S	16	16	16	16	125	26	0°	0°	VBMT 11 02 04	0.9
	16	QS-SVJBR/L1212E16	12	12	12	12	70	30	0°	0°	VBMT 16 04 08	3.0
		QS-SVJBR/L1616E16	16	16	16	16	70	40	0°	0°	VBMT 16 04 08	3.0
		SVJBR/L 1212K 16-S	12	12	12	12	125	30	0°	0°	VBMT 16 04 08	3.0
		SVJBR/L 1616K 16-S	16	16	16	16	125	40	0°	0°	VBMT 16 04 08	3.0
	11	SVJBR/L 0810K 11-S-B1	10	10	8	8	125	26	0°	0°	VBMT 11 03 04	0.9
SVJBR/L 1010K 11-S-B1		10	10	10	10	125	26	0°	0°	VBMT 11 03 04	0.9	
SVJBR/L 1212K 11-S-B1		12	12	12	12	125	26	0°	0°	VBMT 11 03 04	0.9	
SVJBR/L 1616K 11-S-B1		16	16	16	16	125	26	0°	0°	VBMT 11 03 04	0.9	
	11	SVJBR/L 1212F 11	12	16	12	12	80	20.6	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 1616H 11	16	20	16	16	100	21.2	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 2020K 11	20	25	20	20	125	21.2	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 2525M 11	25	32	25	25	150	21.2	0°	0°	VBMT 11 02 04	0.9
	16	SVJBR/L 2020K 16	20	25	20	20	125	31.1	0°	0°	VBMT 16 04 08	3.0
		SVJBR/L 2525M 16	25	32	25	25	150	31.5	0°	0°	VBMT 16 04 08	3.0
		SVJBR/L 3225P 16	25	32	32	32	170	31.5	0°	0°	VBMT 16 04 08	3.0
		11	SVJBR/L 1212F 11-B1	12	16	12	12	80	20.6	0°	0°	VBMT 11 03 04
	SVJBR/L 1616H 11-B1		16	20	16	16	100	21.2	0°	0°	VBMT 11 03 04	0.9
	SVJBR/L 2020K 11-B1		20	25	20	20	125	21.2	0°	0°	VBMT 11 03 04	0.9
	SVJBR/L 2525M 11-B1		25	32	25	25	150	21.2	0°	0°	VBMT 11 03 04	0.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)
22	1/2	5513 020-18	5680 049-02 (15IP)	5322 270-03	5512 090-03	5680 049-02 (15IP)



A10



A173



A457



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

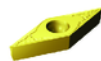
SVJBR/L-S

$\kappa_r 93^\circ$
 -3°

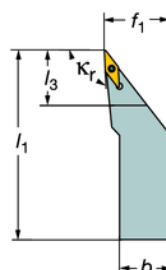
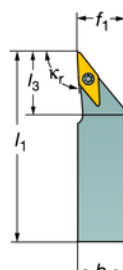
Dedicated for small part
machining

SVJBR/L

$\kappa_r 93^\circ$
 -3°



VBMT, VBG
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW



Right hand style shown unless otherwise stated

Inch version

Main application	iC	Ordering code ³⁾	Dimen								Gauge inserts	ft-lbs ⁴⁾
	1/4	SVJBR/L 062C-S	.375	.375	.375	.375	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 082C-S	.500	.500	.500	.500	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 102C-S	.625	.625	.625	.625	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
	3/8	QS-SVJBR 083X	.500	.500	.500	.500	2.756	1.181	0°	0°	VBMT 332	2.2
		QS-SVJBR 103X	.625	.625	.625	.625	2.756	1.181	0°	0°	VBMT 332	2.2
		SVJBR/L 083C-S	.500	.500	.500	.500	5.000	1.610	0°	0°	VBMT 332	2.2
		SVJBR/L 103C-S	.625	.625	.625	.625	5.000	1.610	0°	0°	VBMT 332	2.2
		SVJBR/L 123C-S	.750	.750	.750	.750	5.000	1.610	0°	0°	VBMT 332	2.2
	1/4	SVJBR/L 062C-S-B1	.375	.375	.375	.375	5.000	.790	0°	0°	VBMT 221	0.7
		SVJBR/L 082C-S-B1	.500	.500	.500	.500	5.000	.790	0°	0°	VBMT 221	0.7
		SVJBR/L 102C-S-B1	.625	.625	.625	.625	5.000	.790	0°	0°	VBMT 221	0.7
	1/4	SVJBR/L 08 2	.500	.625	.500	.500	3.500	.787	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 10 2	.625	.750	.625	.625	4.000	.835	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 12 2B	.750	1.000	.750	.750	4.500	.835	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 16 2C	1.000	1.250	1.000	1.000	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 16 2D	1.000	1.250	1.000	1.000	6.000	.835	0°	0°	VBMT 2(1.5)1	0.7
	3/8	SVJBR/L 12 3B	.750	1.000	.750	.750	4.500	1.228	0°	0°	VBMT 332	2.2
		SVJBR/L 16 3C	1.000	1.250	1.000	1.000	5.000	1.240	0°	0°	VBMT 332	2.2
		SVJBR/L 16 3D	1.000	1.250	1.000	1.000	6.000	1.240	0°	0°	VBMT 332	2.2
		SVJBR/L 20 3D	1.250	1.500	1.250	1.250	6.000	1.240	0°	0°	VBMT 332	2.2
	1/4	SVJBR/L 082-B1	.500	.625	.500	.500	3.500	.799	0°	0°	VBMT 221	0.7
		SVJBR/L 102-B1	.625	.750	.625	.625	4.000	.835	0°	0°	VBMT 221	0.7
		SVJBR/L 122B-B1	.750	1.000	.750	.750	4.500	.835	0°	0°	VBMT 221	0.7
		SVJBR/L 162D-B1	1.000	1.250	1.000	1.000	6.000	.835	0°	0°	VBMT 221	0.5

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)



A10



A173



A457



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

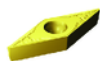
Entering angle:
Lead angle:

SVVBN, SVVBN-S

κ_r 72.5°

17.5°

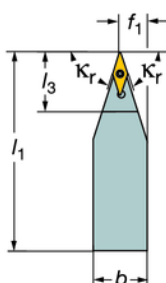
-S = Dedicated for small part machining



VBMT, VBGT
VCGX,
VCGT, VCET



VBMW, VCMW



Neutral style shown.

Metric version

Main application		Ordering code ⁴⁾	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	11	SVVBN 1212F 11	12	6.3	12	12	80	21.1	0°	0°	VBMT 11 02 04	0.9
		SVVBN 1616H 11	16	8.3	16	16	100	21.1	0°	0°	VBMT 11 02 04	0.9
		SVVBN 2020K 11	20	10.3	20	20	125	21.1	0°	0°	VBMT 11 02 04	0.9
		SVVBN 2525M 11	25	12.8	25	25	150	21.1	0°	0°	VBMT 11 02 04	0.9
	16	SVVBN 2020K 16	20	10.6	20	20	125	31.5	0°	0°	VBMT 16 04 08	3.0
		SVVBN 2525M 16	25	13.1	25	25	150	31.5	0°	0°	VBMT 16 04 08	3.0
		SVVBN 3225P 16	25	13.1	32	32	170	31.5	0°	0°	VBMT 16 04 08	3.0
	11	SVVBN 1212F 11-B1	12	6.3	12	12	80	21.1	0°	0°	VBMT 11 03 04	0.9
		SVVBN 1616H 11-B1	16	8.3	16	16	100	21.1	0°	0°	VBMT 11 03 04	0.9
		SVVBN 2020K 11-B1	20	10.3	20	20	125	21.1	0°	0°	VBMT 11 03 04	0.9
		SVVBN 2525M 11-B1	25	12.8	25	25	150	21.1	0°	0°	VBMT 11 03 04	0.9
		SVVBN 0808K 11-S-B1	8	4.3	8	8	125	21	0°	0°	VBMT 11 03 04	0.9
		SVVBN 1010K 11-S-B1	10	5.3	10	10	125	21	0°	0°	VBMT 11 03 04	0.9
		SVVBN 1212K 11-S-B1	12	6.3	12	12	125	21	0°	0°	VBMT 11 03 04	0.9
		SVVBN 1616K 11-S-B1	16	8.3	16	16	125	21	0°	0°	VBMT 11 03 04	0.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

N = Neutral

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)



A10



A173



A457



G6



A2



J2

Shank tools

CoroTurn® 107 screw clamp design

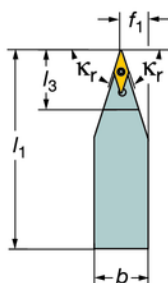
Entering angle:
Lead angle:

SVBN, SVBN-S

κ_r 72.5°
17.5°



VBMT, VBGT
VCGX,
VCGT, VCET
VBMW, VCMW



-S = Dedicated for small part machining

Neutral style shown.

Inch version

Main application	iC	Ordering code ³⁾	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/4	SVBN 08 2	.500	.260	.500	.500	3.500	.831	0°	0°	VBMT 2(1.5)1	0.7
		SVBN 10 2	.625	.323	.625	.625	4.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVBN 12 2B	.750	.384	.750	.750	4.500	.831	0°	0°	VBMT 2(1.5)1	0.7
	3/8	SVBN 12 3B	.750	.395	.750	.750	4.500	1.240	0°	0°	VBMT 332	2.2
		SVBN 16 3C	1.000	.520	1.000	1.000	5.000	1.240	0°	0°	VBMT 332	2.2
		SVBN 16 3D	1.000	.520	1.000	1.000	6.000	1.240	0°	0°	VBMT 332	2.2
		SVBN 20 3D	1.250	.645	1.250	1.250	6.000	1.240	0°	0°	VBMT 332	2.2
	1/4	SVBN 082-B1	.500	.260	.500	.500	3.500	.831	0°	0°	VBMT 221	0.5
		SVBN 122B-B1	.750	.384	.750	.750	4.500	.831	0°	0°	VBMT 221	0.5
		SVBN 062C-S-B1	.375	.190	.375	.375	5.000	.830	0°	0°	VBMT 221	0.7
		SVBN 082C-S-B1	.500	.260	.500	.500	5.000	.830	0°	0°	VBMT 221	0.7
		SVBN 102C-S-B1	.625	.363	.625	.625	5.000	.830	0°	0°	VBMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

4) Insert tightening torque ft-lbs.

N = Neutral

Main spare parts

Insert size						
	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)	-	-	-
16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)



A10



A173



A457



G6



A2



J2

CoroTurn® TR

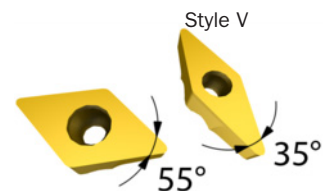
For maximum stability for profiling operations



Locked-in precision with rigid stability
higher productivity from product
consistency

CoroTurn TR – a secure profiling solution

A combination of tool holder and insert provides a good source of stability for demanding profile turning operations, as interlocking T-rail and groove locates the insert precisely and securely.



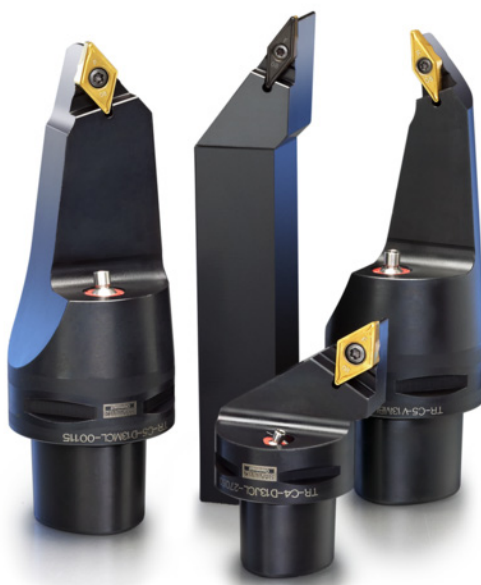
Style D

Prevents insert movement

The T-rail interface firmly locks the insert in the corresponding profile in the insert seat.

Productivity

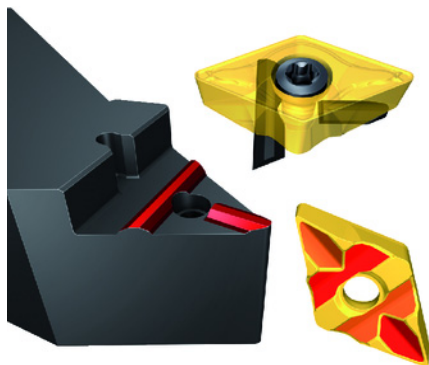
Reduces set-up time and allows increases in cutting data.



Component quality

Achieves unmatched tolerance capability.

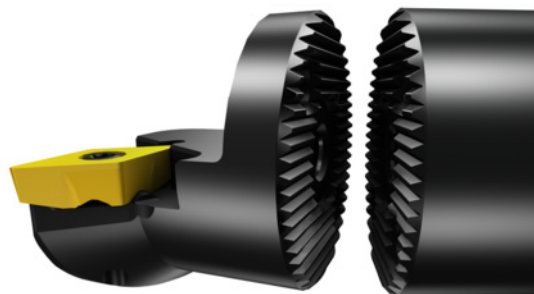
The Coro Turn TR design has T-rails on the tool holder and corresponding slots on the insert; the slotted insert sits rigidly on the T-rails in the pocket. Indexing repeatability is assured during demanding turning operations with greater stability and tolerance.



CoroTurn® TR for Small Part Machining

All new rigid profiling for sliding head machines; higher stability and closer tolerances in small component mass production

For ordering, see Small part machining page A230.

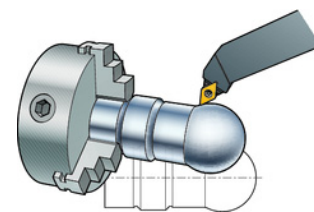
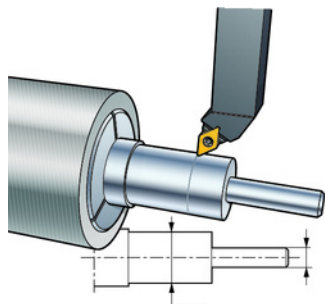


CoroTurn® TR SL internal machining

Two winning concepts in one tool - the flexible SL-system now with cutting heads with T-rail interface - giving you up to 14 000 flexible machining combinations.

For ordering, see CoroTurn SL cutting heads page I18.
Also available as CoroTurn HP

Medium to finish profile turning



Profile turning operations place extreme demands on the insert and tool holder through variations in forces. This can cause problems of reduced component quality in medium to finish machining.

The new design ensures quality requirements are met in external machining and is well suited to medium and finish profile turning, in a wide range of materials.

The CoroTurn TR provides a unique design solution in this area, with an innovative clamping interface to enable highly secure and stable positioning of the insert in the insert seat. This firm location will improve quality and productivity in turning operations for V (35°) and D (55°) style inserts.

Code key for insert

TR	-	D	C	13	04	-	F
1		2	3	4	5		6

1 Family name CoroTurn TR

2 Insert shape

D=55°, V=35°

3 Insert clearance angle

C=7°, B=5°

Code key for shank holder

Metric

TR	-	D	13	J	C	R	-	20	20	K
1		2	3	4	5	6		7	8	9

Inch

TR	-	D	13	J	C	R	-	12	B
1		2	3	4	5	6		13	9

2 Insert shape

D=55°, V=35°

3 Insert size

4 Holder style, entering angle

J=93°, N=63°

5 Insert clearance angle

C=7°, B=5°

4 Insert size

Cutting edge length, 13 mm (.512 inch)

5 Nose radius, r_n

04 = 0.4 mm (.016 inch)

08 = 0.8 mm (.031 inch)

12 = 1.2 mm (.047 inch)

6 Holder style

R = Right hand

L = Left hand

N = Neutral

7 Shank size height, h mm

8 Shank size width, b mm

9 Shank tool length, l_1 mm/ inch

K = 125 mm

M = 150 mm

P = 170 mm

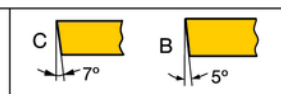
B = 4.5 inch

D = 6 inch

2. Insert shape



3/ 5. Insert clearance angle



6 Insert geometry

F = Finishing

M = Medium machining

Coromant Capto

TR	-	C4	-	D	13	J	C	R	-	27	050
1		10		2	3	4	5	6		11	12

10 Coromant Capto coupling size

11 Coromant Capto f_1 dimension mm

12 Coromant Capto tool length, mm

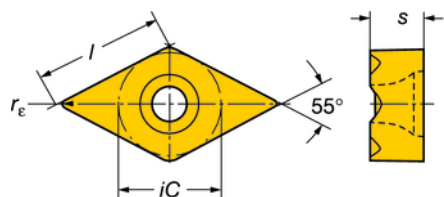
13 Shank size inch width and height

12 = $\frac{3}{4} \times \frac{3}{4}$




16 = 1x1

CoroTurn® TR




Rhombic 55°



For dimensions, see code key on page A190.

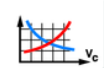
		ISO		Dimensions, mm, inch		P				M		K		N		S				ANSI
				s	Max a _p ¹⁾	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
						1515	1525	4215	4225	1115	1125	2025	H13A	1125	1105	1115	1125	H13A		
Finishing		TR-DC1304-F	13	5.5	3	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TR-DC1304-F
		TR-DC1308-F		.218	.118	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TR-DC1308-F
Medium		TR-DC1308-M	13	5.5	5	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TR-DC1308-M
		TR-DC1312-M		.218	.197	☆		☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	TR-DC1312-M
						P25	P15	P15	P25	M15	M25	M25	K20	N25	S15	S20	S25	S15		

Inserts for advanced cutting materials

		ISO		Dimensions, mm, inch			H		ANSI
				s	l _a	Max a _p ¹⁾	7015	7025	
							CB	CB	
Finishing	 	TR-DC1304S01020F	13	5.5	3	0.4	☆	☆	TR-DC1304S01020F
		TR-DC1308S01020F		.218	.118	.016	☆	☆	TR-DC1308S01020F
							H10	H15	

¹⁾ Max a_p = max cutting depth

A193



A516



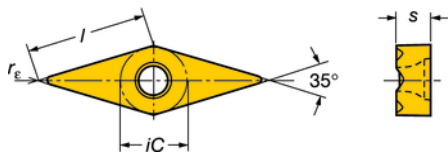
A524





A2

CoroTurn® TR

Rhombic 35°



For dimensions, see code key on page A190.

					Dimensions, mm, inch		P				M		K	N	S				ANSI		
							GC	GC	GC	GC	GC	GC	GC	GC	-	GC	GC	GC		GC	-
							1125	1515	1525	4215	4225	1115	1125	2025	H13A	1125	1105	1115		1125	H13A
							1125	1515	1525	4215	4225	1115	1125	2025	H13A	1125	1105	1115		1125	H13A
Finishing		ISO	13	s	Max a _p ¹⁾	★					★								★	TR-VB1302-F	
		TR-VB1302-F		4.5	2							★									
		TR-VB1304-F		4.5	2		☆	☆	☆	★	☆	☆	☆	★	★	★	★	☆	☆	☆	TR-VB1304-F
		TR-VB1308-F		4.5	2		☆	☆	☆	★	☆	☆	☆	★	★	★	★	☆	☆	☆	TR-VB1308-F
		TR-VB1312-F		4.5	2		☆	☆	☆	★	☆	☆	☆	★	★	★	★	☆	☆	☆	TR-VB1312-F
			</																		

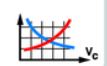
★ = First choice

Inserts for advanced cutting materials

				Dimensions, mm, inch	H		ANSI
					CB	CB	
					7015	7025	
Finishing	TR-VB-F	ISO	13	s	l _a	Max a _p ¹⁾	★
		TR-VB1304S01020F		4.5	3	0.4	☆
				.178	.118	.016	
		TR-VB1308S01020F		4.5	3	0.8	☆
							H10
							H15

¹⁾ Max a_p = max cutting depth

A193



A516



A524



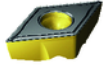
A2

CoroTurn® TR

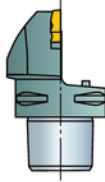
Coromant Capto® cutting units

Screw clamp design

Entering angle:
Lead angle:

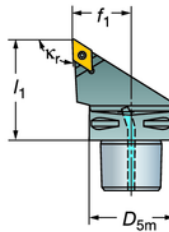


TR-DC



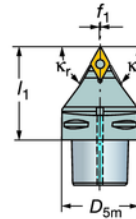
TR-Cx-D13JCR/L

κ_r 93°
-3°



TR-Cx-D13NCN

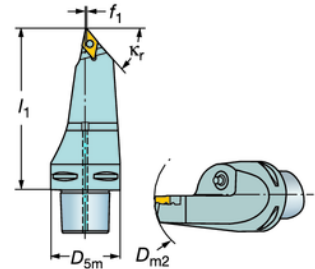
κ_r 63.5°
27.5°



Neutral

TR-Cx-D13MCL


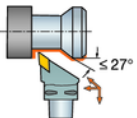
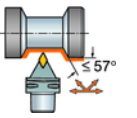
κ_r 50° (93°)
40° (-3°)


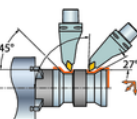


Coolant inlet: Radial through the taper

Coolant inlet: Axial through the center

Right hand style shown when nothing else is stated

Main application			Dimensions, mm, inch						Gauge inserts	
		Ordering code	D_{5m}	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO/ ANSI	Nm ³⁾	
	13	TR-C4-D13JCR/L-27050	40	27	50	0°	0°	TR-DC1308	3.0	
				1.063	1.968					
		TR-C5-D13JCR/L-35060	50	35	60	0°	0°	TR-DC1308	3.0	
				1.378	2.362					
		TR-C6-D13JCR/L-45065	63	45	65	0°	0°	TR-DC1308	3.0	
				1.772	2.559					
	13	TR-C4-D13NCN-00050	40	0.5	50	0°	0°	TR-DC1308	3.0	
				.020	1.968					
		TR-C5-D13NCN-00060	50	0.5	60	0°	0°	TR-DC1308	3.0	
				.020	2.362					
		TR-C6-D13NCN-00065	63	0.5	65	0°	0°	TR-DC1308	3.0	
				.020	2.559					

Main application			Dimensions, mm, inch						Gauge inserts	
		Ordering code	D_{5m}	D_{m2} min ⁴⁾	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO/ ANSI	Nm ³⁾
	13	TR-C5-D13MCL-00115	50	150	0	115	0°	0°	TR-DC1308	3.0
				5.906	.000	4.528				
		TR-C6-D13MCL-00130	63	150	0	130	0°	0°	TR-DC1308	3.0
				5.906	.000	5.118				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

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

Main spare parts

Coromant Capto® size	Insert screw	Key (Torx Plus)	Torque wrench ¹⁾
C4-C6	5513 020-01	5680 049-01 (15IP)	5680 100-06 (15IP)

¹⁾ Accessories, must be ordered separately



A191



A195



A468



G6



A2



J2

CoroTurn® TR

Coromant Capto® cutting units
Screw clamp design

Entering angle:
Lead angle:

TR-Cx-V13JBR/L

 κ_r 93°
-3°

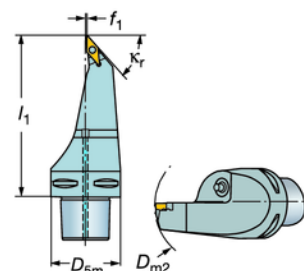
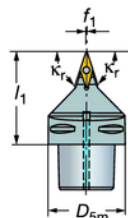
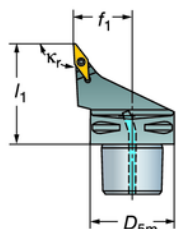
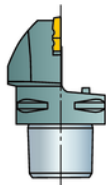
TR-Cx-V13VBN

 κ_r 72.5°
17.5°

TR-Cx-V13MBL

 κ_r 50° (93°)
40° (-3°)


TR-VB


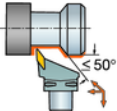
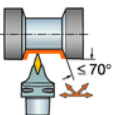


Neutral

Coolant inlet: Radial through the taper

Coolant inlet: Axial through the center

Right hand style shown when nothing else is stated

			Dimensions, mm, inch					Gauge inserts	
Main application		Ordering code	D_{5m}	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO/ ANSI	Nm ³⁾
	13	TR-C4-V13JBR/L-27050	40	27	50	0°	0°	TR-VB1308	2.0
				1.063	1.968				
		TR-C5-V13JBR/L-35060	50	35	60	0°	0°	TR-VB1308	2.0
				1.378	2.362				
		TR-C6-V13JBR/L-45065	63	45	65	0°	0°	TR-VB1308	2.0
				1.772	2.559				
	13	TR-C4-V13VBN-00050	40	0.5	50	0°	0°	TR-VB1308	2.0
				.020	1.968				
		TR-C5-V13VBN-00060	50	0.5	60	0°	0°	TR-VB1308	2.0
				.020	2.362				
		TR-C6-V13VBN-00065	63	0.5	65	0°	0°	TR-VB1308	2.0
				.020	2.559				

Main application		Ordering code	Dimensions, mm, inch						Gauge inserts	
	13	TR-C5-V13MBL-00115	50	150	0	115	γ^1	$\lambda_s^{2)}$	ISO/ ANSI	Nm ³⁾
				5.906	.000	4.528	0°	0°	TR-VB1308	2.0
		TR-C6-V13MBL-00130	63	150	0	130	0°	0°	TR-VB1308	2.0
				5.906	.000	5.118				

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

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

Main spare parts

Coromant Capto® size	Insert screw	Key (Torx Plus)	Torque wrench ¹⁾
C4-C6	5513 020-64	5680 049-04 (10IP)	5680 100-05 (10IP)

1) Accessories, must be ordered separately



A191



A197



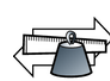
A468



G6



A2



J2

CoroTurn® TR

Shank tools

Screw clamp design

Entering angle:
Lead angle:

TR-D13JCR/L

$\kappa_r 93^\circ$
 -3°

TR-D13JCR/L-S

$\kappa_r 93^\circ$
 -3°

Dedicated for small part machining

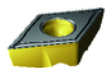
TR-D13NCN

$\kappa_r 62.5^\circ$
 27.5°

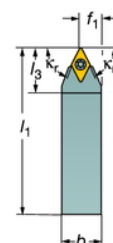
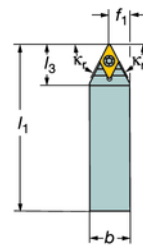
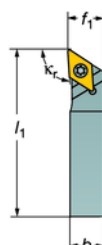
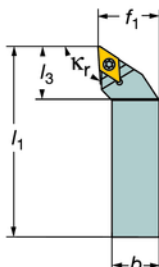
TR-D13NCN-S

$\kappa_r 62.5^\circ$
 27.5°

Dedicated for small part machining



TR-DC


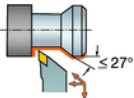
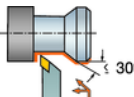
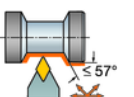
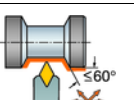


Neutral

Neutral

Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	
			f_1	b	h	h_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO/ ANSI	Nm ³⁾
	13	TR-D13JCR/L 2020K	25.0	20	20.0	20.0	125.0	28.5	0°	0°	TR-DC1308	3.0
		TR-D13JCR/L 2525M	32.0	25	25.0	25.0	150.0	28.5	0°	0°	TR-DC1308	3.0
		TR-D13JCR/L 3225P	32.0	25	32.0	32.0	170.0	28.5	0°	0°	TR-DC1308	3.0
	13	TR-D13JCR/L 1616K-S	16.0	16	16.0	16.0	125.0		0°	0°	TR-DC1308	3.0
	13	TR-D13NCN 2020K	10.5	20	20.0	20.0	125.0	26.0	0°	0°	TR-DC1308	3.0
		TR-D13NCN 2525M	13.0	25	25.0	25.0	150.0	26.0	0°	0°	TR-DC1308	3.0
		TR-D13NCN 3225P	13.0	25	32.0	32.0	170.0	26.0	0°	0°	TR-DC1308	3.0
	13	TR-D13NCN1616K-S	8.3	16	16.0	16.0	125.0		0°	0°	TR-DC1308	3.0

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

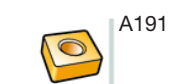
3) Insert tightening torque Nm.

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

Main spare parts

Insert screw	Key (Torx Plus)	Torque wrench ¹⁾
5513 020-01	5680 049-01 (15IP)	5680 100-06 (15IP)

1) Accessories, must be ordered separately



A191



A193



A468



G6



A2



J2

CoroTurn® TR

Shank tools

Screw clamp design

Entering angle:
Lead angle:

TR-D13JCR/L

 $\kappa_r 93^\circ$
 -3°

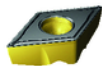
TR-D13JCR/L-S

 $\kappa_r 93^\circ$
 -3° Dedicated for small
part machining

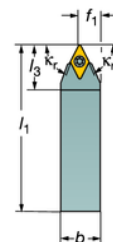
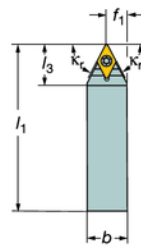
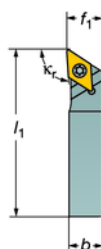
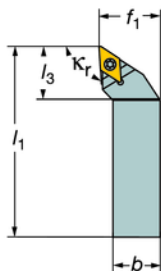
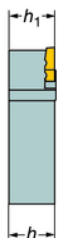
TR-D13NCN

 $\kappa_r 62.5^\circ$
 27.5°

TR-D13NCN-S

 $\kappa_r 62.5^\circ$
 27.5° Dedicated for small
part machining

TR-DC



Neutral

Neutral

Right hand style shown when nothing else is stated

Inch version

Main application		Ordering code	Dimensions, inch								Gauge inserts	
			f_1	b	h	h_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO/ ANSI	ft-lbs ³⁾
	13	TR-D13JCR/L 12B	1.000	.750	.750	.750	4.500	1.122	0°	0°	TR-DC1308	2.2
		TR-D13JCR/L 16D	1.250	1.000	1.000	1.000	6.000	1.122	0°	0°	TR-DC1308	2.2
	13	TR-D13JCR/L 10C-S	.625	.625	.625	.625	5.000		0°	0°	TR-DC1308	2.2
	13	TR-D13NCN 12B	.394	.750	.750	.750	4.500	1.024	0°	0°	TR-DC1308	2.2
		TR-D13NCN 16D	.520	1.000	1.000	1.000	6.000	1.024	0°	0°	TR-DC1308	2.2
	13	TR-D13NCN 10C-S	.331	.625	.625	.625	5.000		0°	0°	TR-DC1308	2.2

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

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

Main spare parts

Insert screw	Key (Torx Plus)	Torque wrench ¹⁾
5513 020-01	5680 049-01 (15IP)	5680 100-06 (15IP)

1) Accessories, must be ordered separately



A191



A193



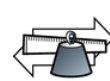
A468



G6



A2



J2

CoroTurn® TR

Shank tools

Screw clamp design

Entering angle:
Lead angle:

TR-V13JBR/L

 $\kappa_r 93^\circ$
-3°

TR-V13JBR/L-S

 $\kappa_r 93^\circ$
-3°Dedicated for small
part machining

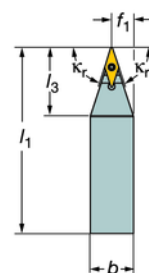
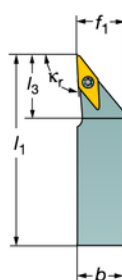
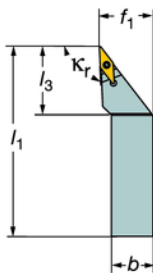
TR-V13VBN

 $\kappa_r 72.5^\circ$
17.5°

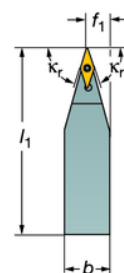
TR-V13VBN-S

 $\kappa_r 72.5^\circ$
17.5°Dedicated for small
part machining

TR-VB



Neutral



Neutral

Right hand style shown when nothing else is stated

Metric version

Main application	13	Ordering code	Dimensions, mm								Gauge inserts	
			f_1	b	h	h_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO/ ANSI	Nm ³⁾
	13	TR-V13JBR/L 2020K	25.0	20	20.0	20.0	125.0	32.0	0°	0°	TR-VB1308	2.0
		TR-V13JBR/L 2525M	32.0	25	25.0	25.0	150.0	40.9	0°	0°	TR-VB1308	2.0
		TR-V13JBR/L 3225P	32.0	25	32.0	32.0	170.0	40.9	0°	0°	TR-VB1308	2.0
	13	TR-V13JBR/L 1616K-S	16.0	16	16.0	16.0	125.0		0°	0°	TR-VB1308	2.0
	13	TR-V13VBN 1616K-S	8.3	16	16.0	16.0	125.0		0°	0°	TR-VB1308	2.0
		TR-V13VBN 2020K	10.5	20	20.0	20.0	125.0	31.8	0°	0°	TR-VB1308	2.0
		TR-V13VBN 2525M	13.0	25	25.0	25.0	150.0	39.7	0°	0°	TR-VB1308	2.0
		TR-V13VBN 3225P	13.0	25	32.0	32.0	170.0	39.7	0°	0°	TR-VB1308	2.0

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

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

Main spare parts

Insert screw	Key (Torx Plus)	Torque wrench ¹⁾
5513 020-64	5680 049-04 (10IP)	5680 100-05 (10IP)

1) Accessories, must be ordered separately



A191



A194



A468



G6



A2



J2

CoroTurn® TR

Shank tools

Screw clamp design

B

Entering angle:
Lead angle:

TR-V13JBR/L

 $\kappa_r 93^\circ$
-3°

TR-V13JBR/L-S

 $\kappa_r 93^\circ$
-3°Dedicated for small
part machining

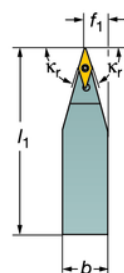
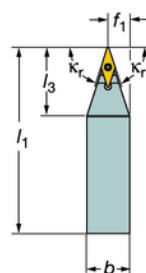
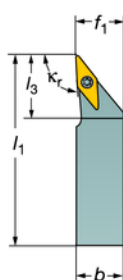
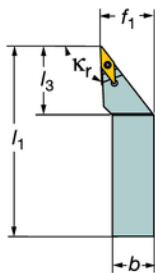
TR-V13VBN

 $\kappa_r 72.5^\circ$
17.5°

TR-V13VBN-S

 $\kappa_r 72.5^\circ$
17.5°Dedicated for small
part machining

TR-VB



Neutral

Neutral

Right hand style shown when nothing else is stated

Inch version

G

Main application	13	Ordering code	Dimensions, inch								Gauge inserts	
			f_1	b	h	h_1	l_1	l_3	γ^1	λ_s^2	ISO/ ANSI	ft-lbs ³
	13	TR-V13JBR/L 12B	1.000	.750	.750	.750	4.500	1.260	0°	0°	TR-VB1308	1.5
		TR-V13JBR/L 16D	1.250	1.000	1.000	1.000	6.000	1.579	0°	0°	TR-VB1308	1.5
	13	TR-V13JBR/L 10C-S	.625	.625	.625	.625	5.000		0°	0°	TR-VB1308	1.5
	13	TR-V13VBN 12B	.394	.750	.750	.750	4.500	1.193	0°	0°	TR-VB1308	1.5
		TR-V13VBN 16D	.520	1.000	1.000	1.000	6.000	1.587	0°	0°	TR-VB1308	1.5
		TR-V13VBN 10C-S	.331	.625	.625	.625	5.000		0°	0°	TR-VB1308	1.5

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

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

Main spare parts

I

Insert screw	Key (Torx Plus)	Torque wrench ¹⁾
5513 020-64	5680 049-04 (10IP)	5680 100-05 (10IP)

1) Accessories, must be ordered separately

J



A191



A194



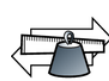
A468



G6



A2



J2

CoroTurn® RC rigid clamping

External tools for negative basic-shape ceramics and CBN inserts

First choice for stability and security in productive turning

CoroTurn® RC system is available in Coromant Capto® cutting units and conventional steel shank design for all insert shapes and lead angles



The 1st choice system for turning, giving:

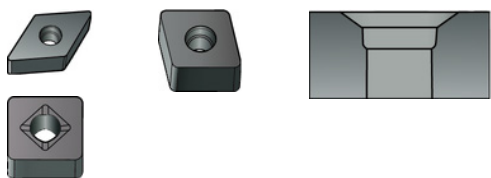
- Unique stability
- Excellent function even in dirty environments e.g. cast iron machining
- User-friendly handling; one Torx Plus key for insert and shim change
- Easy access even if holder is in up side down position

A flexible system

The tip seat on all CoroTurn® RC holders has been designed for total interchangeability by changing clamp set and/or shim.

- Cemented carbide inserts
- Ceramic inserts with holes
- Ceramic inserts without holes
- Different insert thicknesses

For further information see page A445.



Inserts with Q-style holes

The combination of insert with Q-style hole and the CoroTurn® RC holder gives an improved tool performance compared to flat inserts in standard holders. Q-style hole in the insert eliminates the risk of insert movement thanks to superior clamping.



- Clamp sets for ceramic inserts with and without holes.

Coromant Capto® cutting units

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

DCLNR/L -2

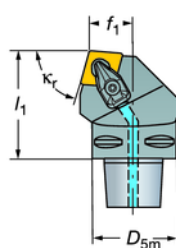
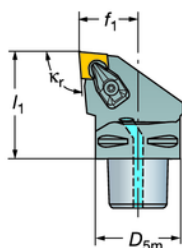
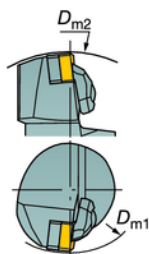
κ_r 95°
-5°

DCRNR/L -2


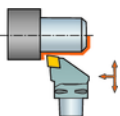
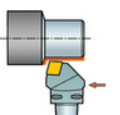
κ_r 75°
15°



CNGQ
CNGA, CNMA



Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)										Gauge inserts		
				D _{5m}	D _{m1} min mm ⁴⁾	D _{m1} min in. ⁴⁾	D _{m2} min mm ⁴⁾	D _{m2} min in. ⁴⁾	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _S ²⁾	ISO	ANSI
	12	1/2	C4-DCLNR/L-27050-12-2	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	CNGQ 12 07 08	CNGQ 452	3.9
			C5-DCLNR/L-35060-12-2	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	CNGQ 12 07 08	CNGQ 452	3.9
			C6-DCLNR/L-45065-12-2	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	CNGQ 12 07 08	CNGQ 452	3.9
	12	1/2	C4-DCRNR/L-22050-12-2	40			140	5.512	22.0	.866	50.0	1.968	-6° -6°	CNGQ 12 07 08	CNGQ 452	3.9
			C5-DCRNR/L-27060-12-2	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	CNGQ 12 07 08	CNGQ 452	3.9
			C6-DCRNR/L-35065-12-2	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	CNGQ 12 07 08	CNGQ 452	3.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

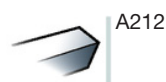
R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
	iC	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
12-2	1/2	5322 234-02	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾
16-2	5/8	5322 234-04	7.94	.312"	5513 020-07	5680 043-14 (20IP)	5412 032-031 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



Coromant Capto® cutting units

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

CCLNR/L -4

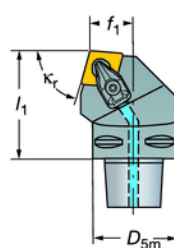
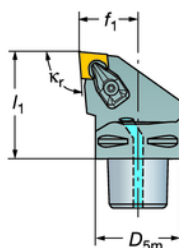
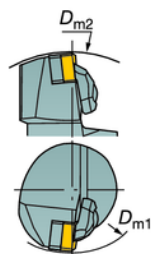
$\kappa_r 95^\circ$
-5°

CCRNR/L -4


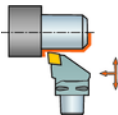
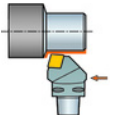
$\kappa_r 75^\circ$
15°



CNG



Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)										Gauge inserts				Nm ³⁾
				D _{5m}	D _{m1} min mm ⁴⁾	D _{m1} min in. ⁴⁾	D _{m2} min mm. ⁴⁾	D _{m2} min in. ⁴⁾	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _S ²⁾	ISO	ANSI		
	12	1/2	C4-CCLNR/L-27050-12-4	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6° -6°	CNGN 12 07 08	CNG 452	3.9		
			C5-CCLNR/L-35060-12-4	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	CNGN 12 07 08	CNG 452	3.9		
			C6-CCLNR/L-45065-12-4	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	CNGN 12 07 08	CNG 452	3.9		
	16	5/8	C5-CCLNR/L-35060-16-4	50	125	4.921	165	6.496	35.0	1.378	60.0	2.362	-6° -6°	CNGN 16 07 12	CNG 553	6.4		
			C6-CCLNR/L-45065-16-4	63	125	4.921	190	7.480	45.0	1.772	65.0	2.559	-6° -6°	CNGN 16 07 12	CNG 553	6.4		
	12	1/2	C4-CCRNR/L-22050-12-4	40			140	5.512	22.0	.866	50.0	1.968	-6° -6°	CNGN 12 07 08	CNG 452	3.9		
			C5-CCRNR/L-27060-12-4	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	CNGN 12 07 08	CNG 452	3.9		
			C6-CCRNR/L-35065-12-4	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	CNGN 12 07 08	CNG 452	3.9		
	16	5/8	C5-CCRNR/L-27060-16-4	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	CNGN 16 07 12	CNG 553	6.4		
			C6-CCRNR/L-35065-16-4	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	CNGN 16 07 12	CNG 553	6.4		

1) γ = Rake angle (valid with flat insert).

2) λs = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness						
□	iC	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set	
12-4	1/2	5322 234-02	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾	
16-4	5/8	5322 234-04	7.94	.312"	5513 020-07	5680 043-14 (20IP)	5412 034-031 ¹⁾	

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A204



A470



G6



A2



J2

Coromant Capto® cutting units

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

DDJNR/L -2

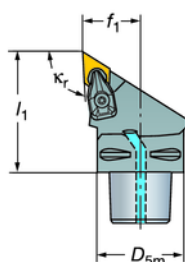
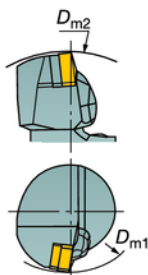
$\kappa_r 93^\circ$
 -3°

CDJNR/L -4

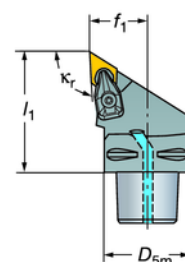
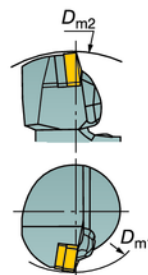
$\kappa_r 93^\circ$
 -3°




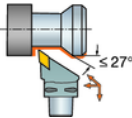
DNGQ
DNGA, DNMA


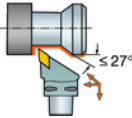


DNG



Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)												Gauge inserts			
				D _{5m}	D _{m1} min mm ⁴⁾	D _{m1} min in. ⁴⁾	D _{m2} min mm ⁴⁾	D _{m2} min in. ⁴⁾	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾		
	15	1/2	C5-DDJNR/L-35060-15-2	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6°	-7°	DNGQ 15 07 08	DNGQ 452	3.9		
			C6-DDJNR/L-45065-15-2	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6°	-7°	DNGQ 15 07 08	DNGQ 452	3.9		

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)												Gauge inserts			
				D _{5m}	D _{m1} min mm ⁴⁾	D _{m1} min in. ⁴⁾	D _{m2} min mm ⁴⁾	D _{m2} min in. ⁴⁾	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾		
	15	1/2	C5-CDJNR/L-35060-15-4	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6°	-7°	DNGN 15 07 08	DNG 452	3.9		
			C6-CDJNR/L-45065-15-4	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6°	-7°	DNGN 15 07 08	DNG 452	3.9		

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

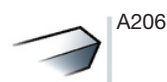
Main spare parts

Insert size							
	iC	Shim	For insert thickness		Shim screw	Key (Torx Plus)	Complete clamp set
15-2	1/2 (-2)	5322 266-03	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾
15-4	5/8 (-4)	5322 266-03	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A206



A470



G6



A2



J2

Coromant Capto® cutting units

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

DSRNR/L -2

κ_r 75°
15°

DSKNR/L -2

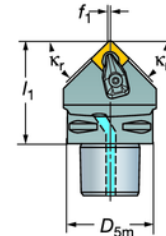
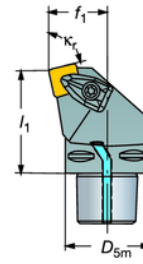
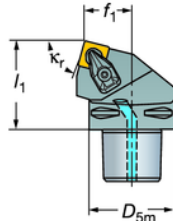
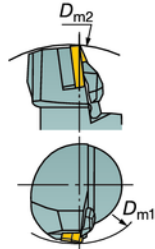
κ_r 75°
15°

DSDNN -2

κ_r 45°
45°


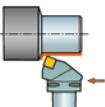
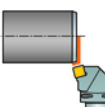
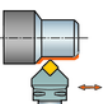


SNGQ
SNGA, SNMA



Neutral

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)										Gauge inserts			
				D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm. ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ^1	λ_s^2	ISO	ANSI	Nm ³⁾
	12	1/2	C4-DSRNR/L-22050-12-2	40			140	5.512	22.0	.866	50.0	1.968	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
			C5-DSRNR/L-27060-12-2	50			165	6.496	27.0	1.063	60.0	2.362	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
			C6-DSRNR/L-35065-12-2	63			190	7.480	35.0	1.378	65.0	2.559	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
	12	1/2	C4-DSKNR/L-27050-12-2	40	110	4.331			27.0	1.063	50.0	1.968	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
			C5-DSKNR/L-35060-12-2	50	110	4.331			35.0	1.378	60.0	2.362	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
			C6-DSKNR/L-45065-12-2	63	110	4.331			45.0	1.772	65.0	2.559	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
	12	1/2	C4-DSDNN-00050-12-2	40			140	5.512	0.3	.012	50.0	1.968	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
			C5-DSDNN-00060-12-2	50			165	6.496	0.3	.012	60.0	2.362	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9
			C6-DSDNN-00065-12-2	63			190	7.480	0.3	.012	65.0	2.559	-6°	-6°	SNGQ 12 07 08	SNGQ 452	3.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

N = Neutral

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
□	iC	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
12-2	1/2	5322 425-02	7.94	.312"	5513 020-02	5680 049-01 (151P)	5412 032-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A219



A473



G6



A2



J2

Coromant Capto® cutting units

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

CSRR/L -4

κ_r 75°
15°

CSKNR/L -4

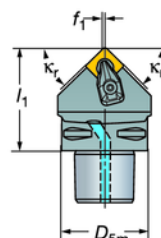
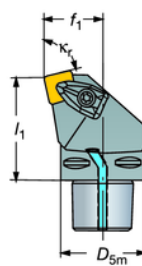
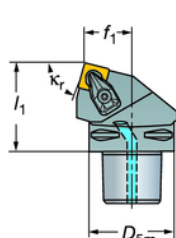
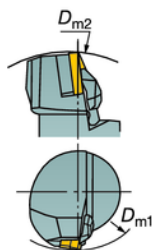
κ_r 75°
15°

CSDNN -4

κ_r 45°
45°


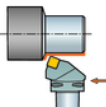
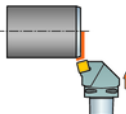
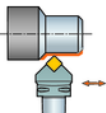


SNG



Neutral

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)										Gauge inserts		Nm ³⁾
				D _{5m}	D _{m1} min mm ⁴⁾	D _{m1} min in. ⁴⁾	D _{m2} min mm. ⁴⁾	D _{m2} min in. ⁴⁾	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾	λ _s ²⁾	ISO	
	12	1/2	C4-CSRNR/L-22050-12-4	40			140	5.512	22.0	.866	50.0	1.968	-6° -6°	SNGN 12 07 08	SNG 452	3.9
			C5-CSRNR/L-27060-12-4	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	SNGN 12 07 08	SNG 452	3.9
			C6-CSRNR/L-35065-12-4	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	SNGN 12 07 08	SNG 452	3.9
	15	5/8	C5-CSRNR/L-27060-15-4	50			165	6.496	27.0	1.063	60.0	2.362	-6° -6°	SNGN 15 07 12	SNG 553	6.4
			C6-CSRNR/L-35065-15-4	63			190	7.480	35.0	1.378	65.0	2.559	-6° -6°	SNGN 15 07 12	SNG 553	6.4
	12	1/2	C4-CSKNR/L-27050-12-4	40	110	4.331			27.0	1.063	50.0	1.968	-6° -6°	SNGN 12 07 08	SNG 452	3.9
			C5-CSKNR/L-35060-12-4	50	110	4.331			35.0	1.378	60.0	2.362	-6° -6°	SNGN 12 07 08	SNG 452	3.9
			C6-CSKNR/L-45065-12-4	63	110	4.331			45.0	1.772	65.0	2.559	-6° -6°	SNGN 12 07 08	SNG 452	3.9
	12	1/2	C4-CSDNN-00050-12-4	40			140	5.512	0.3	.012	50.0	1.968	-6° -6°	SNGN 12 07 08	SNG 452	3.9
			C5-CSDNN-00060-12-4	50			165	6.496	0.3	.012	60.0	2.362	-6° -6°	SNGN 12 07 08	SNG 452	3.9
			C6-CSDNN-00065-12-4	63			190	7.480	0.3	.012	65.0	2.559	-6° -6°	SNGN 12 07 08	SNG 452	3.9
	15	5/8	C5-CSDNN-00060-15-4	50			165	6.496	0.5	.020	60.0	2.362	-6° -6°	SNGN 15 07 12	SNG 553	6.4
			C6-CSDNN-00065-15-4	63			190	7.480	0.5	.020	65.0	2.559	-6° -6°	SNGN 15 07 12	SNG 553	6.4

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

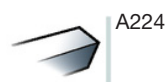
N = Neutral

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

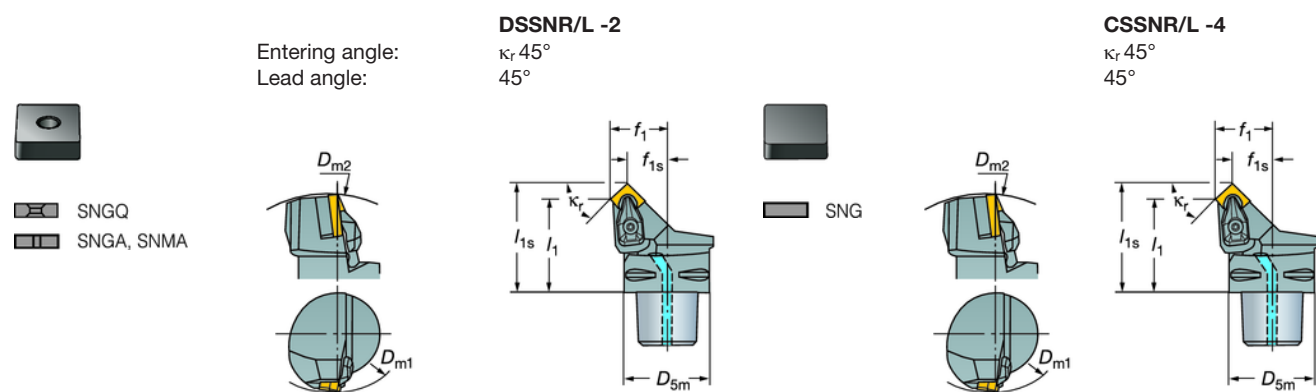
Insert size		For insert thickness					
\square	i/C	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
12-4	1/2	5322 425-02	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾
15-4	5/8	5322 425-05	7.94	.312"	5513 020-07	5680 043-14 (20IP)	5412 034-031 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



Coromant Capto® cutting units

CoroTurn® RC rigid clamp design for ceramic inserts



Right hand style shown unless otherwise stated

Main application			iC	Ordering code	Dimensions, mm, inch										Gauge inserts		
					D _{5m}	D _{m1} min ⁴⁾	D _{m2} min ⁴⁾	f ₁	f _{1s}	l ₁	l _{1s}	γ ¹⁾	λ _s ²⁾		ISO	ANSI	Nm ³⁾
	12	1/2	C4-DSSNR/L-27042-12-2	40	110	140	27	18.7	42	50.3	-8°	0°	0.4	SNGQ 12 07 08	SNGQ 452	3.9	
			C5-DSSNR/L-35052-12-2	50	110	165	35	26.7	52	60.3	-8°	0°	0.7				
			C6-DSSNR/L-45056-12-2	63	110	190	45	36.7	56	64.3	-8°	0°	1.1				
					4.331	7.480	1.772	1.445	2.205	2.532							
Main application			iC	Ordering code	Dimensions, mm, inch										Gauge inserts		
					D _{5m}	D _{m1} min ⁴⁾	D _{m2} min ⁴⁾	f ₁	f _{1s}	l ₁	l _{1s}	γ ¹⁾	λ _s ²⁾		ISO	ANSI	Nm ³⁾
	12	1/2	C4-CSSNR/L-27042-12-4	40	110	140	27	18.7	42	50.3	-8°	0°	0.4	SNGN 12 07 08	SNG 452	3.9	
			C5-CSSNR/L-35052-12-4	50	110	165	35	26.7	52	60.3	-8°	0°	0.7				
			C6-CSSNR/L-45056-12-4	63	110	190	45	36.7	56	64.3	-8°	0°	1.1				
					4.331	7.480	1.772	1.445	2.205	2.532							
	15	5/8	C5-CSSNR/L-35050-15-4	50	125	165	35	24.8	50	60.2	-8°	0°	0.7	SNGN 15 07 12	SNG 553	6.4	
			C6-CSSNR/L-45054-15-4	63	125	190	45	34.8	54	64.2	-8°	0°	1.1				
					4.921	7.480	1.772	1.37	2.126	2.528							

1) γ = Rake angle (valid with flat insert).

2) λs = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

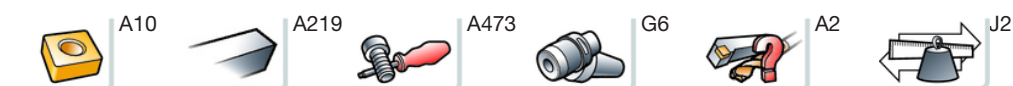
R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
iC		Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
12-2	1/2	5322 425-02	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



Coromant Capto® cutting units

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

DTG NR/L -2

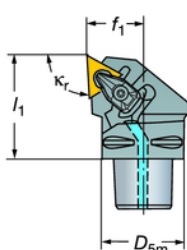
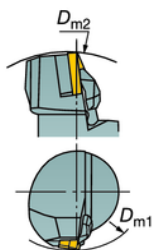
$\kappa_r 91^\circ$
 -1°

CTG NR/L -4

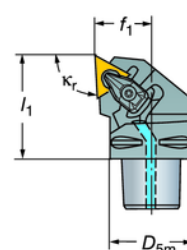
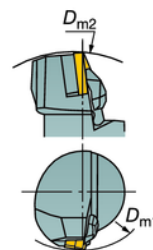
$\kappa_r 91^\circ$
 -1°




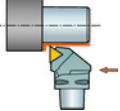

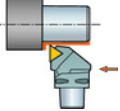
TNGA, TNMA



TNG



Right hand style shown unless otherwise stated

			Dimensions, millimeter, inch (mm, in.)												Gauge inserts		
Main application		iC	Ordering code	D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^1)$	$\lambda_s^2)$	ISO	ANSI	Nm ³⁾
	22	1/2	C4-DTG NR/L-27050-22-2	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6°	-6°	TNGA 22 04 08	TNGA 432	3.9
			C5-DTG NR/L-35060-22-2	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6°	-6°	TNGA 22 04 08	TNGA 432	3.9
			C6-DTG NR/L-45065-22-2	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6°	-6°	TNGA 22 04 08	TNGA 432	3.9
			Dimensions, millimeter, inch (mm, in.)												Gauge inserts		
Main application		iC	Ordering code	D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^1)$	$\lambda_s^2)$	ISO	ANSI	Nm ³⁾
	22	1/2	C4-CTG NR/L-27050-22-4	40	110	4.331	140	5.512	27.0	1.063	50.0	1.968	-6°	-6°	TNGN 22 04 08	TNG 432	3.9
			C5-CTG NR/L-35060-22-4	50	110	4.331	165	6.496	35.0	1.378	60.0	2.362	-6°	-6°	TNGN 22 04 08	TNG 432	3.9
			C6-CTG NR/L-45065-22-4	63	110	4.331	190	7.480	45.0	1.772	65.0	2.559	-6°	-6°	TNGN 22 04 08	TNG 432	3.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

N = Neutral

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

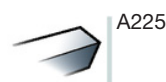
Main spare parts

Insert size							
Δ	iC	Shim	For insert thickness		Shim screw	Key (Torx Plus)	Complete clamp set
			mm	inch			
22-2	1/2-(-2)	5322 315-04	4.76	.187"	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾
22-4	1/2-(-4)	5322 315-04	4.76	.187"	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A225



A470



G6



A2



J2

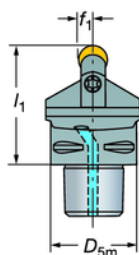
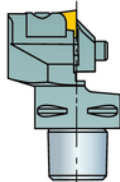
Coromant Capto® cutting units

T-Max® top clamp design for ceramic inserts

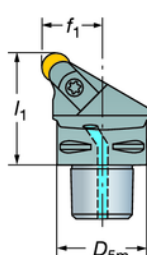
CRDCN

CRSCR/L

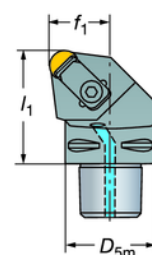
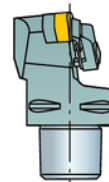
CRSNR/L



Neutral



RGA
RGA2



Right hand style shown unless otherwise stated

Main application	O	iC	Ordering code	Dimensions, millimeter, inch (mm, in.)						Gauge inserts	
				D _{5m}	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	γ ¹⁾ λ _s ²⁾	ISO	ANSI
	09	3/8	C5-CRDCN-00060-09AV	50	4.8	.1875	60.0	2.3622	0° 0°	RCGX 09 07 00	RCGX 35
	12	1/2	C5-CRDCN-00060-12AV	50	6.4	.250	60.0	2.3622	0° 0°	RCGX 12 07 00	RCGX 45
	09	3/8	C5-CRSCR/L-35060-09V	50	35.0	1.378	60.0	2.3622	0° 0°	RCGX 09 07 00	RCGX 35
	12	1/2	C5-CRSCR/L-35060-12V	50	35.0	1.378	60.0	2.3622	0° 0°	RCGX 12 07 00	RCGX 45
	09	3/8	C3-CRSNR/L-22040-09ID	32	22.0	.8661	40.0	1.5748	-6° -6°	RNGN 09 03 00	RNG 32
	12	1/2	C4-CRSNR/L-27050-12ID	40	27.0	1.063	50.0	1.9685	-6° -6°	RNGN 12 07 00	RNG 45
			C5-CRSNR/L-35060-12ID	50	35.0	1.378	60.0	2.3622	-6° -6°	RNGN 12 07 00	RNG 45
			C6-CRSNR/L-45065-12ID	63	45.0	1.7717	65.0	2.5591	-6° -6°	RNGN 12 07 00	RNG 45

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

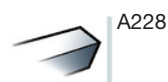
N = Neutral

Main spare parts

Insert size							
O	iC	Clamp	Clamp screw	Key (Torx Plus)			
09 (V, AV)	3/8 (V)	5412 100-01	3212 035-452	5680 043-16 (27IP)			
12 (V, AV)	1/2 (V)	5412 100-02	3212 036-504	5680 043-17 (30IP)			
O	iC	Clamp	Pressure plate	Key (mm)	Shim (For insert thickness)	Shim screw	Key (mm/Torx Plus)
09-ID	3/8(-ID)	5412 127-01	-	3021 010-040 (4.0)	5321 215-01 (7.97 mm, .313 inch)	3212 100-206	174.1-870 (2.0)
12-ID	1/2(-ID)	5412 125-01	5192-020-01	3021 010-040 (4.0)	5322 141-01 (7.97 mm, .313 inch)	5513 013-02	5680 043-14 (20IP)



A10



A228



A472



G6



A2



J2

Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts



CNGQ
CNGA, CNMA

Entering angle:
Lead angle:

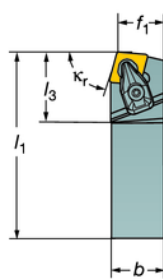
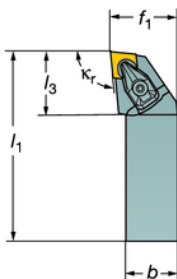
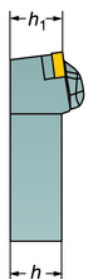
DCLNR/L -2

$\kappa_r 95^\circ$
-5°

DCBNR/L-2

DCRNR/L -2

$\kappa_r 75^\circ$
15°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	12	DCLNR/L 2525M 12-2	25	32	25	25	150	32	-6°	-6°	CNGQ 12 07 08	3.9
		DCLNR/L 3225P 12-2	25	32	32	32	170	32	-6°	-6°	CNGQ 12 07 08	3.9
	12	DCBNR/L 2525M 12-2	25	22	25	25	150	34.6	-6°	-6°	CNGQ 12 07 08	3.9
		DCBNR/L 3225P 12-2	25	22	32	32	170	34.6	-6°	-6°	CNGQ 12 07 08	3.9

Inch version

Main application	i/C	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/2	DCLNR/L 124B-2	.750	1.000	.750	.750	4.500	1.260	-6°	-6°	CNGQ 452	2.1
		DCLNR/L 164C-2	1.000	1.250	1.000	1.000	5.000	1.260	-6°	-6°	CNGQ 452	2.1
		DCLNR/L 164D-2	1.000	1.250	1.000	1.000	6.000	1.260	-6°	-6°	CNGQ 452	2.1
		DCLNR/L 204D-2	1.250	1.500	1.250	1.250	6.000	1.260	-6°	-6°	CNGQ 452	2.1
		DCLNR/L 244D-2	1.500	2.000	1.500	1.500	6.000	1.260	-6°	-6°	CNGQ 452	2.1
		DCLNR/L 854D-2	1.000	1.250	1.250	1.250	6.000	1.260	-6°	-6°	CNGQ 452	2.1
	1/2	DCRNR/L 124BM1-2	.750	.855	.750	.750	4.500	1.350	-6°	-6°	CNGQ 452	2.1
		DCRNR/L 164DM1-2	1.000	1.048	1.000	1.000	6.000	1.350	-6°	-6°	CNGQ 452	2.1
		DCRNR/L 204DM1-2	1.250	1.292	1.250	1.250	6.000	1.350	-6°	-6°	CNGQ 452	2.1
		DCRNR/L 244DM1-2	1.500	1.697	1.500	1.500	6.000	1.350	-6°	-6°	CNGQ 452	2.1

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
	i/C	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
12-2	1/2 (-2)	5322 234-02	7.94	.312	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾
16-2	5/8 (-2)	5322 234-04	7.94	.312	5513 020-07	5680 043-14 (20IP)	5412 032-031 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A200



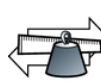
A473



G6



A2



J2

Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts



CNG

Entering angle:
Lead angle:

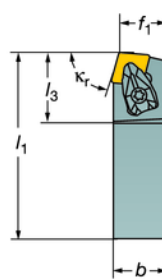
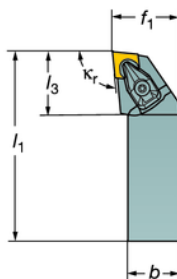
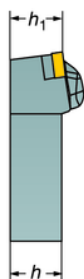
CCLNR/L -4

$\kappa_r 95^\circ$
-5°

CCBNR/L -4




CCRNRL/L -4

$\kappa_r 75^\circ$
15°

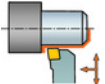
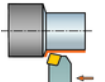


Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	$\gamma^{1)}$	$\lambda_s^{2)}$		
	12	CCLNR/L 2525M 12-4	25	32	25	25	150	32	-6°	-6°	CNGN 12 07 08	3.9
		CCLNR/L 3225P 12-4	25	32	32	32	170	32	-6°	-6°	CNGN 12 07 08	3.9
	16	CCLNR/L 2525M 16-4	25	32	25	25	150	39	-6°	-6°	CNGN 16 07 12	6.4
		CCLNR/L 3225P 16-4	25	32	32	32	170	39	-6°	-6°	CNGN 16 07 12	6.4
		CCLNR/L 3232P 16-4	32	40	32	32	170	39	-6°	-6°	CNGN 16 07 12	6.4
	12	CCBNR/L 2525M 12-4	25	22	25	25	150	34.6	-6°	-6°	CNGN 12 07 08	3.9
		CCBNR/L 3225P 12-4	25	22	32	32	170	34.6	-6°	-6°	CNGN 12 07 08	3.9
	16	CCBNR/L 3225P 16-4	25	22	32	32	170	41.6	-6°	-6°	CNGN 16 07 12	6.4

Inch version

Main application	iC	Ordering code	Dimensions, inch									Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾			
	1/2	CCLNR/L 124B-4	.750	1.000	.750	.750	4.500	1.260	-6°	-6°	CNG 452	2.1	
		CCLNR/L 164D-4	1.000	1.250	1.000	1.000	6.000	1.260	-6°	-6°	CNG 452	2.1	
		CCLNR/L 204D-4	1.250	1.500	1.250	1.250	6.000	1.260	-6°	-6°	CNG 452	2.1	
		CCLNR/L 244D-4	1.500	2.000	1.500	1.500	6.000	1.260	-6°	-6°	CNG 452	2.1	
		CCLNR/L 854D-4	1.000	1.250	1.250	1.250	6.000	1.260	-6°	-6°	CNG 452	2.1	
	5/8	CCLNR/L 205D-4	1.250	1.500	1.250	1.250	6.000	1.540	-6°	-6°	CNG 553	3.5	
		CCLNR/L 245D-4	1.500	2.000	1.500	1.500	6.000	1.540	-6°	-6°	CNG 553	3.5	
	1/2	CCRNR/L 124BM1-4	.750	.855	.750	.750	4.500	1.350	-6°	-6°	CNG 452	2.1	
		CCRNR/L 164DM1-4	1.000	1.048	1.000	1.000	6.000	1.350	-6°	-6°	CNG 452	2.1	
		CCRNR/L 204DM1-4	1.250	1.292	1.250	1.250	6.000	1.350	-6°	-6°	CNG 452	2.1	
		CCRNR/L 244DM1-4	1.500	1.697	1.500	1.500	6.000	1.350	-6°	-6°	CNG 452	2.1	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size								
	iC	Shim	For insert thickness		Shim screw	Key (Torx Plus)	Complete clamp set	
			mm	inch				
12-4	1/2 (-4)	5322 234-02	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾	
16-4	5/8 (-4)	5322 234-04	7.94	.312"	5513 020-07	5680 043-14 (20IP)	5412 034-031 ¹⁾	

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A204



A470



G6



A2



J2

Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts



DNGQ
DNGA, DNMA

Entering angle:
Lead angle:

DDJNR/L -2

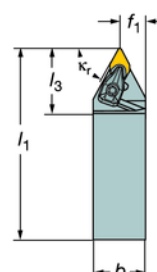
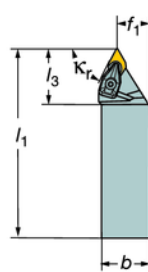
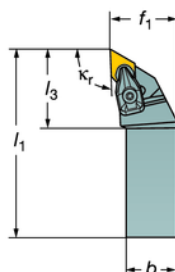
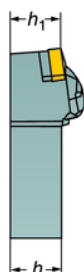
κ_r 93°
-3

DDNNR/L -2

κ_r 62.5°
27.5°

DDNNN -2

κ_r 62.5°
27.5°



Neutral

Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	15	DDJNR/L 2525M 15-2	25	32	25	25	150	39.4	-6°	-7°	DNGQ 15 07 08	3.9
		DDJNR/L 3225P 15-2	25	32	32	32	170	39.4	-6°	-7°	DNGQ 15 07 08	3.9
		DDJNR/L 3232P 15-2	32	40	32	32	170	39.4	-6°	-7°	DNGQ 15 07 08	3.9
	15	DDNNR/L 3225P 15-2	25	13	32	32	170	41.2	-6°	-7°	DNGQ 15 07 08	3.9
	15	DDNNN 5040T 15-2	40	20.5	50	50	300	40.8	-5°	-9°	DNGQ 15 07 08	3.9

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/2	DDJNR/L 164C-2	1.000	1.250	1.000	1.000	5.000	1.550	-6°	-7°	DNGQ 452	2.1
		DDJNR/L 164D-2	1.000	1.250	1.000	1.000	6.000	1.550	-6°	-7°	DNGQ 452	2.1
		DDJNR/L 204D-2	1.250	1.500	1.250	1.250	6.000	1.550	-6°	-7°	DNGQ 452	2.1
		DDJNR/L 244D-2	1.500	2.000	1.500	1.500	6.000	1.550	-6°	-7°	DNGQ 452	2.1

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

N = Neutral

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
	iC	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
15-2	1/2 (-2)	5322 266-03	7.94	.312"	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾

¹⁾ To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A206



A473



G6



A2



J2

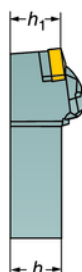
Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts



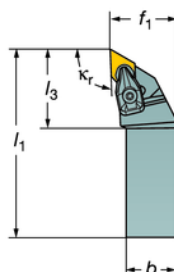
DNG

Entering angle:
Lead angle:



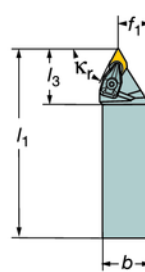
CDJNR/L -4

$\kappa_r 93^\circ$
 -3°



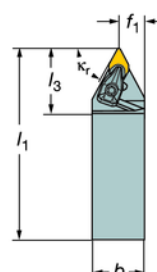
CDNNR/L -4

$\kappa_r 62.5^\circ$
 27.5°



CDNNN -4

$\kappa_r 62.5^\circ$
 27.5°



Neutral

Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ^1	$\lambda_s^{2)}$		
	15	CDJNR/L 2525M 15-4	25	32	25	25	150	39.4	-6°	-7°	DNGN 15 07 08	3.9
		CDJNR/L 3225P 15-4	25	32	32	32	170	39.4	-6°	-7°	DNGN 15 07 08	3.9
		CDJNR/L 3232P 15-4	32	40	32	32	170	39.4	-6°	-7°	DNGN 15 07 08	3.9
	15	CDNNR/L 3225P 15-4	25	13	32	32	170	41.2	-6°	-7°	DNGN 15 07 08	3.9
	15	CDNNN 5040T 15-4	40	20.5	50	50	300	40.8	-5°	-9°	DNGN 15 07 08	3.9

Inch version

Main application		iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
				b	f ₁	h	h ₁	l ₁	l ₃	γ^1	$\lambda_s^{2)}$		
	1/2		CDJNR/L 164D-4	1.000	1.250	1.000	1.000	6.000	1.550	-6°	-7°	DNG 452	2.1
			CDJNR/L 204D-4	1.250	1.500	1.250	1.250	6.000	1.550	-6°	-7°	DNG 452	2.1

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

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

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
	iC	Shim	mm inch		Shim screw	Key (Torx Plus)	Complete clamp set
15-4	1/2 (-4)	5322 266-03	7.94	.312	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A206



A470



G6



A2



J2

Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

DSKNR/L -2

 κ_r 75°
15°

DSRNR/L -2

 κ_r 75°
15°

DSBNR/L -2

 κ_r 75°
15°

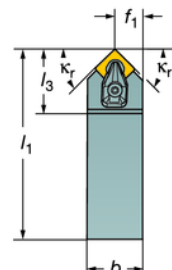
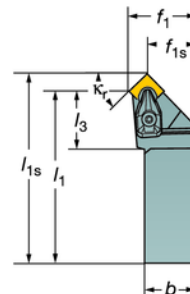
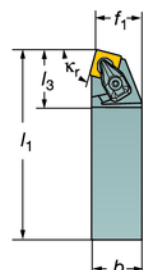
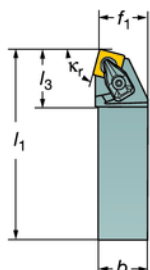
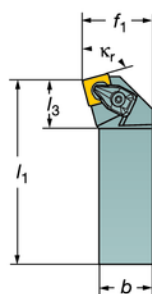
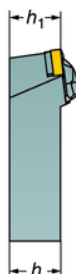
DSSNR/L -2

 κ_r 45°
45°

DSDNN -2

 κ_r 45°
45°


SNGQ
SNGA, SNMA



Right hand style shown unless otherwise stated

Neutral

Metric version

Main application	□	Ordering code	Dimensions, mm										Gauge inserts	Nm ³⁾
			b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ ¹⁾	λ _s ²⁾		
	12	DSKNR/L 2525M 12-2	25	32		25	25	150	23.6		-6°	-6°	SNGQ 12 07 08	3.9
		DSKNR/L 3225P12-2	25	32		32	32	170	23.7		-6°	-6°	SNGQ 12 07 08	3.9
	12	DSBNR/L 2525M 12-2	25	22		25	25	150	34.3		-6°	-6°	SNGQ 12 07 08	3.9
		DSRNR/L 2525M 12-2	25	27		25	25	150	34.3		-6°	-6°	SNGQ 12 07 08	3.9
		DSRNR/L 3225P 12-2	25	27		32	32	170	34.3		-6°	-6°	SNGQ 12 07 08	3.9
	12	DSSNR/L 2525M 12-2	25	32	23.7	25	25	150	27.5	158.3	-8°	0°	SNGQ 12 07 08	3.9
		DSSNR/L 3225P 12-2	25	32	23.7	32	32	170	27.5	178.3	-8°	0°	SNGQ 12 07 08	3.9
	12	DSDNN 2525M 12-2	25	12.8		25	25	150	36.5		-6°	-6°	SNGQ 12 07 08	3.9
		DSDNN 3225P 12-2	25	12.8		32	32	170	36.5		-6°	-6°	SNGQ 12 07 08	3.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

N = Neutral

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		Shim		For insert thickness		Shim screw	Key (Torx Plus)	Complete clamp set
□	iC			mm	inch			
12-2	1/2 (-2)	5322	425-02	7.94	.312	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.

A10



A207



A472



G6



A2



J2

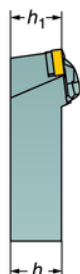
Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts

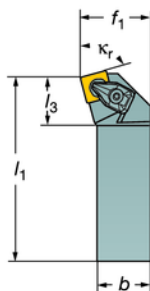


SNGQ
SNGA, SNMA

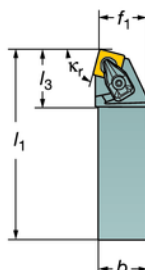
Entering angle:
Lead angle:



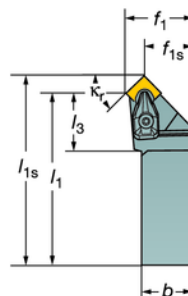
DSKNR/L -2
 $\kappa_r 75^\circ$
 15°



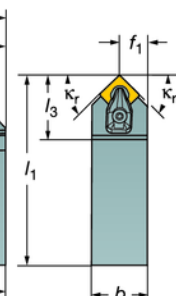
DSRNR/L -2
 $\kappa_r 75^\circ$
 15°



DSSNR/L -2
 $\kappa_r 45^\circ$
 45°



DSDNN -2
 $\kappa_r 45^\circ$
 45°



Right hand style shown unless otherwise stated

Neutral

Inch version

Main application	iC	Ordering code	Dimensions, inch										Gauge inserts	ft-lbs ³⁾
			b	f ₁	f _{1s}	h	h ₁	l ₁	l _{1s}	l ₃	$\gamma^1)$	$\lambda_s^{2)}$		
	1/2	DSKNR/L 164D-2	1.000	1.250		1.000	1.000	6.000		.930	-6°	-6°	SNGQ 452	2.1
	1/2	DSRNR/L 124BM1-2	.750	.855		.750	.750	4.500		1.350	-6°	-6°	SNGQ 452	2.1
		DSRNR/L 164DM1-2	1.000	1.048		1.000	1.000	6.000		1.350	-6°	-6°	SNGQ 452	2.1
		DSRNR/L 204DM1-2	1.250	1.292		1.250	1.250	6.000		1.350	-6°	-6°	SNGQ 452	2.1
	1/2	DSSNR/L 164D-2	1.000	1.250	.925	1.000	1.000	5.672	6.000	1.172	-8°	0°	SNGQ 452	2.1
	1/2	DSDNN 164D-2	1.000	.512		1.000	1.000	6.000		1.450	-6°	-6°	SNGQ 452	2.1

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

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

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size

12-2	iC	Shim	For insert thickness		Shim screw	Key (Torx Plus)	Complete clamp set
			mm	inch			
12-2	1/2 (-2)	5322 425-02	7.94	.312	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A207



A472



G6



A2



J2

Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts

Entering angle:
Lead angle:

CSKNR/L -4

$\kappa_r 75^\circ$
15°

CSRNR/L -4

$\kappa_r 75^\circ$
15°

CSBNR/L -4

$\kappa_r 75^\circ$
15°

CSDNN -4

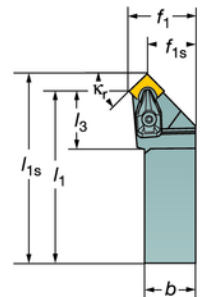
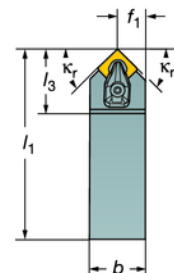
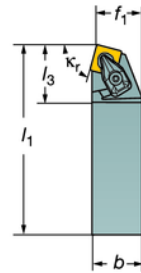
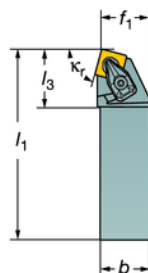
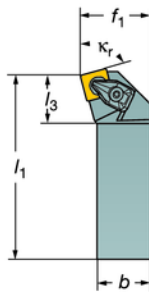
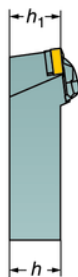
$\kappa_r 45^\circ$
45°

CSSNR/L -4

$\kappa_r 45^\circ$
45°



SNG



Neutral

Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm										Gauge inserts	Nm ³⁾
			b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	$\gamma^1)$	$\lambda_s^2)$		
	12	CSKNR/L 2525M 12-4	25	32		25	25	150	20.3		-6°	-6°	SNGN 12 07 08	3.9
	12	CSBNR/L 2525M 12-4	25	22		25	25	150	34.3		-6°	-6°	SNGN 12 07 08	3.9
		CSRNR/L 2525M 12-4	25	27		25	25	150	34.3		-6°	-6°	SNGN 12 07 08	3.9
		CSRNR/L 3225P 12-4	25	27		32	32	170	34.3		-6°	-6°	SNGN 12 07 08	3.9
	15	CSRNR/L 3225P 15-4	25	27		32	32	170	41.7		-6°	-6°	SNGN 15 07 12	6.4
	12	CSSNR/L 2525M 12-4	25	32	23.7	25	25	150	27.5	158.3	-8°	0°	SNGN 12 07 08	3.9
		CSSNR/L 3225P 12-4	25	32	23.7	32	32	170	27.5	178.3	-8°	0°	SNGN 12 07 08	3.9
	12	CSDNN 2525M 12-4	25	12.8		25	25	150	36.5		-6°	-6°	SNGN 12 07 08	3.9
		CSDNN 3225P 12-4	25	12.8		32	32	170	36.5		-6°	-6°	SNGN 12 07 08	3.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
	iC	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
12-4	1/2 (-4)	5322 425-02	7.94	.312	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾
15-4	5/8 (-4)	5322 425-05	7.94	.312	5513 020-07	5680 043-14 (20IP)	5412 034-031

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A10



A201



A470



G6



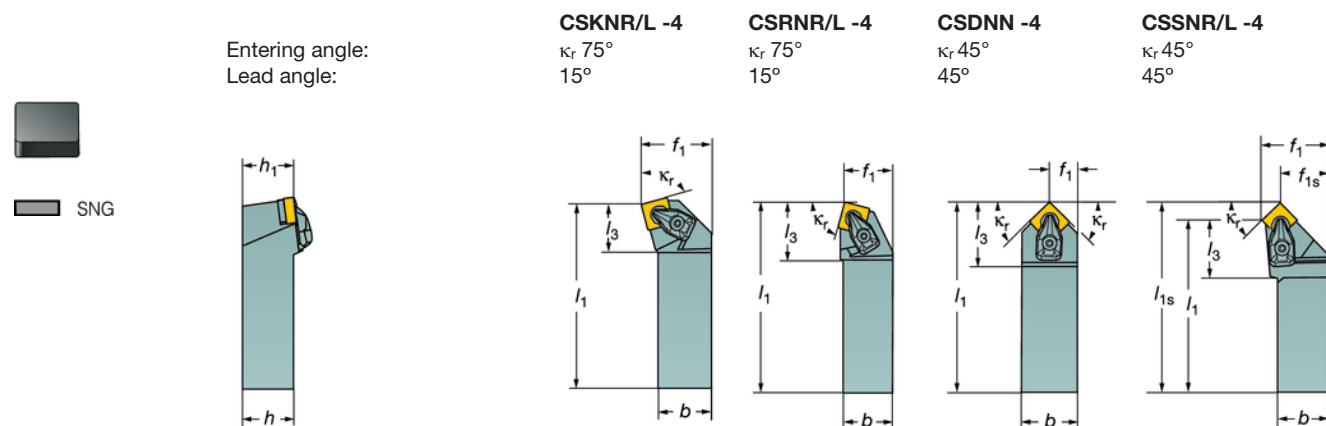
A2



J2

Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts



Neutral

Right hand style shown unless otherwise stated

Inch version

Main application	iC	Ordering code	Dime										Gauge inserts	ft-lbs ³⁾
			b	f ₁	f _{1s}	h	h ₁	l ₁	l _{1s}	l ₃	γ ¹⁾	λ _s ²⁾		
	1/2	CSKNR/L 164D-4	1.000	1.250		1.000	1.000	6.000		.930	-6°	-6°	SNG 452	
	1/2	CSRNR/L 124BM1-4	.750	.855		.750	.750	4.500		1.350	-6°	-6°	SNG 452	2.1
		CSRNR/L 164DM1-4	1.000	1.048		1.000	1.000	6.000		1.350	-6°	-6°	SNG 452	2.1
		CSRNR/L 204DM1-4	1.250	1.292		1.250	1.250	6.000		1.350	-6°	-6°	SNG 452	2.1
	5/8	CSRNR/L 165D-4	1.000	1.047		1.000	1.000	6.000		1.640	-6°	-6°	SNG 553	3.5
		CSRNR/L 855D-4	1.000	1.047		1.250	1.250	6.000		1.640	-6°	-6°	SNG 553	3.5
	1/2	CSSNR/L 164D-4	1.000	1.250	.925	1.000	1.000	5.672	6.000	1.172	-8°	0°	SNG 452	2.1
		CSSNL 854D-4	1.000	1.250	.921	1.250	1.250	6.000	6.327	1.075	-8°	0°	SNG 452	
	1/2	CSDNN 164D-4	1.000	.512		1.000	1.000	6.000		1.450	-6°	-6°	SNG 452	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

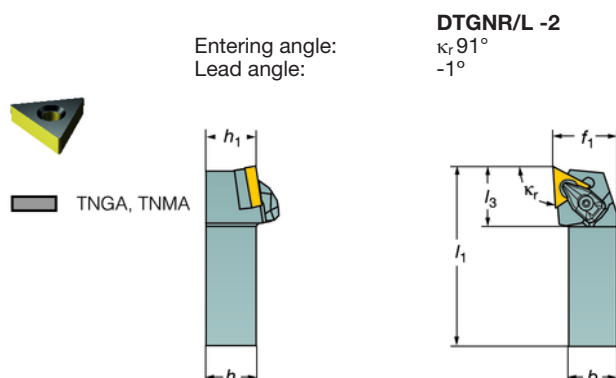
Insert size		For insert thickness					
	iC	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
12-4	1/2 (-4)	5322 425-02	7.94	.312	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾
15-4	5/8 (-4)	5322 425-05	7.94	.312	5513 020-07	5680 043-14 (20IP)	5412 034-031

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	22	DTG NR/L 3232P 22-2	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	TNGA 22 04 08	3.9
			32	40	32	32	170	33.1	-6°	-6°		

Inch version

Main application	i/C	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/2	DTG NR/L 204D-2	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	TNGA 432	2.1
			1.250	1.500	1.250	1.250	6.000	1.310	-6°	-6°		

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

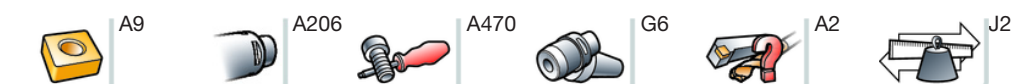
R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

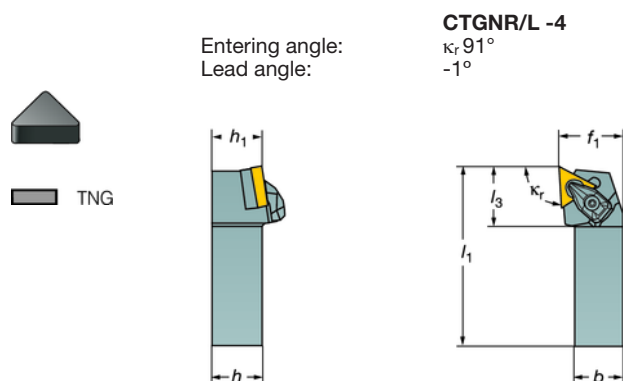
Insert size		For insert thickness					
	i/C	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
22-2	1/2 (-2)	5322 315-04	4.76	.187	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾
22-2	1/2 (-4)	5322 315-04	4.76	.187	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



Shank tools

CoroTurn® RC rigid clamp design for ceramic inserts



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	22	CTGNR/L 3232P 22-4	b	f ₁	h	h ₁	l ₁	l ₃	γ^1	$\lambda_s^{2)}$	TNGN 22 04 08	3.9
			32	40	32	32	170	33.1	-6°	-6°		

Inch version

Main application	i/C	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/2	CTGNR/L 204D-4	b	f ₁	h	h ₁	l ₁	l ₃	γ^1	$\lambda_s^{2)}$	TNG 432	2.1
			1.250	1.500	1.250	1.250	6.000	1.310	-6°	-6°		

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness					
	i/C	Shim	mm	inch	Shim screw	Key (Torx Plus)	Complete clamp set
22-2	1/2 (-2)	5322 315-04	4.76	.187	5513 020-02	5680 049-01 (15IP)	5412 032-021 ¹⁾
22-2	1/2 (-4)	5322 315-04	4.76	.187	5513 020-02	5680 049-01 (15IP)	5412 034-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



A9



A206



A470



G6



A2



J2

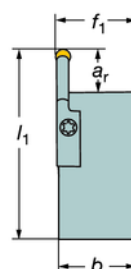
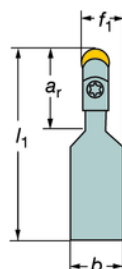
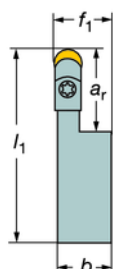
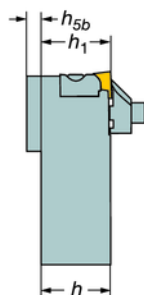
Shank tools

T-Max® top clamp design for ceramic inserts

CRDCR/L

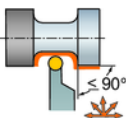
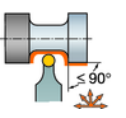

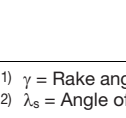
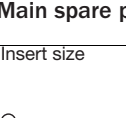
CRDCN

R/L 176.9

RCGX
RPGX

Neutral

Right hand style shown unless otherwise stated

Main application	iO	iC	Ordering code	Dimensions, mm, inch										Gauge inserts	
				a_r	b	f_1	h	h_1	h_{5b}	l_1	γ^1	λ_{s2}	ISO	ANSI	
	06	1/4	R/L176.9-3236-06	19.4	36.0	36.6	32.0	32.0		170.0	0°	0°	RCGX 06 06 00	RCGX 24	
				.764	1.417	1.441	1.260	1.260		6.693					
	09	3/8	CRDCR/L 3225P 09-A	29.5	25.0	25.8	32.0	32.0	6.1	170.0	0°	0°	RCGX 09 07 00	RCGX 35	
				1.161	.984	1.016	1.260	1.260	.240	6.693					
	12	1/2	CRDCR/L 3225P 12-A	38.5	25.0	25.9	32.0	32.0		170.0	0°	0°	RCGX 12 07 00	RCGX 45	
				1.516	.984	1.020	1.260	1.260		6.693					
	06	1/4	CRDCN 3225P 06-A	19.4	25.0	15.6	32.0	32.0	6.1	170.0	0°	0°	RCGX 06 06 00	RCGX 24	
				.764	.984	.614	1.260	1.260	.240	6.693					
	09	3/8	CRDCN 3225P 09-A	29	25.0	17.2	32.0	32.0	6.1	170.0	0°	0°	RCGX 09 07 00	RCGX 35	
				1.142	.984	.677	1.260	1.260	.240	6.693					
	12	1/2	CRDCN 3225P 12-A	38.5	25.0	18.8	32.0	32.0	6.1	170.0	0°	0°	RCGX 12 07 00	RCGX 45	
				1.516	.984	.740	1.260	1.260	.240	6.693					
			CRDCN 5040T 12-ID	30	40.0	26.4	50.0	50.0		300.0	0°	0°	RCGX 12 07 00	RCGX 45	
				1.181	1.575	1.039	1.968	1.968		11.811					
	15	5/8	CRDCN 5040T 15-ID	35	40.0	27.9	50.0	50.0		300.0	0°	0°	RCGX 15 10 00	RCGX 5(6.3)	
				1.378	1.575	1.098	1.968	1.968		11.811					
	19	3/4	CRDCN 5040T 19-ID	45	40.0	29.5	50.0	50.0		300.0	0°	0°	RCGX 19 10 00	RCGX 6(6.3)	
				1.772	1.575	1.161	1.968	1.968		11.811					
	25	1	CRDCN 5040T 25-ID	50	40.0	32.7	50.0	50.0		300.0	0°	0°	RCGX 25 12 00	RCGX 8(7.6)	
				1.968	1.575	1.287	1.968	1.968		11.811					

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size

iC	Clamp	Clamp screw	Key (Torx Plus/mm)
06	5412 105-01	3212 036-506	5680 043-17 (30IP)
06	5412 110-02	3212 036-506	5680 043-17 (30IP)
06	5412 110-01	3212 036-506	5680 043-17 (30IP)
09	5412 100-01	3212 035-452	5680 043-16 (27IP)
12	5412 100-02	3212 036-504	5680 043-17 (30IP)
15	5412 126-01	-	3021 010-040 (4.0)
19	5412 126-02	-	3021 010-040 (4.0)
25	5412 126-02	-	3021 010-040 (4.0)



A10



A210



I117



G6



A2



J2

Shank tools

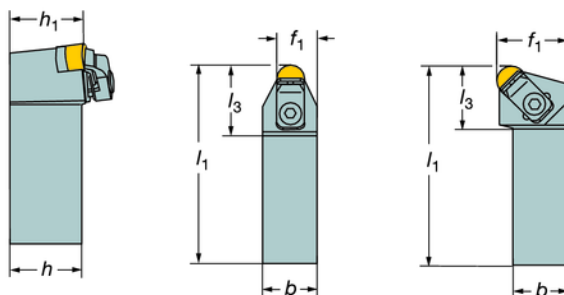
T-Max® top clamp design for ceramic inserts

CRDNN

CRSNR/L



RNG



Neutral

Right hand style shown unless otherwise stated

Main application	ISO	iC	Ordering code	Dimensions, mm, inch								Gauge inserts	
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI
	09	3/8	CRDNN 2525M 09-ID	25.0	17.3	25.0	25.0	150.0	30.0	-8°	0°	RNGN 09 03 00	RNG 32
				.984	.681	.984	.984	5.906	1.181				
	12	1/2	CRDNN 2525M 12-ID	25.0	18.8	25.0	25.0	150.0	32.0	-8°	0°	RNGN 12 07 00	RNG 45
			CRDNN 3225P 12-ID	25.0	18.8	32.0	32.0	170.0	32.0	-8°	0°	RNGN 12 07 00	RNG 45
	09	3/8	CRSNR/L 2525M 09-ID	25.0	32.0	25.0	25.0	150.0	28.0	-6°	-6°	RNGN 09 03 00	RNG 32
				.984	1.260	.984	.984	5.906	1.102				
	12	1/2	CRSNR/L 2525M 12-ID	25.0	32.0	25.0	25.0	150.0	28.0	-6°	-6°	RNGN 12 07 00	RNG 45
			CRSNR/L 3225P 12-ID	25.0	32.0	32.0	32.0	170.0	28.0	-6°	-6°	RNGN 12 07 00	RNG 45
				.984	1.260	1.260	1.260	6.693	1.102				
	15	5/8	CRSNR/L 3232P 15-ID	32.0	40.0	32.0	32.0	170.0	30.0	-6°	-6°	RNGN 15 07 00	RNG 55
				1.260	1.575	1.260	1.260	6.693	1.181				
	19	3/4	CRSNR/L 3232P 19-ID	32.0	40.0	32.0	32.0	170.0	32.0	-6°	-6°	RNGN 19 07 00	RNG 65
				1.260	1.575	1.260	1.260	6.693	1.260				
	25	1	CRSNR/L 5040T 25-ID	40.0	50.0	50.0	50.0	300.0	40.0	-6°	-6°	RNGN 25 07 00	RNG 85
				1.575	1.968	1.968	1.968	11.811	1.575				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

When using inserts with thickness 4.76 mm (.187 inch) optional shims must be ordered. See page A439.

Main spare parts

Insert size		For insert thickness							
ISO	iC	Clamp	Pressure plate	Key (mm)	Shim	mm	inch	Shim screw	Key (mm/Torx Plus)
09	3/8	5412 127-01	-	3021 010-040 (4.0)	5321 215-01	3.18	.125	3212 100-206	174.1-870 (2.0)
12	1/2	5412 125-01	5192 020-01	3021 010-040 (4.0)	5322 141-01	7.97	.314	5513 013-02	5680 043-14 (20IP)
15	5/8	5412 125-01	5192 020-01	3021 010-040 (4.0)	5321 215-02	7.97	.314	3212 100-206	174.1-870 (2.0)
19	3/4	5412 125-01	5192 020-01	3021 010-040 (4.0)	5321 215-03	7.97	.314	3212 100-257	174.3-863 (2.5)
25	1	5412 125-02	5192 020-01	3021 010-040 (4.0)	5322 141-05	7.97	.314	5513 013-03	174.1-864 (3.0)



A10



A210



A475



G6



A2



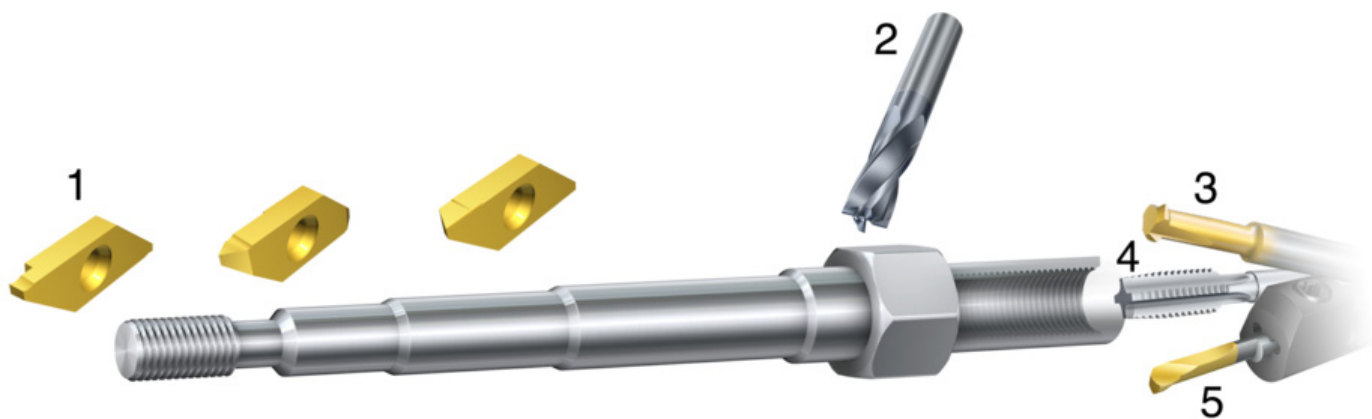
J2

Small part machining

Fine mechanical engineering in automatic sliding head machines

Tools for small part machining are designed for high precision machining in automatic sliding head machines within the automotive, watch, connector and medical industry.

Component diameter 1-8 mm (.039-.315 inch)



1 CoroCut® XS

Precision turning, parting and grooving and threading of small components. See page B85.

3 CoroMill® 326

Solid end mill
Chamfer and threading applications
From 5.8 mm (.228 inch)

4 CoroTap™

Metric, UN, G and NPT thread forms from M1.size.

5 CoroTurn® XS

For internal turning of small components from 0.3 mm (.012 inch) diameter bore. Includes tools for grooving and threading. See page A325.

2 CoroMill® Plura

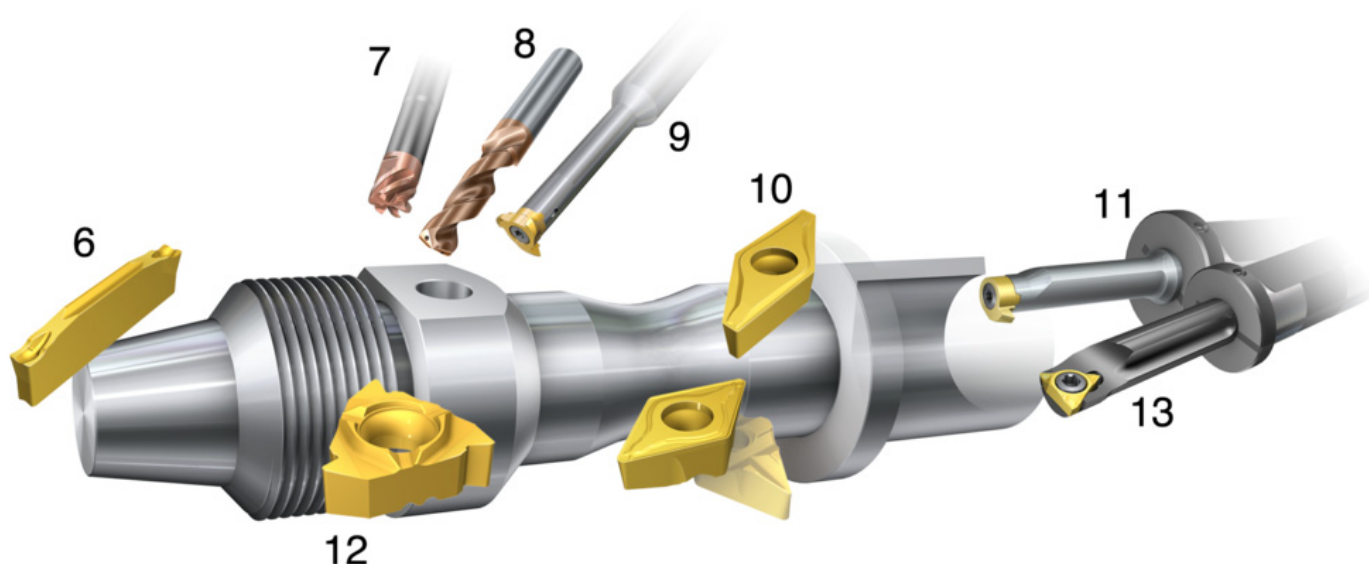
30High precision solid carbide milling cutters in a variety of diameters and geometries. Available in diameters from 0.4 mm (.016 inch).



CoroMill® 325

Thread whirling cutter for threading of long slender components.

Component diameter 6-32 mm (.236-1.260 inch)



6 CoroCut®

1-2 edge and CoroCut® 3 edge inserts for productive parting and grooving. See page B14.

7 CoroMill® 316

Exchangeable milling heads from diameter 10 mm (.394 inch).

9 CoroMill® 327

Slot and thread milling for holes over diameter 10 mm (.394 inch).

10 CoroTurn® 107

Precision inserts for external turning and copying. See page A45.

11 CoroCut® MB

Precision internal grooving, turning and threading from 10 mm (.394 inch) bore. See page B92.

12 CoroThread® 266

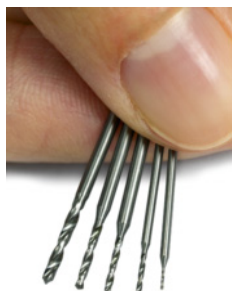
Productive thread turning programme. See page C9.

13 CoroTurn® 107

For internal turning of small components from 6 mm (.375 inch) diameter bore. See page A279.

8 CoroDrill® Delta-C

Available in diameters from 0.3 mm.

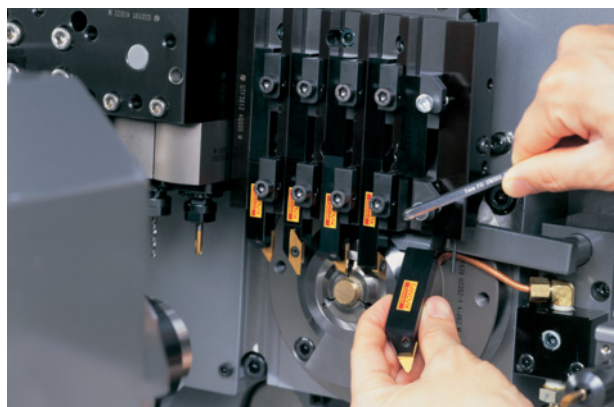


CoroTurn QS™ holding system

QS™ holding system - external

The QS holding system is a quick change tool holder to maximise effective production time in sliding head machines. Conventional wedges can be replaced easily without making any modification to the machine and are available in CoroTurn 107, T-Max P lever design, CoroCut XS, CoroCut 1-2, CoroCut 3 and CoroThread 266.

Combining the quick change capability of the QS holding system with high precision coolant – a first for sliding head machines. QS HP provides problem-free production and improved component quality in the most demanding, long chipping materials. See page .



CoroTurn® 107 - External

For external turning operations with dedicated geometries. Wiper inserts for improved productivity. The unique VCEX-geometry for small to large components with sharp cutting edge and Wiper effect to improve productivity. See page A227.

CoroTurn® XS - Internal

Produce precision holes for turning grooving and threading applications. A unique clamping system makes it reliable and easy to use. See page B92.



CoroCut® MB - Internal

High precision grooving, turning and threading system using both steel and carbide boring bars. See page B92.



Shank tools for small part machining

T-Max® P lever design

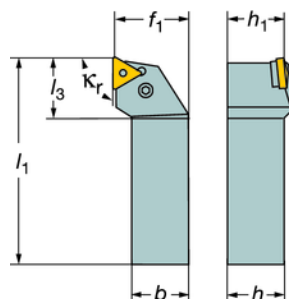


TNMM, TNMX
TNMG
TNMA, TNGA


Entering angle:
Lead angle:

PTGNR-S


$K_r 91^\circ$
 $- 1^\circ$



Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f_1	h	h_1	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$		
		PTGNR 1212K11-S	12	12	12	12	125	15.8	-6°	-6°	TNMG 11 03 04	2.0
		PTGNR 1616K11-S	16	16	16	16	125	15.8	-6°	-6°	TNMG 11 03 04	2.0

Inch version

Main application		iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
				b	f_1	h	h_1	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$		
		1/4	PTGNR 082C-S	.500	.500	.500	.500	5.000	.622	-6°	-6°	TNMG 221	1.5
			PTGNR 102C-S	.625	.625	.625	.625	5.000	.622	-6°	-6°	TNMG 221	1.5

1) γ = Rake angle (valid with flat insert).


2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand

Main spare parts

Insert size				
	iC	Lever	Screw	Key (mm)
11	1/4	174.3-846-1	174.3-829	170.3-864 (1.98)

Overview tools for small part machining, see page A110.



A10



A457



G6



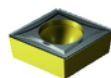
A2



J2

Shank tools for small part machining

CoroTurn® 107 screw clamp design



CCMT, CCGT
CCGX, CCET
CCMW

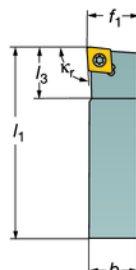
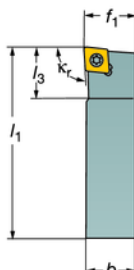
Entering angle:
Lead angle:

SCLCR/L -S

$\kappa_r 95^\circ$
 -5°

SCACR/L -S

$\kappa_r 90^\circ$
 0°



Right hand style shown unless otherwise stated

Metric version

Main application	iC	Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	06	SCLCR/L 0808K 06-S	8	8	8	8	125	8	0°	0°	CCMT 06 02 04	0.9
		SCLCR/L 1010K 06-S	10	10	10	10	125	10	0°	0°	CCMT 06 02 04	0.9
		SCLCR/L 1212K 06-S	12	12	12	12	125	12	0°	0°	CCMT 06 02 04	0.9
		SCLCR/L 1616K 06-S	16	16	16	16	125	16	0°	0°	CCMT 06 02 04	0.9
	09	SCLCR/L 1212K 09-S	12	12	12	12	125	12	0°	0°	CCMT 09 T3 08	3.0
		SCLCR/L 1616K 09-S	16	16	16	16	125	16	0°	0°	CCMT 09 T3 08	3.0
		SCACR/L 0808K 06-S	8	8	8	8	125	8	0°	0°	CCMT 06 02 04	0.9
		SCACR/L 1010K 06-S	10	10	10	10	125	10	0°	0°	CCMT 06 02 04	0.9
	09	SCACR/L 1212K 06-S	12	12	12	12	125	12	0°	0°	CCMT 06 02 04	0.9
		SCACR/L 1212K 09-S	12	12	12	12	125	12	0°	0°	CCMT 09 T3 08	3.0
		SCACR/L 1616K 09-S	16	16	16	16	125	16	0°	0°	CCMT 09 T3 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/4	SCLCR/L 062C-S	.375	.375	.375	.375	5.000	.375	0°	0°	CCMT 2(1.5)1	0.7
		SCLCR/L 082C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 2(1.5)1	0.7
		SCLCR/L 102C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 2(1.5)1	0.7
	3/8	SCLCR/L 083C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 3(2.5)2	2.2
		SCLCR/L 103C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 3(2.5)2	2.2
		SCLCR/L 123C-S	.750	.750	.750	.750	5.000	.750	0°	0°	CCMT 3(2.5)2	2.2
	1/4	SCACR/L 062C-S	.375	.375	.375	.375	5.000	.375	0°	0°	CCMT 2(1.5)1	0.7
		SCACR/L 082C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 2(1.5)1	0.7
		SCACR/L 102C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 2(1.5)1	0.7
	3/8	SCACR/L 083C-S	.500	.500	.500	.500	5.000	.500	0°	0°	CCMT 3(2.5)2	2.2
		SCACR/L 103C-S	.625	.625	.625	.625	5.000	.625	0°	0°	CCMT 3(2.5)2	2.2
		SCACR/L 123C-S	.750	.750	.750	.750	5.000	.750	0°	0°	CCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size

iC	Insert screw (thread)	Key (Torx Plus)
06 1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)
09 3/8	5513 020-09 (M3.5)	5680 049-01 (15IP)

Overview tools for small part machining, see page A110.



A10



A457



G6



A2



J2

Shank tools for small part machining

CoroTurn® 107 screw clamp design



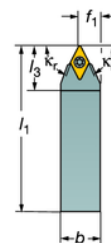
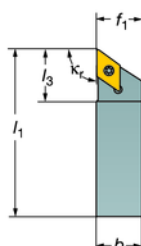
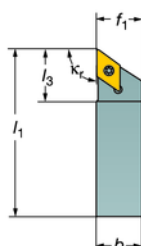
DCMT, DCMX
DCGT, DCGX, DCET
DCMW

Entering angle:
Lead angle:

SDJCR/L -S
 $\kappa_r 93^\circ$
 -3°

SDACR/L -S
 $\kappa_r 90^\circ$
 0°

SDPCN, SDNCN -S
 $\kappa_r 62.5^\circ$
 27.5°



Neutral

Right hand style shown unless otherwise stated

Metric version

Main application	iC	Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	07	SDJCR/L 0808K 07-S	8	8	8	8	125	12.7	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1010K 07-S	10	10	10	10	125	15	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1212K 07-S	12	12	12	12	125	15	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1616K 07-S	16	16	16	16	125	16	0°	0°	DCMT 07 02 04	0.9
		SDJCR/L 1212K 11-S	12	12	12	12	125	18	0°	0°	DCMT 11 T3 08	3.0
	07	SDJCR/L 1616K 11-S	16	16	16	16	125	20	0°	0°	DCMT 11 T3 08	3.0
		SDACL0808K 07-S	8	8	8	8	125	12.7	0°	0°	DCMT 07 02 04	0.9
		SDACR 0808K 07-S	8	8	8	8	125	12.7	0°	0°	DCMT 07 02 04	0.9
		SDACR/L 1010K 07-S	10	10	10	10	125	15	0°	0°	DCMT 07 02 04	0.9
		SDACR/L 1212K 07-S	12	12	12	12	125	15	0°	0°	DCMT 07 02 04	0.9
	11	SDACR/L 1212K 11-S	12	12	12	12	125	18	0°	0°	DCMT 11 T3 08	3.0
		SDACR/L 1616K 11-S	16	16	16	16	125	20	0°	0°	DCMT 11 T3 08	3.0
		SDNCN 1010K 07-S	10	5.2	10	10	125	15	0°	0°	DCMT 07 02 04	0.9
		SDNCN 1212K 11-S	12	6.2	12	12	125	21	0°	0°	DCMT 11 T3 08	3.0
		SDNCN 1616K 11-S	16	8.5	16	16	125	21	0°	0°	DCMT 11 T3 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/4	SDJCR/L 062C-S	.375	.375	.375	.375	5.000	.590	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 082C-S	.500	.500	.500	.500	5.000	.670	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 102C-S	.625	.625	.625	.625	5.000	.670	0°	0°	DCMT 2(1.5)1	0.7
		SDJCR/L 083C-S	.500	.500	.500	.500	5.000	.940	0°	0°	DCMT 3(2.5)2	2.2
		SDJCR/L 103C-S	.625	.625	.625	.625	5.000	.940	0°	0°	DCMT 3(2.5)2	2.2
	3/8	SDJCR/L 123C-S	.750	.750	.750	.750	5.000	.940	0°	0°	DCMT 3(2.5)2	2.2
		SDACR/L 062C-S	.375	.375	.375	.375	5.000	.500	0°	0°	DCMT 2(1.5)1	0.7
		SDACR/L 082C-S	.500	.500	.500	.500	5.000	.500	0°	0°	DCMT 2(1.5)1	0.7
		SDACR/L 102C-S	.625	.625	.625	.625	5.000	.625	0°	0°	DCMT 2(1.5)1	0.7
		SDACR/L 083C-S	.500	.500	.500	.500	5.000	.750	0°	0°	DCMT 3(2.5)2	2.2
	3/8	SDACR/L 103C-S	.625	.625	.625	.625	5.000	.750	0°	0°	DCMT 3(2.5)2	2.2
		SDACR/L 123C-S	.750	.750	.750	.750	5.000	.750	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 083C-S	.500	.251	.500	.500	5.000	.830	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 103C-S	.625	.331	.625	.625	5.000	.830	0°	0°	DCMT 3(2.5)2	2.2
		SDPCN 123C-S	.750	.394	.750	.750	5.000	.830	0°	0°	DCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

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

Main spare parts

Insert size

iC	Insert screw (thread)	Key (Torx Plus)
07 1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)
11 3/8	5513 020-09 (M3.5)	5680 049-01 (15IP)

Overview tools for small part machining, see page A110.



A10



A457



G6



A2



J2

Shank tools for small part machining

CoroTurn® 107 screw clamp design

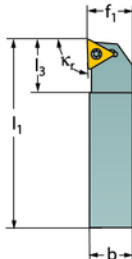


TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Entering angle:
Lead angle:

STJCR/L -S

$\kappa_r 93^\circ$
 -3°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	11	STJCR/L 1010K 11-S	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	TCMT 11 02 04	0.9
		STJCR/L 1212K 11-S	10	10	10	10	125	16	0°	0°	TCMT 11 02 04	0.9
		STJCR/L 1616K 11-S	12	12	12	12	125	16	0°	0°	TCMT 11 02 04	0.9
			16	16	16	16	125	16	0°	0°	TCMT 11 02 04	0.9

Inch version

Main application	i/C	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	STJCR/L 062C-S	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	TCMT 2(1.5)1	0.7
		STJCR/L 082C-S	.375	.375	.375	.375	5.000	.630	0°	0°	TCMT 2(1.5)1	0.7
		STJCR/L 102C-S	.500	.500	.500	.500	5.000	.630	0°	0°	TCMT 2(1.5)1	0.7
			.625	.625	.625	.625	5.000	.630	0°	0°	TCMT 2(1.5)1	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size

	i/C	Insert screw (thread)	Key (Torx Plus)
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)

Overview tools for small part machining, see page A110.



A10



A457



G6



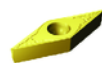
A2



J2

Shank tools for small part machining

CoroTurn® 107 screw clamp design

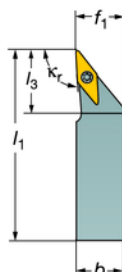


VBMT, VBG
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW

Entering angle:
Lead angle:

SVJBR/L -S

$\kappa_r 93^\circ$
 -3°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	11	SVJBR/L 0810K 11-S-B1	10	10	8	8	125	26	0°	0°	VBMT 11 03 04	0.9
		SVJBR/L 1010K 11-S-B1	10	10	10	10	125	26	0°	0°	VBMT 11 03 04	0.9
		SVJBR/L 1212K 11-S-B1	12	12	12	12	125	26	0°	0°	VBMT 11 03 04	0.9
		SVJBR/L 1616K 11-S-B1	16	16	16	16	125	26	0°	0°	VBMT 11 03 04	0.9
		SVJBR/L 1010K 11-S	10	10	10	10	125	26	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 1212K 11-S	12	12	12	12	125	26	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 1616K 11-S	16	16	16	16	125	26	0°	0°	VBMT 11 02 04	0.9
		SVJBR/L 1212K 16-S	12	12	12	12	125	30	0°	0°	VBMT 16 04 08	3.0
	16	SVJBR/L 1616K 16-S	16	16	16	16	125	40	0°	0°	VBMT 16 04 08	3.0

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/4	SVJBR/L 062C-S-B1	.375	.375	.375	.375	5.000	.790	0°	0°	VBMT 221	0.7
		SVJBR/L 082C-S-B1	.500	.500	.500	.500	5.000	.790	0°	0°	VBMT 221	0.7
		SVJBR/L 102C-S-B1	.625	.625	.625	.625	5.000	.790	0°	0°	VBMT 221	0.7
		SVJBR/L 062C-S	.375	.375	.375	.375	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 082C-S	.500	.500	.500	.500	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVJBR/L 102C-S	.625	.625	.625	.625	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
	3/8	SVJBR/L 083C-S	.500	.500	.500	.500	5.000	1.610	0°	0°	VBMT 332	2.2
		SVJBR/L 103C-S	.625	.625	.625	.625	5.000	1.610	0°	0°	VBMT 332	2.2
		SVJBR/L 123C-S	.750	.750	.750	.750	5.000	1.610	0°	0°	VBMT 332	2.2

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ Insert tightening torque ft-lbs.

⁵⁾ B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size

	iC	Insert screw (thread)	Key (Torx Plus)
11	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)
16	3/8	5513 020-09 (M3.5)	5680 049-01 (15IP)

Overview tools for small part machining, see page A110.



A9



A456



G6



A2



J2

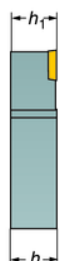
Shank tools for small part machining

CoroTurn® 107 screw clamp design

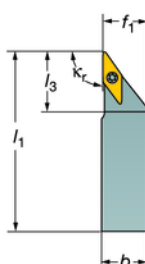


VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW

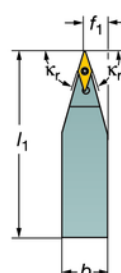
Entering angle:
Lead angle:



SVABR/L -S
 κ_r 90°
0°



SVBN -S
 κ_r 72.5°
17.5°



Neutral

Note: VCEX insert not suitable in SVBN holders
Right hand style shown unless otherwise stated

Metric version

Main application	iC	Ordering code ⁵⁾	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	11	SVABR/L 0810K 11-S-B1	10	10	8	8	125	26	0°	0°	VBMT 11 03 04	0.9
		SVABR/L 1010K 11-S-B1	10	10	10	10	125	26	0°	0°	VBMT 11 03 04	0.9
		SVABR/L 1212K 11-S-B1	12	12	12	12	125	26	0°	0°	VBMT 11 03 04	0.9
		SVABR/L 1616K 11-S-B1	16	16	16	16	125	26	0°	0°	VBMT 11 03 04	0.9
		SVABR/L 0810K 11-S	10	10	8	8	125	26	0°	0°	VBMT 11 02 04	0.9
		SVABR/L 1010K 11-S	10	10	10	10	125	26	0°	0°	VBMT 11 02 04	0.9
		SVABR/L 1212K 11-S	12	12	12	12	125	26	0°	0°	VBMT 11 02 04	0.9
		SVABR/L 1616K 11-S	16	16	16	16	125	26	0°	0°	VBMT 11 02 04	0.9
	16	SVABR/L 1212K 16-S	12	12	12	12	125	40	0°	0°	VBMT 16 04 08	3.0
		SVABR/L 1616K 16-S	16	16	16	16	125	40	0°	0°	VBMT 16 04 08	3.0
	11	SVBN 0808K 11-S-B1	8	4.3	8	8	125		0°	0°	VBMT 11 03 04	0.9
		SVBN 1010K 11-S-B1	10	5.3	10	10	125		0°	0°	VBMT 11 03 04	0.9
		SVBN 1212K 11-S-B1	12	6.3	12	12	125		0°	0°	VBMT 11 03 04	0.9
		SVBN 1616K 11-S-B1	16	8.3	16	16	125		0°	0°	VBMT 11 03 04	0.9

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1/4	SVABR/L 062C-S-B1	.375	.375	.375	.375	5.000	.790	0°	0°	VBMT 221	0.7
		SVABR/L 082C-S-B1	.500	.500	.500	.500	5.000	.790	0°	0°	VBMT 221	0.7
		SVABR/L 102C-S-B1	.625	.625	.625	.625	5.000	.790	0°	0°	VBMT 221	0.7
		SVABR/L 062C-S	.375	.375	.375	.375	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVABR/L 082C-S	.500	.500	.500	.500	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
		SVABR/L 102C-S	.625	.625	.625	.625	5.000	1.060	0°	0°	VBMT 2(1.5)1	0.7
	3/8	SVABR/L 083C-S	.500	.500	.500	.500	5.000	1.610	0°	0°	VBMT 332	2.2
		SVABR/L 103C-S	.625	.625	.625	.625	5.000	1.610	0°	0°	VBMT 332	2.2
	1/4	SVBN 062C-S-B1	.375	.190	.375	.375	5.000		0°	0°	VBMT 221	0.7
		SVBN 082C-S-B1	.500	.260	.500	.500	5.000		0°	0°	VBMT 221	0.7
		SVBN 102C-S-B1	.625	.363	.625	.625	5.000		0°	0°	VBMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

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

Main spare parts

Insert size

iC	Insert screw (thread)	Key (Torx Plus)
11 1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)
16 3/8	5513 020-09 (M3.5)	5680 049-01 (15IP)

Overview tools for small part machining, see page A110.



Shank tools for small part machining

Steel shank inch boring bars

For external machining

CoroTurn® 107 screw clamp design

Cylindrical with flats

Entering angle:

Lead angle:

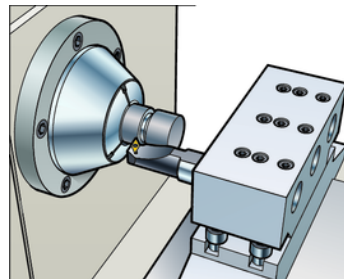
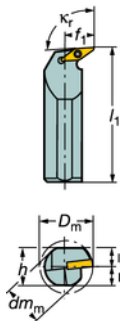
SVUBL

κ_r 93°

-3°



VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VCMW



Boring bars for external machining with diameters 19.05 mm (.750 inch) and 25.4 mm (1.000 inch) boring bar to be used in Swiss machines where inch sleeves are commonly used.

Left hand style shown

Main application		iC	Ordering code ⁴⁾	Dimensions, mm, inch								Gauge inserts		
				dm_m	$D_m \text{ min}$	f_1	l_1	h	γ^1	λ_s^2		ISO	ANSI	Nm ³⁾
	11	1/4	A12S-SVUBL 2-EB1	19.05	25.7	14.7	254	18.03	0°	-5°		VBMT 11 03 04	VBMT 221	0.9
				.750	1.012	.580	10.000	.710						
			A16T-SVUBL 2-DB1	25.4	31.5	17.3	304.8	23.11	0°	-3°		VBMT 11 03 04	VBMT 221	0.9
				1.000	1.240	.680	12.000	.910						

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

L = Left hand

Main spare parts

Insert size			
	iC	Insert screw	Key (Torx Plus)
11	1/4	5513 020-03	5680 051-02 (7IP)

Overview tools for small part machining, see page A110.



A9



G6



A2

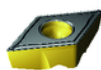
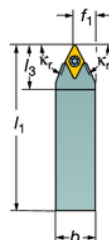
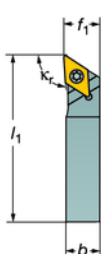


J2

CoroTurn® TR

Screw clamp design

Entering angle:
Lead angle:

$$\kappa_r 93^\circ - 3^\circ$$
 κ_r 62.5°
27.5° TR-DC

Neutral

Right hand style shown when nothing else is stated

Metric version

[illegible]

Inch version

[illegible]

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.


3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

	Insert screw	Key (Torx Plus)	Torque wrench
13	5513 020-01	5680 049-01 (15IP)	5680 100-06 (15IP)

Overview tools for small part machining, see page A110.



A9



A456



G6

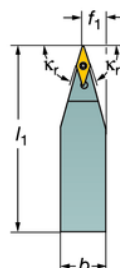
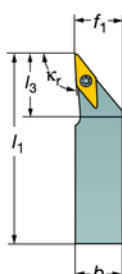


A2



J2

Screw clamp design

 κ_r 72.5° (17.5°)
17.5°

Neutral

Right hand style shown when nothing else is stated

Metric version

[illegible]

Inch version


[illegible]

N = Neutral

Abstract

4) Insert tightening torque ft-lbs.

Main spare parts

			
	Insert screw	Key (Torx Plus)	Torque wrench
13	5513 020-64	5680 049-04 (10IP)	5680 100-05 (15IP)

Overview tools for small part machining, see page A110.



QS™ holding system

To maximise active production time in sliding head machines

QS™-HP for problem-free production and improved component quality

Faster tool changes, increased productivity

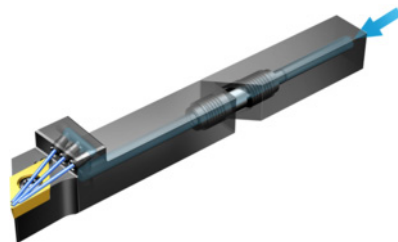
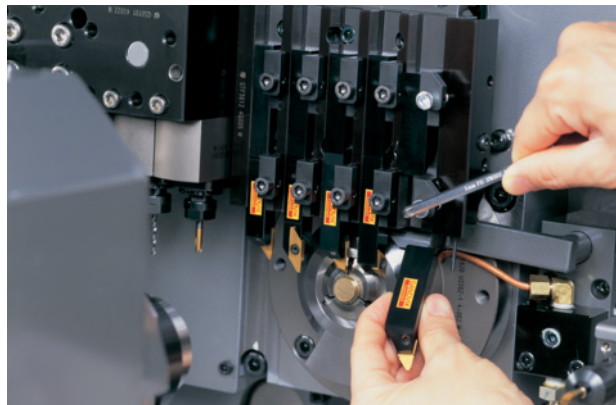
Save time compared to conventional systems

- Clamping and release achieved by turning one screw only
- Insert edge position set up immediately on placement of the short holder against the stop
- Spring loaded wedge secures holder when changing to eliminate problems of dropping the holder into the machine
- Reduce insert indexing downtime from three minutes to one minute

No modification of tool post is needed. Just replace with QS holding system consisting of

- 2 spring loaded QS wedges
- Short QS holder for different applications
- QS stop

Available for Citizen, Star, Tsugami, Tornos and Nexturn machines.



How to use QS holding system

- Remove conventional wedge
- Replace with 2 x QS wedges
- Adjust insert edge position and clamp short holder with QS wedge close to the guide bush
- Clamp stop in contact with short holder using other wedge

QS short holders are available for the following applications

- T-Max® P for general turning
- CoroTurn 107® for general turning
- CoroCut® 1-2 and 3 for parting & grooving
- CoroThread 266® for threading
- CoroCut® XS for turning, parting & grooving and threading

QS holders with high precision coolant

Combining the quick change capability of the QS holding system with high pressure coolant – a first for sliding head machines. QS HP provides problem-free production and improved component quality in the most demanding, long-chipping materials.

QS are available for the following applications

- CoroTurn 107® for general turning
- CoroCut® 1-2 and 3 for parting & grooving
- CoroCut® XS for turning, parting & grooving and threading

See page A233

See page A237

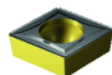
Short holder for QS™ holding system

With high precision coolant

General turning

CoroTurn® 107 screw clamp design

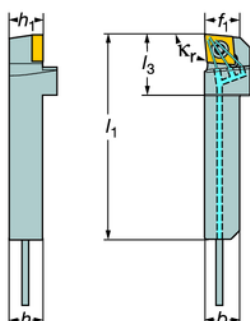
Entering angle:
Lead angle



CCMT, CCGT
CCGX, CCET
CCMW

QS- SCLCR-HP

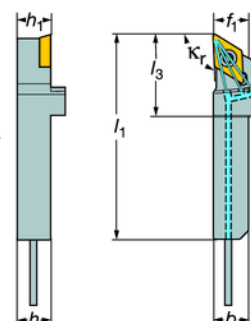
$\kappa_r 95^\circ$
 -5°



DCMT, DCMX
DCGT, DCGX, DCET
DCMW

QS- SDJCR-HP

$\kappa_r 93^\circ$
 -3°

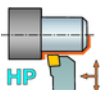



For QS-wedge, see page A249.

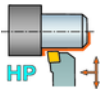
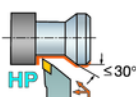
For QS-stop, see page A247.

Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	06	QS-SCLCR1212E09HP	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	CCMT 06 02 04	0.9
			12	12	12	12	70	21	0°	0°		
Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	07	QS-SDJCR1012E07HP	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	DCMT 07 02 04	0.9
		QS-SDJCR1212E07HP	12	12	12	12	70	15	0°	0°	DCMT 07 02 04	0.9
	11	QS-SDJCR1212E11HP	12	12	12	12	70	27.5	0°	0°	DCMT 11 T3 08	3.0
		QS-SDJCR1616E11HP	16	16	16	16	70	27.5	0°	0°	DCMT 11 T3 08	3.0

Inch version

Main application		Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	QS-SCLCR083XHP	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	CCMT 3(2.5)2	2.2
			.500	.500	.500	.500	2.756	.827	0°	0°		
Main application		Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	QS-SDJCR06082XHP	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	DCMT 2(1.5)1	0.7
		QS-SDJCR082XHP	.500	.375	.375	.375	2.756	.827	0°	0°	DCMT 2(1.5)1	0.7
	3/8	QS-SDJCR083XHP	.500	.472	.500	.472	2.756	.591	0°	0°	DCMT 3(2.5)2	2.2
		QS-SDJCR103XHP	.500	.500	.500	.500	2.756	1.083	0°	0°	DCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand

Main spare parts

Insert size		Shank size					
	iC	Metric	Inch	Insert screw (thread)	Key (Torx Plus)	Nozzle (hole diameter, mm) ¹⁾	Coolant tube
09	3/8			5313 020-10 (M3.5)	5680 049-01 (15IP)	5691 026-13 (1.0)	5692 033-05
07	1/4	1012	06082	5313 020-03 (M2.5)	5680 051-02 (7IP)	5691 026-13 (1.0)	5692 033-04
07	1/4	1212	082	5313 020-03 (M2.5)	5680 051-02 (7IP)	5691 026-13 (1.0)	5692 033-05
11	3/8	1212-1616	083-103	5313 020-09 (M3.5)	5680 049-01 (15IP)	5691 026-13 (1.0)	5692 033-05

¹⁾For optional nozzles, see page A247.

Overview tools for small part machining, see page A110.



Short holder for QS™ holding system

With high precision coolant

General turning

CoroTurn® 107 screw clamp design

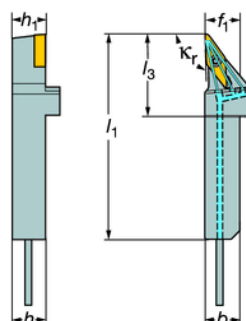
Entering angle:
Lead angle



VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW

QS-SVJCR/L

$\kappa_r 93^\circ$
 -3°



Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	11	QS-SVJCR/L1012E11HP	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	VBMT 11 03 04	0.9
		QS-SVJCR/L1212E11HP	12	10	10	10	70	28	0°	0°	VBMT 11 03 04	0.9
		QS-SVJCR/L1616E11HP	12	12	12	12	70	28	0°	0°	VBMT 11 03 04	0.9
			16	16	16	16	70	28	0°	0°	VBMT 11 03 04	0.9

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	QS-SVJCR/L06082XHP	b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	VBMT 221	0.7
		QS-SVJCR/L082XHP	.500	.375	.375	.375	2.756	1.102	0°	0°	VBMT 221	0.7
		QS-SVJCR/L102XHP	.500	.500	.500	.500	2.756	1.102	0°	0°	VBMT 221	0.7
			.625	.625	.625	.625	2.756	1.102	0°	0°	VBMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand

For QS-wedge, see page A249.

For QS-stop, see page A247.

Main spare parts

Insert size		Shank size		Insert screw (thread)		Key (Torx Plus)		Nozzle (hole diameter, mm) ¹⁾		Coolant tube	
	iC	Metric	Inch								
11	1/4	1012	06082	5513 020-03 (M2.5)		5680 051-02 (7IP)		5691 026-13 (1.0)		5692 033-04	
11	1/4	1212-1616	082-102	5513 020-03 (M2.5)		5680 051-02 (7IP)		5691 026-13 (1.0)		5692 033-05	

¹⁾For optional nozzles, see page A247.

Overview tools for small part machining, see page A110.



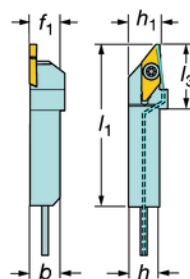
Short holder for QS™ holding system

With high precision coolant

Turning, parting, grooving and threading

CoroCut® XS screw clamp design

QS- SMALR/L



Right hand style shown

Metric version

Seat size ³⁾	Ordering code	Dimensions, mm						Gauge inserts	Nm ¹⁾
		b	f ₁	h	h ₁	l ₁	l ₃		
3	QS-SMALR/L1012E3HP	12	10.0	10	10	70	28.0	MAxL 3..	1.2
	QS-SMALR/L1212E3HP	12	12.0	12	12	70	28.0	MAxL 3..	1.2
	QS-SMALR/L1616E3HP	16	16.0	16	16	70	28.0	MAxL 3..	1.2

Inch version

Seat size ³⁾	Ordering code	Dimensions, inch						Gauge inserts	ft-lbs ²⁾
		b	f ₁	h	h ₁	l ₁	l ₃		
3	QS-SMALR/L06083XHP	.500	.375	.375	.375	2.756	1.102	MAxL 3..	0.9
	QS-SMALR/L083XHP	.500	.500	.500	.500	2.756	1.102	MAxL 3..	0.9
	QS-SMALR/L103XHP	.625	.625	.625	.625	2.756	1.102	MAxL 3..	0.9

¹⁾ Insert tightening torque Nm.

²⁾ Insert tightening torque ft-lbs.

³⁾ To correspond with seat size on insert.

R = Right hand, L = Left hand

For QS-wedge and QS-stop see page A248.

Main spare parts

Shank size					
Metric	Inch	Screw	Key (Torx Plus)	Nozzle (hole diameter, mm) ¹⁾	Coolant tube
1012	0608	5513 027-01	5680 046-01 (8IP)	5691 026-13 (1.0)	5692 033-04
1212-1616	083-103	5513 027-01	5680 046-01 (8IP)	5691 026-13 (1.0)	5692 033-05

¹⁾For optional nozzles, see page A247.

Overview tools for small part machining, see page A110.



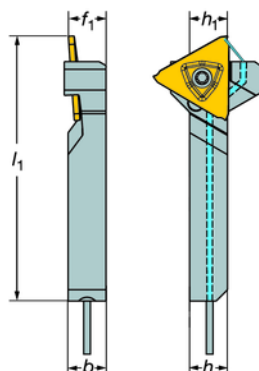
Short holder for QS™ holding system

With high precision coolant

Parting and grooving

CoroCut® 3-edge screw clamp design

QS-RF/LF123 T/U



Note! When using CoroCut® 3-edged insert the a_r of the insert gives the maximum depth of cut.

Right hand tool with right hand insert (T) shown.

Metric version

Main application	Seat size ¹⁾	Ordering code	Dimensions, mm					Gauge inserts	Nm ²⁾
			b	f_1	h	h_1	l_1		
	T	QS-RF123T06-1010BHP	10	10	10	10	70	N123T3-0150- CM	3.0
		QS-RF123T06-1212BHP	12	12	12	12	70	N123T3-0150- CM	3.0
		QS-RF123T06-1616BHP	16	16	16	16	70	N123T3-0150- CM	3.0
	U	QS-LF123U06-1010BHP	10	10	10	10	70	N123U3-0150- CM	3.0
		QS-LF123U06-1212BHP	12	12	12	12	70	N123U3-0150- CM	3.0
		QS-LF123U06-1616BHP	16	16	16	16	70	N123U3-0150- CM	3.0

Inch version

Main application	Seat size ¹⁾	Ordering code	Dimensions					Gauge inserts	ft-lbs ³⁾
			b	f_1	h	h_1	l_1		
	0T	QS-RF123T023-06BHP	.375	.375	.375	.375	2.75	N123T3-0150- CM	2.2
		QS-RF123T023-08BHP	.500	.500	.500	.500	2.75	N123T3-0150- CM	2.2
		QS-RF123T023-10BHP	.625	.625	.625	.625	2.75	N123T3-0150- CM	2.2
	0U	QS-LF123U023-06BHP	.375	.375	.375	.500	2.75	N123U3-0150- CM	2.2
		QS-LF123U023-08BHP	.500	.500	.500	.500	2.75	N123U3-0150- CM	2.2
		QS-LF123U023-10BHP	.625	.625	.625	.625	2.75	N123U3-0150- CM	2.2

1) To correspond with seat size on insert.

2) Insert tightening torque Nm.

3) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For QS-wedge, see page A249.

For QS-stop, see page A247.

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

Main spare parts

Shank size		For screw from bottom of holder				
Metric	Inch	Screw	Key (Torx Plus)	Screwdriver (Torx Plus) ¹⁾	Nozzle (hole diameter, mm) ²⁾	Coolant tube
1010	06	5513 020-63	5680 049-02 (15IP)	5680 046-01 (8IP)	5691 026-13 (1.0)	5692 033-04
1212-1616	08-10	5513 020-62	5680 049-02 (15IP)	5680 046-01 (8IP)	5691 026-13 (1.0)	5692 033-05

1) Accessories, must be ordered separately

2) For optional nozzles, see page A247.

Overview tools for small part machining, see page A110.



Short holder for QS™ holding system

General turning

T-Max® P lever design

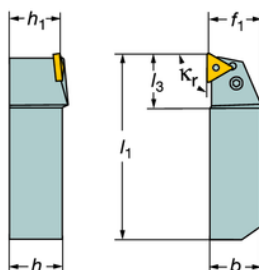


TNMM, TNMX
 TNMG
 TNMA, TNGA

Entering angle:
Lead angle:

QS-PTGNR

K_r 91°
-1°



Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f_1	h	h_1	l_1	l_3	γ^1	$\lambda_s^{2)}$		
	11	QS-PTGNR 1212E11	12	12	12	12	70	15.8	-6°	-6°	TNMG 11 03 04	2.0
		QS-PTGNR 1616E11	16	16	16	16	70	15.8	-6°	-6°	TNMG 11 03 04	2.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f_1	h	h_1	l_1	l_3	γ^1	$\lambda_s^{2)}$		
	1/4	QS-PTGNR 082X	.500	.500	.500	.500	2.756	.622	-6°	-6°	TNMG 221	1.5
		QS-PTGNR 102X	.625	.625	.625	.625	2.756	.622	-6°	-6°	TNMG 221	1.5

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand

For QS-wedge and QS-stop see page A248.

Main spare parts

Insert size				
	iC	Lever	Screw	Key (mm)
11	1/4	174.3-846-1	1743.-829	170.3-864 (1.98)

Overview tools for small part machining, see page A110.



A11



G6



A2

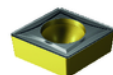


J2

Short holder for QS™ holding system

General turning

CoroTurn® 107 screw clamp design



CCMT, CCGT
CCGX, CCET
CCMW

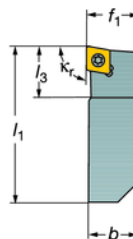
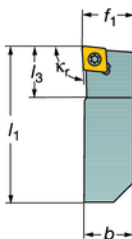
Entering angle:
Lead angle:

QS- SCLCR

$\kappa_r 95^\circ$
 -5°

QS- SCACR

$\kappa_r 90^\circ$
 0°



Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	06	QS-SCLCR0808C06	8	8	8	8	50	8	0°	0°	CCMT 06 02 04	0.9
		QS-SCLCR1010E06	10	10	10	10	70	10	0°	0°	CCMT 06 02 04	0.9
		QS-SCLCR1212E06	12	12	12	12	70	12	0°	0°	CCMT 06 02 04	0.9
	09	QS-SCLCR1212E09	12	12	12	12	70	12	0°	0°	CCMT 09 T3 08	3.0
		QS-SCLCR1616E09	16	16	16	16	70	16	0°	0°	CCMT 09 T3 08	3.0
	06	QS-SCACR0808C06	8	8	8	8	50	8	0°	0°	CCMT 06 02 04	0.9
		QS-SCACR1010E06	10	10	10	10	70	10	0°	0°	CCMT 06 02 04	0.9
		QS-SCACR1212E06	12	12	12	12	70	12	0°	0°	CCMT 06 02 04	0.9

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	QS-SCLCR 062X	.375	.375	.375	.375	2.756	.394	0°	0°	CCMT 2(1.5)1	0.7
	3/8	QS-SCLCR 083X	.500	.500	.500	.500	2.756	.591	0°	0°	CCMT 3(2.5)2	2.2
		QS-SCLCR 103X	.625	.625	.625	.625	2.756	.591	0°	0°	CCMT 3(2.5)2	2.2
	1/4	QS-SCACR 062X	.375	.375	.375	.375	2.756	.394	0°	0°	CCMT 2(1.5)1	0.7
	3/8	QS-SCACR 083X	.500	.500	.500	.500	2.756	.591	0°	0°	CCMT 3(2.5)2	2.2
		QS-SCACR 103X	.625	.625	.625	.625	2.756	.591	0°	0°	CCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand

For QS-wedge and QS-stop see page A248.

Main spare parts

Insert size			
	iC	Insert screw (thread)	Key (Torx Plus)
06	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)
09	3/8	5513 020-09 (M3.5)	5680 049-01 (15IP)

Overview tools for small part machining, see page A110.



Short holder for QS™ holding system

General turning

CoroTurn® 107 screw clamp design



DCMT, DCMX
DCGT, DCGX, DCET
DCMW

Entering angle:
Lead angle:

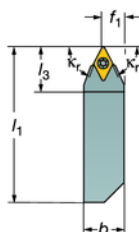
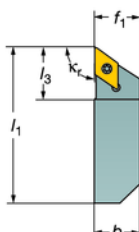
QS- SDJCR

$\kappa_r 93^\circ$
 -3°

QS- SDNCN

QS- SDPCN

$\kappa_r 62.5^\circ$
 27.5°



Neutral

Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	07	QS-SDJCR0808C07	8	8	8	8	50	12.7	0°	0°	DCMT 07 02 04	0.9
		QS-SDJCR1010E07	10	10	10	10	70	15	0°	0°	DCMT 07 02 04	0.9
		QS-SDJCR1212E07	12	12	12	12	70	15	0°	0°	DCMT 07 02 04	0.9
		QS-SDJCR1616E07	16	16	16	16	70	16	0°	0°	DCMT 07 02 04	0.9
	11	QS-SDJCR1212E11	12	12	12	12	70	18	0°	0°	DCMT 11 T3 08	3.0
	11	QS-SDJCR1616E11	16	16	16	16	70	20	0°	0°	DCMT 11 T3 08	3.0
		QS-SDNCN1212E11	12	6.2	12	12	70	21	0°	0°	DCMT 11 T3 08	3.0
		QS-SDNCN1616E11	16	8.5	16	16	70	21	0°	0°	DCMT 11 T3 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	QS-SDJCR 062X	.375	.375	.375	.375	2.756	.591	0°	0°	DCMT 2(1.5)1	0.7
	3/8	QS-SDJCR 083X	.500	.500	.500	.500	2.756	.787	0°	0°	DCMT 3(2.5)2	2.2
		QS-SDJCR 103X	.625	.625	.625	.625	2.756	.787	0°	0°	DCMT 3(2.5)2	2.2
	3/8	QS-SDPCN 083X	.500	.280	.500	.500	2.756	.827	0°	0°	DCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

N = Neutral, R = Right hand

For QS-wedge and QS-stop see page A248.

Main spare parts

Insert size			
iC		Insert screw (thread)	Key (Torx Plus)
07	1/4	5513 020-03 (M2.5)	5680 051-02 (7IP)
11	3/8	5513 020-09 (M3.5)	5680 049-01 (15IP)

Overview tools for small part machining, see page A110.



A11



G6




A2




J2

Short holder for QS™ holding system

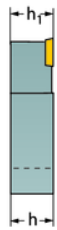
General turning
CoroTurn® 107 screw clamp design



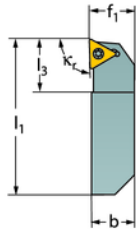


TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Entering angle:
Lead angle


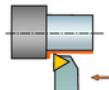


QS- STJCR
 $\kappa_r 93^\circ$
 -3°



Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	11	QS-STJCR1010E11	10	10	10	10	70	16	0°	0°	TCMT 11 02 04	0.9
		QS-STJCR1212E11	12	12	12	12	70	16	0°	0°	TCMT 11 02 04	0.9
		QS-STJCR1616E11	16	16	16	16	70	16	0°	0°	TCMT 11 02 04	0.9


- 1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.
- R = Right hand

For QS-wedge and QS-stop see page A248.

Main spare parts

Insert size		
	Insert screw (thread)	Key (Torx Plus)
11	5513 020-03 (M2.5)	5680 051-02 (7IP)

Overview tools for small part machining, see page A110.

A11

G6

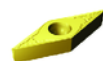
A2

J2

Short holder for QS™ holding system

General turning

CoroTurn® 107 screw clamp design

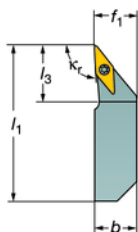


VBMT, VBG
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW

Entering angle:
Lead angle:

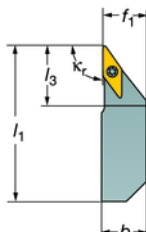
QS- SVJBR/L

$\kappa_r 93^\circ$
 -3°



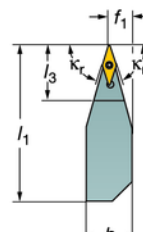
QS- SVABR/L

$\kappa_r 90^\circ$
 0°



QS- SVVBN

$\kappa_r 72.5^\circ$
 17.5°



Neutral

Note: VCEX insert not suitable in SVVBN holders
Right hand style shown when nothing else is stated

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm								Gauge inserts	Nm ³⁾
	11	QS-SVJBR/L1010E11-B1	10	10	10	10	70	26	0°	0°	VBMT 11 03 04	0.9
		QS-SVJBR/L1212E11-B1	12	12	12	12	70	26	0°	0°	VBMT 11 03 04	0.9
		QS-SVJBR/L1616E11-B1	16	16	16	16	70	26	0°	0°	VBMT 11 03 04	0.9
	16	QS-SVJBR/L1212E16	12	12	12	12	70	30	0°	0°	VBMT 16 04 08	3.0
		QS-SVJBR/L1616E16	16	16	16	16	70	40	0°	0°	VBMT 16 04 08	3.0
	11	QS-SVABR/L1010E11-B1	10	10	10	10	70	26	0°	0°	VBMT 11 03 04	0.9
		QS-SVABR/L1212E11-B1	12	12	12	12	70	26	0°	0°	VBMT 11 03 04	0.9
		QS-SVABR/L1616E11-B1	16	16	16	16	70	26	0°	0°	VBMT 11 03 04	0.9
	16	QS-SVABR/L1616E16	16	16	16	16	70	40	0°	0°	VBMT 16 04 08	3.0
	11	QS-SVVBN0808C11-B1	8	4.3	8	8	50	21	0°	0°	VBMT 11 03 04	0.9
		QS-SVVBN1010E11-B1	10	5.3	10	10	70	21	0°	0°	VBMT 11 03 04	0.9
		QS-SVVBN1212E11-B1	12	6.3	12	12	70	21	0°	0°	VBMT 11 03 04	0.9
		QS-SVVBN1616E11-B1	16	8.3	16	16	70	21	0°	0°	VBMT 11 03 04	0.9

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	QS-SVJBR 062X-B1	.375	.375	.375	.375	2.756	.787	0°	0°	VBMT 221	0.7
		QS-SVJBR 082X-B1	.500	.500	.500	.500	2.756	.787	0°	0°	VBMT 221	0.7
		QS-SVJBR 102X-B1	.625	.625	.625	.625	2.756	.787	0°	0°	VBMT 221	0.7
	3/8	QS-SVJBR 083X	.500	.500	.500	.500	2.756	1.181	0°	0°	VBMT 332	2.2
		QS-SVJBR 103X	.625	.625	.625	.625	2.756	1.181	0°	0°	VBMT 332	2.2
	1/4	QS-SVVBN 062X-B1	.375	.201	.375	.375	2.756	.827	0°	0°	VBMT 221	0.7
		QS-SVVBN 082X-B1	.500	.264	.500	.500	2.756	.827	0°	0°	VBMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) B1 = For insert with thickness 03 = 3.18 mm (2 = 1/8").

For QS-wedge and QS-stop see page A248.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Insert size		Insert screw (thread)		Key (Torx Plus)	
	iC				
11	1/4	5513 020-03 (M2.5)		5680 051-02 (7IP)	
16	3/8	5513 020-09 (M3.5)		5680 049-01 (15IP)	

Overview tools for small part machining, see page A110.



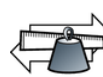
A11



G6



A2



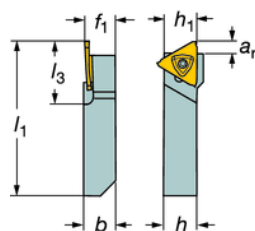
J2

Short holder for QS™ holding system

Parting and grooving

CoroCut® 3-edge screw clamp design

QS-R/LF123



Note! When using CoroCut® 3-edged insert the a_r of the insert gives the maximum depth of cut.

Right hand tool with right hand insert (T) shown.

Metric version

Main application	Seat size ¹⁾	Ordering code	Dimensions, mm							Gauge inserts	Nm ²⁾
			a_r	b	f_1	h	h_1	l_1	l_3		
	T	QS-RF123T06-1010B	6.4	10	10	10	10	70	23	N123T3-0150- CM	3.0
		QS-RF123T06-1212B	6.4	12	12	12	12	70	23	N123T3-0150- CM	3.0
		QS-RF123T06-1616B	6.4	16	16	16	16	70	23	N123T3-0150- CM	3.0
	U	QS-LF123U06-1010B	6.4	10	10	10	10	70	23	N123U3-0150- CM	3.0
		QS-LF123U06-1212B	6.4	12	12	12	12	70	23	N123U3-0150- CM	3.0
		QS-LF123U06-1616B	6.4	16	16	16	16	70	23	N123U3-0150- CM	3.0

Inch version

Main application	Seat size ¹⁾	Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ³⁾
			a_r	b	f_1	h	h_1	l_1	l_3		
	T	QS-RF123T023-06B	.250	.375	.375	.375	.375	2.750	.787	N123T3-0150- CM	2.2
		QS-RF123T023-08B	.250	.500	.500	.500	.500	2.750	.787	N123T3-0150- CM	2.2
		QS-RF123T023-10B	.250	.625	.625	.625	.625	2.750	.787	N123T3-0150- CM	2.2
	U	QS-LF123U023-06B	.252	.375	.375	.375	.500	2.750	.787	N123U3-0150- CM	2.2
		QS-LF123U023-08B	.250	.500	.500	.500	.500	2.750	.787	N123U3-0150- CM	2.2
		QS-LF123U023-10B	.250	.625	.625	.625	.625	2.750	.787	N123U3-0150- CM	2.2

1) To correspond with seat size on insert.

2) Insert tightening torque Nm.

3) Insert tightening torque ft-lbs.

For QS-wedge and QS-stop see page A248.

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

R = Right hand, L = Left hand

Main spare parts

Shank size		For screw from bottom of holder		
Metric	Inch	Screw	Key (Torx Plus)	Screwdriver (Torx Plus) ¹⁾
1010	06	5513 020-63	5680 049-02 (15IP)	5680 046-01 (8IP)
1212-1616	08-10	5513 020-62	5680 049-02 (15IP)	5680 046-01 (8IP)

¹⁾ Accessories, must be ordered separately

Overview tools for small part machining, see page A110.

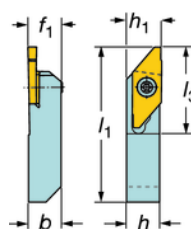


Short holder for QS™ holding system

Turning, parting, grooving and threading

CoroCut® XS screw clamp design

QS- SMALR/L



Right hand style shown

Metric version

Seat size ³⁾	Ordering code	Dimensions, mm						Gauge inserts	Nm ¹⁾
		b	f ₁	h	h ₁	l ₁	l ₃		
03	QS-SMALR/L 1010E3	10	10.0	10	10	70	27.0	MAxL 3..	1.2
	QS-SMALR/L 1212E3	12	12.0	12	12	70	27.0	MAxL 3..	1.2
	QS-SMALR/L 1616E3	16	16.0	16	16	70	27.0	MAxL 3..	1.2

Inch version

Seat size ³⁾	Ordering code	Dimensions, inch						Gauge inserts	ft-lbs ²⁾
		b	f ₁	h	h ₁	l ₁	l ₃		
3	QS-SMALR 083X	.500	.500	.500	.500	2.756	1.063	MAxR 3..	0.9
	QS-SMALR 103X	.625	.625	.625	.625	2.756	1.063	MAxR 3..	0.9

1) Insert tightening torque Nm.

2) Insert tightening torque ft-lbs.

3) To correspond with seat size on insert.

For QS-wedge and QS-stop see page A248.

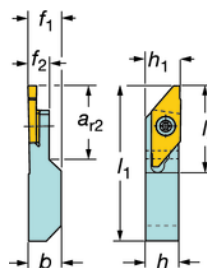
R = Right hand, L = Left hand

Short holder for QS™ holding system

Cut off holder when using sub-spindle

CoroCut® XS screw clamp design

QS- SMALR-X



Right hand style shown

Metric version

Seat size ³⁾	Ordering code	Dimensions, mm								Gauge inserts	Nm ¹⁾
		a ₂	b	f ₁	f ₂	h	h ₁	l ₁	l ₃		
03	QS-SMALR 1010E-X	20	10	10	7.5	10	10	70	27	MAxR 3..	1.2
	QS-SMALR 1212E-X	20	12	12	7.5	12	12	70	27	MAxR 3..	1.2

Inch version

Seat size ³⁾	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ²⁾
		a ₂	b	f ₁	f ₂	h	h ₁	l ₁	l ₃		
3	QS-SMALR 083X-X	.787	.500	.500	.295	.500	.500	2.756	1.063	MAxR 3..	0.9

1) Insert tightening torque Nm.

2) Insert tightening torque ft-lbs.

3) To correspond with seat size on insert.

For QS-wedge and QS-stop see page A248.

R = Right hand

Main spare parts

Holder type		Screw		Key (Torx Plus)	
Metric	Inch				
SMALR E3X	SMALR X	5513 027-01	5680 046-01 (8IP)		
SMALR EX-X	SMALR X-X	5513 027-02	5680 046-01 (8IP)		

Overview tools for small part machining, see page A110.

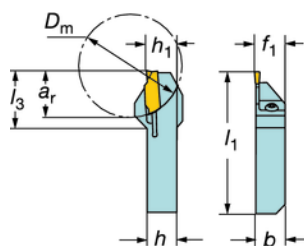


Short holder for QS™ holding system

Parting and grooving

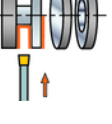
CoroCut® 1- and 2-edge screw clamp design

QS-R/LF123




Note! When using CoroCut® 2-edged insert the a_r of the insert gives the maximum depth of cut.

Metric version

Main application	Seat size ²⁾	Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			D _m max	a _r ¹⁾	b	f ₁	h	h ₁	l ₁	l ₃		
	D	QS-R/LF123D10-1010B	20	10	10	10.15	10	10	70	18.0	N123D2-0150- CM	2.5
		QS-R/LF123D11-1212B	22	11	12	12.15	12	12	70	20.0	N123D2-0150- CM	2.5
		QS-R/LF123D08-1616B	16	8	16	16.0	16	16	70	19.6	N123D2-0150- CM	2.5
		QS-R/LF123D17-1616B	34	17	16	16.0	16	16	70	28.6	N123D2-0150- CM	2.5
	E	QS-R/LF123E10-1010B	20	10	10	10.15	10	10	70	21.0	N123E2-0200- CM	2.5
		QS-R/LF123E11-1212B	22	11	12	12.15	12	12	70	21.0	N123E2-0200- CM	2.5
		QS-R/LF123E11-1616B	22	11	16	16.0	16	16	70	22.6	N123E2-0200- CM	2.5
		QS-R/LF123E17-1616B	34	17	16	16.15	16	16	70	26.0	N123E2-0200- CM	2.5
	F	QS-R/LF123F10-1010B	20	10	10	10.0	10	10	70	21.6	N123F2-0250- CM	2.5
		QS-R/LF123F15-1212B	30	15	12	12.0	12	12	70	20.0	N123F2-0250- CM	2.5
		QS-R/LF123F17-1616B	34	17	16	16.15	16	16	70	26.0	N123F2-0250- CM	2.5
		QS-R/LF123G17-1616B	34	17	16	16.0	16	16	70	28.6	N123G2-0300-CM	2.5

Inch version

Main application	Seat size ²⁾	Ordering code	Dimensions, mm								Gauge inserts	ft-lbs ⁴⁾
			D _m max	a _r ¹⁾	b	f ₁	h	h ₁	l ₁	l ₃		
	D	QS-R/LF123D039-06B	.787	.375	.375	.381	.375	.375	2.756	.709	N123D2-0150- CM	1.8
		QS-R/LF123D043-08B	.866	.433	.500	.506	.500	.500	2.756	.787	N123D2-0150- CM	1.8
		QS-R/LF123D032-10B	.640	.320	.625	.625	.625	.625	2.756	.777	N123D2-0150- CM	1.8
		QS-R/LF123D067-10B	1.34	.670	.625	.625	.625	.625	2.756	1.127	N123D2-0150- CM	1.8
	E	QS-R/LF123E039-06B	.787	.394	.375	.381	.375	.375	2.756	.827	N123E2-0200- CM	1.8
		QS-R/LF123E043-08B	.866	.433	.500	.506	.500	.500	2.756	.827	N123E2-0200- CM	1.8
		QS-R/LF123E043-10B	.860	.430	.625	.625	.625	.625	2.756	.887	N123E2-0200- CM	1.8
		QS-R/LF123E067-10B	1.33	.669	.625	.631	.625	.625	2.756	1.024	N123E2-0200- CM	1.8
	F	QS-R/LF123F039-06B	.780	.390	.375	.375	.375	.375	2.756	.847	N123F2-0250- CM	1.8
		QS-R/LF123F059-08B	1.18	.590	.500	.500	.500	.500	2.756	1.047	N123F2-0250- CM	1.8
G	QS-R/LF123G067-10B	1.34	.670	.625	.625	.625	.625	2.756	1.126	N123G2-0300-CM	1.8	

1) a_r max. for holder. For max stability choose a holder with shortest possible a_r .

R = Right hand, L = Left hand

2) To correspond with seat size on insert.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

For QS-wedge and QS-stop see page A248.

Main spare parts

Seat size		Shank size			
		Metric	Inch	Screw	Key (Torx Plus)
D, E, F,		1010	06	5513 021-07	5680 043-13 (15IP)
D, E, F, G		1212-1616	08-10	5513 021-04	5680 043-13 (15IP)

Overview tools for small part machining, see page A110.



Short holder for QS™ holding system

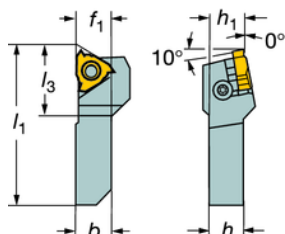
CoroThread® 266

Screw clamp design

QS-266RFA



266 R/LG



x and z, see infeed tables on page C71.

	<i>iC</i>	Angle of inclination with different shims, see page C46.
16	3/8	

Right hand style shown

Metric version

Main application	Insert size	Ordering code	Dimensions, mm						Nm ¹⁾
			<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	
	16	QS-266RFA-1010-16	10	10	10	10	70	19.8	3.0
		QS-266RFA-1212-16	12	12	12	12	70	21.3	3.0
		QS-266RFA-1616-16	16	16	16	16	70	23.3	3.0

Inch version

Main application	Insert size	Ordering code	Dimensions, inch						ft-lbs ²⁾
	<i>iC</i>		<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	
	3/8	QS-266RFA-063	.375	.375	.375	.375	2.756	.780	2.2
		QS-266RFA-083	.500	.500	.500	.500	2.756	.839	2.2
		QS-266RFA-103	.625	.625	.625	.625	2.756	.917	2.2

¹⁾ Insert tightening torque Nm.

²⁾ Insert tightening torque ft-lbs.

For QS-Wedge and QS-Stops see page A248.

R = Right hand

Main spare parts

Insert size		Shim for right hand external toolholder			Shim for left hand external toolholder		
	<i>iC</i>	Insert screw	Key (Torx Plus)	Inclination angle +1° ²⁾	Inclination angle +1° ²⁾	Shim screw	
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 389-11	5322 390-11	5512 032-05	

²⁾ For optional shims, see page C46.

Overview tools for small part machining, see page A110.



C11



G6



J2

Wedge and stop for QS™ holding system

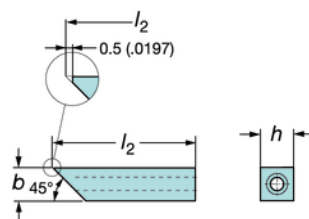
Wedge	MTM	Model	Shank	
			ISO metric	ANSI inch
QS-10	Citizen	R04/R07	0808	
QS-20	Citizen	A16,C12,K12,K16,L16,L20	1010	
QS-30	Citizen	A20,B20,C16,C20,C32,K12,K16,L16,L20	1212	
QS-30A	Citizen	A20,B20,C16,C20,C32,K12,K16,L16,L20		08
QS-31	Citizen	L16 VIII, L720	1212	
QS-31A	Citizen	L16 VIII, L720		08
QS-40	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

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	
QS1212	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

Stop for high precision coolant QS™ holding system

Citizen/Star/Nexturn



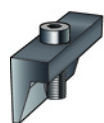
Ordering code	For shank size mm, inch	Dimensions, mm, inch		
		<i>b</i>	<i>h</i>	<i>l₂</i>
Metric				
QS-1010HP	1010, 1012	10	10	51
QS-1212HP	1212	12	12	51
QS-1616HP	1616	16	16	51
Inch				
QS-A06HP	3/8	.375	.375	2.000
QS-A08HP	1/2	.500	.500	2.000
QS-A10HP	5/8	.625	.625	2.000

Optional nozzles (to be ordered separately)

Ordering code	Hole diameter, mm
5691 026-11	0.6
5691 026-12	0.8
5691 026-14	1.2
5691 026-15	1.4

Wedge for QS™ holding system

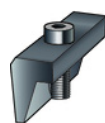
Citizen/Star/Nexturn



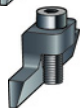
QS-10



QS-351



QS-230, QS230A



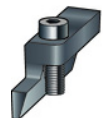
QS-20



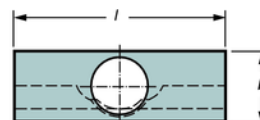
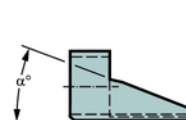
QS-352



QS-240

QS-30, QS-31,
QS-30A, QS-31A

QS-40, QS-40A

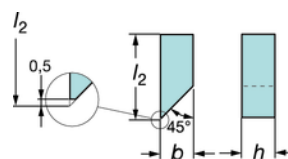


Machine type	Ordering code	Dimensions, mm, inch		
		<i>l</i>	<i>b</i>	α
Citizen	Metric			
	QS-10	20	7	17°
	QS-20	37	9.9	22°
	QS-30	32	12	22°
	QS-31	32	11.3	22°
	QS-40	29	13.5	22°
	Inch			
	QS-30A	1.260	.472	22°
	QS-31A	1.260	.445	22°
	QS-40A	1.142	.531	22°
Star	QS-351	30	13.5	24°20'
	QS-352	35	13.5	24°20'
Nexturn	Metric			
	QS-230 ¹⁾	28	12.5	14°40'
	QS-240	28	13.7	14°40'
	Inch			
	QS-230A	1.102	.465	14°40'

1) Will also work on 5/8" machines.

Stop for QS™ holding system

Citizen/Star/Nexturn



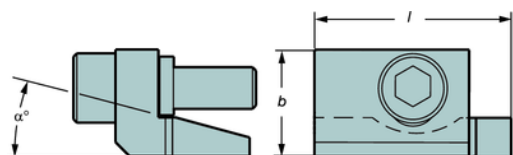
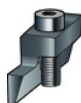
Ordering code	For shank size mm, inch	Dimensions, mm, inch		
		<i>b</i>	<i>h</i>	<i>l</i> ₂
Metric				
QS-0808	0808	8	8	40
QS-1010	1010	10	10	51
QS-1212	1212	12	12	51
QS-1616	1616	16	16	51
Inch				
QS-A06	3/8	.375	.375	2.000
QS-A08	1/2	.500	.500	2.000
QS-A10	5/8	.625	.625	2.000

Wedge and stop for QS™ holding system

Tsugami/Tornos

Wedge

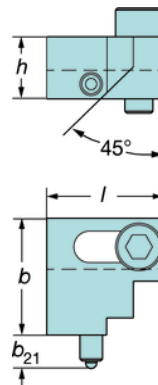
QS-130



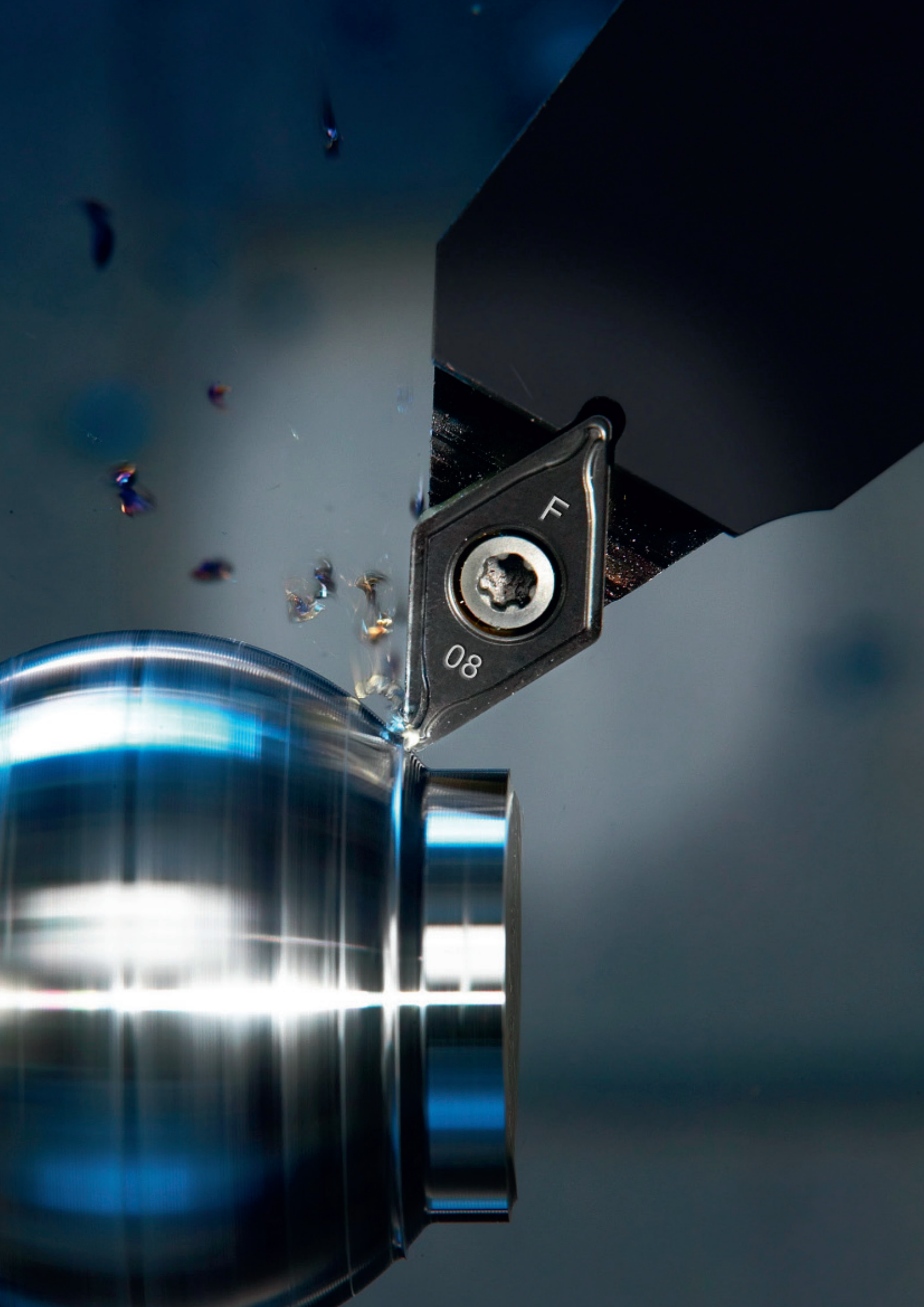
Stop

QS-130-12

QS-130-16



Ordering code	Dimensions, millimeter, inch (mm, in.)							
Wedge	<i>b</i> mm	<i>b</i> in.	<i>l</i> mm	<i>l</i> in.	<i>α</i>			
Metric								
QS-130	15.1	.594	28.0	1.102	15°			
Ordering code	For shank size		Dimensions, millimeter, inch (mm, in.)					
Stop	mm (inch)		<i>b</i> mm	<i>b</i> in.	<i>b</i> ₂₁ mm	<i>b</i> ₂₁ in.	<i>h</i> mm	<i>h</i> in.
Metric								
QS-130-12	1212 (1/2")		24.5	.965	3.1	.122	13.0	.512
QS-130-16	1616 (5/8")		24.5	.965	7.0	.276	13.0	.512

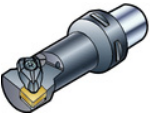
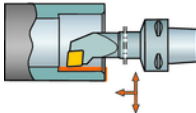

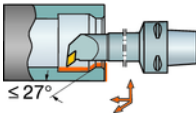

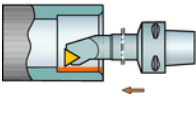

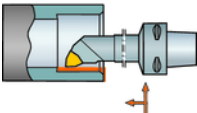



GENERAL TURNING

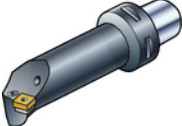
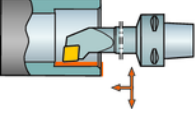

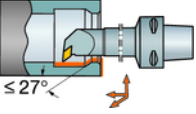

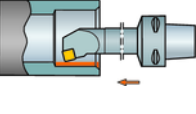

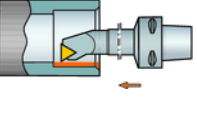

Holdings for internal machining


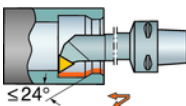

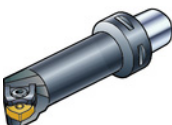
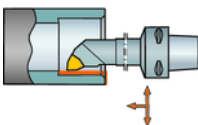

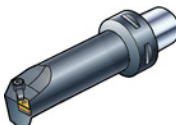
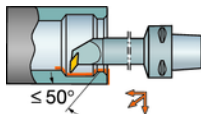

Introduction	A260
Tool holder overview	A252
Code key	A258
Holdings for negative basic-shape inserts	
CoroTurn® RC, rigid clamping, Coromant Capto cutting units	A261
CoroTurn® RC, rigid clamping, boring bars	A269
T-Max® P Lever clamping, Coromant Capto cutting units	A263
T-Max® P, lever clamping, boring bars	A273
T-Max® P, wedge clamping, Coromant Capto cutting units	A266
T-Max® P, wedge clamping, shank holders	A275
T-Max® P, top clamping, shank holders	A277
Holdings for positive basic-shape inserts	
CoroTurn® 107 - 7° clearance angle, Coromant Capto cutting units	A280
CoroTurn® 107 - 7° clearance angle, boring bars	A286
CoroTurn® 111, 11° clearance angle, boring bars	A309
CoroTurn® SL flexible system	I1
Tools for small part machining	
CoroTurn® XS, down to 0.3 mm	A325
Inserts	A328
CoroCut® MB, mini bars	B94
Holders	B105
Sleeves for cylindrical bars	
EasyFix	A320
Spare parts	
Torque wrenches	A438
	A437

Coromant Capto® boring bars for negative basic-shape inserts

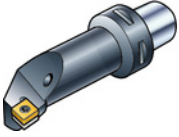
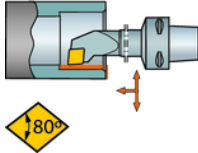
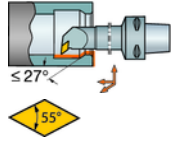
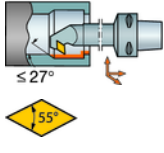
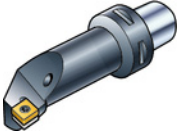
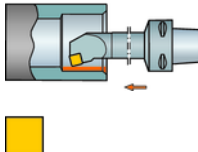
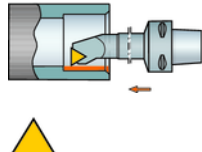
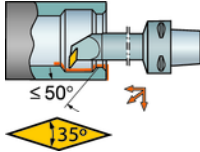
CoroTurn® RC rigid clamp design 	Entering angle (Lead angle)			
	$\kappa_r 95^\circ (-5^\circ)$  	$\kappa_r 93^\circ (-3^\circ)$ $\leq 27^\circ$  	$\kappa_r 91^\circ (-1^\circ)$  	$\kappa_r 95^\circ (-5^\circ)$  
	DCLNR/L	DDUNR/L	DTFNR/L	DWLNR/L
	Insert size, mm (/C inch) 09-16 (3/8-5/8)	11-15 (3/8-1/2)	16 (3/8)	06-08 (3/8-1/2)
	Bar diameter mm,(inch) 20-40 (.787-1.575)	25-40 (.984-1.575)	25 (.984)	20-25 (.787-984)
	Coromant Capto® size C4-C6	C4-C6	C4-C5	C4-C5
Page	A261	A261	A262	A262

Coromant Capto® boring bars for negative basic-shape inserts

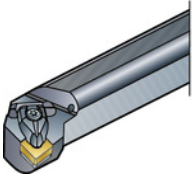
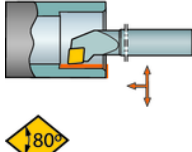
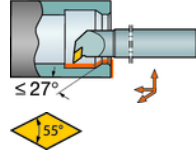
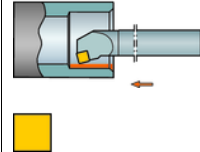
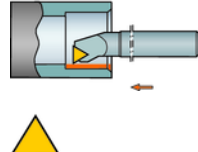
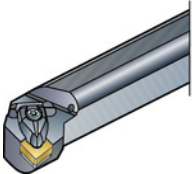
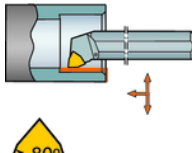
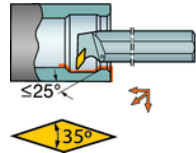
T-Max® P lever design 	Entering angle (Lead angle)			
	$\kappa_r 95^\circ (-5^\circ)$  	$\kappa_r 93^\circ (-3^\circ)$ $\leq 27^\circ$  	$\kappa_r 75^\circ (15^\circ)$  	$\kappa_r 91^\circ (-1^\circ)$  
	PCLNR/L	PDUNR/L	PSKNR/L	PTFNR/L
	Insert size, mm (/C inch) 09-16 (3/8-5/8)	11-15 (3/8-1/2)	12-15 (1/2-5/8)	11 (1/4)
	Bar diameter mm,(inch) 20-50 (.787-1.969)	25-50 (.984-1.969)	25-50 (.984-1.968)	20 (.787)
	Coromant Capto® size C3-C6	C3-C6	C4-C6	C3-C5
Page	A263	A264	A265	A265

T-Max P wedge design	Entering angle (Lead angle)	T-Max P wedge clamp design	Entering angle (Lead angle)	T-Max P screw and top clamp design	Entering angle (Lead angle)
	$\kappa_r 91^\circ (-1^\circ)$  		$\kappa_r 95^\circ (-5^\circ)$  		$\kappa_r 93^\circ (-3^\circ)$  
Insert size, mm (/C inch)	PTFNR/L-W 16-22 (3/8-1/2)	Insert size, mm, (inch)	MWLNRL/L 06-08 (3/8-1/2)	Insert size, mm, (inch)	MVUNRL/L 16 (3/8)
Bar diameter mm,(inch)	25-50 (.984-1.969)	Bar diameter mm,(inch)	20-40 (.787-1.575)	Bar diameter mm,(inch)	32-50 (1.260-1.969)
Coromant Capto® size	C3-C6	Coromant Capto® size	C3-C5	Coromant Capto® size	C4-C6
Page	A266	Page	A267	Page	A268

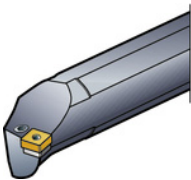
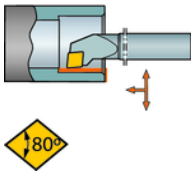
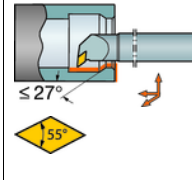
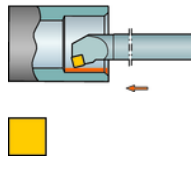
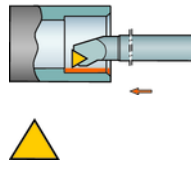
Coromant Capto® cutting units for positive basic-shape inserts

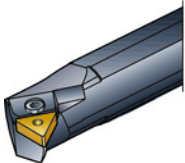
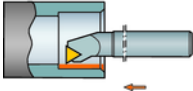

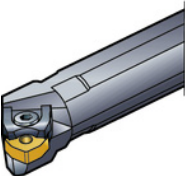
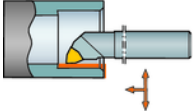

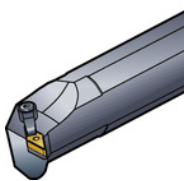
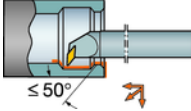

CoroTurn® 107 screw clamp design 	Entering angle (Lead angle)		
	$\kappa_r 95^\circ (-5^\circ)$  SCLCR/L Insert size, mm (iC inch) 09-12 (3/8-1/2) Bar diameter mm,(inch) 16-50 (.630-1.969) Coromant Capto® size C3-C5 Page A280	$\kappa_r 93^\circ (-3^\circ)$  SDUCR/L Insert size, mm (iC inch) 07-11 (1/4-3/8) Bar diameter mm,(inch) 16-50 (.630-1.969) Coromant Capto® size C3-C5 Page A281	$\kappa_r 93^\circ (-3^\circ)$ Back boring  SDUCR/L-X Insert size, mm (iC inch) 07 (1/4) Bar diameter mm,(inch) 16-25 (.630-.984) Coromant Capto® size C3-C5 Page A281
CoroTurn® 107 screw clamp design 	Entering angle (Lead angle)		
	$\kappa_r 75^\circ (15^\circ)$  SSKCR/L Insert size, mm (iC inch) 09 (3/8) Bar diameter mm,(inch) 20 (.787) Coromant Capto® size C4-C5 Page A282	$\kappa_r 91^\circ (-1^\circ)$  STFCR/L Insert size, mm (iC inch) 11-16 (1/4-3/8) Bar diameter mm,(inch) 16-32 (.630-1.260) Coromant Capto® size C3-C6 Page A283	$\kappa_r 107.5^\circ (-17.5^\circ)$  SVQBR/L Insert size, mm (iC inch) 11 (1/4) Bar diameter mm,(inch) 16-20 (.630-.787) Coromant Capto® size C3-C6 Page A284

Boring bars for negative basic-shape inserts

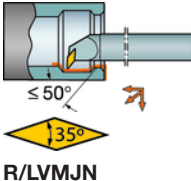
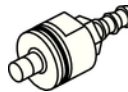

CoroTurn® RC rigid clamp design 	Entering angle (Lead angle)			
	$\kappa_r 95^\circ (-5^\circ)$  DCLNR/L Insert size, mm (iC inch) 09-16 (3/8-5/8) Bar diameter, mm 25-50 Bar diameter, inch .750-2.500 Page A269	$\kappa_r 93^\circ (-3^\circ)$  DDUNR/L Insert size, mm (iC inch) 11-15 (3/8-1/2) Bar diameter, mm 25-50 Bar diameter, inch .750-2.500 Page A270	$\kappa_r 75^\circ (15^\circ)$  DSKNR/L Insert size, mm (iC inch) 09-12 (1/2) Bar diameter, mm 25-40 Bar diameter, inch 1.000-1.500 Page A271	$\kappa_r 91^\circ (-1^\circ)$  DTFNR/L Insert size, mm (iC inch) 16-22 (3/8-1/2) Bar diameter, mm 25-50 Bar diameter, inch .750-2.000 Page A271
CoroTurn® RC rigid clamp design 	Entering angle (Lead angle)			
	$\kappa_r 95^\circ (-5^\circ)$  DWLNR/L Insert size, mm (iC inch) 06-08 (3/8-1/2) Bar diameter, mm 25-50 Bar diameter, inch 1.000-2.000 Page A272	$\kappa_r 93^\circ (-3^\circ)$  DVUNR/L Insert size, mm (iC inch) 16 (3/8) Bar diameter, mm 40 Bar diameter, inch 1.500 Page A272		

Boring bars for negative basic-shape inserts


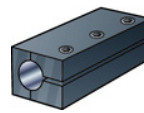
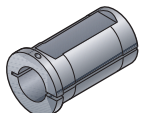
T-Max® P lever design		Entering angle (Lead angle)			
					
	$\kappa_r 95^\circ (-5^\circ)$	$\kappa_r 93^\circ (-3^\circ)$	$\kappa_r 75^\circ (15^\circ)$	$\kappa_r 91^\circ (-1^\circ)$	
	$\leq 27^\circ$	$\leq 27^\circ$			
	$\leq 80^\circ$	$\leq 55^\circ$			
	$\leq 80^\circ$	$\leq 55^\circ$			
PCLNR/L	PDUNR/L	PSKNR/L	PTFNR/L		
Insert size, mm, (inch)	09-19 (3/8-3/4)	11-15 (3/8-1/2)	12 (1/2)	11 (1/4)	
Bar diameter, mm	16-50	25-50	25-40	16-25	
Page	A273	A274	A274	A275	

T-Max P wedge design	Entering angle (Lead angle)	T-Max P wedge clamp design	Entering angle (Lead angle)	T-Max P screw and top clamp design	Entering angle (Lead angle)
	κ_r 91° (-1°)  		κ_r 95° (-5°)  		κ_r 93° (-3°)  
Insert size, mm (iC inch)	PTFNR/L-W 16-22 (3/8-1/2)	Insert size, mm (iC inch)	MWLNR/L 06-08 (3/8-1/2)	Insert size, mm (iC inch)	MVUNR/L 16 (3/8)
Bar diameter, mm	25-50	Bar diameter, mm	20-50	Bar diameter, mm	40
Page	A275	Bar diameter, inch Page	1.000-2.000 A276	Page	A277

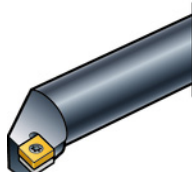
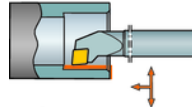

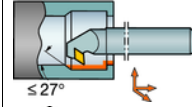

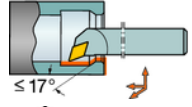

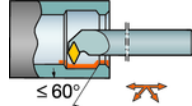

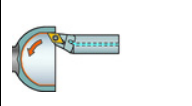

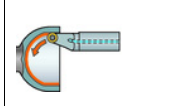
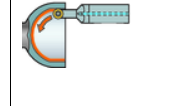
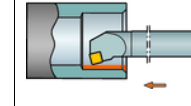

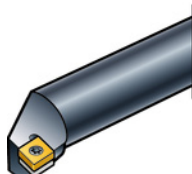
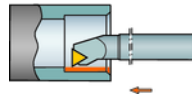

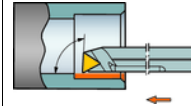

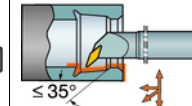

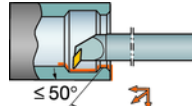

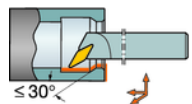

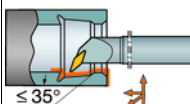

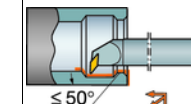

Accessories

T-Max M, Top Clamp	Entering angle (Lead angle)		Accessories for cutting fluid supply	Coolant connector		Coolant nozzle	
	$\kappa_r 93^\circ (-3^\circ)$ 	R/LVMJN $\leq 50^\circ$					
	Insert size, mm (iC inch)	16 (3/8)		For boring bars		For Coromant Capto® cutting units	
	Bar diameter, inch	1.250-1.500					
	Page	A277		A324		A324	

Accessories

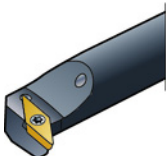
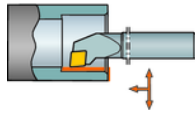
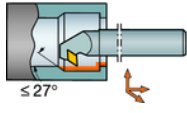
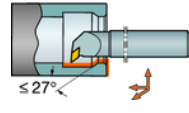
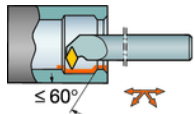
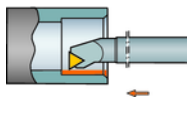
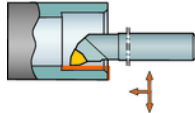

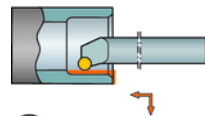
Sleeves for cylindrical boring bars	EasyFix		
			
	131 5-25 (.187-.750)	132 5-25 (.187-1.000)	
	Bar diameter, mm (inch)		
	Page	A321	A323

Boring bars for positive basic-shape inserts

CoroTurn® 107 screw clamp design 	Entering angle (Lead angle) $\kappa_r 95^\circ (-5^\circ)$  					Back boring $\kappa_r 93^\circ (-3^\circ)$  			$\kappa_r 107.5^\circ (-17.5^\circ)$  		
	SCLCR/L Steel shank		Carbide shank	SDUCR/L Steel shank	Carbide shank	Dampened carbide shank	SDUCR/L-X Steel shank	SDQCR/L Steel shank			
	Insert size, mm, (inch)		06-12 (1/4-1/2) 06-09 (1/4-3/8)	07-11 (1/4-3/8)	07 (1/4)	07 (1/4)	07-11 (1/4-3/8)	07-11 (1/4-3/8)			
	Bar diameter, mm		8-40	8-16	10-25	10-16	10-12	16-32		10-20	
	Bar diameter, inch		.375-1.500	.312-1.000	.375-.750	.750-1.000	–	.750-1.250		.375-1.000	
Page	A286		A286	A288	A288	A288	A288	A289			
	Entering angle (Lead angle) $\kappa_r 62.5^\circ (27.5^\circ)$  		$\kappa_r 120^\circ (-30^\circ)$  		– 		– 		$\kappa_r 75^\circ (15^\circ)$  		
	SDXCR/L Steel shank		SDXCR/L Steel shank		SRDXCR/L Steel shank		SRDDN Steel shank		SSKCR/L Steel shank		
	Insert size, mm, (inch)		07-11 (1/4-3/8)		08-10		08		09-12 (3/8-1/2)		
	Bar diameter, mm		12-20		20		16		16-32		
	Bar diameter, inch		.500-1.000		.750		.625		–		
Page	A289		A294		A295		A295		A297		
CoroTurn® 107 screw clamp design 	Entering angle (Lead angle) $\kappa_r 91^\circ (-1^\circ)$  			$\kappa_r 93^\circ (-3^\circ)$  		$\kappa_r 107.5^\circ (-17.5^\circ)$  		$\kappa_r 93^\circ (-3^\circ)$  			
	STFCR/L Steel shank		Carbide shank	Dampened carbide shank	STUCR/L Steel shank		SVQBR/L Steel shank		SVUBR/L Steel shank		
	Insert size, mm, (inch)		06-16 (5/32-3/8)	06-16 (5/32-3/8)	09	05-06 (1/8-5/32)	11-16 (1/4-3/8)	11-16 (1/4-3/8)			
	Bar diameter, mm		6-40	6-16	10-12	5-10	16-40	16-40			
	Bar diameter, inch		.375-1.500	.250-1.000	–	–	1.000-1.500	.625-1.500			
Page	A298		A298	A298	A302	A303	A303				
	Entering angle (Lead angle) $\kappa_r 117.5^\circ (-27.5^\circ)$  			$\kappa_r 107.5^\circ (-17.5^\circ)$  		$\kappa_r 93^\circ (-3^\circ)$  					
	SVPBR/L Steel shank			SVQCR/L Steel shank		Carbide shank	SVUCR/L Steel shank	Carbide shank			
	Insert size, mm, (inch)			11 (1/4)		11 (1/4)	11 (1/4)	11 (1/4)			
	Bar diameter, mm			16		16	16	16			
	Bar diameter, inch			.625		.625	.625	.625			
Page	A305			A304		A304	A304	A304			


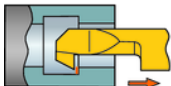
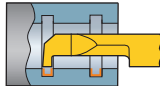
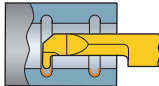
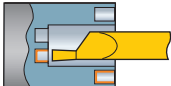
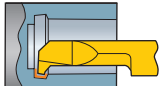
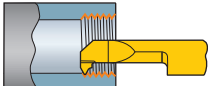
Note: Boring bars type SVUCR/L and SVQCR/L on page A256.

Boring bars for positive basic-shape inserts

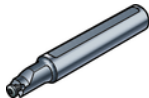
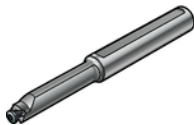
<div>CoroTurn® 111 screw clamp design</div> <div></div>	<div>Entering angle (Lead angle)</div> <div><div><div>$\kappa_r 95^\circ (-5^\circ)$<div><div><div>80°</div></div></div><div>SCLPR/L</div><div>Steel shank</div><div>Carbide shank</div></div><div><div>$\kappa_r 93^\circ (-3^\circ)$ Back boring<div><div><div>≤ 27°</div><div>55°</div></div><div>SDUPR/L-X</div><div>Steel shank</div><div>Carbide shank</div></div><div><div>$\kappa_r 93^\circ (-3^\circ)$<div><div><div>≤ 27°</div><div>55°</div></div><div>SDUPR/L</div><div>Steel shank</div><div>Carbide shank</div><div>Dampened carbide shank</div></div></div><div>Silent Tools®</div></div></div></div></div></div>							
	Insert size, mm, (inch)	06 (1/4)	06-09 (1/4)	07 (1/4)	07 (1/4)	07-11 (1/4-3/8)	07 (1/4)	07 (1/4)
	Bar diameter, mm	8-12	8-16	16	16	10-25	10-16	10-12
	Bar diameter, inch	.312-.500	.312-.500	.625	.625	.375-1.000	.312-.500	.375-.500
Page	A309	A309	A312	A312	A311	A311	A311	
<div>Insert size, mm, (inch)</div> <div>Bar diameter, mm</div> <div>Bar diameter, inch</div> <div>Page</div>	<div>Entering angle (Lead angle)</div> <div><div><div>$\kappa_r 62.5^\circ (27.5^\circ)$<div><div><div>≤ 60°</div><div>55°</div></div><div>SDXPR/L</div><div>Steel shank</div></div><div><div>$\kappa_r 91^\circ (-1^\circ)$<div><div><div>55°</div></div><div>STFPR/L</div><div>Steel shank</div><div>Carbide shank</div><div>Dampened carbide shank</div></div></div><div>Silent Tools®</div></div></div></div></div>							
	Insert size, mm, (inch)	07 (1/4)	6-16 (5/32-3/8)	6-11 (5/32-1/4)				
	Bar diameter, mm	16	6-25	6-16	10-12			
	Bar diameter, inch	.625	.250-1.000	.250-.625	.375-.500			
Page	A313	A315	A315	A315				
<div>Insert size, mm, (inch)</div> <div>Bar diameter, mm</div> <div>Bar diameter, inch</div> <div>Page</div>	<div>Entering angle (Lead angle)</div> <div><div><div>$\kappa_r 95^\circ (-5^\circ)$<div><div><div>80°</div></div><div>SWLPR/L</div><div>Steel shank</div><div>Carbide shank</div></div><div><div>T-Max® top clamp design for ceramic inserts</div><div></div></div><div><div><div><div>CRSPR/L</div><div>CRSNR/L</div></div><div>Steel shank</div><div>Steel shank</div></div></div></div></div></div>							
	Insert size, mm, (inch)	02-04 (5/32-1/2)	02-04 (5/32-1/2)	Insert size, mm, (inch)	09 (3/8)	12 (1/2)		
	Bar diameter, mm	5-12	5-12	Bar diameter, mm	25	40		
	Bar diameter, inch	.187-.500	.187-.500					
Page	A317	A317	Page	A319	A319			

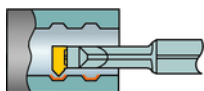
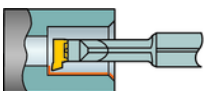
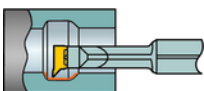
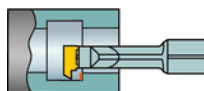
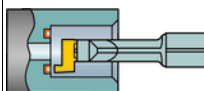
Tools for small part machining

CoroTurn® XS tools and inserts

CoroTurn® XS	Boring bar	Inserts			
		Entering angle (Lead angle) 45° (45°) Turning/profiling	90° (0°) Turning	98° (-8°) Copying	98° (-8°) Turning
	CXS	CXS T045	CXS T090	CXS TE98	CXS T098
Bar diameter, mm	10-28				
Bar diameter, inch	.500-1.000				
Insert size		05-07	04-05	04-06	04-07
Page	A342	A328	A328	A333	A329
Inserts 90° (0°) Back boring  CXS B 04-07 A333					
Grooving  CXS G 04-07 A334					
Profiling  CXS R 04-07 A337					
Face grooving  CXS F 06 A338					
Pre-parting  CXS GX 05 A338					
Threading  CXS TH 04-06 A339					

CoroCut® MB boring bars/inserts

CoroCut® MB	Steel shank boring bar	Carbide shank boring bar	Inserts		
			Grooving	Profiling	Pre-parting
	MB-A	MB-E	MB G	MB R	MB GX
Bar diameter, mm	16	12-16			
Bar diameter, inch	.625	.500-.625			
Insert size	07-09	07-09	07-09	07-09	07-09
Page	B106	B106	B94	B100	B100

CoroCut® MB	Inserts				
	Entering angle (Lead angle) 45° (45°) Turning/profiling	93° (-3°) Turning	93° (-3°) Copying	90° (0°) Back boring	Face grooving
	 MB T045 07	 MB T093 07	 MB TE 93 07	 MB B 030 07	 MB FA/FB 09
Insert size					
Page	B96	B96	B96	B96	B101

Code key for shank tools and Coromant Capto® boring bars

Coromant Capto®

C3	-	S	C	L	C	R	-	11065	-	09	
1		5	6	7	8	9		13		10	11

Shank tools, metric

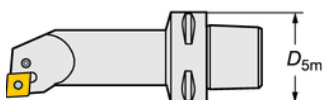
S	40	V	-	S	C	L	C	R	12		-	ID
2	3	4		5	6	7	8	9	10	11		12

Shank tools, inch

S	24	V	-	S	C	L	C	R	4	-	
2	3	4		5	6	7	8	9	10		11

1 Coupling size

C = Coromant Capto®
D_{5m} = Coupling size



	mm	inch
C3	D5m = 32	1.260
C4	D5m = 40	1.575
C5	D5m = 50	1.969
C6	D5m = 63	2.480
C8	D5m = 80	3.150

2 Type of bar

A = Solid steel bar with internal coolant supply.

E = Carbide shank bar

F = Dampened, carbide shank bar

S = Solid steel bar without coolant

3 Bar diameter

mm¹⁾ inch

03 = .1875

04 = .250

05 = .3125

06 = .375

08 = .500

10 = .625

12 = .750

16 = 1.000

20 = 1.250

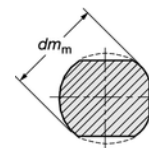
24 = 1.500

28 = 1.750

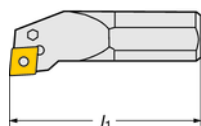
32 = 2.000

36 = 2.250

40 = 2.500

4 Tool length, l₁ mm, inch

Shank tool



	Metric	Inch		Metric	Inch
F =	80	3.250	S =	250	10.000
H =	100	4.000	T =	300	12.000
K =	125	5.000	U =	350	14.000
M =	150	6.000	V =	400	15.750
P =	170	6.250	W =	450	17.750
Q =	180	7.250	Y =	500	20.000
R =	200	8.000	X =	Special	

5 Clamping system

C



Top clamping

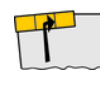
D

Top and hole
clamping (RC)

M,W

Top and hole
clamping

P








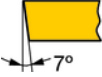















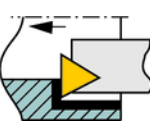
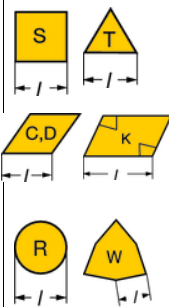
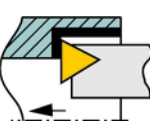
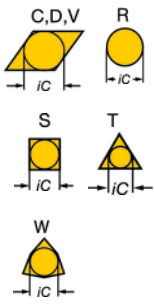
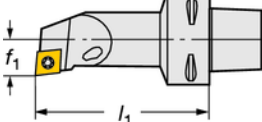
Hole clamping

S



Screw clamping

1) For metric bars dm_m in mm.

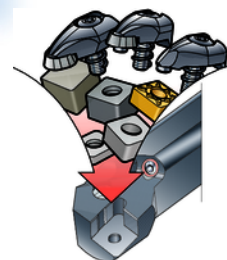
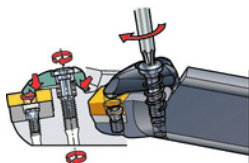
6 Insert shape		7 Bar style, lead angle (entering angle)		8 Clearance angle on major cutting edge	
C		D		B	
K		R		C	
S		T		D	
V		U		E	
		F		N	
		J		O	Specific description
		K		P	
		L			
		P			
		Q			
		U-X			
9 Hand of tool		10 Cutting edge length		11 Manufacturer's option	
R		Metric 		When required a supplementary symbol of max. 3 letters may be added to the ISO code, separated by a dash, e.g. C = Coolant thru capabilities. D = Extended f_1 dimension, + 1.0mm (.04") E = Extended f_1 dimension, + 2.0mm (.08") F = Extended f_1 dimension, + 3mm (.12") G = Altered dimensions L = Extended l_1 -dimension. R = Round shank W = Wedge design X = Back boring	
L		Inch 			
12 Clamping system Ceramics		13 Coromant Capto cutting unit size, mm			
ID = Clamp with pressure plate		$f_1 \times l_1$			
					
		Example C4-SCLCR 11065-09 $f_1 = 11$ mm (2 digits) $l_1 = 065$ mm (3 digits)			

CoroTurn® RC rigid clamping

Internal tools for T-Max P negative basic-shape inserts

First choice for stability and security in productive turning

CoroTurn® RC system is available in Coromant Capto® cutting units and conventional steel shank design for all insert shapes and lead angles



The 1st choice system for internal turning of large hole diameters, giving:

- Unique stability
- Excellent function even in dirty environments e.g. cast iron machining
- User-friendly handling; one Torx Plus key for insert and shim change
- Easy access even if holder is in up side down position

A flexible system

The tip seat on all CoroTurn® RC holders has been designed for total interchangeability by changing clamp set and/or shim.

CoroTurn® RC can hold:

- Cemented carbide inserts
- Ceramic inserts with holes
- Ceramic inserts without holes
- Different insert thicknesses

For further information see page A445.

Internal coolant supply

All Coromant Capto® and most of the conventional steel shank bars have internal coolant supply.

EasyFix sleeves

For round conventional boring bars the EasyFix sleeve is the best clamping method as it reduces set up time by guaranteeing the correct center height.

Modular internal solution

Negative basic-shape turning inserts and the CoroTurn® RC clamping system can also be used in the modular CoroTurn® SL system using exchangeable cutting heads and different types of boring bars, see page I11

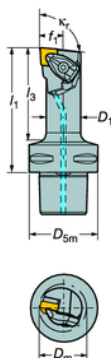


Coromant Capto® boring bars

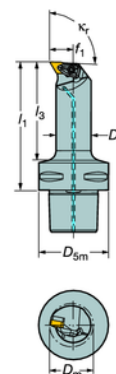
CoroTurn® RC rigid clamp

DCLNR/LEntering angle: $\kappa_r 95^\circ$ Lead angle: -5° **DDUNR/L**Entering angle: $\kappa_r 93^\circ$ Lead angle: -3° 

CNMM, CNGP
 CNMG
 CNMA, CNGA


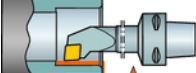



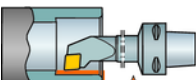
DNMM, DNGP,
DNMX
 DNMG
 DNMA, DNGA



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		Nm ³⁾
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI	
	09	3/8	C4-DCLNR/L-13080-09	40	25	20	13	80	57	-6°	-14°	CNMG 09 03 08	CNMG 322	1.7
				1.575	.984	.787	.512	3.150	2.244					
			C5-DCLNR/L-13080-09	50	25	20	13	80	56	-6°	-14°	CNMG 09 03 08	CNMG 322	1.7
					1.968	.984	.787	.512	3.150	2.205				
	12	1/2	C4-DCLNR/L-17090-12	40	32	25	17	90	68	-6°	-12°	CNMG 12 04 08	CNMG 432	3.9
				1.575	1.260	.984	.669	3.543	2.677					
			C5-DCLNR/L-17090-12	50	32	25	17	90	66	-6°	-12°	CNMG 12 04 08	CNMG 432	3.9
					1.968	1.260	.984	.669	3.543	2.598				
			C6-DCLNR/L-17100-12	63	32	25	17	100	72	-6°	-12°	CNMG 12 04 08	CNMG 432	3.9
				2.480	1.260	.984	.669	3.937	2.835					
16	5/8	C6-DCLNR/L-27140-16	63	50	40	27	140	114	-6°	-16°	CNMG 16 06 12	CNMG 543	6.4	
			2.480	1.968	1.575	1.063	5.512	4.488						

Main application		iC	Ordering code	Dimensions, mm, inch									Gauge inserts		Nm ³⁾
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI		
	11	3/8	C4-DDUNR/L-17090-11	40	32	25	17	90	68	-6°	-12°	DNMG 11 04 08	DNMG 332	1.7	
				1.575	1.260	.984	.669	3.543	2.677						
			C5-DDUNR/L-17090-11	50	32	25	17	90	66	-6°	-12°	DNMG 11 04 08	DNMG 332	1.7	
				1.968	1.260	.984	.669	3.543	2.598						
	15	1/2	C4-DDUNR/L-27080-15	40	50	39.7	27	80	59	-6°	-11°	DNMG 15 06 08	DNMG 442	3.9	
				1.575	1.968	1.563	1.063	3.150	2.323						
			C5-DDUNR/L-27140-15	50	50	40	27	140	118	-6°	-11°	DNMG 15 06 08	DNMG 442	3.9	
				1.968	1.968	1.575	1.063	5.512	4.646						
		C6-DDUNR/L-27140-15	63	50	40	27	140	114	-6°	-11°	DNMG 15 06 08	DNMG 442	3.9		
			2.480	1.968	1.575	1.063	5.512	4.488							

1) γ = Rake angle (valid with flat insert).

R = Right hand, L = Left hand

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

Main spare parts

For complete spare part list, see main catalogue.

Insert size

	iC		iC	Shim	Shim screw	Key (Torx Plus)	Complete clamp set
09	3/8			5322 236-04	5513 020-04	5680 051-03 (9IP)	5412 028-011
12	1/2			5322 236-03	5513 020-02	5680 049-01 (15IP)	5412 028-021
16	5/8			5322 234-03	5513 020-07	5680 043-14 (20IP)	5412 028-031
		11	3/8	5322 267-01	5513 020-04	5680 051-03 (9IP)	5412 028-011
		15	1/2	5322 266-02	5513 020-02	5680 049-01 (15IP)	5412 028-021



A9



A268



A482



G6



A2



J2

Coromant Capto® boring bars

CoroTurn® RC rigid clamp

Entering angle: **DTFNR/L**
 $\kappa_r 91^\circ$

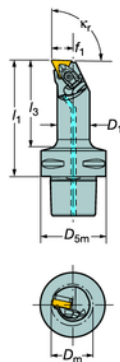
Lead angle: -1°

Entering angle: **DWLNRL/L**
 $\kappa_r 95^\circ$

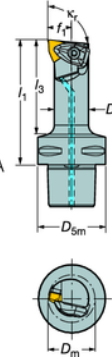
Lead angle: -5°



TNMM, TNMX
TNMG
TNMA, TNGA



WNMM,
WNMG
WNGA, WNMA



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				D_{5m}	$D_{m \min}$	D_1	f_1	l_1	l_3	γ^1	λ_s^2	ISO	ANSI	Nm ³⁾
	16	3/8	C4-DTFNR/L-17090-16	40	32	25	17	90	68	-6°	-12°	TNMG 16 04 08	TNMG 332	1.7
				1.575	1.260	.984	.669	3.543	2.677					
			C5-DTFNR/L-17090-16	50	32	25	17	90	66	-6°	-12°	TNMG 16 04 08	TNMG 332	1.7
				1.968	1.260	.984	.669	3.543	2.598					

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				D_{5m}	$D_{m \min}$	D_1	f_1	l_1	l_3	γ^1	λ_s^2	ISO	ANSI	Nm ³⁾
	06	3/8	C4-DWLNRL/L-13075-06	40	27	20	13	75	52	-6°	-17°	WNMG 06 04 08	WNMG 332	1.7
				1.575	1.063	.787	.512	2.953	2.047					
			C4-DWLNRL/L-17090-08	40	33	25	17	90	68	-6°	-12°	WNMG 08 04 08	WNMG 432	3.9
				1.575	1.299	.984	.669	3.543	2.677					
		1/2	C5-DWLNRL/L-17090-08	50	33	25	17	90	66	-6°	-12°	WNMG 08 04 08	WNMG 432	3.9
				1.968	1.299	.984	.669	3.543	2.598					

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

For complete spare part list, see main catalogue.

Insert size

	iC		iC	Shim	Screw	Key (Torx Plus)	Complete clamp set
16	3/8			5322 316-01	5513 020-04	5680 051-03 (9IP)	5412 028-011
		06	3/8	5322 328-01	5513 020-04	5680 051-03 (9IP)	5412 028-011
		08	1/2	5322 328-02	5513 020-02	5680 049-01 (15IP)	5412 028-021



A9



A268



A477



G6



A2



J2

Coromant Capto® boring bars

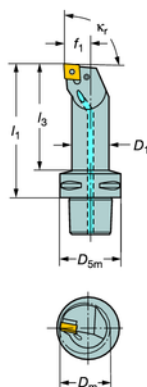
T-Max P lever clamp design

Entering angle:
Lead angle:

PCLNR/L
 $\kappa_r 95^\circ$
 -5°



CNMM, CNGP
 CNMG
 CNMA, CNGA



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts	
				D5m	Dm min	D1	f1	l1	l3	γ^1	λ_s^2	ISO	ANSI
	09	3/8	C4-PCLNR/L-13080-09	40	25	20	13	80	58	-6°	-11°	CNMG 09 03 08	CNMG 322
				1.575	.984	.787	.512	3.150	2.284				
			C5-PCLNR/L-13080-09	50	25	20	13	80	56	-6°	-11°	CNMG 09 03 08	CNMG 322
12	1/2	1/2	C3-PCLNR/L-17090-12	32	32	25	17	90	75	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.260	1.260	.984	.669	3.543	2.953				
			C3-PCLNR/L-22064-12	32	40	32	22	64	50	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.260	1.575	1.260	.866	2.520	1.968				
			C3-PCLNR/L-22096-12	32	40	32	22	96	82	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.260	1.575	1.260	.866	3.780	3.228				
			C4-PCLNR/L-17090-12	40	32	25	17	90	69	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.575	1.260	.984	.669	3.543	2.716				
			C4-PCLNR/L-22110-12	40	40	32	22	110	89	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.575	1.575	1.260	.866	4.331	3.504				
			C4-PCLNR/L-27080-12	40	50	40	27	80	60	-6°	-10°	CNMG 12 04 08	CNMG 432
				1.575	1.968	1.575	1.063	3.150	2.362				
			C4-PCLNR/L-27120-12	40	50	40	27	120	100	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.575	1.968	1.575	1.063	4.724	3.937				
			C5-PCLNR/L-17090-12	50	32	25	17	90	67	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.968	1.260	.984	.669	3.543	2.638				
			C5-PCLNR/L-22110-12	50	40	32	22	110	88	-6°	-11°	CNMG 12 04 08	CNMG 432
				1.968	1.575	1.260	.866	4.331	3.465				
16	5/8	5/8	C5-PCLNR/L-35100-12	50	63	50	35	100	81	-6°	-7°	CNMG 12 04 08	CNMG 432
				1.968	2.480	1.968	1.378	3.937	3.189				
			C6-PCLNR/L-17100-12	63	32	25	17	100	74	-6°	-11°	CNMG 12 04 08	CNMG 432
				2.480	1.260	.984	.669	3.937	2.913				
			C6-PCLNR/L-22110-12	63	40	32	22	110	84	-6°	-11°	CNMG 12 04 08	CNMG 432
				2.480	1.575	1.260	.866	4.331	3.307				
16	5/8	5/8	C5-PCLNR/L-35150-16	50	63	50	35	150	131	-6°	-11°	CNMG 16 06 12	CNMG 543
				1.968	2.480	1.968	1.378	5.906	5.158				
			C6-PCLNR/L-27140-16	63	50	40	27	140	115	-6°	-11°	CNMG 16 06 12	CNMG 543
16	5/8	5/8		2.480	1.968	1.575	1.063	5.512	4.528				
			C6-PCLNR/L-35175-16	63	63	50	35	175	152	-6°	-11°	CNMG 16 06 12	CNMG 543
				2.480	2.480	1.968	1.378	6.890	5.984				

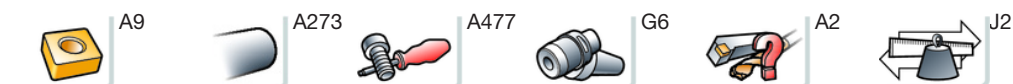
1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Bar dia., D1		Lever	Screw	Key (mm)	Shim
mm	inch	mm	inch				
09	3/8	20	.787	174.3-845-1	174.3-829	170.3-864 (1.98)	-
12	1/2	25	.984	438.3-841-1	438.3-832M	174.1-863 (2.5)	-
12	1/2	32-50	1.260-1.968	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M
16	5/8	40-50	1.575-1.968	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852



Coromant Capto® boring bars

T-Max P lever clamp design

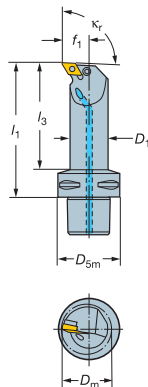
Entering angle:
Lead angle:

PDUNR/L

$\kappa_r 93^\circ$
 -3°



DNMM, DNGP,
DNMX
DNMG
DNMA, DNGA



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts	
				D5m	Dm min	D1	f1	l1	l3	γ^1	λ_s^2	ISO	ANSI
	11	3/8	C3-PDUNR/L-17090-11	32	32	25	17	90	75	-6°	-11°	DNMG 11 04 08	DNMG 332
				1.260	1.260	.984	.669	3.543	2.953				
			C4-PDUNR/L-17090-11	40	32	25	17	90	69	-6°	-11°	DNMG 11 04 08	DNMG 332
				1.575	1.260	.984	.669	3.543	2.716				
			C4-PDUNR/L-22110-11	40	40	32	22	110	89	-6°	-10°	DNMG 11 04 08	DNMG 332
				1.575	1.575	1.260	.866	4.331	3.504				
			C5-PDUNR/L-17090-11	50	32	25	17	90	67	-6°	-11°	DNMG 11 04 08	DNMG 332
				1.968	1.260	.984	.669	3.543	2.638				
			C5-PDUNR/L-22110-11	50	40	32	22	110	88	-6°	-10°	DNMG 11 04 08	DNMG 332
				1.968	1.575	1.260	.866	4.331	3.465				
	15	1/2	C4-PDUNR/L-27080-15	40	50	40	27	80	60	-6°	-11°	DNMG 15 06 08	DNMG 442
				1.575	1.968	1.575	1.063	3.150	2.362				
			C4-PDUNR/L-27120-15	40	50	40	27	120	100	-6°	-11°	DNMG 15 06 08	DNMG 442
				1.575	1.968	1.575	1.063	4.724	3.937				
			C5-PDUNR/L-27140-15	50	50	40	27	140	119	-6°	-11°	DNMG 15 06 08	DNMG 442
				1.968	1.968	1.575	1.063	5.512	4.685				
			C5-PDUNR/L-35100-15	50	63	50	35	100	81	-6°	-10°	DNMG 15 06 08	DNMG 442
				1.968	2.480	1.968	1.378	3.937	3.189				
			C5-PDUNR/L-35150-15	50	63	50	35	150	131	-6°	-10°	DNMG 15 06 08	DNMG 442
				1.968	2.480	1.968	1.378	5.906	5.158				
			C6-PDUNR/L-22110-15	63	40	32	22	110	84	-6°	-12°	DNMG 15 06 08	DNMG 442
				2.480	1.575	1.260	.866	4.331	3.307				
			C6-PDUNR/L-27140-15	63	50	40	27	140	115	-6°	-11°	DNMG 15 06 08	DNMG 442
				2.480	1.968	1.575	1.063	5.512	4.528				
			C6-PDUNR/L-35175-15	63	63	50	35	175	152	-6°	-10°	DNMG 15 06 08	DNMG 442
				2.480	2.480	1.968	1.378	6.890	5.984				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Bar dia., D1		Lever	Screw	Key (mm)	Shim
mm	inch						
11	3/8	25	.984	5432 015-021	438.3-830	174.1-870 (1.98)	-
11	3/8	32	1.260	5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01
15	1/2	40-50	1.575-1.968	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M



A9



A274



A477



G6



A2



J2

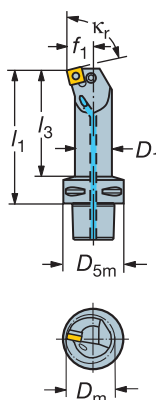
Coromant Capto® boring bars

T-Max P lever clamp design

Entering angle:
Lead angle:

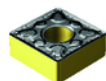
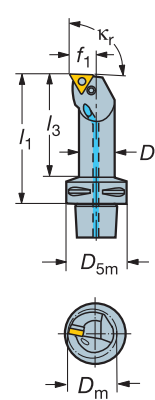
PSKNR/L

$\kappa_r 75^\circ$
 15°



PTFNR/L

$\kappa_r 91^\circ$
 -1°



SNMM
SNMG
SNMA, SNGA



TNMM, TNMX
TNMG
TNMA, TNGA

Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts	
				D_{5m}	$D_{m \min}$	D_1	f_1	l_1	l_3	γ^1	λ_s^2	ISO	ANSI
		12	C4-PSKNR-17090-12	40	32	25	17	90	69	-6°	-11°	SNMG 12 04 08	SNMG 432
			C5-PSKNR/L-27140-12	50	50	40	27	140	119	-6°	-10°	SNMG 12 04 08	SNMG 432
			C5-PSKNR-17090-12	50	32	25	17	90	67	-6°	-11°	SNMG 12 04 08	SNMG 432
			C5-PSKNR-22110-12	50	40	32	22	110	88	-6°	-10°	SNMG 12 04 08	SNMG 432
			C6-PSKNR-22110-12	63	40	32	22	110	84	-6°	-10°	SNMG 12 04 08	SNMG 432
			C6-PSKNR-22110-12	63	50	40	35	175	152	-6°	-9°	SNMG 15 06 08	SNMG 542
			C6-PSKNR/L-35175-15	63	50	40	35	175	152	-6°	-9°	SNMG 15 06 08	SNMG 542
			C6-PSKNR/L-35175-15	63	50	40	35	175	152	-6°	-9°	SNMG 15 06 08	SNMG 542
		11	C3-PTFNR/L-13075-11	32	25	20	13	75	59	-6°	-12°	TNMG 11 03 04	TNMG 221
			C4-PTFNR/L-13080-11	40	25	20	13	80	58	-6°	-12°	TNMG 11 03 04	TNMG 221
			C5-PTFNR/L-13080-11	50	25	20	13	80	56	-6°	-12°	TNMG 11 03 04	TNMG 221
			C5-PTFNR/L-13080-11	50	25	20	13	80	56	-6°	-12°	TNMG 11 03 04	TNMG 221
			C5-PTFNR/L-13080-11	50	25	20	13	80	56	-6°	-12°	TNMG 11 03 04	TNMG 221

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Bar dia., D1 mm (inch)	Lever	Screw	Key (mm)	Shim	
12	1/2	25 (.984)	438.3-841-1	438.3-832M	174.1-863 (2.5)	-	
12	1/2	32-40 (1.260-1.575)	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M	
15	5/8	50 (1.968)	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857	

Insert size							
	iC	Bar dia., D1 mm (inch)	Lever	Screw	Key (mm)	Shim	
11	1/4	20 (.767)	174.3-846-1	174.3-829	170.3-864 (1.98)	-	



A9



A274



A477



G6



A2



J2

Coromant Capto® boring bars

T-Max P wedge design

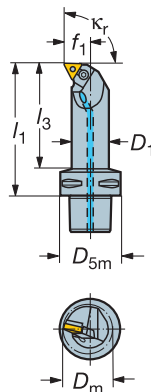
Entering angle:
Lead angle:

PTFNR/L-W

$\kappa_r 91^\circ$
 -1°



TNMM, TNMX
TNMG
TNMA, TNGA



Coolant inlet: Axial through the center

Right hand style shown

Main application	\triangle	i/C	Ordering code	Dimensions, mm, inch								Gauge inserts	
				D_{5m}	$D_{m \min}$	D_1	f_1	l_1	l_3	γ^1	λ_s^2	ISO	ANSI
 $\leq 24^\circ$	16	3/8	C3-PTFNR-17090-16W	32	32	25	17	90	75	-6°	-13°	TNMG 16 04 08	TNMG 332
			C4-PTFNR/L-17090-16W	1.260	1.260	.984	.669	3.543	2.953	-6°	-13°	TNMG 16 04 08	TNMG 332
			C4-PTFNR/L-22110-16W	40	32	25	17	90	69	-6°	-13°	TNMG 16 04 08	TNMG 332
			C4-PTFNR/L-22110-16W	1.575	1.260	.984	.669	3.543	2.716	-6°	-12°	TNMG 16 04 08	TNMG 332
			C4-PTFNR/L-27120-16W	40	40	32	22	110	89	-6°	-12°	TNMG 16 04 08	TNMG 332
			C4-PTFNR/L-27120-16W	1.575	1.575	1.260	.866	4.331	3.504	-6°	-11°	TNMG 16 04 08	TNMG 332
			C5-PTFNR/L-17090-16W	50	32	25	17	90	67	-6°	-13°	TNMG 16 04 08	TNMG 332
			C5-PTFNR/L-22110-16W	1.968	1.260	.984	.669	3.543	2.638	-6°	-12°	TNMG 16 04 08	TNMG 332
			C5-PTFNR/L-27140-16W	1.968	1.575	1.260	.866	4.331	3.465	-6°	-11°	TNMG 16 04 08	TNMG 332
			C5-PTFNR/L-27140-16W	1.968	1.968	1.575	1.063	5.512	4.685	-6°	-12°	TNMG 16 04 08	TNMG 332
			C6-PTFNR/L-22110-16W	63	40	32	22	110	84	-6°	-12°	TNMG 16 04 08	TNMG 332
			C6-PTFNR/L-27140-16W	2.480	1.575	1.260	.866	4.331	3.307	-6°	-11°	TNMG 16 04 08	TNMG 332
	22	1/2	C4-PTFNR-27120-22W	40	50	40	27	120	100	-6°	-11°	TNMG 22 04 08	TNMG 432
			C5-PTFNL-35150-22W	1.575	1.968	1.575	1.063	4.724	3.937	-6°	-10°	TNMG 22 04 08	TNMG 432
			C5-PTFNR/L-27140-22W	50	63	50	35	150	131	-6°	-10°	TNMG 22 04 08	TNMG 432
			C5-PTFNR/L-27140-22W	1.968	2.480	1.968	1.378	5.906	5.158	-6°	-11°	TNMG 22 04 08	TNMG 432
			C6-PTFNR/L-27140-22W	50	50	40	27	140	119	-6°	-11°	TNMG 22 04 08	TNMG 432
			C6-PTFNR/L-27140-22W	1.968	1.968	1.575	1.063	5.512	4.685	-6°	-11°	TNMG 22 04 08	TNMG 432
			C6-PTFNR/L-35175-22W	63	50	40	27	140	115	-6°	-11°	TNMG 22 04 08	TNMG 432
			C6-PTFNR/L-35175-22W	2.480	1.968	1.575	1.063	5.512	4.528	-6°	-10°	TNMG 22 04 08	TNMG 432
				2.480	2.480	1.968	1.378	6.890	5.984				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size									
\triangle	i/C	Bar dia., D1		Wedge set	Key (mm)	Shim	Pin	Screw	Key (Torx Plus)
mm	inch	mm	inch						
16	3/8	25	.984	170.38-823-2	174.1-864 (3.0)	-	5313 021-01	5512 031-01	5680 051-03 (9IP)
16	3/8	32-40	1.260-1.575	170.38-823-1	174.1-864 (3.0)	170.3-852	5313 021-02	5512 031-01	5680 051-03 (9IP)
22	1/2	40	1.575	170.38-824-1	3021 010-040 (4.0)	170.3-855	5313 021-03	5512 031-02	5680 049-02 (15IP)
22	1/2	50	1.969	170.38-821-1	3021 010-040 (4.0)	170.3-852	5313 021-02	5512 031-01	5680 051-03 (9IP)



A9



A275



A480



G6



A2



J2

Coromant Capto® boring bars

T-Max P wedge clamp design

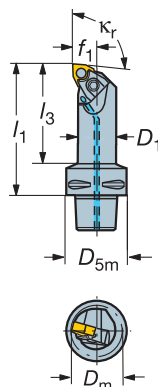
Entering angle:
Lead angle:

MWLN/L

$\kappa_r 95^\circ$
 -5°


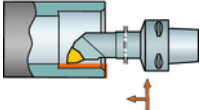


WNMM,
WNMG
WNGA, WNMA



Coolant inlet: Axial through the center

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI	
	06	3/8	C3-MWLN/L-13075-06	32	25	20	13	75	59	-6°	-14°	WNMG 06 04 08	WNMG 332	
			C3-MWLN/L-17090-06M1	32	32	25	17	90	75	-6°	-12°	WNMG 06 04 08	WNMG 332	
			C4-MWLN/L-13075-06	40	25	20	13	75	53	-6°	-14°	WNMG 06 04 08	WNMG 332	
	08	1/2	C4-MWLN/L-17090-06M1	40	32	25	17	90	69	-6°	-12°	WNMG 06 04 08	WNMG 332	
			C4-MWLN/L-17090-08	40	32	25	17	90	69	-6°	-14°	WNMG 08 04 08	WNMG 432	
			C4-MWLN/L-22110-08	40	40	32	22	110	89	-6°	-14°	WNMG 08 04 08	WNMG 432	
			C4-MWLN/L-27120-08	40	50	40	27	120	100	-6°	-12°	WNMG 08 04 08	WNMG 432	
			C4-MWLN/L-27120-08	40	50	40	27	120	100	-6°	-12°	WNMG 08 04 08	WNMG 432	
			C5-MWLN/L-17090-08	50	32	25	17	90	67	-6°	-14°	WNMG 08 04 08	WNMG 432	
			C5-MWLN/L-22110-08	50	40	32	22	110	88	-6°	-14°	WNMG 08 04 08	WNMG 432	
			C5-MWLN/L-27140-08	50	50	40	27	140	119	-6°	-12°	WNMG 08 04 08	WNMG 432	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size								
Δ	iC	Bar dia., D1 mm inch	Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm)
06	3/8	20-25 .787-.984	5431 125-011	170.3-860 (2.5)	-	5313 022-02	-	-
08	1/2	25 .984	5431 125-021	174.1-864 (3.0)	5322 331-09	5313 022-03	-	-
08	1/2	32 1.260	5431 125-021	174.1-864 (3.0)	5322 331-07	5313 022-03	-	-
		40 1.575	5431 125-021	174.1-864 (3.0)	5322 331-07	5313 022-03	5512 030-04	174.1-863 (2.5)



A9



A276



A480



G6



A2



J2

Coromant Capto® boring bars

T-Max P screw and top clamp design

Entering angle:
Lead angle:

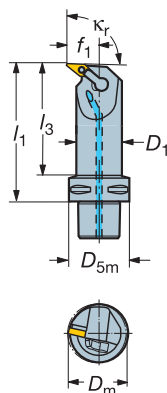
MVUNR/L

$\kappa_r 93^\circ$
 -3°



VNMG

VNGP



Coolant inlet: Axial through the center

Right hand style shown

Main application		i/C	Ordering code	Dimensions, mm, inch								Gauge inserts	
				D_{5m}	$D_{m\ min}$	D_1	f_1	l_1	l_3	γ^1	λ_s^2	ISO	ANSI
	16	3/8	C4-MVUNR/L-27120-16	40	50	40	27	120	100	-6°	-10°	VNMG 16 04 08	VNMG 332
			C5-MVUNR/L-27140-16	1.575	1.968	1.575	1.063	4.724	3.937				
				50	50	40	27	140	119	-6°	-10°	VNMG 16 04 08	VNMG 332
			C5-MVUNR/L-35150-16	1.968	1.968	1.575	1.063	5.512	4.685				
				50	63	50	35	150	131	-6°	-10°	VNMG 16 04 08	VNMG 332
			C6-MVUNL-22120-16	1.968	2.480	1.968	1.378	5.906	5.158				
				63	40	32	22	120	94	-6°	-12°	VNMG 16 04 08	VNMG 332
			C6-MVUNR-35175-16	2.480	1.575	1.260	.866	4.724	3.701				
				63	63	50	35	175	152	-6°	-10°	VNMG 16 04 08	VNMG 332
				2.480	2.480	1.968	1.378	6.890	5.984				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	i/C	Clamp	Clamp screw	Key (mm)		Lock pin	Shim
16	3/8	MC-12	MS-510	3021 011-532 (3.96)		MN-34L	174.1-870 (1.98)
							MVN-322



Boring bars

CoroTurn® RC rigid clamp design

Cylindrical with flats

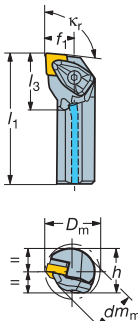
Entering angle:
Lead angle:

A...-DCLNR/L

$\kappa_r 95^\circ$
 -5°



CNMM, CNGP
 CNMG
 CNMA, CNGA



Max overhang $4 \times d_m$

All with internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	09	A25T-DCLNR/L 09	25	32	17	23	300	31	-6°	-11°	CNMG 09 03 08	1.7
	12	A25T-DCLNR/L 12	25	32	17	23	300	31	-6°	-12°	CNMG 12 04 08	3.9
		A32T-DCLNR/L 12	32	40	22	30	300	30	-6°	-10°	CNMG 12 04 08	3.9
		A40T-DCLNR/L 12	40	50	27	37	300	32	-6°	-15°	CNMG 12 04 08	3.9
	16	A50U-DCLNR/L 16	50	63	35	47	350	38	-6°	-13°	CNMG 16 06 12	6.4

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	A12S-DCLNR/L 3	.750	1.000	.500	.709	10.000	1.024	-6°	-14°	CNMG 322	1.3
		A16T-DCLNR/L 3	1.000	1.201	.640	.906	12.000	1.339	-6°	-11°	CNMG 322	1.3
		A20T-DCLNR/L 3	1.250	1.468	.765	1.181	12.000	1.299	-6°	-9°	CNMG 322	1.3
	1/2	A16T-DCLNR/L 4	1.000	1.280	.640	.906	12.000	1.339	-6°	-12°	CNMG 432	2.9
		A20T-DCLNR/L 4	1.250	1.468	.765	1.181	12.000	1.299	-6°	-11°	CNMG 432	2.9
		A24T-DCLNR/L 4	1.500	1.760	.890	1.374	12.000	1.575	-6°	-16°	CNMG 432	2.9
	5/8	A24T-DCLNR/L 5	1.500	1.760	.890	1.374	12.000	1.575	-6°	-18°	CNMG 543	4.7
		A32U-DCLNR/L 5	2.000	2.402	1.281	1.874	14.000	1.700	-6°	-14°	CNMG 543	4.7
		A40V-DCLNR/L 5	2.500	3.032	1.531	2.374	15.752	1.710	-6°	-11°	CNMG 543	4.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
	iC	Bar dia, d_m		Shim	Shim screw	Key (Torx Plus)	Complete clamp set
		mm	inch				
09	3/8	25	.750-1.250	5322 236-04	5513 020-04	5680 051-03 (9IP)	5412 028-011
12	1/2	25-32	1.000-1.500	5322 236-03	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾
12	1/2	40	-	5322 234-01	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾
16	5/8	50	1.500-2.500	5322 234-03	5513 020-07	5680 043-14 (20IP)	5412 028-031 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



Boring bars

CoroTurn® RC rigid clamp design

Cylindrical with flats

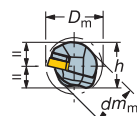
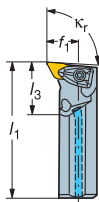
Entering angle:

Lead angle:

A...-DDUNR/L

 $\kappa_r 93^\circ$ -3° 

DNMM, DNGP, DNMX
 DNMG
 DNMA, DNGA

Max overhang $4 \times d_m$

All with internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	11	A25T-DDUNR/L 11	25	32	17	23	300	28	-6°	-12°	DNMG 11 04 08	1.7
		A32T-DDUNR/L 11	32	40	22	30	300	30	-6°	-10°	DNMG 11 04 08	1.7
	15	A40T-DDUNR/L 15	40	50	27	37	300	36	-6°	-11°	DNMG 15 06 08	3.9
		A50U-DDUNR/L 15	50	63	35	47	350	39	-6°	-8°	DNMG 15 06 08	3.9

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	A12S-DDUNR/L 3	.750	1.201	.625	.709	10.000	.945	-6°	-12°	DNMG 332	1.3
		A16T-DDUNR/L 3	1.000	1.299	.750	.906	12.000	1.142	-6°	-12°	DNMG 332	1.3
		A20T-DDUNR/L 3	1.250	1.705	1.000	1.181	12.000	1.181	-6°	-9°	DNMG 332	1.3
	1/2	A16T-DDUNR/L 4	1.000	1.500	.750	.906	12.000	1.142	-6°	-15°	DNMG 442	2.9
		A20T-DDUNR/L 4	1.250	1.705	1.000	1.181	12.000	1.181	-6°	-13°	DNMG 442	2.9
		A24T-DDUNR/L 4	1.500	2.000	1.125	1.374	12.000	1.299	-6°	-11°	DNMG 442	2.9
		A32U-DDUNR/L 4	2.000	2.673	1.500	1.874	14.000	1.410	-6°	-8°	DNMG 442	2.9
		A40V-DDUNR/L 4	2.500	3.248	1.750	2.374	15.752	1.490	-6°	-7°	DNMG 442	2.9

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
	iC	Bar dia, d_m		Shim	Shim screw	Key (Torx Plus)	Complete clamp set
		mm	inch				
11	3/8	25-32	.750-1.250	5322 267-01	5513 020-04	5680 051-03 (9IP)	5412 028-011
15	1/2	40-50	1.000-2.500	5322 266-02	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.

A9



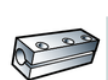
A476



G6



A2



A320



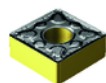
J2

Boring bars

CoroTurn® RC rigid clamp design

Cylindrical with flats

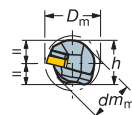
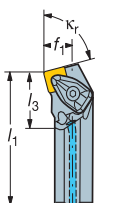
Entering angle:
Lead angle:



SNMM
SNMG
SNMA, SNGA

DSKNR/L

$\kappa_r 75^\circ$
 15°

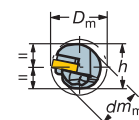
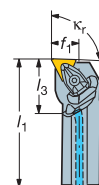


DTFNR/L

$\kappa_r 91^\circ$
 -1°



TNMM, TNMX
TNMG
TNMA, TNGA



Max overhang 4 x dm_m
All with internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	09	A25T-DSKNR/L 09	dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$	SNMG 09 03 08	1.7
	12	A25T-DSKNR/L 12	25	32	17	23	300	30	-6°	-9°	SNMG 12 04 08	3.9
		A32T-DSKNR/L 12	32	40	22	30	300	33	-6°	-9°	SNMG 12 04 08	3.9
		A40T-DSKNR/L 12	40	50	27	37	300	34	-6°	-13°	SNMG 12 04 08	3.9
Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	16	A25T-DTFNR/L 16	dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$	TNMG 16 04 08	1.7
		A32T-DTFNR/L 16	25	32	17	23	300	32	-6°	-12°	TNMG 16 04 08	1.7
		A40T-DTFNR/L 16	32	40	22	30	300	33	-6°	-10°	TNMG 16 04 08	1.7
		A40T-DTFNR/L 16	40	50	27	37	300	36	-6°	-8°	TNMG 16 04 08	1.7
	22	A40T-DTFNR/L 22	40	50	27	37	300	36	-6°	-13°	TNMG 22 04 08	3.9
		A50U-DTFNR/L 22	50	63	35	47	350	39	-6°	-10°	TNMG 22 04 08	3.9

Inch version

Main application		Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/2	A16T-DSKNR/L 4	dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$	SNMG 432	2.9
		A20T-DSKNR/L 4	1.000	1.280	.640	.906	12.000	1.260	-6°	-11°	SNMG 432	2.9
		A24T-DSKNR/L 4	1.250	1.468	.765	1.181	12.000	1.417	-6°	-9°	SNMG 432	2.9
			1.500	1.760	.890	1.374	12.000	1.654	-6°	-15°	SNMG 432	2.9
Main application		Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	3/8	A12S-DTFNR/L 3	dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$	TNMG 332	1.3
		A16T-DTFNR/L 3	.750	1.024	.500	.709	10.000	1.181	-6°	-14°	TNMG 332	1.3
		A16T-DTFNR/L 3	1.000	1.201	.640	.906	12.000	1.339	-6°	-12°	TNMG 332	1.3
		A20T-DTFNR/L 3	1.250	1.468	.765	1.181	12.000	1.417	-6°	-11°	TNMG 332	1.3
		A24T-DTFNR/L 3	1.500	1.760	.890	1.374	12.000	1.417	-6°	-9°	TNMG 332	1.3
	1/2	A24T-DTFNR/L 4	1.500	1.760	.890	1.374	12.000	1.417	-6°	-15°	TNMG 432	2.9
		A32U-DTFNR/L 4	2.000	2.402	1.281	1.874	14.000	1.520	-6°	-11°	TNMG 432	2.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

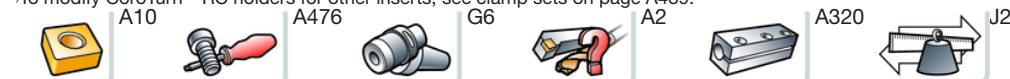
R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size				Bar dia, dm_m				Bar dia, dm_m				Shim		Shim screw		Key (Torx Plus)		Complete clamp set	
	iC	mm	inch		iC	mm	inch		iC	mm	inch								
09	3/8	25	-									5322 426-01		5513 020-04		5680 051-03 (9IP)		5412 028-011	
12	1/2	25-32	1.000-1.250									5322 426-02		5513 020-02		5680 049-01 (15IP)		5412 028-021 ¹⁾	
12	1/2	40	1.500									5322 425-01		5513 020-02		5680 049-01 (15IP)		5412 028-021 ¹⁾	
				16	3/8	25-40	.750-1.500					5322 316-01		5513 020-04		5680 051-03 (9IP)		5412 028-011	
				22	1/2	40-50	1.500-2.000					5322 315-04		5513 020-02		5680 049-01 (15IP)		5412 028-021 ¹⁾	

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.

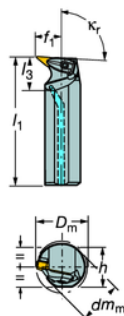


CoroTurn® RC rigid clamp design

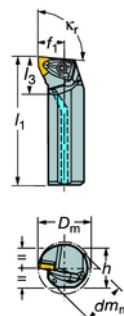
Entering angle:
Lead angle:





Metric version

$$\kappa_r 93^\circ - 3^\circ$$



WNMM,
WNMG
WNGA, WNMA

 $\kappa_r 95^\circ$
 -5° [illegible]

			Dimensions, mm										
Main application		Ordering code	dm_m	$D_{m \min}$	f_1	h	l_1	l_3	$\gamma^{1)}$	$\lambda_{s2)}$	Gauge inserts	Nm ³⁾	
	06	A25T-DWLNR/L 06	25	32	17	23	300	31	-6°	-14°	WNMG 06 04 08	1.7	
		A32T-DWLNR/L 06	32	40	22	30	300	33	-6°	-11°	WNMG 06 04 08	1.7	
		A40T-DWLNR/L 06	40	50	27	37	300	36	-6°	-9°	WNMG 06 04 08	1.7	
	08	A25T-DWLNR/L 08	25	32	17	23	300	31	-6°	-12°	WNMG 08 04 08	3.9	
		A32T-DWLNR/L 08	32	40	22	30	300	33	-6°	-10°	WNMG 08 04 08	3.9	
		A40T-DWLNR/L 08	40	50	27	37	300	36	-6°	-13°	WNMG 08 04 08	3.9	
		A50U-DWLNR/L 08	50	63	35	47	350	39	-6°	-11°	WNMG 08 04 08	3.9	

Inch version

[illegible]

			Dimensions, inch									
Main application	iC	Ordering code	dm_m	D_m min	f_1	h	l_1	l_3	$\gamma^{(1)}$	$\lambda_s^{(2)}$	Gauge inserts	ft-lbs ⁴⁾
	3/8	A16T-DWLNR/L 3	1.000	1.299	.750	.906	12.000	1.339	-6°	-14°	WNMG 332	1.3
		A20T-DWLNR/L 3	1.250	1.705	1.000	1.181	12.000	1.339	-6°	-10°	WNMG 332	1.3
	1/2	A16T-DWLNR/L 4	1.000	1.299	.750	.906	12.000	1.339	-6°	-12°	WNMG 432	2.9
		A20T-DWLNR/L 4	1.250	1.705	1.000	1.181	12.000	1.339	-6°	-15°	WNMG 432	2.9
		A24T-DWLNR/L 4	1.500	2.000	1.000	1.374	12.000	1.339	-6°	-13°	WNMG 432	2.9
		A32U-DWLNR/L 4	2.000	2.500	1.325	1.874	14.000	1.339	-6°	-11°	WNMG 432	2.9

1) γ = Rake angle (valid with flat insert).



2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

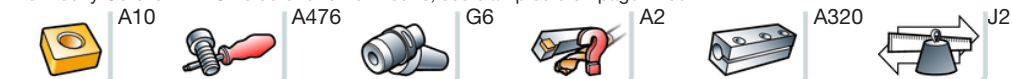
4) Insert tightening torque ft-lbs.

R = Right hand. L = Left hand

Main spare parts

Insert size				Bar dia, dm_m					
	iC		iC	mm	Inch	Shim	Shim screw	Key (Torx Plus)	Complete clamp set
16	3/8			40	1.500	5322 269-01	5513 020-09	5680 049-01 (15IP)	5412 028-061
		06	3/8	25-40	1.000-1.250	5322 328-01	5513 020-04	5680 051-03 (9IP)	5412 028-011
		08	1/2	25-32	1.000-1.250	5322 328-02	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾
				40-50	1.500-2.000	5322 331-12	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.



Boring bars

T-Max® P lever design

Cylindrical with flats

Entering angle:
Lead angle:

A...PCLNR/L

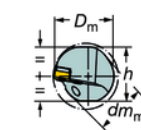
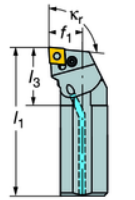
$\kappa_r 95^\circ$
-5°

S...-PCLNR/L

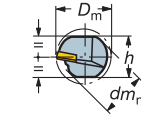
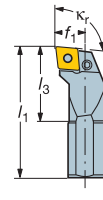
$\kappa_r 95^\circ$
-5°



CNMM, CNGP
 CNMG
 CNMA, CNGA



With internal coolant supply



Without internal coolant supply

Max overhang 4 x dm_m

Right hand style shown

Metric version

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts	
				dm_m	$D_{m \min}$	f_1	h	l_1	l_3	γ^1	λ_s^2	ISO	
	09	3/8	A16R-PCLNR/L 09	16	20	11	15	200	30.8	-6°	-13°	CNMG 09 03 08	
				.630	.787	.433	.591	7.874	1.213				
			A20S-PCLNR/L 09	20	25	13	18	250	31.1	-6°	-11°	CNMG 09 03 08	
				.787	.984	.512	.709	9.842	1.224				
			A25T-PCLNR/L 09	25	32	17	23	300	34.9	-6°	-10°	CNMG 09 03 08	
				.984	1.260	.669	.906	11.811	1.374				
	12	1/2	S16R-PCLNR/L 09	16	20	11	15	200	26	-6°	-13°	CNMG 09 03 08	
				.630	.787	.433	.591	7.874	1.024				
			S20S-PCLNR/L 09	20	25	13	18	250	29	-6°	-11°	CNMG 09 03 08	
				.787	.984	.512	.709	9.842	1.142				
			S25T-PCLNR/L 09	25	32	17	23	300	33	-6°	-10°	CNMG 09 03 08	
				.984	1.260	.669	.906	11.811	1.299				
	16	5/8	A25T-PCLNR/L 12	25	32	17	23	300	39.3	-6°	-10°	CNMG 12 04 08	
				.984	1.260	.669	.906	11.811	1.547				
			A32T-PCLNR/L 12	32	41.5	22	30	300	40	-6°	-11°	CNMG 12 04 08	
				1.260	1.634	.866	1.181	11.811	1.575				
	19	3/4	A40T-PCLNR/L 12	40	50	27	37	300	45.6	-6°	-10°	CNMG 12 04 08	
				1.575	1.968	1.063	1.457	11.811	1.795				
			A50U-PCLNR/L 16	50	63	35	47	350	55.4	-6°	-11°	CNMG 16 06 12	
				1.968	2.480	1.378	1.850	13.780	2.181				
	16	5/8	S50W-PCLNR/L 16	50	63	35	47	450	56	-6°	-11°	CNMG 16 06 12	
				1.968	2.480	1.378	1.850	17.716	2.205				
			A50U-PCLNR/L 19	50	63	35	47	350	60.7	-6°	-11°	CNMG 19 06 12	
				1.968	2.480	1.378	1.850	13.780	2.390				
	19	3/4	S50W-PCLNR/L 19	50	63	35	47	450	63	-6°	-11°	CNMG 19 06 12	
				1.968	2.480	1.378	1.850	17.716	2.480				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
	iC	Bar dia, dm_m		Lever	Screw	Key (mm)	Shim
		mm	Inch				
09	3/8	16-25	.630-.984	174.3-845-1	174.3-829	170.3-864 (1.98)	-
12	1/2	25	.984	438.3-841-1	438.3-832M	174.1-863 (2.5)	-
12	1/2	32	1.260	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M
12	1/2	40	1.575	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M
16	5/8	50	1.969	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852
19	3/4	50	1.969	174.3-849M	174.3-822M	3021 010-040 (4.0)	171.31-851M



Boring bars

T-Max® P lever design

Cylindrical with flats

Entering angle: A...-PDUNR/L
 $\kappa_r 93^\circ$ S...-PDUNR/L
 $\kappa_r 93^\circ$ A...PSKNR/L
 $\kappa_r 75^\circ$

Lead angle: -3°

-3°

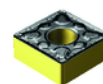
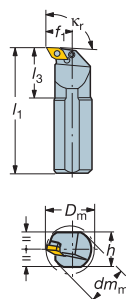
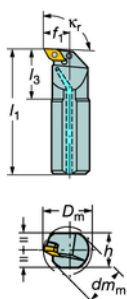
15°



DNMM, DNGP,
DNMX

DNMG

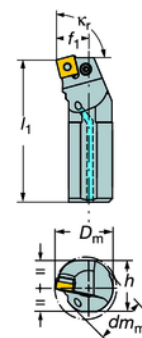
DNMA, DNGA



SNMM

SNMG

SNMA, SNGA

Max overhang 4 x dm_m

With internal coolant supply

Without internal coolant supply

With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^1)$	$\lambda_s^{2)}$		
	11	A25T-PDUNR/L 11	25	32	17	23	300	39.4	-6°	-11°	DNMG 11 04 08	2.0
		A32T-PDUNR/L 11	32	40	22	30	300	41	-6°	-10°	DNMG 11 04 08	2.0
		S25T-PDUNR/L 11	25	32	17	23	300	35	-6°	-11°	DNMG 11 04 08	2.0
		S32U-PDUNR/L 11	32	40	22	30	350	40	-6°	-10°	DNMG 11 04 08	2.0
	15	A40T-PDUNR/L 15	40	50	27	37	400	49.7	-6°	-11°	DNMG 15 06 08	5.0
		A50U-PDUNR/L 15	50	63	35	47	350	54.2	-6°	-10°	DNMG 15 06 08	5.0
		S40V-PDUNR/L 15	40	50	27	37	400	56	-6°	-11°	DNMG 15 06 08	5.0
		S50W-PDUNR/L 15	50	63	35	47	450	63	-6°	-10°	DNMG 15 06 08	5.0
Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^1)$	$\lambda_s^{2)}$		
	12	A25T-PSKNR/L 12	25	32	17	23	300	39.7	-6°	-11°	SNMG 12 04 08	5.0
		A32T-PSKNR/L 12	32	40	22	30	300	41.7	-6°	-10°	SNMG 12 04 08	5.0
		A40T-PSKNR/L 12	40	50	27	37	300	45.7	-6°	-10°	SNMG 12 04 08	5.0
	19	A50U-PSKNR/L 19	50	63	35	47	350	61	-6°	-9°	SNMG 19 06 12	10.0

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
	Bar dia, dm_m		Bar dia, dm_m				
	mm	iC	mm	Lever	Screw	Key (mm)	Shim
11	25			5432 015-021	438.3-830	174.1-870 (1.98)	-
11	32			5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01
15	40-50			174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M
		12	1/2 25	438.3-841-1	438.3-832M	174.1-863 (2.5)	-
		12	1/2 32	174.3-848M	174.3-858	174.1-864 (3.0)	174.3-851M
		12	1/2 40	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M



A9



A264



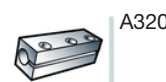
A477



G6



A2



A320



J2

Boring bars

Cylindrical with flats

Entering angle:

Lead angle:

T-Max® P lever design

A...-PTFNR/L

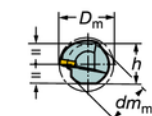
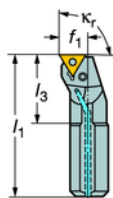
 $\kappa_r 91^\circ$ -1°

T-Max P wedge design

S...PTFNR/L-W

 $\kappa_r 91^\circ$ -1° 

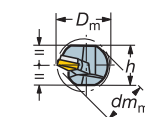
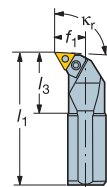
TNMM, TNMX
 TNMG
 TNMA, TNGA



With internal coolant supply



TNMM, TNMX
 TNMG
 TNMA, TNGA



Without internal coolant supply

Max overhang $4 \times dm_m$

Right hand style shown


Metric version


Main application		Ordering code	Dimensions, mm								Gauge inserts
			dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	
		11 A16R-PTFNR/L 11	16	20	11	15	200	27.4	-6°	-14°	TNMG 11 03 04
		A20S-PTFNR/L 11	20	25	13	18	250	30	-6°	-12°	TNMG 11 03 04
		A25T-PTFNR/L 11	25	32	17	23	300	34	-6°	-10°	TNMG 11 03 04
		S16R-PTFNR/L 11	16	20	11	15	200	27	-6°	-14°	TNMG 11 03 04
		S20S-PTFNR/L 11	20	25	13	18	250	30	-6°	-12°	TNMG 11 03 04
		S25T-PTFNR/L 11	25	32	17	23	300	34	-6°	-10°	TNMG 11 03 04
Main application		Ordering code	Dimensions, mm								Gauge inserts
			dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	
		16 S25T-PTFNR/L 16-W	25	32	17	23	300	36.8	-6°	-13°	TNMG 16 04 08
		S32U-PTFNR/L 16-W	32	40	22	30	350	45	-6°	-12°	TNMG 16 04 08
		S40V-PTFNR/L 16-W	40	50	27	37	400	49.5	-6°	-11°	TNMG 16 04 08
		S50W-PTFNR/L 16-W	50	63	35	47	450	56	-6°	-10°	TNMG 16 04 08
		22 S40V-PTFNR/L 22-W	40	50	27	37	400	58.9	-6°	-11°	TNMG 22 04 08
		S50W-PTFNR/L 22-W	50	63	35	47	450	65.9	-6°	-10°	TNMG 22 04 08

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	Bar dia, dm_m mm	Lever	Screw	Key (mm)			
11	16-25	174.3-846-1	174.3-829	170.3-864 (1.98)			

Insert size							
	Bar dia, dm_m mm	Wedge set	Key (mm)	Shim	Pin	Screw	Key (mm/Torx Plus)
16	25	170.38-823-2	174.1-864 (3.0)	-	5313 021-01	5512 031-01	5680 051-03 (9IP)
16	32-40	170.38-823-1	174.1-864 (3.0)	170.3-852	5313 021-02	5512 031-01	5680 051-03 (9IP)
16	50	170.38-823-1	174.1-864 (3.0)	170.3-852	5313 021-02	3212 100-206	174.1-870 (1.98)
22	40-50	170.38-824-1	3021 010-040 (4.0)	170.3-855	5313 021-03	5512 031-02	5680 049-02 (15IP)



Boring bars

T-Max P wedge clamp design

Cylindrical with flats

Entering angle:
Lead angle:

A...-MWLNR/L

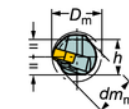
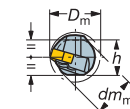
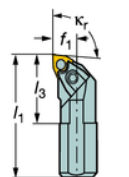
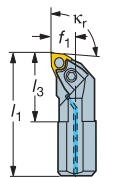
$\kappa_r 95^\circ$
-5°

S...-MWLNR/L

$\kappa_r 95^\circ$
-5°



WNMM,
WNMG
WNGA, WNMA



With internal coolant supply

Max overhang $4 \times dm_m$

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts
	06	A20S-MWLNR/L 06	20	25	13	18	250	32.3	-6°	-14°	WNMG 06 04 08
		A25T-MWLNR/L 06	25	32	17	23	300	31.7	-6°	-12°	WNMG 06 04 08
		A32U-MWLNR/L 06	32	40	22	30	350	40	-6°	-14°	WNMG 06 04 08
	08	A25T-MWLNR/L 08	25	32	17	23	300	39.9	-6°	-14°	WNMG 08 04 08
		A32U-MWLNR/L 08	32	40	22	30	350	40	-6°	-14°	WNMG 08 04 08
		A40V-MWLNR/L 08	40	50	27	37	400	56	-6°	-12°	WNMG 08 04 08
		A50W-MWLNR/L 08	50	63	35	47	450	60	-6°	-10°	WNMG 08 04 08

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts
	3/8	S16T-MWLNR/L 3	1.000	1.280	.640	.710	12.000	1.250	6°	-12°	WNMG 332
		S20U-MWLNR/L 3	1.250	1.530	.760	.910	14.000	1.250	6°	-15°	WNMG 332
		S24V-MWLNR/L 3	1.500	2.252	1.125	1.110	15.750	1.570	6°	-12°	WNMG 332
		S32W-MWLNR/L 3	2.000	2.559	1.281	1.310	17.750	1.570	6°	-12°	WNMG 332
	1/2	S16T-MWLNR/L 4	1.000	1.280	.640	.910	12.000	1.570	6°	-14°	WNMG 432
		S20U-MWLNR/L 4	1.250	1.530	.760	1.180	14.000	1.250	6°	-14°	WNMG 432
		S24V-MWLNR/L 4	1.500	2.252	1.125	1.110	15.750	1.570	6°	-14°	WNMG 432
		S32W-MWLNR/L 4	2.000	2.559	1.281	1.310	17.750	1.570	6°	-14°	WNMG 432

1) γ = Rake angle (valid with flat insert).

R = Right hand, L = Left hand

2) λ_s = Angle of inclination.

For coolant connector, see page A324.

Main spare parts

Insert size									
	iC	Bar dia, dm_m		Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm)
06	3/8	-	1.000	5431 125-011	170.3-860 (2.5)	-	5313 022-02	5512 030-03	170.3-864 (1.98)
06	3/8	20	-	5431 125-011	170.3-860 (2.5)	-	5313 022-02	-	-
06	3/8	-	1.250	5431 125-011	170.3-860 (2.5)	5322 331-06	5313 022-01	5512 030-03	170.3-864 (1.98)
06	3/8	-	1.500	5431 125-011	170.3-860 (2.5)	-	5313 022-01	5512 030-03	170.3-864 (1.98)
06	3/8	25	-	5431 125-011	170.3-860 (2.5)	5322 331-11	5313 022-02	5512 030-03	170.3-864 (1.98)
06	3/8	32	-	5431 125-011	170.3-860 (2.5)	5322 331-06	5313 022-01	5512 030-03	170.3-864 (1.98)
06	3/8	-	2.000	5431 125-011	170.3-860 (2.5)	-	5313 022-02	5512 030-03	170.3-864 (1.98)
08	1/2	25	1.000	5431 125-021	174.1-864 (3.0)	5322 331-09	5313 022-03	-	-
08	1/2	32-50	1.250-2.000	5431 125-021	174.1-864 (3.0)	5322 331-07	5313 022-03	5512 030-04	174.1-863 (2.5)



A9



A267



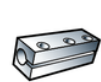
A480



G6



A2



A320



J2

Boring bars

T-Max P screw and top clamp design

Cylindrical with flats

Entering angle:
Lead angle:

S...-MVUNR/L

κ_r 93°
-3°

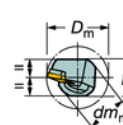
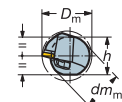
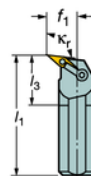
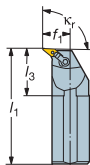
R/LVMJN

κ_r 93°
-3°



VNMG

VNGP



Without internal coolant supply

Max overhang 4 x dm_m

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts
			dm_m	D_m min	f_1	h	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	
	16	S40V-MVUNR/L 16	40	50	27	37	400	56	-6°	-10°	VNMG 16 04 08

Inch version

Main application		Ordering code	Dimensions, inch								Gauge inserts
			dm_m	D_m min	f_1	h	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	
	3/8	R/LVMJN 20 3	1.250	2.250	1.125	1.180	14.000	5.000	-5°	-12°	VNMG 332
		LVMJN 24 3	1.500	2.500	1.225	1.370	15.000	6.000	-5°	-12°	VNMG 332

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size									
Bar dia, dm_m									
	iC	mm	Inch	Clamp	Clamp screw	Key (inch)	Shim	Lock pin	Key (inch)
16	3/8	40	1.250-1.500	MC-12	MS-510	3021 011-532 (5/32)	MVN-322	MN-34L	174.1-870 (5/64)



A9



G6



A2



A320



J2

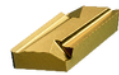
Boring bars for copying

T-Max® top clamp design

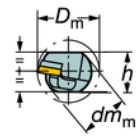
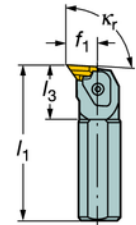
Cylindrical with flats

Entering angle:
Lead angle:

CKUNR/L
 $\kappa_r 93^\circ$
 -3°



KNUX, KNMX



Tools in right hand (R) style must be used with left hand (L) inserts, and left hand (L) tools with right hand (R) inserts.

Without internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts
			dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	γ^1	λ_s^2	
	16	S32U-CKUNR/L 16	32	44	22	30	350	54	-6°	-10°	KNUX 16 04 05R
		S40V-CKUNR/L 16	40	48	27	37	400	60	-6°	-8°	KNUX 16 04 05R

- 1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Clamp	Clamp	Screw	Key (mm)	Shim for	Shim for
Right hand	Left hand			Right hand bars	Left hand bars
170.5-825	170.5-824	170.5-865	3021 010-040 (4.0)	L170.5-851 ¹⁾ L170.5-852 ²⁾ L170.5-850 ³⁾	R170.5-851 ¹⁾ R170.5-852 ²⁾ R170.5-850 ³⁾

- 1) Fitted as standard: For inserts with $r_c = 1.0$ mm.
2) Optional shim delivered to separate order. For insert with $r_c = 6.5$ mm
3) Optional shim delivered to separate order. For insert with $r_c = 1.5$ mm

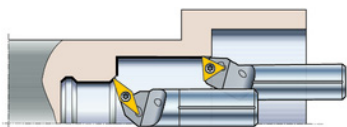


CoroTurn® 107/111 screw clamping

Internal tools for positive basic-shape inserts with 7° and 11° clearance angle

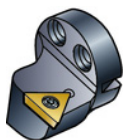
For light roughing to finishing of small, long and slender components, ideal for copy machining

CoroTurn® 107/111 systems are available as Coromant Capto® cutting units and conventional steel shank design for all insert shapes and lead angles



A screw clamping system, providing:

- Secure insert clamping
- Excellent repeatability
- Unhampered chip flow
- Few spare parts



CoroTurn® SL the modular internal solution

Positive CoroTurn® 107 and 111 systems can also be used in the modular CoroTurn® SL system using exchangeable cutting heads and different types of boring bars, see page I11

Different types of bars

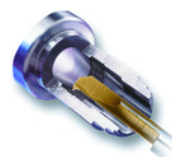
Both CoroTurn® 107 and 111 boring bars are available as:

- Solid steel, for overhang up to 4 x bar dia.
- Carbide reinforced, for overhang up to 6 x bar dia.
- Carbide reinforced and dampened, for overhang up to 10 x bar dia.



Correct clamping with EasyFix

Fast, simple and correct setting of center height due to spring loaded plunger. Available for all cylindrical boring bars. For more information see page A320

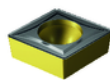


CoroTurn® XS

For even smaller bores, down to 0.3 mm (0.012 inch), use CoroTurn® XS tools. See page A325

Coromant Capto® boring bars

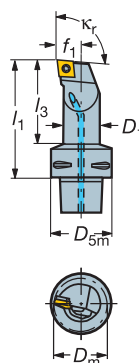
CoroTurn® 107 screw clamp design



CCMT, CCGT
CCGX, CCET
CCMW


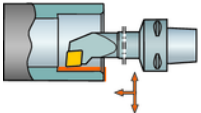
Entering angle:
Lead angle:

SCLCR/L

 $\kappa_r 95^\circ$
 -5°


Coolant inlet: Radial through the taper

Right hand style shown

Main application		i/C	Ordering code	Dimensions, mm, inch									Gauge inserts		
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾	
	09	3/8	C3-SCLCR/L-11065-09	32	20	16	11	65	48	0°	-12°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.260	.787	.630	.433	2.559	1.890						
			C3-SCLCR/L-13075-09	32	25	20	13	75	59	0°	-8°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.260	.984	.787	.512	2.953	2.323						
			C3-SCLCR/L-17090-09	32	32	25	17	90	75	0°	-6°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.260	1.260	.984	.669	3.543	2.953						
			C4-SCLCR/L-11070-09	40	20	16	11	70	47	0°	-12°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.575	.787	.630	.433	2.756	1.850						
			C4-SCLCR/L-13080-09	40	25	20	13	80	58	0°	-8°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.575	.984	.787	.512	3.150	2.284						
			C4-SCLCR/L-17090-09	40	32	25	17	90	69	0°	-6°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.575	1.260	.984	.669	3.543	2.716						
			C4-SCLCR/L-27080-09	40	50	40	27	80	60	0°	-6°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.575	1.968	1.575	1.063	3.150	2.362						
			C5-SCLCR/L-11070-09	50	20	16	11	70	46	0°	-12°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				1.968	.787	.630	.433	2.756	1.811						
C5-SCLCR/L-13080-09	50	25	20	13	80	56	0°	-8°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0				
	1.968	.984	.787	.512	3.150	2.205									
C5-SCLCR/L-17090-09	50	32	25	17	90	67	0°	-6°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0				
	1.968	1.260	.984	.669	3.543	2.638									
C5-SCLCR/L-35100-09	50	63	50	35	100	81	0°	-4°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0				
	1.968	2.480	1.968	1.378	3.937	3.189									
	12	1/2	C3-SCLCR/L-17090-12	32	32	25	17	90	75	0°	-6°	CCMT 12 04 08	CCMT 432	3.0	
				1.260	1.260	.984	.669	3.543	2.953						
			C3-SCLCR/L-22064-12	32	40	32	22	64	50	0°	-10°	CCMT 12 04 08	CCMT 432	3.0	
				1.260	1.575	1.260	.866	2.520	1.968						
			C3-SCLCR/L-22096-12	32	40	32	22	96	82	0°	-10°	CCMT 12 04 08	CCMT 432	3.0	
				1.260	1.575	1.260	.866	3.780	3.228						
			C4-SCLCR/L-17090-12	40	32	25	17	90	69	0°	-6°	CCMT 12 04 08	CCMT 432	3.0	
				1.575	1.260	.984	.669	3.543	2.716						
			C4-SCLCR/L-22110-12	40	40	32	22	110	89	0°	-10°	CCMT 12 04 08	CCMT 432	3.0	
				1.575	1.575	1.260	.866	4.331	3.504						
			C4-SCLCR/L-27080-12	40	50	40	27	80	60	0°	-8°	CCMT 12 04 08	CCMT 432	3.0	
				1.575	1.968	1.575	1.063	3.150	2.362						
			C5-SCLCR/L-17090-12	50	32	25	17	90	67	0°	-6°	CCMT 12 04 08	CCMT 432	3.0	
				1.968	1.260	.984	.669	3.543	2.638						
			C5-SCLCR/L-22110-12	50	40	32	22	110	88	0°	-10°	CCMT 12 04 08	CCMT 432	3.0	
				1.968	1.575	1.260	.866	4.331	3.465						
C5-SCLCR/L-27140-12	50	50	40	27	140	119	0°	-8°	CCMT 12 04 08	CCMT 432	3.0				
	1.968	1.968	1.575	1.063	5.512	4.685									
C5-SCLCR-35100-12	50	63	50	35	100	80	0°	-5°	CCMT 12 04 08	CCMT 432	3.0				
	1.968	2.480	1.968	1.378	3.937	3.150									

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Bar dia., D1 mm Inch	Insert screw (Thread)	Shim	Shim screw (Thread)	Key (Torx Plus/mm)
09	3/8	16-20 .630-.787	5513 020-09 (M3.5)	-	-	5680 049-01 (15IP/3.5)
09	3/8	25 .984	5513 020-10 (M3.5)	-	-	5680 049-01 (15IP/3.5)
09	3/8	40 - 50 1.563-1.968	5513 020-01 (M3.5)	5322 232-01	5512 090-01 (M3.5)	5680 049-01 (15IP/3.5)
12	1/2	25 .984	5513 020-17 (M4x0.5)	-	-	5680 049-02 (15IP/4.0)
12	1/2	32 - 50 1.248-1.968	5513 020-18 (M4x0.5)	5322 232-02	5512 090-03 (M3.5)	5680 049-02 (15IP/4.0)



A9



A268



A482



G6



A2



J2

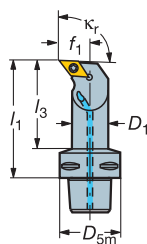
Coromant Capto® boring bars

CoroTurn® 107 screw clamp design

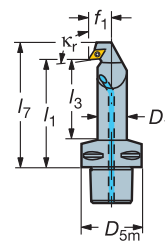
Entering angle:
Lead angle:

DCMT, DCMX
DCGT, DCGX, DCET
DCMW

SDUCR/L



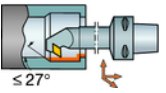
 $\kappa_r 93^\circ$
 -3°


SDUCR/L-X

 $\kappa_r 93^\circ$
 -3°


Back boring

Coolant inlet: Radial through the taper
Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch										Gauge inserts		
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	l ₇	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾	
	07	1/4	C3-SDUCR/L-11065-07	32	20	16	11	65	48		0°	-8°	DCMT 07 02 04	DCMT 2(1.5)1	0.9	
				1.260	.787	.630	.433	2.559	1.890		0°	-8°	DCMT 07 02 04	DCMT 2(1.5)1	0.9	
			C4-SDUCR/L-11070-07	40	20	16	11	70	47		0°	-8°	DCMT 07 02 04	DCMT 2(1.5)1	0.9	
				1.575	.787	.630	.433	2.756	1.850		0°	-8°	DCMT 07 02 04	DCMT 2(1.5)1	0.9	
	11	3/8	C5-SDUCR/L-11070-07	50	20	16	11	70	46		0°	-8°	DCMT 07 02 04	DCMT 2(1.5)1	0.9	
				1.968	.787	.630	.433	2.756	1.811		0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C3-SDUCR/L-13075-11	32	25	20	13	75	59		0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.260	.984	.787	.512	2.953	2.323		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C3-SDUCR/L-17090-11	32	32	25	17	90	75		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.260	1.260	.984	.669	3.543	2.953		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C3-SDUCR/L-22064-11	32	40	32	22	64	50		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.260	1.575	1.260	.866	2.520	1.968		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
	07	1/4	C3-SDUCR/L-22096-11	32	40	32	22	96	82		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.260	1.575	1.260	.866	3.780	3.228		0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C4-SDUCR/L-13080-11	40	25	20	13	80	58		0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.575	.984	.787	.512	3.150	2.284		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C4-SDUCR/L-17090-11	40	32	25	17	90	69		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.575	1.260	.984	.669	3.543	2.716		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C4-SDUCR/L-22110-11	40	40	32	22	110	89		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.575	1.575	1.260	.866	4.331	3.504		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C4-SDUCR/L-27080-11	40	50	40	27	80	60		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.575	1.968	1.575	1.063	3.150	2.362		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
			C5-SDUCR/L-13080-11	50	25	20	13	80	56		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
				1.968	.984	.787	.512	3.150	2.205		0°	-3.5°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0	
		C5-SDUCR/L-17090-11	50	32	25	17	90	67		0°	-3.5°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0		
			1.968	1.260	.984	.669	3.543	2.638		0°	-7.5°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0		
		C5-SDUCR/L-22110-11	50	40	32	22	110	88		0°	-7.5°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0		
			1.968	1.575	1.260	.866	4.331	3.465		0°	-3.5°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0		
		C5-SDUCR/L-35100-11	50	63	50	35	100	80		0°	-3.5°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0		
			1.968	2.480	1.968	1.378	3.937	3.150								

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size

	Bar dia., D1					
	iC	mm	inch	Insert screw (thread)	Shim	Shim screw (thread)
07	1/4	16-25	.630-.984	5513 020-03 (M2.5)	-	-
11	3/8	20-25	.787-.984	5513 020-10 (M3.5)	-	-
11	3/8	32-50	1.260-1.968	5513 020-01 (M3.5)	5322 263-01	5512 090-01 (M3.5)



A9



A268



A482



G6



A2



J2

Coromant Capto® boring bars

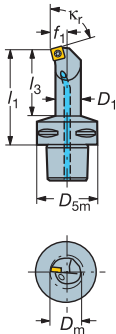
CoroTurn® 107 screw clamp design



SCMT, SCGX
SCMW

Entering angle:
Lead angle:

SSKCR/L
 $\kappa_r 75^\circ$
 15°



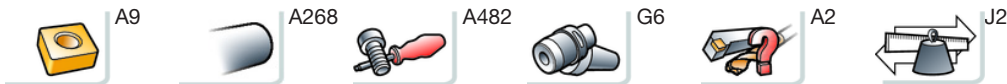
Coolant inlet: Radial through the taper
Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				D_{5m}	$D_{m\min}$	D_1	f_1	l_1	l_3	γ^1	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾
		09	C4-SSKCR-13080-09	40	25	20	13	80	58	0°	-6°	SCMT 09 T3 08	SCMT 3(2.5)2	3.0
				1.575	.984	.787	.512	3.150	2.284					
				50	25	20	13	80	56	0°	-6°	SCMT 09 T3 08	SCMT 3(2.5)2	3.0
			C5-SSKCR/L-13080-09	1.968	.984	.787	.512	3.150	2.205					

- 1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.
3) Insert tightening torque Nm.
- R = Right hand, L = Left hand

Main spare parts

Insert size			
	iC	Insert screw (thread)	Key (Torx plus/mm)
09	3/8	5513 020-09 (M3.5)	5680 049-01 (15IP/3.5)



Coromant Capto® boring bars

CoroTurn® 107 screw clamp design

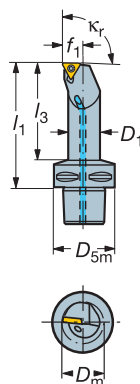
Entering angle:
Lead angle:

STFCR/L

$\kappa_r 91^\circ$
 -1°



TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW



Coolant inlet: Radial through the taper
Right hand style shown

Main application		iC	Ordering code ⁴⁾	Dimensions, mm, inch								Gauge inserts		Nm ³⁾
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI	
	11	1/4	C3-STFCR/L-11065-11-B1	32	20	16	11	65	48	0°	-4°	TCMT 11 03 04	TCMT 221	0.9
				1.260	.787	.630	.433	2.559	1.890					
			C3-STFCR/L-13075-11-B1	32	25	20	13	75	59	0°	-3°	TCMT 11 03 04	TCMT 221	0.9
				1.260	.984	.787	.512	2.953	2.323					
			C4-STFCR/L-11070-11-B1	40	20	16	11	70	47	0°	-4°	TCMT 11 03 04	TCMT 221	0.9
				1.575	.787	.630	.433	2.756	1.850					
			C4-STFCR/L-13080-11-B1	40	25	20	13	80	57	0°	-3°	TCMT 11 03 04	TCMT 221	0.9
				1.575	.984	.787	.512	3.150	2.244					
			C5-STFCR/L-11070-11-B1	50	20	16	11	70	46	0°	-4°	TCMT 11 03 04	TCMT 221	0.9
				1.968	.787	.630	.433	2.756	1.811					
			C5-STFCR/L-13080-11-B1	50	25	20	13	80	56	0°	-3°	TCMT 11 03 04	TCMT 221	0.9
				1.968	.984	.787	.512	3.150	2.205					
			C3-STFCR/L-11065-11	32	20	16	11	65	48	0°	-4°	TCMT 11 02 04	TCMT 2(1.5)1	0.9
				1.260	.787	.630	.433	2.559	1.890					
			C3-STFCR/L-13075-11	32	25	20	13	75	59	0°	-3°	TCMT 11 02 04	TCMT 2(1.5)1	0.9
				1.260	.984	.787	.512	2.953	2.323					
	16	3/8	C4-STFCR/L-11070-11	40	20	16	11	70	47	0°	-4°	TCMT 11 02 04	TCMT 2(1.5)1	0.9
				1.575	.787	.630	.433	2.756	1.850					
			C4-STFCR/L-13080-11	40	25	20	13	80	57	0°	-3°	TCMT 11 02 04	TCMT 2(1.5)1	0.9
				1.575	.984	.787	.512	3.150	2.244					
			C5-STFCR/L-11070-11	50	20	16	11	70	46	0°	-4°	TCMT 11 02 04	TCMT 2(1.5)1	0.9
				1.968	.787	.630	.433	2.756	1.811					
			C5-STFCR/L-13080-11	50	25	20	13	80	56	0°	-3°	TCMT 11 02 04	TCMT 2(1.5)1	0.9
				1.968	.984	.787	.512	3.150	2.205					
			C3-STFCR-17090-16	32	32	25	17	90	74	0°	-3.5°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
				1.260	1.260	.984	.669	3.543	2.913					
			C4-STFCR/L-17090-16	40	32	25	17	90	69	0°	-6°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
				1.575	1.260	.984	.669	3.543	2.716					
			C4-STFCR/L-22110-16	40	40	32	22	110	89	0°	-10°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
				1.575	1.575	1.260	.866	4.331	3.504					
			C5-STFCR/L-17090-16	50	32	25	17	90	67	0°	-6°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
				1.968	1.260	.984	.669	3.543	2.638					
			C5-STFCR/L-22110-16	50	40	32	22	110	88	0°	-10°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0
				1.968	1.575	1.260	.866	4.331	3.465					

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Bar dia., D1 mm	inch	Insert screw (thread)	Shim	Shim screw (thread)	Key (Torx Plus/mm)
11	1/4	16-20	.630-.787	5513 020-03 (M2.5)	-	-	5680 051-02 (7IP)
16	3/8	25	.984	5513 020-10 (M3.5)	-	-	5680 049-01 (15IP)
16	3/8	32	1.260	5513 020-01 (M3.5)	5322 320-01	5512 090-01 (M5)	5680 049-01 (15IP/3.5)
				A9	A298	A482	G6
				A2	J2		

Coromant Capto® boring bars

CoroTurn® 107 screw clamp design

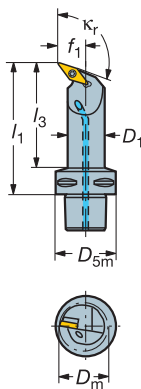
Entering angle:
Lead angle:

SVQBR/L


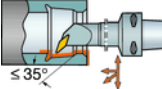
κ_r 107.5°
-17.5°



VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW



Coolant inlet: Radial through the taper
Right hand style shown

Main application		iC	Ordering code ⁴⁾	Dimensions, mm, inch								Gauge inserts		
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾
	11	1/4	C3-SVQBR/L-13070-11-B1	32	22	16	13	70	53.4	0°	-7°	VBMT 11 03 04	VBMT 221	0.9
			C3-SVQBR/L-15080-11-B1	1.260	.866	.630	.512	2.756	2.102	0°	-5°	VBMT 11 03 04	VBMT 221	0.9
			C4-SVQBR/L-13070-11-B1	32	27	20	15	80	63.9	0°	-5.5°	VBMT 11 03 04	VBMT 221	0.9
			C4-SVQBR/L-15080-11-B1	1.260	1.063	.787	.591	3.150	2.516	0°	-5.5°	VBMT 11 03 04	VBMT 221	0.9
			C5-SVQBR/L-15080-11-B1	40	25	20	15	80	56.5	0°	-5°	VBMT 11 03 04	VBMT 221	0.9
				1.968	1.063	.787	.591	3.150	2.224					
	11	1/4	C3-SVQBR/L-13070-11	32	22	16	13	70	54	0°	-7°	VBMT 11 02 04	VBMT 2(1.5)1	0.9
			C3-SVQBR/L-15080-11	1.260	.866	.630	.512	2.756	2.126	0°	-5°	VBMT 11 02 04	VBMT 2(1.5)1	0.9
			C4-SVQBR/L-13070-11	32	27	20	15	80	64	0°	-7°	VBMT 11 02 04	VBMT 2(1.5)1	0.9
			C4-SVQBR/L-15080-11	1.260	1.063	.787	.591	3.150	2.520	0°	-5°	VBMT 11 02 04	VBMT 2(1.5)1	0.9
			C5-SVQBR/L-15080-11	40	25	20	15	80	57	0°	-5°	VBMT 11 02 04	VBMT 2(1.5)1	0.9
				1.968	1.063	.787	.591	3.150	2.244					

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

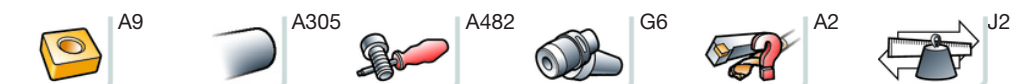
3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts (see next page)

Continued...



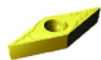
Coromant Capto® boring bars

CoroTurn® 107 screw clamp design

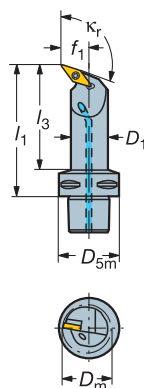
Entering angle:
Lead angle:

SVQBR/L

κ_r 107.5°
-17.5°


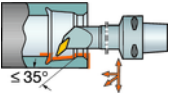


VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW



... Continued

Coolant inlet: Radial through the taper
Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch								Gauge inserts		
				D _{5m}	D _{m min}	D ₁	f ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾
	16	3/8	C3-SVQBR/L-18090-16	32	33	25	18	90	75	0°	-6°	VBMT 16 04 08	VBMT 332	3.0
				1.260	1.299	.984	.709	3.543	2.953					
			C3-SVQBR/L-22096-16	32	40	32	22	96	82	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				1.260	1.575	1.260	.866	3.780	3.228					
			C3-SVQBR-22064-16	32	40	32	22	64	49	0°	-7.5°	VBMT 16 04 08	VBMT 332	3.0
				1.260	1.575	1.260	.866	2.520	1.929					
			C4-SVQBR/L-18090-16	40	33	25	18	90	69	0°	-6°	VBMT 16 04 08	VBMT 332	3.0
				1.575	1.299	.984	.709	3.543	2.716					
			C4-SVQBR/L-22110-16	40	40	32	22	110	89	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				1.575	1.575	1.260	.866	4.331	3.504					
			C4-SVQBR/L-27080-16	40	50	40	27	80	60	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				1.575	1.968	1.575	1.063	3.150	2.362					
			C4-SVQBR/L-27120-16	40	50	40	27	120	100	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				1.575	1.968	1.575	1.063	4.724	3.937					
			C5-SVQBR/L-18090-16	50	33	25	18	90	67	0°	-6°	VBMT 16 04 08	VBMT 332	3.0
				1.968	1.299	.984	.709	3.543	2.638					
			C5-SVQBR/L-22110-16	50	40	32	22	110	88	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				1.968	1.575	1.260	.866	4.331	3.465					
			C5-SVQBR/L-27140-16	50	50	40	27	140	119	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				1.968	1.968	1.575	1.063	5.512	4.685					
			C5-SVQBR/L-35100-16	50	63	50	35	100	81	0°	-7°	VBMT 16 04 08	VBMT 332	3.0
				1.968	2.480	1.968	1.378	3.937	3.189					
			C5-SVQBR/L-35150-16	50	63	50	35	150	131	0°	-7°	VBMT 16 04 08	VBMT 332	3.0
				1.968	2.480	1.968	1.378	5.906	5.158					
			C6-SVQBR/L-22120-16	63	40	32	22	120	94	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				2.480	1.575	1.260	.866	4.724	3.701					
			C6-SVQBR/L-27145-16	63	50	40	27	145	120	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				2.480	1.968	1.575	1.063	5.709	4.724					
			C6-SVQBR/L-35175-16	63	63	50	35	175	152	0°	-8°	VBMT 16 04 08	VBMT 332	3.0
				2.480	2.480	1.968	1.378	6.890	5.984					

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size		Bar dia., D1		Insert screw (thread)	Shim	Shim screw (thread)	Key (Torx Plus/mm)
	iC	mm	inch				
11	1/4	16-20	.630-.787	5513 020-03 (M2.5)	-	-	5680 051-02 (7IP)
16	3/8	25	.984	5513 020-10 (M2.5)	-	-	5680 049-01 (15IP/3.5)
16	3/8	32-50	1.248-1.969	5513 020-01 (M2.5)	5322 270-01	5512 090-01 (M5x0.5)	5680 049-01 (15IP/3.5)



A9



A305



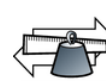
A482



G6



A2



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Entering angle:
Lead angle:

Steel shank

A...-SCLCR/L

$\kappa_r 95^\circ$

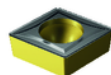
-5°

Carbide shank

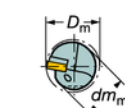
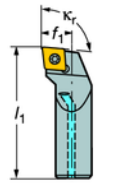
E...-SCLCR/L

$\kappa_r 95^\circ$

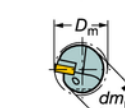
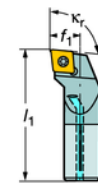
-5°



CCMT, CCGT
CCGX, CCET
CCMW



4 x dm_m



6 x dm_m

Max overhang

With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm						Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	06	A08H-SCLCR/L 06-R	8	10	5	100	0°	-14°	CCMT 06 02 04	0.9
		A10K-SCLCR/L 06-R	10	12	6	125	0°	-11°	CCMT 06 02 04	0.9
		A12M-SCLCR/L 06-R	12	16	9	150	0°	-7°	CCMT 06 02 04	0.9
		A16R-SCLCR/L 06-R	16	20	11	200	0°	-5°	CCMT 06 02 04	0.9
		A16R-SCLCR/L 09-R	16	20	11	200	0°	-8°	CCMT 09 T3 08	3.0
	09	A20S-SCLCR/L 09-R	20	25	13	250	0°	-6°	CCMT 09 T3 08	3.0
		E08K-SCLCR/L 06-R	8	10	5	125	0°	-10°	CCMT 06 02 04	0.9
		E10M-SCLCR/L 06-R	10	12	6	150	0°	-7°	CCMT 06 02 04	0.9
		E12Q-SCLCR/L 06-R	12	16	9	180	0°	-3°	CCMT 06 02 04	0.9
		E16R-SCLCR/L 06-R	16	20	11	200	0°	0°	CCMT 06 02 04	0.9
	09	E16R-SCLCR/L 09-R	16	20	11	200	0°	0°	CCMT 09 T3 08	3.0
		E20S-SCLCR/L 09-R	20	25	13	220	0°	-6°	CCMT 09 T3 08	3.0
		E25T-SCLCR/L 09-R	25	32	17	270	0°	-3°	CCMT 09 T3 08	3.0

Inch version

Main application		iC	Ordering code	Dimensions, inch						Gauge inserts	ft-lbs ⁴⁾
				dm_m	$D_m \text{ min}$	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	1/4	1/4	A06M-SCLCR/L 2-R	.375	.480	.250	6.000	0°	-11°	CCMT 2(1.5)1	0.5
			A08M-SCLCR/L 2-R	.500	.598	.312	6.000	0°	-8°	CCMT 2(1.5)1	0.5
			A10R-SCLCR/L 2-R	.625	.772	.406	8.000	0°	-5°	CCMT 2(1.5)1	0.5
			A10R-SCLCR/L 3-R	.625	.772	.406	8.000	0°	-9°	CCMT 3(2.5)2	2.2
			A12S-SCLCR/L 3-R	.750	.929	.500	10.000	0°	-6°	CCMT 3(2.5)2	2.2
	3/8	1/4	E05K-SCLCR/L 2-R	.312	.413	.219	5.000	0°	-13°	CCMT 2(1.5)1	0.7
			E06M-SCLCR/L 2-R	.375	.480	.250	6.000	0°	-11°	CCMT 2(1.5)1	0.7
			E08R-SCLCR/L 2-R	.500	.598	.312	8.000	0°	-8°	CCMT 2(1.5)1	0.7
			E10R-SCLCR/L 2-R	.625	.772	.406	8.000	0°	-5°	CCMT 2(1.5)1	0.7
			E10R-SCLCR/L 3-R	.625	.772	.406	8.000	0°	-9°	CCMT 3(2.5)2	2.2
	3/8	3/8	E12R-SCLCR/L 3-R	.750	.929	.500	8.752	0°	-6°	CCMT 3(2.5)2	2.2
			E16S-SCLCR/L 3-R	1.000	1.201	.640	10.752	0°	-4°	CCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

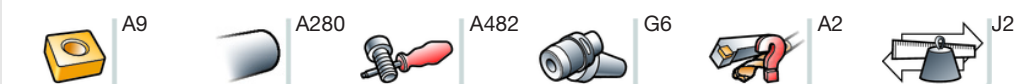
3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

For coolant connector, see page A324.

Main spare parts

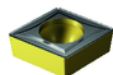
Insert size					
	iC	Bar dia, dm_m mm	inch	Insert screw	Key (Torx Plus)
06	1/4	8-10	.312	5513 020-46	5680 051-02 (7IP)
06	1/4	12-16	.375-.750	5513 020-03	5680 051-02 (7IP)
09	3/8	16-25	.625-1.000	5513 020-09	5680 049-01 (15IP)



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats



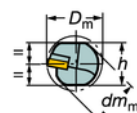
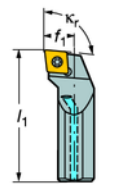
CCMT, CCGT
CCGX, CCET
CCMW

Entering angle:
Lead angle:

Steel shank

A...-SCLCR/L

$\kappa_r 95^\circ$
 -5°

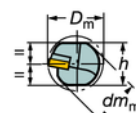
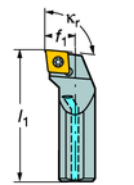


4 x dm_m

Carbide shank

E...SCLCR/L

$\kappa_r 95^\circ$
 -5°



6 x dm_m

Max overhang

With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^1)$	$\lambda_s^2)$		
	06	A08H-SCLCR/L 06	8	10	5	7	100	0°	-14°	CCMT 06 02 04	0.9
		A10K-SCLCR/L 06	10	12	6	9	125	0°	-11°	CCMT 06 02 04	0.9
		A12M-SCLCR/L 06	12	16	9	11	150	0°	-7°	CCMT 06 02 04	0.9
		A16R-SCLCR/L 06	16	20	11	15	200	0°	-5°	CCMT 06 02 04	0.9
	09	A16R-SCLCR/L 09	16	20	11	15	200	0°	-8°	CCMT 09 T3 08	3.0
		A20S-SCLCR/L 09	20	25	13	18	250	0°	-6°	CCMT 09 T3 08	3.0
		A25T-SCLCR/L 09	25	32	17	23	300	0°	-3°	CCMT 09 T3 08	3.0
	12	A25T-SCLCR/L 12	25	32	17	23	300	0°	-4.5°	CCMT 12 04 08	3.0
		A32T-SCLCR/L 12	32	40	22	30	300	0°	-10°	CCMT 12 04 08	3.0
		A40T-SCLCR/L 12	40	50	27	37	300	0°	-7°	CCMT 12 04 08	3.0

Inch version

Main application		IC	Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
				dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^1)$	$\lambda_s^2)$		
	1/4	A06M-SCLCR/L 2	A06M-SCLCR/L 2	.375	.480	.250	.336	6.000	0°	-11°	CCMT 2(1.5)1	0.7
			A10R-SCLCR/L 2	.625	.772	.406	.562	8.000	0°	-5°	CCMT 2(1.5)1	0.7
			A08M-SCLCR/L 2	.500	.598	.312	.460	6.000	0°	-8°	CCMT 2(1.5)2	0.7
	3/8	A10R-SCLCR/L 3	A10R-SCLCR/L 3	.625	.772	.406	.562	8.000	0°	-9°	CCMT 3(2.5)2	2.2
			A12S-SCLCR/L 3	.750	.929	.500	.709	10.000	0°	-6°	CCMT 3(2.5)2	2.2
			A16T-SCLCR/L 3	1.000	1.201	.640	.906	12.000	0°	-4°	CCMT 3(2.5)2	2.2
	1/2	A16T-SCLCR/L 4	A16T-SCLCR/L 4	1.000	1.201	.640	.906	12.000	0°	-5°	CCMT 432	2.2
			A20T-SCLCR/L 4	1.250	1.468	.765	1.181	12.000	0°	-11°	CCMT 432	2.2
			A24T-SCLCR/L 4	1.500	1.760	.890	1.374	12.000	0°	-8°	CCMT 432	2.2
	3/8	E12S-SCLCR/L 3	E12S-SCLCR/L 3	.750	.929	.500	.734	10.000	0°	-6°	CCMT 3(2.5)2	2.2
			E16T-SCLCR/L 3	1.000	1.201	.640	.984	12.000	0°	-4°	CCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
	IC	Bar dia, dm_m		Insert screw	Shim	Shim screw	Key (Torx Plus)
06	1/4	8-10	.375-.500	5513 020-46	-	-	5680 051-02 (7IP)
06	1/4	12-16	.625-.750	5513 020-03	-	-	5680 051-02 (7IP)
09	3/8	16-20	.625-.750	5513 020-09	-	-	5680 049-01 (15IP)
09	3/8	25	1.000	5513 020-10	-	-	5680 049-01 (15IP)
12	1/2	25	1.000	5513 020-17	-	-	5680 049-02 (15IP)
12	1/2	32-40	1.250-1.500	5513 020-18	5322 232-02	5512 090-03	5680 049-02 (15IP)



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

Steel shank

Carbide shank

Dampened
carbide shank

Steel shank

With groove for EasyFix sleeve

Entering angle:

A...-SDUCR/L
 $\kappa_r 93^\circ$

E...-SDUCR/L
 $\kappa_r 93^\circ$

F...-SDUCR/L
 $\kappa_r 93^\circ$

A...-SDUCR/L-ERX
 $\kappa_r 93^\circ$

Lead angle:

-3°

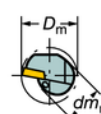
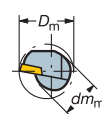
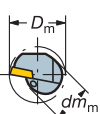
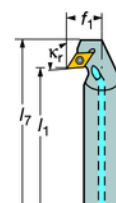
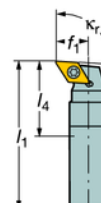
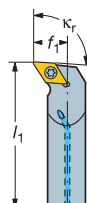
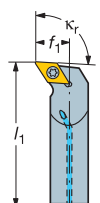
-3°

-3°

-3°



DCMT, DCMX
DCGT, DCGX, DCET
DCMW



Max overhang

4 x dm_m
With internal coolant
supply

6 x dm_m
With internal coolant
supply

10 x dm_m


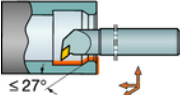
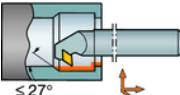
4 x dm_m
With internal coolant supply

Back boring

Right hand style shown

Silent Tools®

Metric version

			Dimensions, mm										
Main application		Ordering code	dm_m	$D_{m\min}$	f_1	l_1	l_4	l_7	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts	Nm ³⁾	
	07	A10K-SDUCR/L 07-ER	10	15	9	125			0°	-7°	DCMT 07 02 04	0.9	
		A12M-SDUCR/L 07-ER	12	18	11	150			0°	-5°	DCMT 07 02 04	0.9	
		A16R-SDUCR/L 07-R	16	20	11	200			0°	-4°	DCMT 07 02 04	0.9	
	11	A20S-SDUCR/L 11-R	20	25	13	250			0°	-6°	DCMT 11 T3 08	3.0	
	07	E10M-SDUCR/L 07-ER	10	15	9	150			0°	-5°	DCMT 07 02 04	0.9	
		E12Q-SDUCR/L 07-ER	12	18	11	180			0°	-5°	DCMT 07 02 04	0.9	
		E16R-SDUCR/L 07-ER	16	22	13	200			0°	-5°	DCMT 07 02 04	0.9	
	11	E20S-SDUCR/L 11-R	20	25	13	220			0°	-6°	DCMT 11 T3 08	3.0	
		E25T-SDUCR/L 11-R	25	32	17	270			0°	-3°	DCMT 11 T3 08	3.0	
	07	F10M-SDUCR/L 07-ER	10	15	9	150	60		0°	-7°	DCMT 07 02 04	0.9	
	F12Q-SDUCR/L 07-ER	12	18	11	180	72		0°	-9°	DCMT 07 02 04	0.9		
	07	A16R-SDUCR/L 07-ERX	16	22	13	200		212.2	0°	-3°	DCMT 07 02 04	0.9	
		A20S-SDUCR/L 07-ERX	20	27	15	250		262.2	0°	-2°	DCMT 07 02 04	0.9	

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	i/C	Bar dia, dm_m			
		mm	inch	Insert screw	Key (Torx Plus)
07	1/4	10-20	.375-.625	5513 020-03	5680 051-02 (7IP)
11	3/8	20-25	.750	5513 020-09	5680 049-01 (15IP)



A9



A281



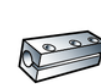
A482



G6



A2



A320



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve

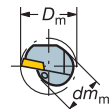
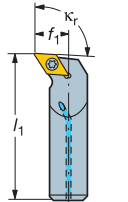
Entering angle:
Lead angle:



DCMT, DCMX
DCGT, DCGX, DCET
DCMW

Steel shank
A...SDUCR/L

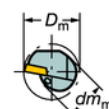
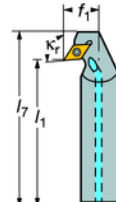
$K_r 93^\circ$
 -3°



4 x dm_m
With internal coolant supply

Steel shank
A...SDUCR/L-ERX

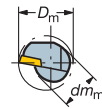
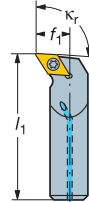
$K_r 93^\circ$
 -3°



4 x dm_m
With internal coolant supply

Carbide shank
E...SDUCR/L

$K_r 93^\circ$
 -3°



6 x dm_m
With internal coolant supply

Max overhang

Right hand style shown

Back boring

Inch version

Main application	iC	Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_7	γ^1	λ_s^2		
 $\leq 27^\circ$	1/4	A06M-SDUCR/L 2-R	.375	.598	.375	6.000		0°	-7°	DCMT 2(1.5)1	0.5
		A08M-SDUCR/L 2-R	.500	.728	.438	6.000		0°	-5°	DCMT 2(1.5)1	0.5
		A10R-SDUCR/L 2-R	.625	.850	.500	8.000		0°	-4°	DCMT 2(1.5)1	0.5
	3/8	A12S-SDUCR/L 3-R	.750	1.051	.625	10.000		0°	-5°	DCMT 3(2.5)2	2.2
	3/8	E12R-SDUCR/L 3-R	.750	1.039	.625	8.752		0°	-5°	DCMT 3(2.5)2	2.2
 $\leq 27^\circ$		E16S-SDUCR/L 3-R	1.000	1.299	.750	10.752		0°	-3°	DCMT 3(2.5)2	2.2
	1/4	A12S-SDUCR/L 2-ERX	.750	1.051	.625	10.000	10.480	0°	-2°	DCMT 2(1.5)1	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For bars,

E12R-SDUCR/L 3-R

E16S-SDUCR/L 3-R

A12S-SDUCR/L 2-ERX

the l_7 - dimension is .752 inch longer than the ordering code indicates.

For coolant connector, see page A324.

Main spare parts

Insert size					
	iC	Bar dia, dm_m		Insert screw	Key (Torx Plus)
		mm	inch		
07	1/4	10-16	.375-.750	5513 020-03	5680 051-02 (7IP)
11	3/8	20	.750-1.000	5513 020-09	5680 049-01 (15IP)



A9



A281



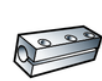
A482



G6



A2



A320



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical
With groove for EasyFix
sleeve

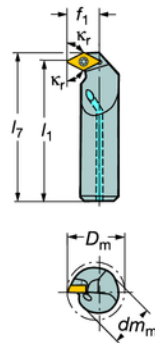
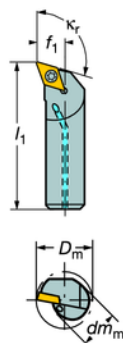
Entering angle
Lead angle:

Steel shank
A...-SDQCR/L
 κ_r 107.5°
-17.5°

Steel shank
A...-SDXCR/L
 κ_r 62.5°
27.5°



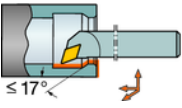
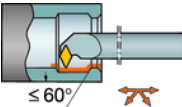
DCMT, DCMX
DCGT, DCGX, DCET
DCMW



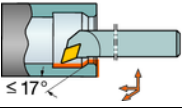
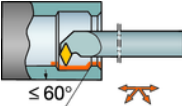
Max overhang 4 x dm_m
With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
	07	A10K-SDQCR/L 07-R	10	13	7	125		0°	-10°	DCMT 07 02 04	0.9
		A12M-SDQCR/L 07-R	12	16	9	150		0°	-7°	DCMT 07 02 04	0.9
		A16R-SDQCR/L 07-R	16	20	11	200		0°	-5°	DCMT 07 02 04	0.9
	11	A20S-SDQCR/L 11-R	20	25	13	250		0°	-6°	DCMT 11 T3 08	3.0
	07	A12M-SDXCR/L 07-R	12	16	9	150	155.1	-3°	-6°	DCMT 07 02 04	0.9
		A16R-SDXCR/L 07-R	16	20	11	200	205.1	-2°	-4°	DCMT 07 02 04	0.9
	11	A20S-SDXCR/L 11-R	20	25	13	250	256.8	-3°	-5°	DCMT 11 T3 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
	1/4	A06M-SDQCR/L 2-R	.375	.598	.375	6.000		0°	-8°	DCMT 2(1.5)1	0.5
		A08M-SDQCR/L 2-R	.500	.728	.437	6.000		0°	-6°	DCMT 2(1.5)1	0.5
		A10R-SDQCR/L 2-R	.625	.850	.500	8.000		0°	-4°	DCMT 2(1.5)1	0.5
	3/8	A12S-SDQCR/L 3-R	.750	.980	.562	10.000		0°	-6°	DCMT 3(2.5)2	2.1
	1/4	A08M-SDXCR/L 2-R	.500	.681	.392	6.000	6.20	-2°	-5°	DCMT 2(1.5)1	0.5
		A10R-SDXCR/L 2-R	.625	.850	.486	8.000	8.20	-2°	-3°	DCMT 2(1.5)1	0.5
	3/8	A12S-SDXCR/L 3-R	.750	1.012	.580	10.000	10.2	-3°	-5°	DCMT 3(2.5)2	2.1

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

For coolant connector, see page A324.

R = Right hand, L = Left hand

Main spare parts

Insert size					
	iC	Bar dia, dm_m		Insert screw	Key (Torx Plus)
		mm	inch		
07	1/4	10-16	.375-.625	5513 020-03	5680 051-02 (7IP)
11	3/8	20	.750	5513 020-09	5680 049-01 (15IP)
11	3/8	25	1.000	5513 020-10	5680 049-01 (15IP)



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

Entering angle:
Lead angle:

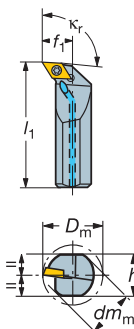


DCMT, DCMX
DCGT, DCGX, DCET
DCMW

Steel shank

A...-SDUCR/L

$\kappa_r 93^\circ$
 -3°

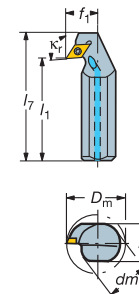


4 x dm_m

Steel shank

A...-SDUCR/L-X

$\kappa_r 93^\circ$
 -3°



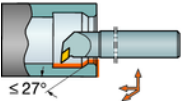
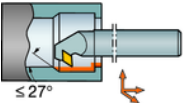
Back boring
4 x dm_m

With internal coolant supply

Max overhang

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	l_7	$\gamma^1)$	$\lambda_s^2)$		
	07	A10K-SDUCR/L 07	10	13	7	9	125		0°	-9°	DCMT 07 02 04	0.9
		A12M-SDUCR/L 07	12	16	9	11	150		0°	-6°	DCMT 07 02 04	0.9
		A16R-SDUCR/L 07	16	20	11	15	200		0°	-4°	DCMT 07 02 04	0.9
	11	A20S-SDUCR/L 11	20	25	13	18	250		0°	-6°	DCMT 11 T3 08	3.0
		A25T-SDUCR/L 11	25	32	17	23	300		0°	-3°	DCMT 11 T3 08	3.0
	07	A16R-SDUCR/L 07-EX	16	22	13	15	200	212.2	0°	-3°	DCMT 07 02 04	0.9
		A20S-SDUCR/L 07-EX	20	27	15	18	250	262.2	0°	-2°	DCMT 07 02 04	0.9
		A25T-SDUCR/L 07-DX	25	33	18	23	300	312.2	0°	0°	DCMT 07 02 04	0.9
	11	A32T-SDUCR/L 11-X	32	40	22	30	300	316.7	0°	-7°	DCMT 11 T3 08	3.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts (see next page)



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

Steel shank

Carbide shank

Steel shank

Entering angle:
Lead angle:

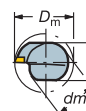
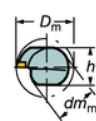
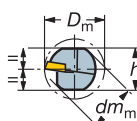
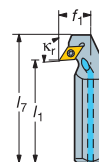
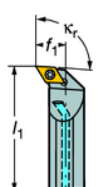
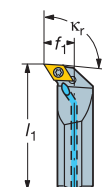
A...-SDUCR/L
 $\kappa_r 93^\circ$
 -3°

E...-SDUCR/L
 $\kappa_r 93^\circ$
 -3°

A...-SDUCR/L-X
 $\kappa_r 93^\circ$
 -3°



DCMT, DCMX
DCGT, DCGX, DCET
DCMW



4 x dm_m

6 x dm_m

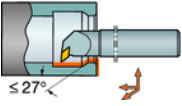
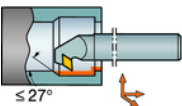
Back boring
4 x dm_m

With internal coolant supply

Max overhang

Right hand style shown

Inch version

Main application	iC	Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_7	$\gamma^1)$	$\lambda_s^2)$		
	1/4	A06M-SDUCR/L 2	.375	.598	.375	6.000		0°	-7°	DCMT 2(1.5)1	0.7
		A08M-SDUCR/L 2	.500	.728	.438	6.000		0°	-5°	DCMT 2(1.5)1	0.7
		A10R-SDUCR/L 2	.625	.850	.500	8.000		0°	-4°	DCMT 2(1.5)1	0.7
	1/4	E06M-SDUCR/L 2	.375	.598	.375	6.000		0°	-7°	DCMT 2(1.5)1	0.7
		E08R-SDUCR/L 2	.500	.716	.438	8.000		0°	-5°	DCMT 2(1.5)1	0.7
		E10R-SDUCR/L 2	.625	.850	.500	8.000		0°	-4°	DCMT 2(1.5)1	0.7
	3/8	A12S-SDUCR/L 3	.750	1.051	.625	10.000		0°	-5°	DCMT 3(2.5)2	2.2
		A16T-SDUCR/L 3	1.000	1.299	.750	12.000		0°	-3°	DCMT 3(2.5)2	2.2
		A20T-SDUCR/L 3	1.250	1.579	.875	12.000		0°	-8°	DCMT 3(2.5)2	2.2
	3/8	E12S-SDUCR/L 3	.750	1.039	.625	10.000		0°	-3°	DCMT 3(2.5)2	2.2
		E16T-SDUCR/L 3	1.000	1.299	.750	12.000		0°	-3°	DCMT 3(2.5)2	2.2
	1/4	A12S-SDUCR/L 2-EX	.750	1.051	.625	10.000	10.480	0°	-2°	DCMT 2(1.5)1	0.7
		A16T-SDUCR/L 2-DX	1.000	1.299	.750	12.000	12.480	0°	0.5°	DCMT 2(1.5)1	0.7
	3/8	A20T-SDUCR/L 3-X	1.250	1.579	.875	12.000	12.658	0°	-7°	DCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).


2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
	iC	Bar dia, dm_m		Insert screw	Shim	Shim screw	Key (Torx Plus)
		mm	inch				
07	1/4	10-25	.375-1.000	5513 020-03	-	-	5680 051-02 (7IP)
11	3/8	20	.750	5513 020-09	-	-	5680 049-01 (15IP)
11	3/8	25	1.000	5513 020-10	-	-	5680 049-01 (15IP)
11	3/8	32	1.250	5513 020-01	5322 263-01	5512 090-01	5680 049-01 (15IP)



A9



A281



A482



G6



A2



A320



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

Entering angle:
Lead angle:

Steel shank
A...-SDQCR/L

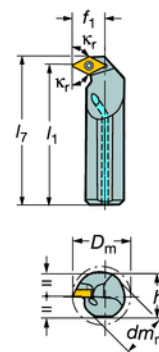
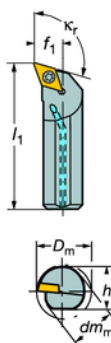
κ_r 107.5°
-17.5°

Steel shank
A...-SDXCR/L

κ_r 62.5°
27.5°



DCMT, DCMX
DCGT, DCGX, DCET
DCMW



Max overhang 4 x dm_m
With internal coolant supply
Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			dm_m	D_m min	f_1	h	l_1	l_7	$\gamma^1)$	$\lambda_s^2)$		
	07	A10K-SDQCR/L 07	10	13	7	9	125		0°	-10°	DCMT 07 02 04	0.9
		A12M-SDQCR/L 07	12	16	9	11	150		0°	-7°	DCMT 07 02 04	0.9
		A16R-SDQCR/L 07	16	20	11	15	200		0°	-5°	DCMT 07 02 04	0.9
		A20S-SDQCR/L 11	20	25	13	18	250		0°	-6°	DCMT 11 T3 08	3.0
	11	A25T-SDQCR/L 11	25	32	17	23	300		0°	-4°	DCMT 11 T3 08	3.0
	07	A12M-SDXCR/L 07	12	16	9	11	150	155.1	-3°	-6°	DCMT 07 02 04	0.9
		A16R-SDXCR/L 07	16	20	11	15	200	205.1	-2°	-4°	DCMT 07 02 04	0.9
		A20S-SDXCR/L 11	20	25	13	18	250	256.8	-3°	-5°	DCMT 11 T3 08	3.0
		A25T-SDXCR/L 11	25	32	17	23	300	306.8	-2°	-3°	DCMT 11 T3 08	3.0
	11											

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			dm_m	D_m min	f_1	h	l_1	l_7	$\gamma^1)$	$\lambda_s^2)$		
	1/4	A06M-SDQCR/L 2	.375	.598	.375	.336	6.000		0°	-8°	DCMT 2(1.5)1	0.5
		A08M-SDQCR/L 2	.500	.728	.437	.460	6.000		0°	-6°	DCMT 2(1.5)1	0.5
		A10R-SDQCR/L 2	.625	.850	.500	.562	8.000		0°	-4°	DCMT 2(1.5)1	0.5
		A12S-SDQCR/L 3	.750	.980	.562	.709	10.000		0°	-6°	DCMT 3(2.5)2	2.1
	3/8	A16T-SDQCR/L 3	1.000	1.299	.750	.906	12.000		0°	-3°	DCMT 3(2.5)2	2.1
	1/4	A08M-SDXCR/L 2	.500	.681	.392	.460	6.000	6.201	-2°	-5°	DCMT 2(1.5)1	0.5
		A10R-SDXCR/L 2	.625	.850	.486	.562	8.000	8.201	-2°	-3°	DCMT 2(1.5)1	0.5
		A12S-SDXCR/L 3	.750	1.012	.580	.709	10.000	10.268	-3°	-5°	DCMT 3(2.5)2	2.1
		A16T-SDXCR/L 3	1.000	1.280	.720	.906	12.000	12.268	-2°	-3°	DCMT 3(2.5)2	2.1
	3/8											

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
	iC	Bar dia, dm_m mm	inch	Insert screw	Shim	Shim screw	Key (Torx Plus)
07	1/4	10-16	.375-.625	5513 020-03	-	-	5680 051-02 (7IP)
11	3/8	20	.750	5513 020-09	-	-	5680 049-01 (15IP)
11	3/8	25	1.000	5513 020-10	-	-	5680 049-01 (15IP)



Boring bars for medical

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Entering angle:

Lead angle:

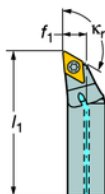
Steel shank
A...-SDXCR/L

κ_r 120°

-30°




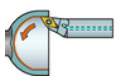
 DCMT, DCGT



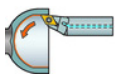
Max overhang 4 x dm_m
With internal coolant supply

Right hand style shown

Metric version

			Dimensions, mm							
Main application		Ordering code	dm_m	$D_{m\ min}$	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts	Nm ³⁾
	07	A16K-SDXCR/L 07-R	16	20	9	125	3°	-3°	DCMT 07 02 04	0.9
	11	A20M-SDXCR/L 11-R	20	25	12	150	0°	-3°	DCMT 11 T3 08	3.0

Inch version

			Dimensions, inch							
Main application	iC	Ordering code	$d_{m\text{}}$	$D_{m\text{ min}}$	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts	ft-lbs ⁴⁾
	1/4	A10K-SDXCR/L 2-R	.625	.787	.354	4.921	3°	-3°	DCMT 2(1.5)1	0.7
	3/8	A12M-SDXCR/L 3-R	.750	.984	.472	5.906	0°	-3°	DCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.


3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

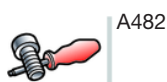
For coolant connector, see page A324.

Main spare parts

Insert size					
	iC	Bar dia, dm_m	Insert screw	Key (Torx Plus)	
07	1/4	16	5513 020-03	5680 051-02 (7IP)	
11	3/8	20	5513 020-09	5680 049-01 (15IP)	



A9



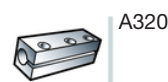
A482



G6



A2



A320



J2

Boring bars for medical

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve


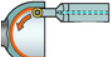



R300

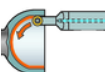
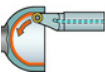
Max overhang 4 x dm_m
With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ⁴⁾
			dm_m	D_m min ¹⁾	f_1	l_1	l_3	$\gamma^{2)}$	$\lambda s^{3)}$			
	08	A16K-SRDDN 08-R	16	20	4	125	19.8	0°	0°	R300-0828..	0.9	
	08	A20M-SRXDR/L 08-R	20	25	9	150	30	0°	0°	R300-0828..	1.2	
	10	A20M-SRXDR/L 10-R	20	25	9	150	30	0°	0°	R300-1032..	3.0	

Inch version

Main application	i/C mm	Ordering code	Dimensions, inch								Gauge inserts	ft- lbs ⁵⁾
			dm_m	D_m min ¹⁾	f_1	l_1	l_3	$\gamma^{2)}$	$\lambda.s^{3)}$			
	08	A10K-SRDDN 08-R	.625	.787	.157	4.921	.780	0°	0°	R300-0828..	0.7	
	08	A12M-SRXDR/L 08-R	.750	.984	.354	5.906	1.18	0°	0°	R300-0828..	0.9	
	10	A12M-SRXDR/L 10-R	.750	.748	.354	5.906	1.18	0°	0°	R300-1032..	2.2	

1) D_m min = minimum cup diameter.

2) γ = Rake angle (valid with flat insert).


3) λ_s = Angle of inclination.

4) Insert tightening torque Nm.

5) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size		Insert screw		Key (Torx Plus)	
	Bar dia, dm_m mm inch				
08	16 .625	5513 020-48	5680 051-02 (7IP)		
08	20 .750	5513 020-56	5680 046-01 (8IP)		
10	20 .750	5513 020-43	5680 046-02 (15IP)		



Inserts

Boring bars for medical



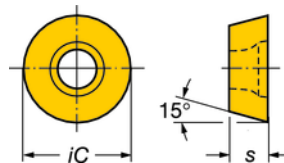
E-xM

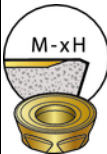




M-xH



E-xL



		iO	iC	ISO	P				M	K				N		S				H				ANSI			
					GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC				
					1025	1030	4220	4230	4240	1030	3040	4220	4240	H13A	1025	1030	H13A	1010	1025	1030	H13A	S30T	S40T		1010	1025	1030
Heavy		08	8	R300-0828M-KH							☆				☆				☆					☆		R300-0828M-KH	
			8	R300-0828M-PH		☆	☆	☆	☆			☆					☆		☆				☆		☆	R300-0828M-PH	
		10	10	R300-1032M-KH							☆									☆				☆		☆	R300-1032M-KH
			10	R300-1032M-PH		☆	☆	☆	☆			☆					☆			☆				☆		☆	R300-1032M-PH
Light		08	8	R300-0828E-KL									☆		☆				☆								R300-0828E-KL
			8	R300-0828E-PL		☆				☆					☆	☆		☆	☆	☆	☆		☆				R300-0828E-PL
		10	10	R300-1032E-KL									☆		☆		☆		☆								R300-1032E-KL
			10	R300-1032E-PL		☆				☆				☆	☆		☆	☆	☆	☆	☆		☆				R300-1032E-PL
Medium		08	8	R300-0828E-PM	☆	☆			☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		R300-0828E-PM	
		10	10	R300-1032E-PM	☆	☆			☆			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		R300-1032E-PM	

A282

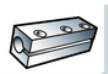
A482

G6

A2

A320

J2



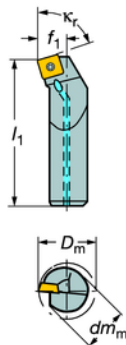
Boring bars

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

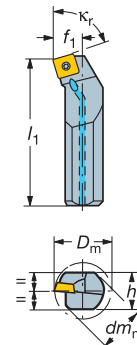
Steel shank
Cylindrical
With groove for EasyFix sleeve

A...-SSKCR/L
 κ_r 75°
15°



Steel shank
Cylindrical with flat

A...-SSKCR/L
 κ_r 75°
15°





SCMT, SCGX
SCMW

Max overhang 4 x dm_m
With internal coolant supply
Right hand style shown

Metric version

Cylindrical

Main application		Ordering code	Dimensions, mm						Gauge inserts	Nm ³⁾
			dm_m	D_m min	f_1	l_1	$\gamma^{1)}$	$\lambda_{s2)}$		
	09	A16R-SSKCR/L 09-R	16	20	11	200	0°	-9°	SCMT 09 T3 08	3.0
		A20S-SSKCR/L 09-R	20	25	13	250	0°	-6°	SCMT 09 T3 08	3.0

Cylindrical with flats

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	D_m min	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	09	A16R-SSKCR/L 09	16	20	11	15	200	0°	-9°	SCMT 09 T3 08	3.0
		A20S-SSKCR/L 09	20	25	13	18	250	0°	-6°	SCMT 09 T3 08	3.0
	12	A25T-SSKCR/L 12	25	32	17	23	300	0°	-4.5°	SCMT 12 04 08	3.0
		A32T-SSKCR/L 12	32	40	22	30	300	0°	-9°	SCMT 12 04 08	3.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	Bar dia, dm_m mm	Insert screw	Shim	Shim screw	Key (Torx Plus)
09	16-20	5513 020-09	-	-	5680 049-01 (15IP)
12	25	5513 020-17	-	-	5680 049-02 (15IP)
12	32	5513 020-18	5322 420-02	5512 090-03	5680 049-02 (15IP)



A9



A282



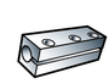
A482



G6



A2



A320



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve



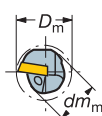
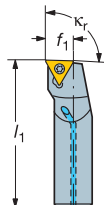
TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Entering angle:
Lead angle:

Steel shank

A...-STFCR/L...R

$\kappa_r 91^\circ$
 -1°

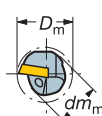
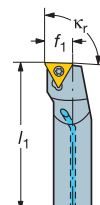


4 x dm_m
With internal coolant
supply

Carbide shank

E...-STFCR/L

$\kappa_r 91^\circ$
 -1°

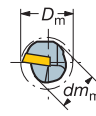
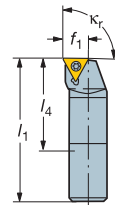


6 x dm_m
With internal coolant
supply

Dampened carbide shank

F...-STFCR/L

$\kappa_r 91^\circ$
 -1°



10 x dm_m

Max overhang
Right hand style shown

Metric version

Silent Tools®

Main application		Ordering code ⁵⁾	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	D_m min	f_1	l_1	$l_4^{4)}$	$\gamma^{1)}$	$\lambda_s^{2)}$		
		06 A06F-STFCR/L 06-R	6	8.5	4.5	80		0°	-10°	TCMT 06 T1 02	0.6
		A08H-STFCR/L 06-R	8	11	5.9	100		0°	-6°	TCMT 06 T1 02	0.6
		09 A10K-STFCR/L 09-R	10	13	7	125		0°	-8°	TCMT 09 02 04	0.9
		A12M-STFCR/L 09-R	12	16	9	150		0°	-6°	TCMT 09 02 04	0.9
		11 A12M-STFCR/L 11-RB1	12	16	9	150		0°	-8°	TCMT 11 03 04	0.9
		A16R-STFCR/L 11-RB1	16	20	11	200		0°	-5°	TCMT 11 03 04	0.9
		A20S-STFCR/L 11-RB1	20	25	13	250		0°	-3°	TCMT 11 03 04	0.9
		A25T-STFCR/L 11-RB1	25	32	17	300		0°	1°	TCMT 11 03 04	0.9
		06 E06H-STFCR/L 06-R	6	8.5	4.5	100		0°	-10°	TCMT 06 T1 02	0.6
		E08K-STFCR/L 06-R	8	11	5.9	125		0°	-10°	TCMT 06 T1 02	0.6
		09 E10M-STFCR/L 09-R	10	13	7	150		0°	-8°	TCMT 09 02 04	0.9
		E12Q-STFCR/L 09-R	12	16	9	180		0°	-6°	TCMT 09 02 04	0.9
		11 E16R-STFCR/L 11-R	16	20	11	200		0°	-4°	TCMT 11 02 04	0.9
		E16R-STFCR/L 11-RB1	16	20	11	200		0°	-5°	TCMT 11 03 04	0.9
		E20S-STFCR/L 11-RB1	20	25	13	220		0°	-3°	TCMT 11 03 04	0.9
		E25T-STFCR/L 11-RB1	25	32	17	270		0°	-1°	TCMT 11 03 04	0.9
		16 E25T-STFCR/L 16-R	25	32	17	270		0°	-3°	TCMT 16 T3 08	3.0
		09 F10M-STFCR/L 09-R	10	13	7	150	60	0°	-8°	TCMT 09 02 04	0.9
		F12Q-STFCR/L 09-R	12	16	9	180	72	0°	-10°	TCMT 09 02 04	0.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Do not clamp in this area.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

For coolant connector, see page A324.

For main spare parts, see next page.



A9



A283



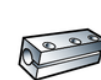
A482



G6



A2



A320



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Entering angle:
Lead angle:

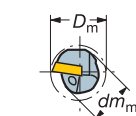
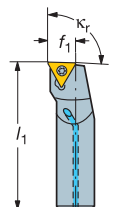


TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Steel shank

A...-STFCR/L...R

$\kappa_r 91^\circ$
 -1°

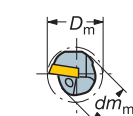
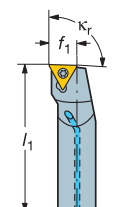


4 x dm_m
With internal coolant
supply

Carbide shank

E...-STFCR/L

$\kappa_r 91^\circ$
 -1°

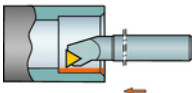


6 x dm_m
With internal coolant
supply

Max overhang

Right hand style shown

Inch version

Main application	iC	Ordering code ⁴⁾	Dimensions, inch						Gauge inserts	ft-lbs ³⁾
			dm_m	D_m min	f_1	l_1	$\gamma^1)$	$\lambda_s^{2)}$		
	5/32	A04F-STFCR/L 1.2-R	.250	.342	.172	3.248	0°	-12°	TCMT 1.2(1.2)0	0.4
		A05H-STFCR/L 1.2-R	.312	.413	.219	4.000	0°	-10°	TCMT 1.2(1.2)0	0.4
	7/32	A06M-STFCR/L 1.8-R	.375	.500	.266	6.000	0°	-9°	TCMT 1.8(1.5)1	0.7
		A08M-STFCR/L 1.8-R	.500	.642	.344	6.000	0°	-6°	TCMT 1.8(1.5)1	0.7
	1/4	A06M-STFCR/L 2-RB1	.375	.500	.250	6.000	0°	-12°	TCMT 221	0.7
		A08M-STFCR/L 2-RB1	.500	.598	.312	6.000	0°	-9°	TCMT 221	0.7
		A10R-STFCR/L 2-RB1	.625	.772	.406	8.000	0°	-6°	TCMT 221	0.7
		A12S-STFCR/L 2-RB1	.750	.929	.500	10.000	0°	-3°	TCMT 221	0.7
	5/32	E04H-STFCR/L 1.2-R	.250	.342	.172	4.000	0°	-12°	TCMT 1.2(1.2)0	0.4
		E05K-STFCR/L 1.2-R	.312	.413	.219	5.000	0°	-11°	TCMT 1.2(1.2)0	0.4
	1/4	E12R-STFCR/L 2-RB1	.750	.929	.500	8.752	0°	-3°	TCMT 221	0.7
		E16S-STFCR/L 2-R	1.000	1.201	.640	10.752	0°	-2°	TCMT 2(1.5)1	0.7
		E16S-STFCR/L 2-RB1	1.000	1.201	.640	10.752	0°	-1°	TCMT 221	0.7
	3/8	E16S-STFCR/L 3-R	1.000	1.201	.640	10.752	0°	-4°	TCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

For bars,

E12R-STFCR/L 2-RB1

E16S-STFCR/L 2-RB1

E16S-STFCR/L 2-R

E16S-STFCR/L 3-R,

the l_1 - dimension is .752 inch longer than the ordering code indicates.

For coolant connector, see page A324.

Main spare parts

Insert size		Bar dia, dm_m		Insert screw		Key (Torx Plus)	
	iC	mm	inch				
06	5/32	6	.250	5513 020-28		5680 051-01 (6IP)	
06	5/32	8	.312	5513 020-27		5680 051-01 (6IP)	
09	7/32	10-12	.375-.500	5513 020-05		5680 051-02 (7IP)	
11	1/4	12-20	.375-1.000	5513 020-03		5680 051-02 (7IP)	
16	3/8	25	1.000	5513 020-10		5513 049-01 (15IP)	



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

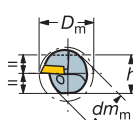
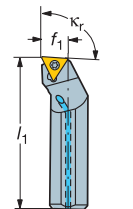


TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Entering angle:
Lead angle:

Steel shank

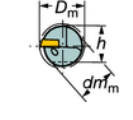
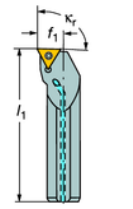
A...-STFCR/L
 $\kappa_r 91^\circ$
 -1°



4 x dm_m

Carbide shank

E...STFCR/L
 $\kappa_r 91^\circ$
 -1°

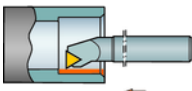
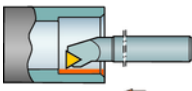


6 x dm_m

Max overhang
With internal coolant supply

Right hand style shown

Inch version

Main application	iC	Ordering code ⁴⁾	Dimensions, inch							Gauge inserts	ft-lbs ³⁾
	5/32	A04F-STFCR/L 1.2	.250	.342	.172	.210	3.248	0°	-12°	TCMT 1.2(1.2)0	0.4
		A05H-STFCR/L 1.2	.312	.413	.219	.272	4.000	0°	-10°	TCMT 1.2(1.2)0	0.4
	7/32	A06M-STFCR/L 1.8	.375	.500	.266	.336	6.000	0°	-9°	TCMT 1.8(1.5)1	0.7
		A08M-STFCR/L 1.8	.500	.642	.344	.460	6.000	0°	-6°	TCMT 1.8(1.5)1	0.7
	1/4	A06M-STFCR/L 2	.375	.500	.250	.336	6.000	0°	-10°	TCMT 2(1.5)1	0.7
		A08M-STFCR/L 2	.500	.598	.312	.460	6.000	0°	-7°	TCMT 2(1.5)1	0.7
		A10R-STFCR/L 2	.625	.772	.406	.562	8.000	0°	-5°	TCMT 2(1.5)1	0.7
		A12S-STFCR/L 2	.750	.929	.500	.709	10.000	0°	-3°	TCMT 2(1.5)1	0.7
	1/4	A06M-STFCR/L 2-B1	.375	.500	.250	.336	6.000	0°	-12°	TCMT 221	0.7
		A08M-STFCR/L 2-B1	.500	.598	.312	.460	6.000	0°	-9°	TCMT 221	0.7
		A10R-STFCR/L 2-B1	.625	.772	.406	.562	8.000	0°	-6°	TCMT 221	0.7
		A12S-STFCR/L 2-B1	.750	.929	.500	.709	10.000	0°	-3°	TCMT 221	0.7
	3/8	A16T-STFCR/L 3	1.000	1.201	.640	.906	12.000	0°	-4°	TCMT 3(2.5)2	2.2
		A20T-STFCR/L 3	1.250	1.468	.765	1.181	12.000	0°	-8°	TCMT 3(2.5)2	2.2
		A24T-STFCR/L 3	1.500	1.760	.890	1.374	12.000	0°	-6°	TCMT 3(2.5)2	2.2
	7/32	E06M-STFCR/L 1.8	.375	.500	.264	.359	6.000	0°	-9.5°	TCMT 1.8(1.5)1	0.7
		E08R-STFCR/L 1.8	.500	.630	.342	.484	8.000	0°	-7°	TCMT 1.8(1.5)1	0.7
	1/4	E06M-STFCR/L 2-B1	.375	.480	.250	.359	6.000	0°	-12°	TCMT 221	0.7
		E08R-STFCR/L 2-B1	.500	.598	.312	.484	8.000	0°	-9°	TCMT 221	0.7
		E10R-STFCR/L 2-B1	.625	.772	.406	.609	8.000	0°	-6°	TCMT 221	0.7
		E12S-STFCR/L 2-B1	.750	.929	.500	.734	10.000	0°	-4°	TCMT 221	0.7
	3/8	E16T-STFCR/L 3	1.000	1.201	.640	.984	12.000	0°	-4°	TCMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).


2) λ_s = Angle of inclination.

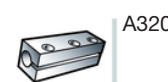
3) Insert tightening torque ft-lbs.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Bar dia, dm_m Inch	Insert screw	Shim	Shim screw	Key (Torx Plus)
06	5/32	.250	5513 020-28	-	-	5680 051-01 (6IP)
06	5/32	.312	5513 020-27	-	-	5680 051-01 (6IP)
09	7/32	.375-.500	5513 020-05	-	-	5680 051-02 (7IP)
11	1/4	.375-.750	5513 020-03	-	-	5680 051-02 (7IP)
16	3/8	1.000	5513 020-10	-	-	5680 049-01 (15IP)
16	3/8	1.250-1.500	5513 020-01	5322 320-01	5512 090-01	5680 049-01 (15IP)



Boring bars

CoroTurn® 107 screw clamp design

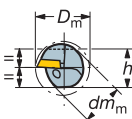
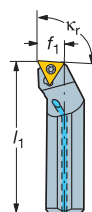
Cylindrical with flats



TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Entering angle:
Lead angle:

Steel
A...-STFCR/L
 $\kappa_r 91^\circ$
 -1°



Max overhang $4 \times d_{m\max}$
With internal coolant supply
Right hand style shown

Metric version

Main application		Ordering code ⁴⁾	Dimensions, mm							Gauge inserts	Nm ³⁾
			$d_{m\max}$	$D_{m\min}$	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	06	A06F-STFCR/L 06	6	8.5	4.5	5	80	0°	-12°	TCMT 06 T1 02	0.6
		A08H-STFCR/L 06	8	11	5.9	7	100	0°	-10°	TCMT 06 T1 02	0.6
		A10K-STFCR/L 09	10	13	7	9	125	0°	-9°	TCMT 09 02 04	0.9
		A12M-STFCR/L 09	12	16	9	11	150	0°	-6.5°	TCMT 09 02 04	0.9
		A12M-STFCR/L 11	12	16	9	11	150	0°	-7°	TCMT 11 02 04	0.9
		A16R-STFCR/L 11	16	20	11	15	200	0°	-5°	TCMT 11 02 04	0.9
	11	A20S-STFCR/L 11	20	25	13	18	250	0°	-3°	TCMT 11 02 04	0.9
		A12M-STFCR/L 11-B1	12	16	9	11	150	0°	-8°	TCMT 11 03 04	0.9
		A16R-STFCR/L 11-B1	16	20	11	15	200	0°	-5°	TCMT 11 03 04	0.9
		A20S-STFCR/L 11-B1	20	25	13	18	250	0°	-3°	TCMT 11 03 04	0.9
		A25T-STFCR/L 16	25	32	17	23	300	0°	-3°	TCMT 16 T3 08	3.0
		A32T-STFCR/L 16	32	40	22	30	300	0°	-7°	TCMT 16 T3 08	3.0
	16	A40T-STFCR/L 16	40	50	27	37	300	0°	-4.5°	TCMT 16 T3 08	3.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Bar dia, $d_{m\max}$ mm	Insert screw	Shim	Shim screw	Key (Torx Plus)
06	5/32	6	5513 020-28	-	-	5680 051-01 (6IP)
06	5/32	8	5513 020-27	-	-	5680 051-01 (6IP)
09	7/32	10-12	5513 020-05	-	-	5680 051-02 (7IP)
11	1/4	12-20	5513 020-03	-	-	5680 051-02 (7IP)
16	3/8	25	5513 020-10	-	-	5680 049-01 (15IP)
16	3/8	32-40	5513 020-01	5322 320-01	5512 090-01	5680 049-01 (15IP)



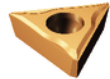
Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Entering angle:
Lead angle:

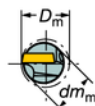
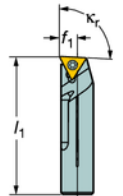


 TCEX

Steel shank

A...-STUCR/L-GR

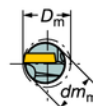
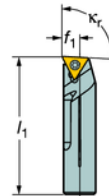
$\kappa_r 93^\circ$
 -3°



Carbide shank

E...-STUCR/L-GR

$\kappa_r 93^\circ$
 -3°


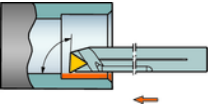


Max overhang $4 \times d_{m\max}$

With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code ⁴⁾	Dimensions, mm						Gauge inserts	Nm ³⁾
			$d_{m\max}$	$D_{m\min}$	f_1	l_1	$\gamma^1)$	$\lambda_s^2)$		
	05	A05F-STUCR/L 05-GR	5	6	2.9	80	0°	0°	TCEX 05 01 00	0.4
		A06F-STUCR/L 05-GR	6	7	3.2	80	0°	0°	TCEX 05 01 00	0.4
		A08H-STUCR/L 06-GR	8	9	4.2	100	0°	0°	TCEX 06 T1 00R-F	0.6
		A10K-STUCR/L 06-GR	10	11	5.2	125	0°	0°	TCEX 06 T1 00R-F	0.6
	05	E05H-STUCR/L 05-GR	5	6	2.9	100	0°	0°	TCEX 05 01 00	0.4
		E06H-STUCR/L 05-GR	6	7	3.2	100	0°	0°	TCEX 05 01 00	0.4
		E08K-STUCR/L 06-GR	8	9	4.2	125	0°	0°	TCEX 06 T1 00R-F	0.6
		E10M-STUCR/L 06-GR	10	11	5.2	150	0°	0°	TCEX 06 T1 00R-F	0.6

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.


3) Insert tightening torque Nm.

4) The right hand (R) boring bar uses left hand (L) TCEX- inserts and vice versa.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size			
	Bar dia, $d_{m\max}$ mm	Insert screw	Key (Torx Plus)
05	5-6	5513 020-53	5680 041-03 (6IP)
06	8	5513 020-44	5680 041-03 (6IP)
06	10	5513 020-28	5680 041-03 (6IP)



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with groove for
EasyFix sleeve

Entering angle:
Lead angle:

Steel shank
A...-SVQBR/L

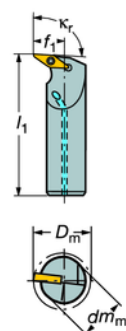
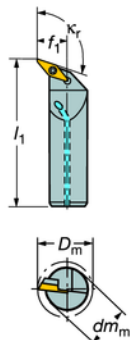
κ_r 107.5°
-17.5°

Steel shank
A...-SVUBR/L

κ_r 93°
-3°



VBMT, VBG
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW



Max overhang 4 x dm_m
With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm						Gauge inserts	Nm ³⁾
	11	A16R-SVQBR/L 11-ERB1	dm_m 16	D_m min 22	f_1 13	L_1 200	$\gamma^{1)}$ 0°	$\lambda_s^{2)}$ -7°	VBMT 11 03 04	0.9
		A20S-SVQBR/L 11-ERB1	20	27	15	250	0°	-5°	VBMT 11 03 04	0.9
	11	A16R-SVUBR/L 11-ERB1	16	22	13	200	0°	-7°	VBMT 11 03 04	0.9
		A20S-SVUBR/L 11-ERB1	20	27	15	250	0°	-5°	VBMT 11 03 04	0.9

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch						Gauge inserts	ft-lbs ⁴⁾
	1/4	A10R-SVUBR/L 2-ERB1	dm_m .625	D_m min .850	f_1 .486	L_1 8.000	$\gamma^{1)}$ 0°	$\lambda_s^{2)}$ -7°	VBMT 221	0.7
		A12S-SVUBR/L 2-ERB1	.750	1.012	.580	10.000	0°	-5°	VBMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	Bar dia, dm_m		Insert screw	Shim	Shim screw	Key (Torx Plus)
		mm	inch				
11	1/4	16-25	.625-1.000	5513 020-20	-	-	5680 051-02 (7IP)



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Steel shank

Carbide shank

Steel shank

Carbide shank

A...-SVQCR/L

E...-SVQCR/L

A...-SVUCR/L

E...-SVUCR/L

Entering angle:

$\kappa_r 107.5^\circ$

$\kappa_r 107.5^\circ$

$\kappa_r 93^\circ$

$\kappa_r 93^\circ$

Lead angle:

-17.5°

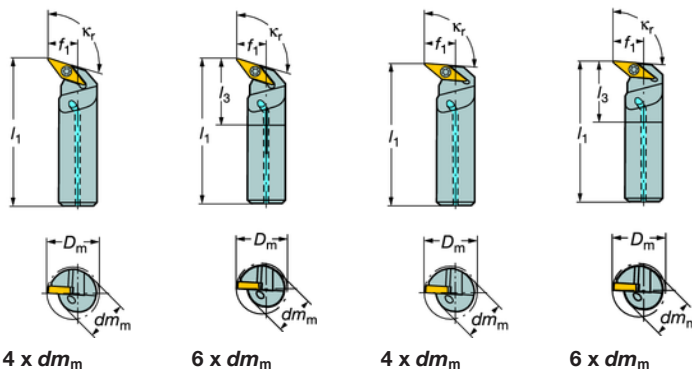
-17.5°

-3°

-3°



VCMT, VCEX,
VCGX
VCMW



Max overhang

With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$		
	11	A16R-SVQCR/L 11-ER	16	22	13	200		0°	-4°	VCMT 11 03 04	0.9
	11	E16R-SVQCR/L 11-ER	16	22	13	200	33	0°	-4°	VCMT 11 03 04	0.9
	11	A16R-SVUCR/L 11-ER	16	22	13	200		0°	-4°	VCMT 11 03 04	0.9
	11	E16R-SVUCR/L 11-ER	16	22	13	200	33	0°	-4°	VCMT 11 03 04	0.9

Inch version

Main application		Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$			
	1/4	A10R-SVQCL 2-ER	.625	.850	.486	8.000	2°	-4°		VCMT 221	0.7
	1/4	A10R-SVUCR/L 2-ER	.625	.850	.486	8.000	2°	-4°		VCMT 221	0.7

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

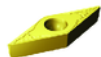
Insert size				Key (Torx Plus)	
	iC	Bar dia, dm_m	inch	Insert screw	
11	1/4	16	.625	5513 020-03	5680 051-02 (7IP)
A9		A490		G6	A2
				A320	J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

Entering angle:
Lead angle:



VBMT, VBGT
VCGX, VCEX,
VCGT, VCET

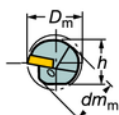
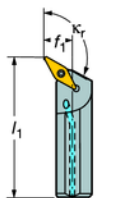


VBMT, VCMW

Steel shank

A...-SVPBR/L

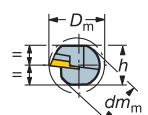
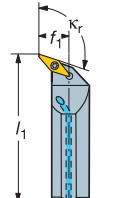
κ_r 117.5°
-27.5°



Steel shank

A...-SVQBR/L

κ_r 107.5°
-17.5°


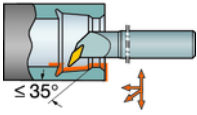
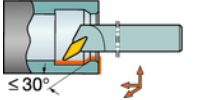


Max overhang 4 x dm_m

With internal coolant supply

Right hand style shown

Metric version

			Dimensions, mm								
Main application		Ordering code ⁴⁾	$d_{m\text{}}$	$D_{m\text{ min}}$	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts	Nm ³⁾
 ≤ 35°	11	A16R-SVQBR/L 11-E	16	22	13	15	200	0°	-7°	VBMT 11 02 04	0.9
		A20S-SVQBR/L 11-E	20	27	15	18	250	0°	-5°	VBMT 11 02 04	0.9
		A25T-SVQBR/L 11-D	25	33	18	23	300	0°	-4°	VBMT 11 02 04	0.9
	11	A16R-SVQBR/L 11-EB1	16	22	13	15	200	0°	-7°	VBMT 11 03 04	0.9
		A20S-SVQBR/L 11-EB1	20	27	15	18	250	0°	-5°	VBMT 11 03 04	0.9
 ≤ 30°		A25T-SVQBR/L 11-DB1	25	33	18	23	300	0°	-4°	VBMT 11 03 04	0.9
	16	A25T-SVQBR/L 16-D	25	33	18	23	300	0°	-7°	VBMT 16 04 08	3.0
		A32T-SVQBR/L 16	32	40	22	30	300	0°	-7°	VBMT 16 04 08	3.0
		A40T-SVQBR/L 16	40	50	27	37	300	0°	-5°	VBMT 16 04 08	3.0
	16	A25T-SVPBR/L 16	25	32	17	23	300	0°	-8°	VBMT 16 04 08	3.0
		A32T-SVPBR/L 16	32	40	22	30	300	0°	-9°	VBMT 16 04 08	3.0
		A40T-SVPBR/L 16	40	50	27	37	300	0°	-6°	VBMT 16 04 08	3.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts (see next page)



Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

Entering angle:

Lead angle:

Steel shank

A...-SVPBR/L

κ_r 117.5°

-27.5°

Steel shank

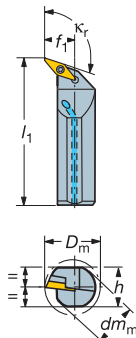
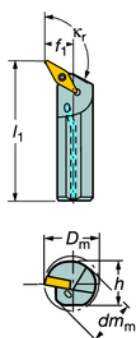
A...-SVQBR/L

κ_r 107.5°

-17.5°



VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW



Max overhang 4 x dm_m
With internal coolant supply
Right hand style shown

Inch version

Main application	iC	Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ³⁾
			dm_m	D_m min	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
 ≤ 30°	3/8	A16T-SVPBR/L 3	1.000	1.299	.750	.906	12.000	0°	-8°	VBMT 332	2.2
		A20T-SVPBR/L 3	1.250	1.579	.875	1.181	12.000	0°	-9°	VBMT 332	2.2
		A24T-SVPBR/L 3	1.500	1.941	1.063	1.374	12.000	0°	-6°	VBMT 332	2.2
 ≤ 35°	3/8	A16T-SVQBR/L 3-D	1.000	1.299	.750	.906	12.000	0°	-7°	VBMT 332	2.2
		A20T-SVQBR/L 3	1.250	1.579	.875	1.181	12.000	0°	-7°	VBMT 332	2.2
		A24T-SVQBR/L 3	1.500	1.941	1.063	1.374	12.000	0°	-5°	VBMT 332	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size							
Bar dia, dm_m							
iC	mm	inch		Insert screw	Shim	Shim screw	Key (Torx Plus)
11	1/4	16-25	.	5513 020-20	-	-	5680 051-02 (7IP)
16	3/8	25	1.000	5513 020-10	-	-	5680 049-01 (15IP)
16	3/8	32-40	1.250-1.500	5513 020-01	5322 270-01	5512 090-01	5680 049-01 (15IP)



A9



A284



A482



G6



A2



A320



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

Steel shank

Steel shank

Entering angle:

A...-SVQCR/L
 $\kappa_r 107.5^\circ$

A...SVUCR/L
 $\kappa_r 93^\circ$

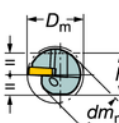
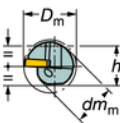
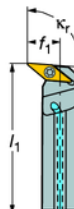
Lead angle:

-17.5°

-3°



VCMT, VCEX,
VCGX
VCMW



Max overhang 4 x dm_m
With internal coolant supply
Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	11	A16R-SVQCR/L 11-E	16	22	13	15	200	0°	-4°	VCMT 11 03 04	0.9
	11	A16R-SVUCR/L 11-E	16	22	13	15	200	0°	-4°	VCMT 11 03 04	0.9

Inch version

Main application		iC Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	1/4	A10R-SVQCR/L 2-E	.625	.850	.486	.562	8.000	2°	-4°	VCMT 221	0.7
	1/4	A10R-SVUCR/L 2-E	.625	.850	.486	.562	8.000	2°	-4°	VCMT 221	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	iC	Bar dia, dm_m mm	inch	Insert screw	Key (Torx Plus)
11	1/4	16	.625	5513 020-03	5680 051-02 (71P)



A9



A490



A490



G6



A2



A320



J2

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

Entering angle:

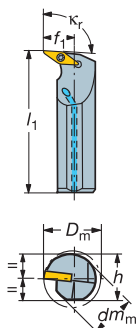
Lead angle:

Steel shank

A...-SVUBR/L

 $\kappa_r 93^\circ$ -3° 

VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW



Max overhang $4 \times dm_m$
With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code ⁵⁾	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^1)$	$\lambda_s^2)$		
	11	A16R-SVUBR/L 11-EB1	16	22	13	15	200	0°	-7°	VBMT 11 03 04	0.9
		A20S-SVUBR/L 11-EB1	20	27	15	18	250	0°	-5°	VBMT 11 03 04	0.9
		A25T-SVUBR/L 11-DB1	25	33	18	23	300	0°	-4°	VBMT 11 03 04	0.9
		A16R-SVUBR/L 11-E	16	22	13	15	200	0°	-6°	VBMT 11 02 04	0.9
		A20S-SVUBR/L 11-E	20	27	15	18	250	0°	-5°	VBMT 11 02 04	0.9
		A25T-SVUBR/L 11-D	25	33	18	23	300	0°	-4°	VBMT 11 02 04	0.9
	16	A25T-SVUBR/L 16-D	25	33	18	23	300	0°	-6.5°	VBMT 16 04 08	3.0
		A32T-SVUBR/L 16	32	40	22	30	300	0°	-6°	VBMT 16 04 08	3.0
		A40T-SVUBR/L 16	40	50	27	37	300	0°	-4°	VBMT 16 04 08	3.0

Inch version

Main application	iC	Ordering code ⁵⁾	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^1)$	$\lambda_s^2)$		
	1/4	A10R-SVUBR/L 2-EB1	.625	.850	.486	.560	8.000	0°	-7°	VBMT 221	0.7
		A12S-SVUBR/L 2-EB1	.750	1.012	.580	.710	10.000	0°	-5°	VBMT 221	0.7
		A16T-SVUBR/L 2-DB1	1.000	1.240	.680	.910	12.000	0°	-4°	VBMT 221	0.7
		A10R-SVUBR/L 2-E	.625	.850	.486	.560	8.000	0°	-7°	VBMT 2(1.5)1	0.7
		A12S-SVUBR/L 2-E	.750	1.012	.580	.710	10.000	0°	-5°	VBMT 2(1.5)1	0.7
		A16T-SVUBR/L 2-D	1.000	1.240	.680	.910	12.000	0°	-4°	VBMT 2(1.5)1	0.7
	3/8	A20T-SVUBR/L 3	1.250	1.705	1.000	1.181	12.000	0°	-5°	VBMT 332	2.2
		A24T-SVUBR/L 3	1.500	2.126	1.125	1.374	12.000	0°	-3°	VBMT 332	2.2
		A32U-SVUBR/L 3	2.000	2.551	1.375	1.874	14.000	0°	-6°	VBMT 332	2.2

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

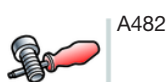
Insert size							
Bar dia, dm_m							
	iC	mm	inch	Insert screw	Shim	Shim screw	Key (Torx Plus)
11	1/4	16-25	.625-1.000	5513 020-20	-	-	5680 051-02 (7IP)
16	3/8	25	-	5513 020-10	-	-	5680 049-01 (15IP)
16	3/8	32-40	1.250-2.000	5513 020-01	5322 270-01	5512 090-01	5680 049-01 (15IP)



A9



A284



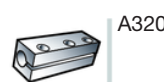
A482



G6



A2



A320



J2

Boring bars

CoroTurn® 111 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Entering angle:

Lead angle:

Steel shank

A...-SCLPR/L

$\kappa_r 95^\circ$

-5°

Carbide shank

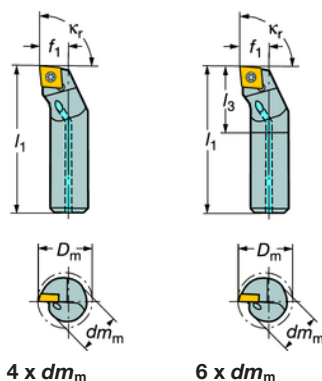
E...-SCLPR/L

$\kappa_r 95^\circ$

-5°



 CPMT



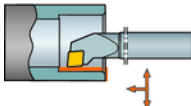
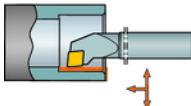
Max overhang

With internal coolant supply

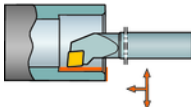
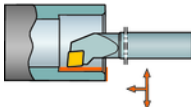
Right hand style shown

Cylindrical

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$		
	06	A08K-SCLPR/L 06-R	8	10	5	125		0°	-10°	CPMT 06 02 04	0.9
		A10K-SCLPR/L 06-R	10	12	6	125		0°	-7°	CPMT 06 02 04	0.9
		A12M-SCLPR/L 06-R	12	16	9	150		0°	-3°	CPMT 06 02 04	0.9
	06	E08K-SCLPR/L 06-R	8	10	5	125	17	0°	-10°	CPMT 06 02 04	0.9
		E10M-SCLPR/L 06-R	10	12	6	150	21	0°	-7°	CPMT 06 02 04	0.9
		E12Q-SCLPR/L 06-R	12	16	9	180	25	0°	-3°	CPMT 06 02 04	0.9

Inch version

Main application		Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$		
	1/4	A05K-SCLPR/L 2-R	.312	.413	.219	5.000		2°	-9°	CPMT 2(1.5)1	0.7
		A06M-SCLPR/L 2-R	.375	.480	.250	6.000		4°	-6.5°	CPMT 2(1.5)1	0.7
		A08M-SCLPR/L 2-R	.500	.598	.312	6.000		6°	-3°	CPMT 2(1.5)1	0.7
	1/4	E05K-SCLPR/L 2-R	.312	.413	.219	5.000	.758	2°	-9°	CPMT 2(1.5)1	0.7
		E06M-SCLPR/L 2-R	.375	.480	.250	6.000	.886	4°	-7°	CPMT 2(1.5)1	0.7
		E08R-SCLPR/L 2-R	.500	.598	.312	8.000	.955	6°	-3°	CPMT 2(1.5)1	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.


3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	iC	Bar dia, dm_m	Insert screw	Key (Torx Plus)	
06	1/4	8-10	5513 020-21	5680 051-02 (7IP)	
06	1/4	12	5513 020-46	5680 051-02 (7IP)	



Boring bars

CoroTurn® 111 screw clamp design

Cylindrical with flats

Steel shank

Carbide shank

Entering angle:

A...-SCLPR/L
 $\kappa_r 95^\circ$

E...SCLPR/L
 $\kappa_r 95^\circ$

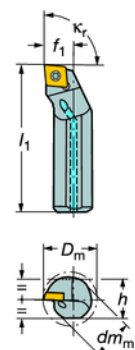
Lead angle:

-5°

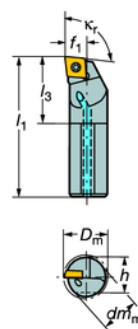
-5°



CPMT



4 x dm_m



6 x dm_m

Max overhang


With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
	06	A08K-SCLPR/L 06	8	10	5	7	125	0°	-10°	CPMT 06 02 04	0.9
		A10K-SCLPR/L 06	10	12	6	9	125	0°	-7°	CPMT 06 02 04	0.9
		A12M-SCLPR/L 06	12	16	9	11	150	0°	-3°	CPMT 06 02 04	0.9

Inch version

			Dimensions, inch										ft-lbs ⁴⁾
Main application	iC	Ordering code	<i>dm_m</i>	<i>D_m min</i>	<i>f₁</i>	<i>h</i>	<i>l₁</i>	<i>l₃</i>	<i>γ</i> ¹⁾	<i>λ_s</i> ²⁾	Gauge inserts		
	1/4	A05K-SCLPR/L 2	.312	.413	.219	.272	5.000		2°	-9°	CPMT 2(1.5)1	0.7	
		A06M-SCLPR/L 2	.375	.480	.250	.336	6.000		4°	-6.5°	CPMT 2(1.5)1	0.7	
		A08M-SCLPR/L 2	.500	.598	.312	.460	6.000		6°	-3°	CPMT 2(1.5)1	0.7	
	1/4	E06M-SCLPR/L 2	.375	.480	.250	.359	6.000	.886	4°	-7°	CPMT 2(1.5)1	0.7	
		E08R-SCLPR/L 2	.500	.598	.312	.484	8.000	.955	6°	-3°	CPMT 2(1.5)1	0.7	

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	iC	Bar dia, dm_m mm	inch	Insert screw	Key (Torx Plus)
06	1/4	8-10	.312-.375	5513 020-21	5680 051-02 (7IP)
06	1/4	12	.500	5513 020-46	5680 051-02 (7IP)



A9



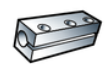
A490



G6



A2



A320



J2

Boring bars

CoroTurn® 111 screw clamp design

Cylindrical

Steel shank

Carbide shank

Dampened carbide shank

With groove for EasyFix sleeve

Entering angle:

A...-SDUPR/L-ER
 $\kappa_r 93^\circ$

E...-SDUPR/L-ER
 $\kappa_r 93^\circ$

F...-SDUPR/L-ER
 $\kappa_r 93^\circ$

Lead angle:

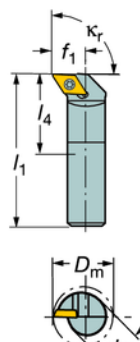
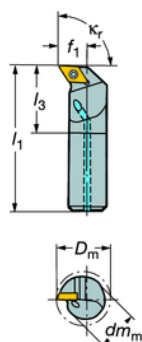
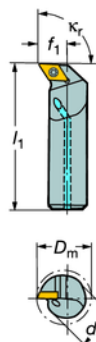
-3°

-3°

-3°



DPMT



Max overhang

4 x dm_m
With internal coolant supply

6 x dm_m
With internal coolant supply

10 x dm_m
Silent Tools®

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	07	A10K-SDUPR/L 07-ER	dm_m	$D_m \text{ min}$	f_1	l_1	l_3	$l_4^{5)}$	$\gamma^{1)}$	$\lambda_s^{2)}$	DPMT 07 02 04	0.9
		A12M-SDUPR/L 07-ER	10	15	9	125			4°	-2°	DPMT 07 02 04	0.9
		A16R-SDUPR/L 07-R	12	18	11	150			6°	-1°	DPMT 07 02 04	0.9
		A16R-SDUPR/L 07-R	16	20	11	200			6°	0°	DPMT 07 02 04	0.9
	07	E10M-SDUPR/L 07-ER	10	15	9	150	21		4°	-2°	DPMT 07 02 04	0.9
		E12Q-SDUPR/L 07-ER	12	18	11	180	25		6°	-1°	DPMT 07 02 04	0.9
		E16R-SDUPR/L 07-R	16	20	11	200	33		6°	0°	DPMT 07 02 04	0.9
	07	F10M-SDUPR/L 07-ER	10	15	9	150	60		0°	-3°	DPMT 07 02 04	0.9
		F12Q-SDUPR/L 07-ER	12	18	11	180	72		0°	-1°	DPMT 07 02 04	0.9
	11	A20S-SDUPR/L 11-R	20	25	13	250			6°	-1°	DPMT 11 T3 08	3.0

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	1/4	A06M-SDUPR/L 2-ER	dm_m	$D_m \text{ min}$	f_1	l_1	l_3	$l_4^{5)}$	$\gamma^{1)}$	$\lambda_s^{2)}$	DPMT 2(1.5)1	0.7
		A08M-SDUPR/L 2-ER	.375	.559	.330	6.000			4°	-2°	DPMT 2(1.5)1	0.7
		A10R-SDUPR/L 2-R	.500	.681	.392	6.000			6°	-1°	DPMT 2(1.5)1	0.7
		A10R-SDUPR/L 2-R	.625	.772	.406	8.000			6°	0°	DPMT 2(1.5)1	0.7
	1/4	E06M-SDUPR/L 2-ER	.375	.559	.330	6.000	.886		4°	-2°	DPMT 2(1.5)1	0.7
		E08R-SDUPR/L 2-ER	.500	.681	.392	8.000	.955		6°	-1°	DPMT 2(1.5)1	0.7
		E10R-SDUPR/L 2-R	.625	.772	.406	8.000	1.112		6°	0°	DPMT 2(1.5)1	0.7
	1/4	F06M-SDUPR 2-ER	.375	.591	.350	6.000	2.756		0°	-3°	DPMT 2(1.5)1	0.7
		F08Q-SDUPR 2-ER	.500	.709	.429	7.250	3.307		0°	-1°	DPMT 2(1.5)1	0.7
	3/8	A12S-SDUPR/L 3-R	.750	.929	.500	10.000			6°	-2°	DPMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

5) Do not clamp in this area.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size			Bar dia, dm_m			Insert screw			Key (Torx Plus)		
	iC		mm	inch							
07	1/4	10		.375-.500		5513 020-48			5680 051-02 (7IP)		
07	1/4	12-16		.625		5513 020-03			5680 051-02 (7IP)		
11	3/8	20		.750		5513 020-09			5680 049-01 (15IP)		



A9



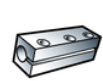
A490



G6



A2



A320



J2

Boring bars

CoroTurn® 111 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Steel shank

A...-SDUPR/L-ERX

Carbide shank

E...-SDUPR/L-ERX

Steel shank

A...-SDXPR/L-ER

Entering angle: $\kappa_r 93^\circ$

Lead angle: -3°

$\kappa_r 93^\circ$

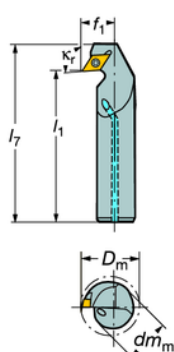
-3°

$\kappa_r 62.5^\circ$

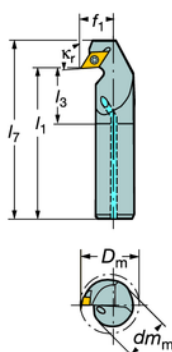
27.5°



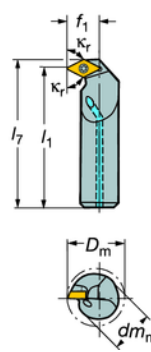
DPMT



4 x dm_m
Back boring



6 x dm_m
Back boring



4 x dm_m

Max overhang
With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	l_7	$\gamma^{1)}$		
	07	A16R-SDUPR/L 07-ERX	16	22	13	200		212.1	0°	DPMT 07 02 04	0.9
	07	E16R-SDUPR/L 07-ERX	16	22	13	200	33	212.1	0°	DPMT 07 02 04	0.9
	07	A16R-SDXPR/L 07-ER	16	22	13	200		204.6	0°	DPMT 07 02 04	0.9

Inch version

Main application	i/C	Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_7	$\gamma^{1)}$	$\lambda_s^{2)}$		
	1/4	A10R-SDUPR/L 2-ERX	.625	.850	.486	8.000	8.47	6°	0°	DPMT 2(1.5)1	0.7
	1/4	A10R-SDXPR/L 2-ER	.625	.850	.486	8.000	8.20	0°	0°	DPMT 2(1.5)1	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	i/C	Bar dia, dm_m		Insert screw	Key (Torx Plus)
07	1/4	16	.625	5513 020-03	5680 051-02 (7IP)



A9



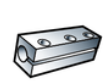
A490



G6



A2



A320



J2

Boring bars

CoroTurn® 111 screw clamp design

Cylindrical with flats

Entering angle:

Lead angle:

Steel shank

A...-SDUPR/L
 $\kappa_r 93^\circ$

-3°

Steel shank

A...-SDUPR/L-EX
 $\kappa_r 93^\circ$

-3°

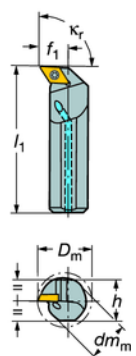
Steel shank

A...-SDXPR/L
 $\kappa_r 62.5^\circ$

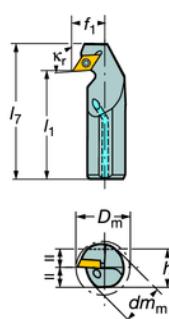
27.5°



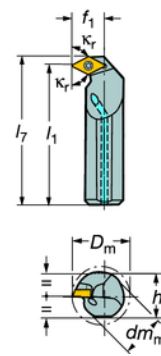
DPMT



$4 \times dm_m$



$4 \times dm_m$
Back boring



$4 \times dm_m$

Max overhang
With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
 ≤ 27°	07	A10K-SDUPR/L 07-E	10	15	9	9	125	0°	-2°		DPMT 07 02 04	0.9
		A12M-SDUPR/L 07-E	12	18	11	11	150	0°	-1°		DPMT 07 02 04	0.9
		A16R-SDUPR/L 07	16	20	11	15	200	0°	0°		DPMT 07 02 04	0.9
	11	A20S-SDUPR/L 11	20	25	13	18	250	0°	-1°		DPMT 11 T3 08	3.0
		A25T-SDUPR/L 11	25	32	17	23	300	0°	2°		DPMT 11 T3 08	3.0
 ≤ 27°	07	A16R-SDUPR/L 07-EX	16	22	13	15	200	212.1	0°	1°	DPMT 07 02 04	0.9
 ≤ 60°	07	A16R-SDXPR/L 07-E	16	22	13	15	200	204.6	0°	0°	DPMT 07 02 04	0.9

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

For coolant connector, see page A324.

R = Right hand, L = Left hand

Main spare parts (see next page)



A9



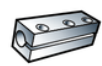
A490



G6



A2




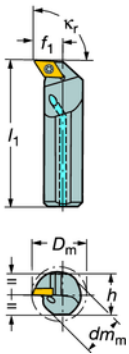
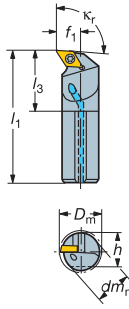
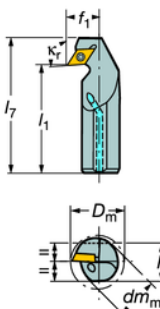
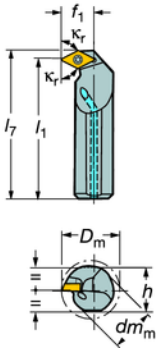
A320



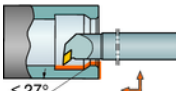
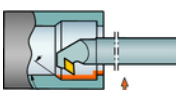
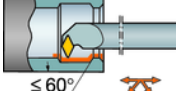
J2

Boring bars

CoroTurn® 111 screw clamp design

	Steel shank	Carbide shank	Steel shank	Steel shank
Cylindrical with flats	A...-SDUPR/L	E...SDUPR/L	A...-SDUPR/L-EX	A...-SDXPR/L
Entering angle:	$\kappa_r 93^\circ$	$\kappa_r 93^\circ$	$\kappa_r 93^\circ$	$\kappa_r 62.5^\circ$
Lead angle:	-3°	-3°	-3°	27.5°
				
Max overhang With internal coolant supply Right hand style shown	$4 \times dm_m$	$6 \times dm_m$	$4 \times dm_m$ Back boring	$4 \times dm_m$

Inch version

			Dimensions, inch											
Main application	iC	Ordering code	dm _m	D _m min	f ₁	h	l ₁	l ₃	l ₇	γ ¹⁾	λ _s ²⁾	Gauge inserts	ft-lbs ³⁾	
	1/4	A06M-SDUPR/L 2-E	.375	.559	.330	.336	6.000			4°	-2°	DPMT 2(1.5)1	0.7	
		A08M-SDUPR/L 2-E	.500	.681	.392	.460	6.000			6°	-1°	DPMT 2(1.5)1	0.7	
		A10R-SDUPR/L 2	.625	.772	.486	.562	8.000			6°	1°	DPMT 2(1.5)1	0.7	
	1/4	E06M-SDUPR 2-E	.375	.559	.330	.359	6.000	.886		4°	-2°	DPMT 2(1.5)1	0.7	
		E10R-SDUPR/L 2	.625	.772	.406	.609	8.000	1.112		6°	0°	DPMT 2(1.5)1	0.7	
		3/8	A12S-SDUPR/L 3	.750	.929	.500	.709	10.000			6°	-2°	DPMT 3(2.5)2	2.2
A16T-SDUPR/L 3	1.000		1.201	.640	.906	12.000			6°	1°	DPMT 3(2.5)2	2.2		
	1/4	A10R-SDUPR/L 2-EX	.625	.850	.486	.562	8.000		8.476	6°	0°	DPMT 2(1.5)1	0.7	
	1/4	A10R-SDXPR/L 2-E	.625	.850	.486	.562	8.000		8.201	0°	0°	DPMT 2(1.5)1	0.7	

1) γ = Rake angle (valid with flat insert).


2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	i/C	Bar dia, dm_m		Insert screw	Key (Torx Plus)
07	1/4	10	.375-.500	5513 020-48	5680 051-02 (7IP)
07	1/4	12-16	.625	5513 020-03	5680 051-02 (7IP)
11	3/8	20-25	.750-1.000	5513 020-09	5680 049-01 (15IP)



Boring bars

CoroTurn® 111 screw clamp design

Cylindrical

With groove for EasyFix sleeve

Entering angle:

Lead angle:

Steel shank

A...-STFPR/L-R
 $\kappa_r 91^\circ$

-1°

Carbide shank

E...-STFPR/L
 $\kappa_r 91^\circ$

-1°

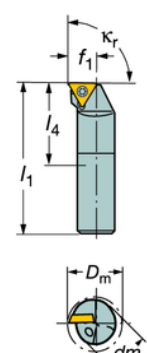
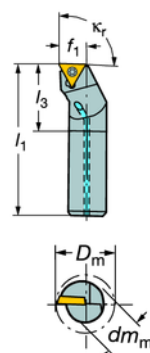
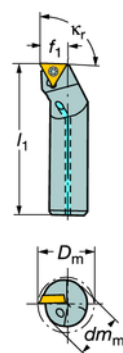
Dampened carbide shank

F...-STFPR/L
 $\kappa_r 91^\circ$

-1°



TPMT



Max overhang

4 x dm_m
With internal coolant supply

6 x dm_m
With internal coolant supply

10 x dm_m

Silent Tools®

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	l_4	$\gamma^{1)}$	$\lambda_s^{2)}$		
	06	A06F-STFPR/L 06-R	6	8.5	4.5	80			0°	-9°	TPMT 06 T1 02	0.6
		A08H-STFPR/L 06-R	8	10	5	100			0°	-8°	TPMT 06 T1 02	0.6
	09	A10K-STFPR/L 09-R	10	13	7	125			0°	-3°	TPMT 09 02 04	0.9
		A12M-STFPR/L 09-R	12	16	9	150			0°	-2°	TPMT 09 02 04	0.9
	11	A12M-STFPR/L 11-R	12	16	9	150			0°	-2°	TPMT 11 03 04	0.9
		A16R-STFPR/L 11-R	16	20	11	200			0°	0°	TPMT 11 03 04	0.9
	16	A20S-STFPR/L 16-R	20	25	13	250			0°	-1°	TPMT 16 T3 08	3.0
	06	E06H-STFPR/L 06-R	6	8.5	4.5	100	13		0°	-9°	TPMT 06 T1 02	0.6
		E08K-STFPR/L 06-R	8	10	5	125	17		0°	-8°	TPMT 06 T1 02	0.6
	09	E10M-STFPR/L 09-R	10	13	7	150	21		0°	-3°	TPMT 09 02 04	0.9
		E12Q-STFPR/L 09-R	12	16	9	180	25		0°	-2°	TPMT 09 02 04	0.9
	11	E12Q-STFPR/L 11-R	12	16	9	180	25		0°	-2°	TPMT 11 03 04	0.9
		E16R-STFPR/L 11-R	16	20	11	200	33		0°	0°	TPMT 11 03 04	0.9
	09	F10M-STFPR/L 09-R	10	13	7	150		60	0°	-4°	TPMT 09 02 04	0.9
		F12Q-STFPR/L 09-R	12	16	9	180		72	0°	-3°	TPMT 09 02 04	0.9

Inch version

Main application	IC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	l_4	$\gamma^{1)}$	$\lambda_s^{2)}$		
	5/32	A04F-STFPR/L 1.2-R	.250	.323	.156	3.250			0°	-10°	TPMT 1.2(1.2)0	0.4
		A05H-STFPR/L 1.2-R	.312	.413	.219	4.000			2°	-8°	TPMT 1.2(1.2)0	0.4
	7/32	A06M-STFPR/L 1.8-R	.375	.480	.250	6.000			4°	-3.83°	TPMT 1.8(1.5)1	0.7
		A08M-STFPR/L 1.8-R	.500	.598	.312	6.000			6°	-2°	TPMT 1.8(1.5)1	0.7
	1/4	A08M-STFPR/L 2-R	.500	.598	.312	6.000			6°	-3°	TPMT 221	0.7
		A10R-STFPR/L 2-R	.625	.772	.406	8.000			6°	0°	TPMT 221	0.7
	3/8	A12S-STFPR/L 3-R	.750	.929	.500	10.000			6°	-2°	TPMT 3(2.5)2	2.2
	5/32	E04H-STFPR/L 1.2-R	.250	.335	.156	4.000	.585		0°	-9°	TPMT 1.2(1.2)0	0.4
		E05K-STFPR/L 1.2-R	.312	.413	.219	5.000	.758		2°	-8°	TPMT 1.2(1.2)0	0.4
	7/32	E06M-STFPR/L 1.8-R	.375	.480	.250	6.000	.886		4°	-3°	TPMT 1.8(1.5)1	0.7
		E08Q-STFPR/L 1.8-R	.500	.598	.312	7.250	.955		6°	-2°	TPMT 1.8(1.5)1	0.7
	1/4	E08R-STFPR/L 2-R	.500	.598	.312	8.000	.955		6°	-2°	TPMT 221	0.7
		E10R-STFPR/L 2-R	.625	.772	.406	8.000	1.112		6°	0°	TPMT 221	0.7
	7/32	F06M-STFPR 1.8-R	.375	.512	.272	6.000		2.756	0°	-4°	TPMT 1.8(1.5)1	0.7
		F08Q-STFPR 1.8-R	.500	.630	.350	7.250		3.307	0°	-3°	TPMT 1.8(1.5)1	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

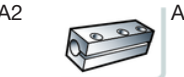
3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts (see next page)



Boring bars

CoroTurn® 111 screw clamp design

Cylindrical with flats

Steel shank

Carbide shank

Entering angle:

A...-STFPR/L
 $\kappa_r 91^\circ$

E...-STFPR/L
 $\kappa_r 91^\circ$

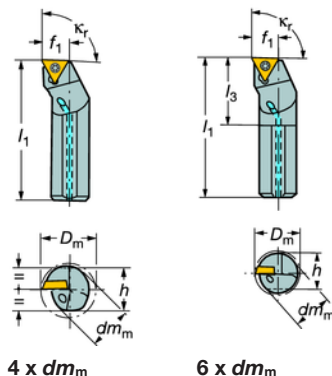
Lead angle:

-1°

-1°



TPMT



Max overhang

With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
		06 A06H-STFPR/L 06	6	8.5	4.5	5	100	0°	-9°	TPMT 06 T1 02	0.6
		A08K-STFPR/L 06	8	10	5	7	125	0°	-8°	TPMT 06 T1 02	0.6
		09 A10K-STFPR/L 09	10	13	7	9	125	0°	-3°	TPMT 09 02 04	0.9
		A12M-STFPR/L 09	12	16	9	11	150	0°	-2°	TPMT 09 02 04	0.9
		11 A12M-STFPR/L 11	12	16	9	11	150	0°	-2°	TPMT 11 03 04	0.9
		A16R-STFPR/L 11	16	20	11	15	200	0°	0°	TPMT 11 03 04	0.9
		16 A20S-STFPR/L 16	20	25	13	18	250	0°	-1°	TPMT 16 T3 08	3.0
		A25T-STFPR/L 16	25	32	17	23	300	0°	1°	TPMT 16 T3 08	3.0

Inch version

Main application		IC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
				dm_m	$D_m \text{ min}$	f_1	h	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$		
		5/32	A04F-STFPR/L 1.2	.250	.323	.156	.210	3.250		0°	-9°	TPMT 1.2(1.2)0	0.4
			A05H-STFPR/L 1.2	.312	.402	.219	.272	4.000		2°	-8°	TPMT 1.2(1.2)0	0.4
		7/32	A06M-STFPR/L 1.8	.375	.480	.250	.336	6.000		4°	-3°	TPMT 1.8(1.5)1	0.7
			A08M-STFPR/L 1.8	.500	.598	.312	.460	6.000		6°	-2°	TPMT 1.8(1.5)1	0.7
		7/32	E06M-STFPR/L 1.8	.375	.480	.250	.359	6.000	.886	4°	-3°	TPMT 1.8(1.5)1	0.7
			A08M-STFPR/L 2	.500	.598	.312	.460	6.000		6°	-2°	TPMT 221	0.7
		1/4	A10R-STFPR/L 2	.625	.772	.406	.562	8.000		6°	0°	TPMT 221	0.7
			E08R-STFPR/L 2	.500	.598	.312	.484	8.000	.955	6°	-2°	TPMT 221	0.7
		3/8	A12S-STFPR/L 3	.750	.929	.500	.709	10.000		6°	-1°	TPMT 3(2.5)2	2.2
			A16T-STFPR/L 3	1.000	1.201	.640	.906	12.000		6°	1°	TPMT 3(2.5)2	2.2

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	IC	Bar dia, dm_m mm	inch	Insert screw	Key (Torx Plus)
06	5/32	6	.250	5513 020-44	5680 051-01 (6IP)
06	5/32	8	.312	5513 020-28	5680 051-01 (6IP)
09	7/32	10-12	.375-.500	5513 020-47	5680 051-02 (7IP)
11	1/4	12	.500	5513 020-48	5680 051-02 (7IP)
11	1/4	16	.625	5513 020-03	5680 051-02 (7IP)
16	3/8	20	.750	5513 020-09	5680 049-01 (15IP)
16	3/8	25	1.000	5513 020-10	5680 049-01 (15IP)



Boring bars

CoroTurn® 111 screw clamp design

Cylindrical

Steel shank

Carbide shank

With groove for EasyFix sleeve

A...-SWLPR/L

E...-SWLPR/L

Entering angle: $\kappa_r 95^\circ$

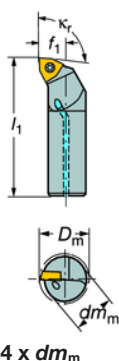
$\kappa_r 95^\circ$

Lead angle: -5°

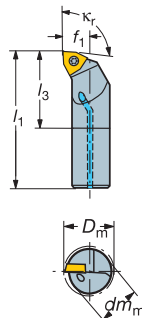
-5°



WPMT



4 x dm_m



6 x dm_m

Max overhang

With internal coolant supply

Right hand style shown

Cylindrical

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$		
	02	A05F-SWLPR/L 02-R	5	6.5	4	80		0°	-13°	WPMT 02 01 02	0.6
		A06F-SWLPR/L 02-R	6	8.5	4.5	80		0°	-11°	WPMT 02 01 02	0.6
		A08H-SWLPR/L 02-R	8	10	5	100		0°	-10°	WPMT 02 01 02	0.6
	02	E05H-SWLPR/L 02-R	5	7	4	100	11	0°	-13°	WPMT 02 01 02	0.6
		E06H-SWLPR/L 02-R	6	8.5	4.5	100	13	0°	-11°	WPMT 02 01 02	0.6
		E08K-SWLPR/L 02-R	8	10	5	125	17	0°	-10°	WPMT 02 01 02	0.6
		A10K-SWLPR/L 04-R	10	12	6	125		0°	-7°	WPMT 04 02 04	0.9
	04	A12M-SWLPR/L 04-R	12	16	9	150		0°	-3°	WPMT 04 02 04	0.9
		E10M-SWLPR/L 04-R	10	12	6	150	21	0°	-7°	WPMT 04 02 04	0.9
	04	E12Q-SWLPR/L 04-R	12	16	9	180	25	0°	-3°	WPMT 04 02 04	0.9

Inch version

Main application		iC Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
			dm_m	$D_m \text{ min}$	f_1	l_1	l_3	$\gamma^1)$	$\lambda_s^2)$		
	5/32	A03F-SWLPR/L 1.2-R	.188	.260	.126	3.250		0°	-13°	WPMT 1.2(1)0	0.4
		A04F-SWLPR/L 1.2-R	.250	.323	.156	3.250		0°	-11°	WPMT 1.2(1)0	0.4
		A05H-SWLPR/L 1.2-R	.312	.413	.219	4.000		2°	-10°	WPMT 1.2(1)0	0.4
	5/32	E03H-SWLPR/L 1.2-R	.188	.260	.126	3.250	.430	0°	-13°	WPMT 1.2(1)0	0.4
		E04H-SWLPR/L 1.2-R	.250	.323	.156	4.000	.580	0°	-11°	WPMT 1.2(1)0	0.4
		E05K-SWLPR/L 1.2-R	.312	.413	.219	5.000	.760	2°	-10°	WPMT 1.2(1)0	0.4
	1/4	A06M-SWLPR/L 2-R	.375	.480	.250	6.000		4°	-6°	WPMT 2(1.5)1	0.7
		A08M-SWLPR/L 2-R	.500	.598	.312	6.000		6°	-4°	WPMT 2(1.5)1	0.7
	1/4	E06M-SWLPR/L 2-R	.375	.480	.250	6.000	.880	4°	-6°	WPMT 2(1.5)1	0.7
		E08R-SWLPR/L 2-R	.500	.598	.312	8.000	.950	6°	-4°	WPMT 2(1.5)1	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	iC	Bar dia, dm_m	Insert screw	Key (Torx Plus)	
02	5/32	5	5513 020-53	5680 051-01 (6IP)	
02	5/32	6-8	5513 020-44	5680 051-01 (6IP)	
04	1/4	10	5513 020-21	5680 051-02 (7IP)	
04	1/4	12	5513 020-46	5680 051-02 (7IP)	



A9



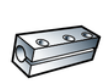
A490



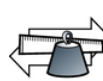
G6



A2



A320



J2

Boring bars

CoroTurn® 111 screw clamp design

Cylindrical with flats

Steel shank

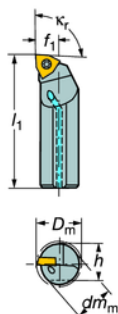
A...SWLPR/L

Entering angle: $\kappa_r 95^\circ$

Lead angle: -5°



WPMT



4 x dm_m

Max overhang

With internal coolant supply

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
	02	A06F-SWLPR/L 02	dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^1)$	$\lambda_s^{2)}$	WPMT 02 01 02	0.6
		A08H-SWLPR/L 02	6	8.5	4.5	5	80	0°	-11°	WPMT 02 01 02	0.6
	04	A10K-SWLPR/L 04	8	10	5	7	100	0°	-10°	WPMT 04 02 04	0.9
		A12M-SWLPR/L 04	10	12	6	9	125	0°	-7°	WPMT 04 02 04	0.9
			12	16	9	11	150	0°	-3°	WPMT 04 02 04	0.9

Inch version

Main application		Ordering code	Dimensions, inch							Gauge inserts	ft-lbs ⁴⁾
	5/32	A04F-SWLPR/L 1.2	dm_m	$D_m \text{ min}$	f_1	h	l_1	$\gamma^1)$	$\lambda_s^{2)}$	WPMT 1.2(1)0	0.4
		A05H-SWLPR/L 1.2	.250	.323	.156	.210	3.250	0°	-11°	WPMT 1.2(1)0	0.4
	1/4	A06M-SWLPR/L 2	.312	.413	.219	.272	4.000	2°	-10°	WPMT 2(1.5)1	0.7
		A08M-SWLPR/L 2	.375	.480	.250	.336	6.000	4°	-6°	WPMT 2(1.5)1	0.7
			.500	.598	.312	.460	6.000	6°	-4°	WPMT 2(1.5)1	0.7

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

For coolant connector, see page A324.

Main spare parts

Insert size					
	iC	Bar dia, dm_m		Insert screw	Key (Torx Plus)
		mm	inch		
02	02	-	.250	5513 020-53	5680 051-01 (6IP)
02	5/32	6-8	.312	5513 020-44	5680 051-01 (6IP)
04	1/4	10	.375	5513 020-21	5680 051-02 (7IP)
04	1/4	12	.500	5513 020-46	5680 051-02 (7IP)



A9



A490



G6



A2



A320



J2

Steel shank boring bars

T-Max® top clamp design

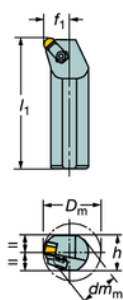
Cylindrical with flats

Steel shank
S...-CRSNR/L

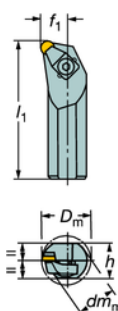
Steel shank
S...-CRSPR/L



RNGA
RNG




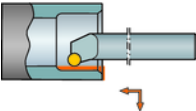
RPG


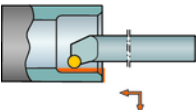


Max overhang $4 \times dm_m$

Right hand style shown

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts
			dm_m	D_m min	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	12	S40T-CRSNR/L 12-ID	40	70	27	37	300	-6°	-12°	RNGN 12 07 00	

Main application		Ordering code	Dimensions, mm								Gauge inserts
			dm_m	D_m min	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
	09	S25T-CRSPR/L 09-ID	25	32	17	23	300	0°	-2°	RPGN 09 03 00	

1) γ = Rake angle.

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size					
	Clamp	Key (mm)	Shim (for insert thickness)	Shim screw	Key (Torx Plus)
09	5412 126-03	3021 010-040 (4.0)	-	-	-
12	5412 125-01	3021 010-040 (4.0)	5322 141-01 (7.97)	5513 013-02	5680 043-14(20IP)



A9



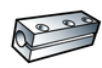
A492



G6



A2



A320



J2

EasyFix

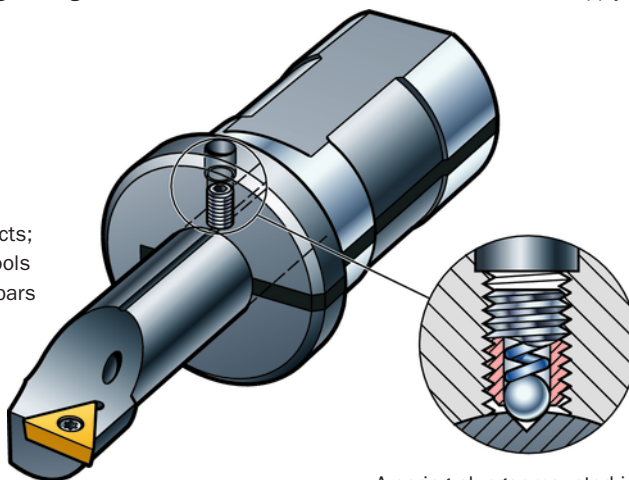
Sleeves for cylindrical bars

For correct mounting of cylindrical bars

EasyFix gives a fast and simple way of achieving correct indexing of centre height when mounting cylindrical bars into the machine, due to a spring loaded plunger design.

The slot in the cylindrical sleeve is filled with a silicon sealer which allows the existing coolant supply system to be used.

The EasyFix sleeves can hold many products; CoroTurn® 107, CoroTurn® 111, Silent Tools dampened boring bars, CoroCut® boring bars and CoroCut® MB.



A spring plunger mounted in the sleeve clicks into a groove in the bar and guarantees correct centre height and fast and simple handling when mounting the cylindrical bar into the machine.

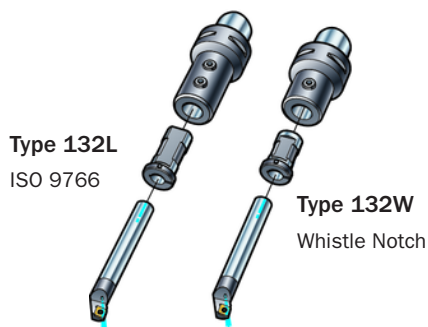
Correct clamping with Easy Fix™

Conventional lathe



Type 131

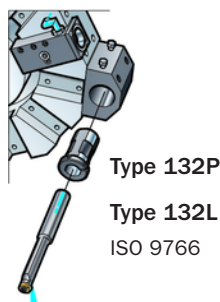
Coromant Capto®



Type 132L
ISO 9766

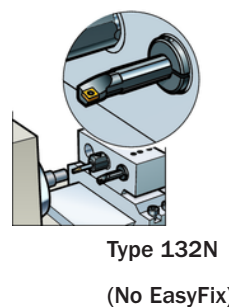
Type 132W
Whistle Notch

Turret type lathe



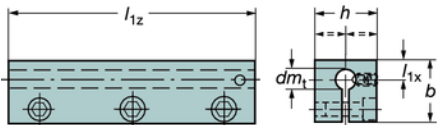
Type 132P
Type 132L
ISO 9766

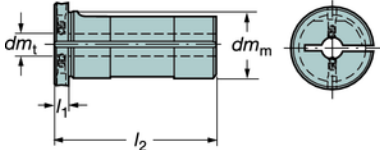
Sliding head machine



Type 132N
(No EasyFix)

EasyFix sleeves for cylindrical bars

Square sleeves	For bar diameter	Ordering code	Dimensions, mm				Spare parts	
131-	dm_t		l_{1z}	h	b	l_{1x}	Screw	Key (mm)
	mm		mm					
	5	131 -2005-B	80	20	20	5.5	3212 010-258	174.1-864 (3.0)
	6	131 -2006-B	80	20	20	6	3212 010-258	174.1-864 (3.0)
	8	131 -2008-B	80	20	20	7	3212 010-258	174.1-864 (3.0)
	10	131 -2010-B	80	20	20	7.5	3212 010-258	174.1-864 (3.0)
	12	131 -2512-B	80	25	25	9	3212 010-259	174.1-864 (3.0)
	16	131 -2516-B	80	25	25	10	3212 010-259	174.1-864 (3.0)
	20	131 -3220-B	100	32	40	12	3212 010-310	3021 010-040 (4.0)
	25	131 -3225-B	100	32	40	14.5	3212 010-310	3021 010-040 (4.0)
	Inch		Inch					
	.187	131 -A1203-B	3.15	.75	.75	.216	3212 010-258	174.1-864 (3.0)
	.250	131 -A1204-B	3.15	.75	.75	.236	3212 010-258	174.1-864 (3.0)
	.312	131 -A1205-B	3.15	.75	.75	.276	3212 010-258	174.1-864 (3.0)
	.375	131 -A1206-B	3.15	.75	.75	.295	3212 010-258	174.1-864 (3.0)
	.500	131 -A1608-B	3.15	1.00	1.00	.354	3212 010-259	174.1-864 (3.0)
	.625	131 -A1610-B	3.15	1.00	1.00	.394	3212 010-259	174.1-864 (3.0)
	.750	131 -A2012-B	3.94	1.25	1.25	.453	3212 010-310	3021 010-040 (4.0)

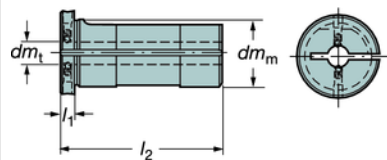
Cylindrical sleeves for inch bars	For bar diameter	Ordering code	Dimensions, inch		
132P-	dm_t	IS09766	l_1	l_2	dm_m
	Inch		Inch		
	.187	132P -25A03-B	.197	2.40	.984
	.250	132P -25A04-B	.197	2.40	.984
	.312	132P -25A05-B	.197	2.40	.984
	.375	132P -25A06-B	.197	2.40	.984
	.500	132P -25A08-B	.197	2.40	.984
	.625	132P -25A10-B	.197	2.40	.984
	.312	132P -32A05-B	.197	2.56	1.260
	.375	132P -32A06-B	.197	2.56	1.260
	.500	132P -32A08-B	.197	2.56	1.260
	.625	132P -32A10-B	.197	2.56	1.260
	.750	132P -32A12-B	.197	2.56	1.260
	.187	132P -160333-B	.197	3.35	1.000
	.250	132P -160433-B	.197	3.35	1.000
	.312	132P -160533-B	.197	3.35	1.000
	.375	132P -160633-B	.197	3.35	1.000
	.500	132P -160833-B	.197	3.35	1.000
	.625	132P -161033-B	.197	3.35	1.000
	.312	132P -200533-B	.197	3.35	1.250
	.375	132P -200633-B	.197	3.35	1.250
	.500	132P -200833-B	.197	3.35	1.250
	.625	132P -201033-B	.197	3.35	1.250
	.750	132P -201233-B	.197	3.35	1.250
	.375	132P -240641-B	.197	4.13	1.500
	.500	132P -240841-B	.197	4.13	1.500
	.625	132P -241041-B	.197	4.13	1.500
	.750	132P -241241-B	.197	4.13	1.500
	1.000	132P -241641-B	.197	4.13	1.500
	.500	132P -320849-B	.197	4.92	2.000
	.625	132P -321049-B	.197	4.92	2.000
	.750	132P -321249-B	.197	4.92	2.000
	1.000	132P -321649-B	.197	4.92	2.000

Groove for EasyFix sleeve is available on all cylindrical boring bars in diameter 5-25 mm (.197-1.000 inch)

EasyFix sleeves for cylindrical bars

Cylindrical sleeves for metric bars

132L-

For bar
diameter

Ordering code

Dimensions, mm (inch)

mm

 dm_t

132L-ISO 9766

 l_1 l_2 dm_m

6

132L -2506-B

5

61

25

8

132L -2508-B

5

61

25

10

132L -2510-B

5

61

25

12

132L -2512-B

5

61

25

16

132L -2516-B

5

61

25

20

132L -4020-B

5

75

40

25

132L -4025-B

5

75

40

 dm_t

132L

 l_1 l_2 dm_m

5

132L -1205050-B

5

55

19.05 (3/4)

5

132L -2005050-B

5

55

20

5

132L -2205050-B

5

55

22

5

132L -1605050-B

5

55

25.4 (1)

6

132L -1206050-B

5

55

19.05 (3/4)

6

132L -2006050-B

5

55

20

6

132L -2206050-B

5

55

22

6

132L -1606050-B

5

55

25.4 (1)

8

132L -1208050-B

5

55

19.05 (3/4)

8

132L -2008050-B

5

55

20

8

132L -2208050-B

5

55

22

8

132L -1608050-B

5

55

25.4 (1)

10

132L -1210050-B

5

55

19.05 (3/4)

10

132L -2010050-B

5

55

20

10

132L -2210050-B

5

55

22

10

132L -1610050-B

5

55

25.4 (1)

12

132L -1212050-B

5

55

19.05 (3/4)

12

132L -2012050-B

5

55

20

12

132L -2212050-B

5

55

22

12

132L -1612050-B

5

55

25.4 (1)

16

132L -1616050-B

5

55

25.4 (1)

5

132L -2505085-B

5

85

25

5

132L -3205085-B

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85

32

6

132L -3206085-B

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132L -3208085-B

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132L -3210085-B

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32

12

132L -3212085-B

5

85

32

16

132L -3216085-B

5

85

32

20

132L -3220085-B

5

85

32

6

132L -4006105-B

5

105

40

8

132L -4008105-B

5

105

40

10

132L -4010105-B

5

105

40

12

132L -4012105-B

5

105

40

16

132L -4016105-B

5

105

40

20

132L -4020105-B

5

105

40

25

132L -4025105-B

5

105

40

12

132L -5012125-B

5

125

50

16

132L -5016125-B

5

125

50

20

132L -5020125-B

5

125

50

25

132L -5025125-B

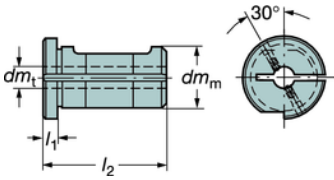
5

125

50

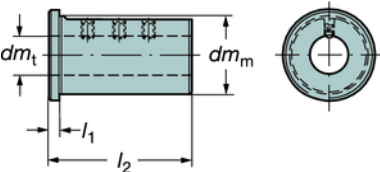
Groove for EasyFix sleeve is available on all cylindrical boring bars in diameter
5-25 mm (.197-1.000 inch)

EasyFix sleeves for cylindrical bars

	For bar diameter	Ordering code	Dimensions, mm		
	mm		l_1	l_2	dm_m
	dm_t				
132W- (Whistle Notch) for metric bars EasyFix 	5	132W-2505-B	5	50	25
	6	132W-2506-B	5	50	25
	8	132W-2508-B	5	50	25
	10	132W-2510-B	5	50	25
	12	132W-2512-B	5	50	25
	16	132W-2516-B	5	50	25
	20	132W-4020-B	5	75	40
	25	132W-4025-B	5	75	40

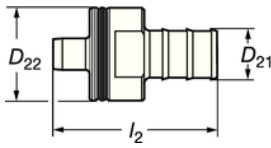
Groove for EasyFix sleeve is available on all cylindrical boring bars in diameter 5-25 mm (.197-1.000 inch)

Cylindrical sleeves

	For bar diameter	Ordering code	Dimensions			Spare parts	
	dm_t		l_1	l_2	dm_m	Screw	Key (mm)
<div>132N-</div> <div>Screw down (No EasyFix)</div> <div></div>	mm		mm				
	6	132N-2506	5	61	25	3214 010-356	3021 010-030 (3.0)
	8	132N-2508	5	61	25	3214 010-406	3021 010-040 (4.0)
	10	132N-2510	5	61	25	3214 010-405	3021 010-040 (4.0)
	12	132N-2512	5	61	25	3214 010-405	3021 010-040 (4.0)
	16	132N-2516	5	61	25	—	—
	20	132N-2520	5	61	25	—	—
	20	132N-4020	5	75	40	3214 010-457	3021 010-050 (5.0)
	25	132N-4025	5	75	40	3214 010-456	3021 010-050 (5.0)
	32	132N-4032	5	75	40	—	—
	Inch		Inch				
	.250	132N-25A04	.197	2.402	.984	3214 010-356	3021 010-030 (3.0)
	.312	132N-25A05	.197	2.402	.984	3214 010-406	3021 010-040 (4.0)
	.375	132N-25A06	.197	2.402	.984	3214 010-405	3021 010-040 (4.0)
	.500	132N-25A08	.197	2.402	.984	3214 010-405	3021 010-040 (4.0)
	.625	132N-25A10	.197	2.402	.984	—	—
	.750	132N-25A12	.197	2.402	.984	—	—
	.750	132N-40A12	.197	2.953	1.575	3214 010-457	3021 010-050 (5.0)
	1.000	132N-40A16	.197	2.953	1.575	3214 010-456	3021 010-050 (5.0)
1.250	132N-40A20	.197	2.953	1.575	—	—	

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)

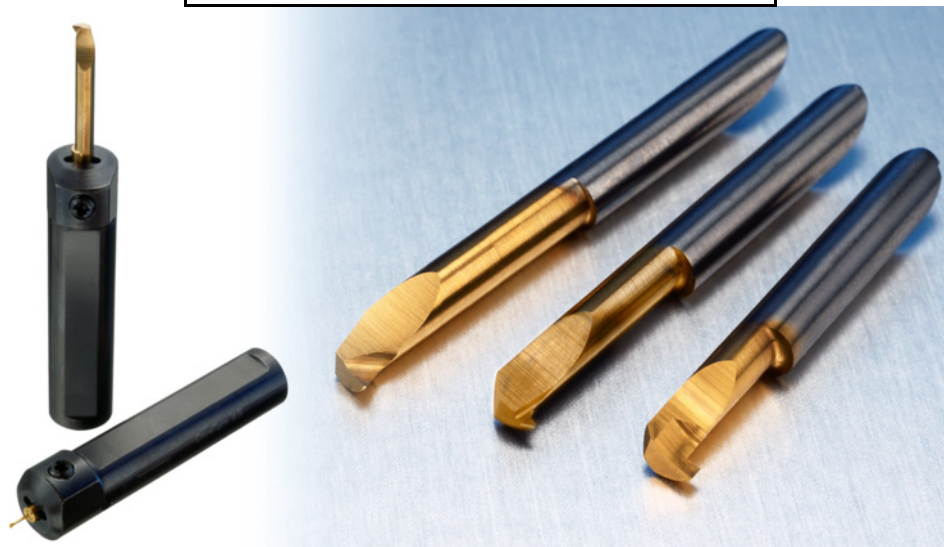
Coolant connectors

	For bar diameter	Ordering code	Dimensions, mm, inch		
	dm_m		D_{21}	D_{22}	l_2
	mm	Metric			
	6	CS-060-054	5.4	6.0	25.0
	8	CS-080-066	6.6	8.0	28.5
	10	CS-100-086	8.6	10.0	28.5
	12	CS-120-086	8.6	12.0	38.0
	16	CS-160-137	13.7	16.0	40.0
	20	CS-200-137	13.7	20.0	40.0
	25	CS-250-137	13.7	25.0	44.0
	Inch	Inch			
	.250	CS-063-054	.213	.250	.984
	.312	CS-079-066	.260	.312	1.122
	.375	CS-095-086	.339	.375	1.122
	.500	CS-127-086	.339	.500	1.496
	.625	CS-159-137	.539	.625	1.575
	.750	CS-190-137	.539	.750	1.575
	1.000	CS-254-137	.539	1.000	1.732

CoroTurn® XS

For internal small part machining

For internal turning, grooving and threading of small bores, down to 0.3 mm (.012 inch)



CoroTurn® XS tooling

The system consists of inserts in the well proven grades GC1025 and H10F.

- Turning
- Turning copying
- Grooving
- Face grooving
- Profiling full radius
- Pre-parting
- Threading

Boring bars in different outer diameters adapted to different machine types. The assortment also consists of shank holders for internal machining, sliding head machines and Coromant Capto® cutting units for turning and rotating applications.

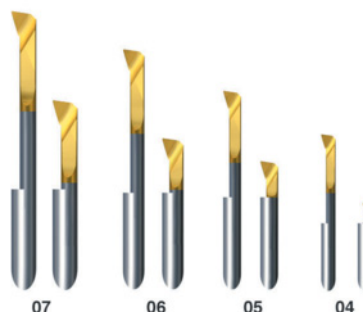


CoroTurn® XS grooving

All grooving inserts produce grooves with flat bottom and sharp corner radii

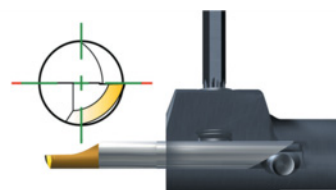
CoroTurn® XS assortment

The program consists of four different insert sizes



CoroTurn® XS precision

The insert locates precisely into the boring bar thanks to a locating pin which locks the insert into the correct orientation



CoroTurn® XS coolant supply

The boring bars are designed with internal cutting fluid supply



Code key for CoroTurn® XS

Insert for turning

CXS	04	T	098	A	10	-	22	06	R
1	2	3	4	13	5		9	10	12

Insert for grooving

CXS	06	F	100	-	62	15	A	R
1	2	3	6		9	10	11	12

Insert for threading

CXS	04	TH	050	VM	-	42	15	R
1	2	3	7	8		9	10	12

1 Main code

CXS = CoroTurn® XS

2 Insert size mm



04 = 4 mm (.157 inch)
 05 = 5 mm (.197 inch)
 06 = 6 mm (.236 inch)
 07 = 7 mm (.276 inch)

3 Type of operation

T = Turning
 TE = Turning copying, extended f_1 -dimension
 F = Face grooving
 G = Grooving
 GX = Pre-parting
 R = Profiling full radius
 TH = Threading
 B = Back boring

4 Entering angle
(Turning)

E.g.: 098 = Entering angle 98°
 98° Lead angle -8°

5 Nose radius, r_ϵ mm
(Turning)

E.g.:
 10 = 0.1 mm (.004 inch)
 15 = 0.15 mm (.006 inch)
 20 = 0.2 mm (.008 inch)

6 Insert width, l_a mm
(Grooving)

E.g.: 100 = 1.00 mm

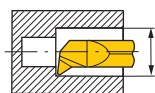
7 Pitch, mm
(Threading)

mm: pitch x 100

inch: No. of threads per inch x 10

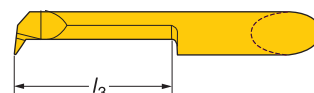
8 Thread profile
(Threading)

VM = V-Profile 60°
 WH = Whitworth 55°
 NT = NPT 60°
 UN = UN 60°
 MM = MM 60°
 TR = Trapezoidal 30°

9 Min bore diameter, D_m min.

E.g.: 22 = 2.2 mm (.087 inch)

min. hole

10 Penetration depth, l_3 

E.g.: 06 = 6 mm (.236 inch)

11 Type of curve
(Face grooving)

A = A-curved

13 Geometry

- = Without chip forming geometry
 A = Chip forming geometry

12 Hand of insert

R = Right hand style
 L = Left hand style

Code key for CoroTurn® XS

Boring bars

CXS	A	10	-	04
1	2	3		4

Double ended boring bars

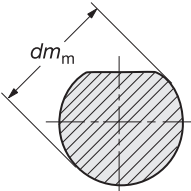

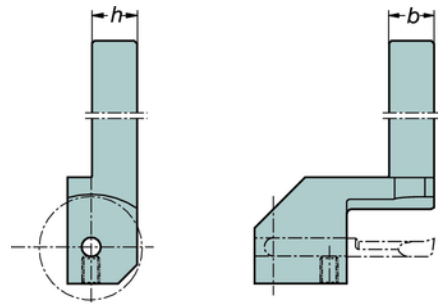
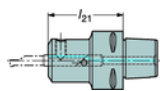
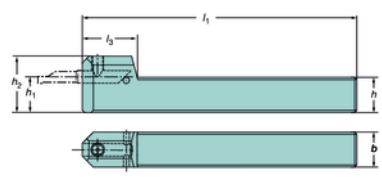
CXS	A	10	-	04	-	04
1	2	3		4		5

Shank tool

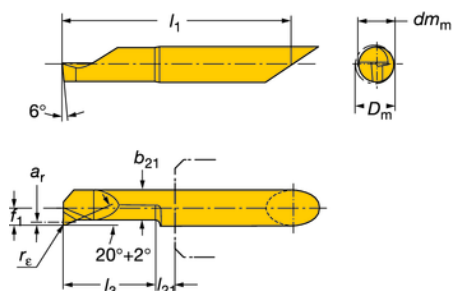
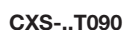
CXS	-	1010	-	04	F	N
1		6		4	10	7

Coromant Capto® holder

C4	-	CXS	-	47	-	04
8		1		9		4

1 Main code CXS = CoroTurn® XS	2 Type of bar A = Steel bar with internal coolant supply	3 Bar diameter, dm_m  Metric 10 = 10 mm Inch 0500 = 1/2"
4 Insert size  04 = 4 mm (.157 inch) 05 = 5 mm (.197 inch) 06 = 6 mm (.236 inch) 07 = 7 mm (.276 inch)	5 Insert size for sub-spindle For double ended boring bars, same as 4.	6 Shank size (width and height), mm  h = 10 mm (.394 inch) b = 10 mm (.394 inch)
7 Hand of tool L = Left hand style R = Right hand style N = Neutral	9 Coromant Capto® length $l_{21} = 47 \text{ mm (1.850 inch)}$ 	10 Shank style $F = 0^\circ$ 
8 Coromant Capto® size C3: D5m = 32 mm (1.260 inch) C4: D5m = 40 mm (1.575 inch) C5: D5m = 50 mm (1.968 inch) C6: D5m = 63 mm (2.480 inch)		

Turning



90°

Lead angle:

0°


Tolerances, mm (inch):

$$r_{\varepsilon} = \pm 0.02 \ (\pm .0008)$$
$$I_1 = \pm 0.02 (\pm 0.0008)$$

Centre height:

+0.05/-0 (+.002/-0)

Right hand style shown

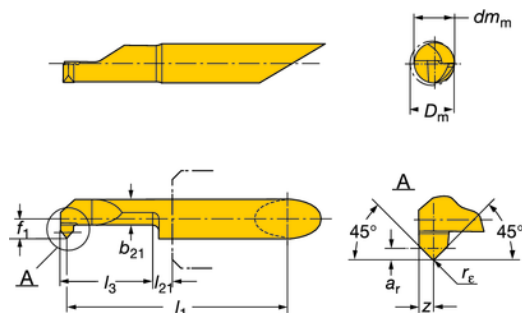
	Insert size ¹⁾		Selection criteria, millimeter, inch (mm, in.)						Dimensions, millimeter, inch (mm, in.)										P	M	N	S
			a_r max		D_m min	D_m min	l_3		r_e		b_{21}		f_1		l_1		l_{21}		GC	GC	GC	GC
			mm	in.			mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	1025	1025	1025	1025
	04	CXS-04T090-15-3212R	0.2	.008	3.2	.126	12	.472	0.15	.006	2.55	.100	1.45	.057	29.26	1.152	3	.118	★	★	★	★
		CXS-04T090-15-4215R/L	0.3	.012	4.2	.165	15	.591	0.15	.006	3.45	.136	1.95	.077	39.26	1.546	3	.118	★	★	★	★
	05	CXS-05T090-20-5210R/L	0.5	.020	5.2	.205	10	.394	0.2	.008	4.2	.165	2.45	.096	32.25	1.270	3	.118	★	★	★	★
		CXS-05T090-20-5215R/L	0.5	.020	5.2	.205	15	.591	0.2	.008	4.2	.165	2.45	.096	37.25	1.466	3	.118	★	★	★	★
		CXS-05T090-20-5220R/L	0.5	.020	5.2	.205	20	.787	0.2	.008	4.2	.165	2.45	.096	42.25	1.663	3	.118	★	★	★	★
																		P25	M15	N25	S15	

1) To correspond with insert size on holder.

R = Right hand, L = Left hand

★= First choice

Turning/profiling



Entering angle:

45°

Lead angle:

 45°


Tolerances, mm (inch):

 $r_{\varepsilon} = \pm 0.02 (\pm 0.0008)$
$$I_1 = \pm 0.02 (\pm 0.0008)$$

Centre height:

+0.05/-0 (+.002/-0)

Right hand style shown

	Insert size ¹⁾		Selection criteria, millimeter, inch (mm, in.)						Dimensions, millimeter, inch (mm, in.)										P	M	N	S			
			a_r max		D_m min		l_3		r_f		b_{21}		f_1		l_1		l_{21}		GC	GC	GC	GC			
			mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	1025	1025	1025	1025			
	dm_m	Ordering code																							
	05	CXS-05T045-20-5215R	0.7	.028	5.2	.205	15	.591	0.2	.008	3.75	.148	2.4	.096	37.25	1.466	3	.118	★	★	☆	★	☆	★	☆
		CXS-05T045-20-5220R/L	0.7	.028	5.2	.205	20	.787	0.2	.008	3.75	.148	2.4	.096	42.25	1.663	3	.118	★	★	★	★			
	06	CXS-06T045-20-6220R	0.7	.028	6.2	.244	20	.787	0.2	.008	3.95	.156	2.9	.116	42.25	1.663	3	.118	★	★	★	★			
		CXS-06T045-20-6225R/L	0.7	.028	6.2	.244	25	.984	0.2	.008	3.95	.156	2.9	.116	47.25	1.860	3	.118	★	★	★	★			
	07	CXS-07T045-20-7220R/L	0.7	.028	7.2	.284	20	.787	0.2	.008	4.25	.167	3.4	.136	42.25	1.663	3	.118	★	★	★	★			
		CXS-07T045-20-7240R/L	0.7	.028	7.2	.284	40	1.575	0.2	.008	4.25	.167	3.4	.136	62.25	2.451	3	.118	★	★	★	★			
																		P25	M15	M20	N25	N20	S15	S15	

1) To correspond with insert size on holder.

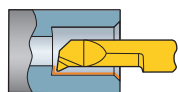
R = Right hand, L = Left hand

★= First choice



CoroTurn® XS inserts

Turning



Entering angle:

98°

Lead angle:

-8°

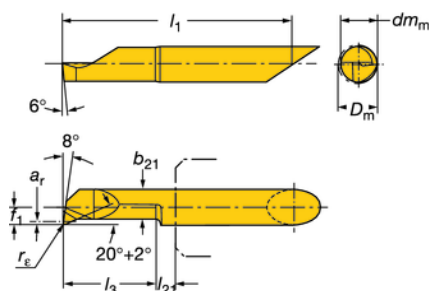
Tolerances, mm (inch):

 $r_6 = \pm 0.02 (\pm .0008)$ $l_1 = \pm 0.02 (\pm .0008)$


Centre height:

 $+0.05/-0 (+.002/-0)$

CXS-..T098



Right hand style shown

	Insert size ¹⁾	dm _m	Ordering code	Selection criteria, millimeter, inch (mm, in.)						Dimensions, millimeter, inch (mm, in.)										P	M	N	S		
				a _r max		a _r max		D _m min		l ₃		r _ε		b ₂₁		f ₁		l ₁		l ₂₁		GC	GC	GC	GC
				mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	1025	1025	1025	1025
	04	CXS-04T098-00-0301R	0.06	.002	0.3	.012	1.2	.047	0	.000	0.19	.008	0.1	.004	27.25	1.073	11.8	.465	★	★	★	★			
		CXS-04T098-00-0401R	0.07	.003	0.4	.016	1.6	.063	0	.000	0.28	.011	0.15	.006	27.25	1.073	11.4	.449	★	★	★	★			
		CXS-04T098-00-0502R	0.08	.003	0.5	.020	2	.079	0	.000	0.37	.015	0.2	.008	27.25	1.073	11	.433	★	★	★	★			
		CXS-04T098-00-0602R	0.09	.004	0.6	.024	2.5	.098	0	.000	0.46	.018	0.25	.010	27.25	1.073	10.5	.413	★	★	★	★			
		CXS-04T098-00-0703R	0.1	.004	0.7	.028	3.5	.138	0	.000	0.55	.022	0.3	.012	27.25	1.073	9.5	.374	★	★	★	★			
		CXS-04T098-00-0804R	0.1	.004	0.8	.032	4	.157	0	.000	0.64	.025	0.35	.014	27.25	1.073	9	.354	★	★	★	★			
		CXS-04T098-00-0905R	0.1	.004	0.9	.035	5	.197	0	.000	0.73	.029	0.4	.016	27.25	1.073	8	.315	★	★	★	★			
		CXS-04T098-05-1004R	0.1	.004	1	.039	4	.157	0.0	.002	0.65	.026	0.45	.018	26.25	1.034	8	.315	★	★	★	★			
		CXS-04T098-05-1006R	0.1	.004	1	.039	6	.236	0.0	.002	0.65	.026	0.45	.018	26.25	1.034	6	.236	★	★	★	★			
		CXS-04T098-05-1706R	0.2	.008	1.7	.067	6	.236	0.0	.002	1.05	.041	0.7	.028	26.25	1.034	6	.236	★	★	★	★			
		CXS-04T098-05-1709R	0.2	.008	1.7	.067	9	.354	0.0	.002	1.05	.041	0.7	.028	26.25	1.034	3	.118	★	★	★	★			
		CXS-04T098-05-2206R	0.2	.008	2.2	.087	6	.236	0.0	.002	1.55	.061	0.95	.037	26.25	1.034	6	.236	★	★	★	★			
		CXS-04T098-05-2209R	0.2	.008	2.2	.087	9	.354	0.0	.002	1.55	.061	0.95	.037	26.25	1.034	3	.118	★	★	★	★			
		CXS-04T098-05-2710R	0.2	.008	2.7	.106	10	.394	0.0	.002	2.05	.081	1.2	.047	27.25	1.073	3	.118	★	★	★	★			
		CXS-04T098-05-2715R	0.2	.008	2.7	.106	15	.591	0.0	.002	2.05	.081	1.2	.047	32.25	1.270	3	.118	★	★	★	★			
		CXS-04T098-05-3215R	0.2	.008	3.2	.126	15	.591	0.0	.002	2.55	.100	1.45	.057	32.25	1.270	3	.118	★	★	★	★			
		CXS-04T098-05-3220R	0.2	.008	3.2	.126	20	.787	0.0	.002	2.55	.100	1.45	.057	37.25	1.466	3	.118	★	★	★	★			
		CXS-04T098-05-4215R	0.3	.012	4.2	.165	15	.591	0.0	.002	3.45	.136	1.95	.077	32.25	1.270	3	.118	★	★	★	★			
		CXS-04T098-05-4220R	0.3	.012	4.2	.165	20	.787	0.0	.002	3.45	.136	1.95	.077	37.25	1.466	3	.118	★	★	★	★			
		CXS-04T098-05-4225R	0.3	.012	4.2	.165	25	.984	0.0	.002	3.45	.136	1.95	.077	42.25	1.663	3	.118	★	★	★	★			
		CXS-04T098-10-1004L	0.1	.004	1	.039	4	.157	0.1	.004	0.65	.026	0.45	.018	27.25	1.073	8	.315	★	★	★	★			
		CXS-04T098-10-1004R	0.1	.004	1	.039	4	.157	0.1	.004	0.65	.026	0.45	.018	27.25	1.073	8	.315	★	★	★	★			
		CXS-04T098-10-1006R	0.1	.004	1	.039	6	.236	0.1	.004	0.65	.026	0.45	.018	27.25	1.073	6	.236	★	★	★	★			
		CXS-04T098-10-1706L	0.2	.008	1.7	.067	6	.236	0.1	.004	1.05	.041	0.7	.028	27.25	1.073	6	.236	★	★	★	★			
		CXS-04T098-10-1706R	0.2	.008	1.7	.067	6	.236	0.1	.004	1.05	.041	0.7	.028	27.25	1.073	6	.236	★	★	★	★			
		CXS-04T098-10-1709R/L	0.2	.008	1.7	.067	9	.354	0.1	.004	1.05	.041	0.7	.028	27.25	1.073	3	.118	★	★	★	★			
		CXS-04T098-10-2206R/L	0.2	.008	2.2	.087	6	.236	0.1	.004	1.55	.061	0.95	.037	27.25	1.073	6	.236	★	★	★	★			
		CXS-04T098-10-2209L	0.2	.008	2.2	.087	9	.354	0.1	.004	1.55	.061	0.95	.037	27.25	1.073	3	.118	★	★	★	★			
		CXS-04T098-10-2209R	0.2	.008	2.2	.087	9	.354	0.1	.004	1.55	.061	0.95	.037	27.25	1.073	3	.118	★	★	★	★			
		CXS-04T098-10-2213R/L	0.2	.008	2.2	.087	13	.512	0.1	.004	1.55	.061	0.95	.037	32.25	1.270	5	.197	★	★	★	★			
		CXS-04T098-15-2710L	0.2	.008	2.7	.106	10	.394	0.1	.006	2.05	.081	1.2	.047	27.26	1.073	3	.118	★	★	★	★			
		CXS-04T098-15-2710R	0.2	.008	2.7	.106	10	.394	0.1	.006	2.05	.081	1.2	.047	27.26	1.073	3	.118	★	★	★	★			
	CXS-04T098-15-2715R/L	0.2	.008	2.7	.106	15	.591	0.1	.006	2.05	.081	1.2	.047	32.26	1.270	3	.118	★	★	★	★				
	CXS-04T098-15-3210L	0.2	.008	3.2	.126	10	.394	0.1	.006	2.55	.100	1.45	.057	27.26	1.073	3	.118	★	★	★	★				
	CXS-04T098-15-3210R	0.2	.008	3.2	.126	10	.394	0.1	.006	2.55	.100	1.45	.057	27.26	1.073	3	.118	★	★	★	★				
	CXS-04T098-15-3215R/L	0.2	.008	3.2	.126	15	.591	0.1	.006	2.55	.100	1.45	.057	32.26	1.270	3	.118	★	★	★	★				
	CXS-04T098-15-3220R/L	0.2	.008	3.2	.126	20	.787	0.1	.006	2.55	.100	1.45	.057	37.26	1.467	3	.118	★	★	★	★				
	CXS-04T098-15-4210R/L	0.3	.012	4.2	.165	10	.394	0.1	.006	3.45	.136	1.95	.077	27.26	1.073	3	.118	★	★	★	★				
	CXS-04T098-15-4215L	0.3	.012	4.2	.165	15	.591	0.1	.006	3.45	.136	1.95	.077	32.26	1.270	3	.118	★	★	★	★				
	CXS-04T098-15-4215R	0.3	.012	4.2	.165	15	.591	0.1	.006	3.45	.136	1.95	.077	32.26	1.270	3	.118	★	★	★	★				
	CXS-04T098-15-4220R/L	0.3	.012	4.2	.165	20	.787	0.1	.006	3.45	.136	1.95	.077	37.26	1.467	3	.118	★	★	★	★				
	CXS-04T098-15-4225R/L	0.3	.012	4.2	.165	25	.984	0.1	.006	3.45	.136	1.95	.077	43.26	1.703	3	.118	★	★	★	★				
																		P25	M15	M20	N25	N20	S15	S15	

¹⁾ To correspond with insert size on holder.

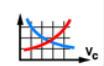
R = Right hand, L = Left hand

★ = First choice

Continued...



A346



A499



A525

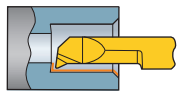


A3

CoroTurn® XS inserts

Turning

CXS-..T098



Entering angle:

98°

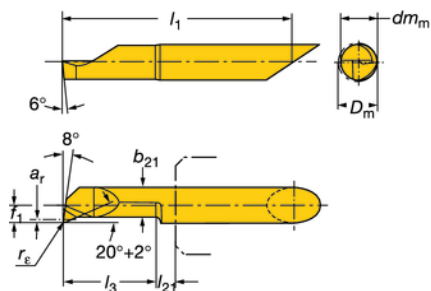
Lead angle:

-8°

Tolerances, mm (inch):


 $r_e = \pm 0.02 (\pm 0.0008)$ $l_1 = \pm 0.02 (\pm 0.0008)$

Centre height:

 $+0.05/-0 (+.002/-0)$ 

Right hand style shown

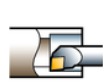
... Continued

	Insert size ¹⁾	Selection criteria, millimeter, inch (mm, in.)	Dimensions, millimeter, inch (mm, in.)																P	M	N	S		
			a_r max		D_m min	D_m min	l_3		r_ϵ		b_{21}		f_1		l_1		l_{21}		GC	GC	-	GC	GC	-
			mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	1025	1025	H10F	1025	H10F	1025
	dm_m	Ordering code																						
	05	CXS-05T098-05-5220R	0.5	.020	5.2	.205	20	.787	0.0	.002	4.25	.167	2.45	.096	42.25	1.663	3	.118	★	★	★	★	★	★
		CXS-05T098-05-5230R	0.5	.020	5.2	.205	30	1.181	0.0	.002	4.25	.167	2.45	.096	57.25	2.254	3	.118	★	★	★	★	★	★
		CXS-05T098-20-5210R/L	0.5	.020	5.2	.205	10	.394	0.2	.008	4.25	.167	2.45	.096	32.25	1.270	3	.118	★	★	★	★	★	★
		CXS-05T098-20-5220R/L	0.5	.020	5.2	.205	20	.787	0.2	.008	4.25	.167	2.45	.096	42.25	1.663	3	.118	★	★	★	★	★	★
		CXS-05T098-20-5225R/L	0.5	.020	5.2	.205	25	.984	0.2	.008	4.25	.167	2.45	.096	47.25	1.860	3	.118	★	★	★	★	★	★
		CXS-05T098-20-5230R/L	0.5	.020	5.2	.205	30	1.181	0.2	.008	4.25	.167	2.45	.096	57.25	2.254	3	.118	★	★	★	★	★	★
	06	CXS-06T098-20-6215R/L	0.5	.020	6.2	.244	15	.591	0.2	.008	5.25	.207	2.95	.116	37.25	1.466	3	.118	★	★	★	★	★	★
		CXS-06T098-20-6220L	0.5	.020	6.2	.244	20	.787	0.2	.008	5.25	.207	2.95	.116	42.25	1.663	3	.118	★	★	★	★	★	★
		CXS-06T098-20-6220R	0.5	.020	6.2	.244	20	.787	0.2	.008	5.25	.207	2.95	.116	42.25	1.663	3	.118	★	★	★	★	★	★
		CXS-06T098-20-6225R/L	0.5	.020	6.2	.244	25	.984	0.2	.008	5.25	.207	2.95	.116	47.25	1.860	3	.118	★	★	★	★	★	★
		CXS-06T098-20-6230R/L	0.5	.020	6.2	.244	30	1.181	0.2	.008	5.25	.207	2.95	.116	52.25	2.057	3	.118	★	★	★	★	★	★
		CXS-06T098-20-6235R/L	0.5	.020	6.2	.244	35	1.378	0.2	.008	5.25	.207	2.95	.116	57.25	2.254	3	.118	★	★	★	★	★	★
	07	CXS-06T098-20-6240R	0.5	.020	6.2	.244	40	1.575	0.2	.008	5.25	.207	2.95	.116	62.25	2.451	3	.118	★	★	★	★	★	★
		CXS-07T098-20-7225L	0.5	.020	7.2	.284	25	.984	0.2	.008	6.25	.246	3.45	.136	47.25	1.860	3	.118	★	★	★	★	★	★
		CXS-07T098-20-7225R	0.5	.020	7.2	.284	25	.984	0.2	.008	6.25	.246	3.45	.136	47.25	1.860	3	.118	★	★	★	★	★	★
		CXS-07T098-20-7230R	0.5	.020	7.2	.284	30	1.181	0.2	.008	6.25	.246	3.45	.136	52.25	2.057	3	.118	★	★	★	★	★	★
		CXS-07T098-20-7240L	0.5	.020	7.2	.284	40	1.575	0.2	.008	6.25	.246	3.45	.136	62.25	2.451	3	.118	★	★	★	★	★	★
		CXS-07T098-20-7240R	0.5	.020	7.2	.284	40	1.575	0.2	.008	6.25	.246	3.45	.136	62.25	2.451	3	.118	★	★	★	★	★	★
		CXS-07T098-20-7245R/L	0.5	.020	7.2	.284	45	1.772	0.2	.008	6.25	.246	3.45	.136	67.25	2.648	3	.118	★	★	★	★	★	★
		CXS-07T098-20-7250R	0.5	.020	7.2	.284	50	1.968	0.2	.008	6.25	.246	3.45	.136	72.25	2.844	3	.118	★	★	★	★	★	★
																		P25	M15	M20	N25	N20	S15	S15

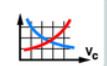
¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand

★ = First choice



A346



A499



A525

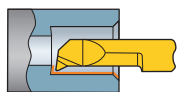


A3

CoroTurn® XS inserts

Turning

With chip forming geometry



Entering angle:

98°

Lead angle:

-8°

Tolerances, mm (inch):

$l_a = +0.05 (+.002/-0)$

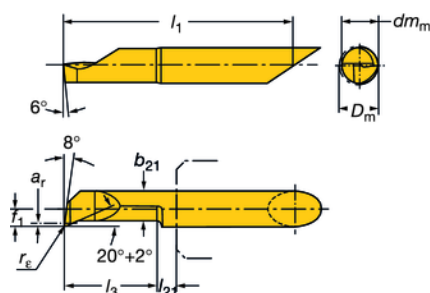
$r_e = \pm 0.02 (\pm .0008)$

$l_1 = \pm 0.02 (\pm .0008)$


Centre height:

$+0.05/-0 (+.002/-0)$

CXS-..T098



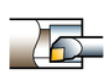
Right hand style shown

	Insert size ¹⁾		Selection criteria, millimeter, inch (mm, in.)								Dimensions, millimeter, inch (mm, in.)																P	M	N	S								
			a_r max		a_r max		D_m min		D_m min		l_3 mm		l_3 in.		r_e mm		r_e in.		b_{21} mm		b_{21} in.		f_1 mm		f_1 in.						l_1 mm		l_1 in.		l_{21} mm		l_{21} in.	
			mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.					mm	in.	mm	in.	mm	in.		
	04	CXS-04T098A20-4215R	0.3	.012	4.2	.165	15	.591	0.2	.008	3.45	.136	1.95	.077	32.25	1.270	3	.118	★	★	★	★																
	05	CXS-05T098A20-5225R	0.5	.020	5.2	.205	25	.984	0.2	.008	4.25	.167	2.45	.096	47.25	1.860	3	.118	★	★	★	★																
	06	CXS-06T098A20-6230R	0.5	.020	6.2	.244	30	1.181	0.2	.008	5.25	.207	2.95	.116	52.25	2.057	3	.118	★	★	★	★																
	07	CXS-07T098A20-7240R	0.5	.020	7.2	.284	40	1.575	0.2	.008	6.25	.246	3.45	.136	62.25	2.451	3	.118	★	★	★	★																
																			P25	M15	N25	S15																

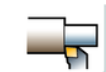
¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand

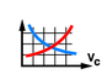
★ = First choice



A345



A344



A499



A423



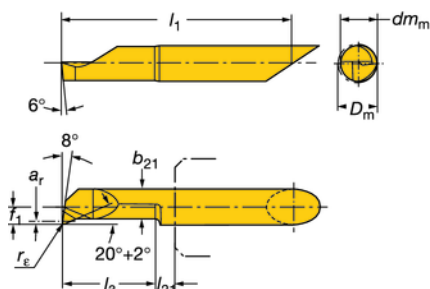
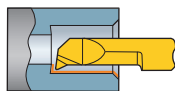
J2

CoroTurn® XS inserts

Turning

For hardened materials

CXS-..T098



Entering angle:

98°

Lead angle:

-8°

Tolerances, mm (inch):

 $r_E = \pm 0.02 (\pm .0008)$ $l_1 = \pm 0.02 (\pm .0008)$

Centre height:

 $+0.05/-0 (+.002/-0)$

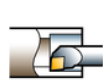
Right hand style shown

Insert size ¹⁾	dm_m	Ordering code	Selection criteria, millimeter, inch (mm, in.)						Dimensions, millimeter, inch (mm, in.)										H
			a_r max mm	a_r max in.	D_m min mm	D_m min in.	l_3 mm	l_3 in.	r_E mm	r_E in.	b_{21} mm	b_{21} in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	l_{21} mm	l_{21} in.	
	04	CXS-04T098-10-1706R	0.2	.008	1.7	.067	6	.236	0.1	.004	1.05	.041	0.7	.028	27.25	1.073	6	.236	★
		CXS-04T098-10-2209R	0.2	.008	2.2	.087	9	.354	0.1	.004	1.55	.061	0.95	.037	27.25	1.073	4	.157	★
		CXS-04T098-15-2710R	0.2	.008	2.7	.106	10	.394	0.15	.006	2.05	.081	1.2	.047	27.26	1.073	3	.118	★
		CXS-04T098-15-3215R	0.2	.008	3.2	.126	15	.591	0.15	.006	2.55	.100	1.45	.057	32.26	1.270	3	.118	★
		CXS-04T098-15-3715R	0.2	.008	3.7	.146	15	.591	0.15	.006	3.05	.120	1.7	.067	32.25	1.270	3	.118	★
		CXS-04T098-15-4210R	0.3	.012	4.2	.165	10	.394	0.15	.006	3.45	.136	1.95	.077	27.26	1.073	3	.118	★
		CXS-04T098-15-4215R	0.3	.012	4.2	.165	15	.591	0.15	.006	3.45	.136	1.95	.077	32.26	1.270	3	.118	★
		CXS-04T098-15-4220R	0.3	.012	4.2	.165	20	.787	0.15	.006	3.45	.136	1.95	.077	37.26	1.467	3	.118	★
		CXS-04T098-15-4225R	0.3	.012	4.2	.165	25	.984	0.15	.006	3.45	.136	1.95	.077	43.26	1.703	3	.118	★
		CXS-04T098-15-4225R	0.3	.012	4.2	.165	25	.984	0.15	.006	3.45	.136	1.95	.077	43.26	1.703	3	.118	★
	05	CXS-05T098-20-5210R	0.5	.020	5.2	.205	10	.394	0.2	.008	4.25	.167	2.45	.096	32.25	1.270	3	.118	★
		CXS-05T098-20-5220R	0.5	.020	5.2	.205	20	.787	0.2	.008	4.25	.167	2.45	.096	42.25	1.663	3	.118	★
		CXS-05T098-20-5225R	0.5	.020	5.2	.205	25	.984	0.2	.008	4.25	.167	2.45	.096	47.25	1.860	3	.118	★
		CXS-05T098-20-5230R	0.5	.020	5.2	.205	30	1.181	0.2	.008	4.25	.167	2.45	.096	57.25	2.254	3	.118	★
		CXS-05T098-20-5230R	0.5	.020	5.2	.205	30	1.181	0.2	.008	4.25	.167	2.45	.096	57.25	2.254	3	.118	★
	06	CXS-06T098-20-6215R	0.5	.020	6.2	.244	15	.591	0.2	.008	5.25	.207	2.95	.116	37.25	1.466	3	.118	★
		CXS-06T098-20-6220R	0.5	.020	6.2	.244	20	.787	0.2	.008	5.25	.207	2.95	.116	42.25	1.663	3	.118	★
		CXS-06T098-20-6225R	0.5	.020	6.2	.244	25	.984	0.2	.008	5.25	.207	2.95	.116	47.25	1.860	3	.118	★
		CXS-06T098-20-6230R	0.5	.020	6.2	.244	30	1.181	0.2	.008	5.25	.207	2.95	.116	52.25	2.057	3	.118	★
		CXS-06T098-20-6240R	0.5	.020	6.2	.244	40	1.575	0.2	.008	5.25	.207	2.95	.116	62.25	2.451	3	.118	★
	07	CXS-07T098-20-7225R	0.5	.020	7.2	.284	25	.984	0.2	.008	6.25	.246	3.45	.136	47.25	1.860	3	.118	★
		CXS-07T098-20-7230R	0.5	.020	7.2	.284	30	1.181	0.2	.008	6.25	.246	3.45	.136	57.25	2.254	3	.118	★
		CXS-07T098-20-7240R	0.5	.020	7.2	.284	40	1.575	0.2	.008	6.25	.246	3.45	.136	62.25	2.451	3	.118	★
		CXS-07T098-20-7250R	0.5	.020	7.2	.284	50	1.968	0.2	.008	6.25	.246	3.45	.136	72.25	2.844	3	.118	★
																			HS

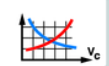
¹⁾ To correspond with insert size on holder.

R = Right hand

★ = First choice



A346



A499



A525



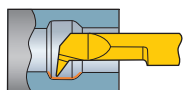
A3

CoroTurn® XS inserts

Copying

Insert with extended f_1 dimension

CXS-...TE98 Copying



Entering angle:

98°

Lead angle:

-8°

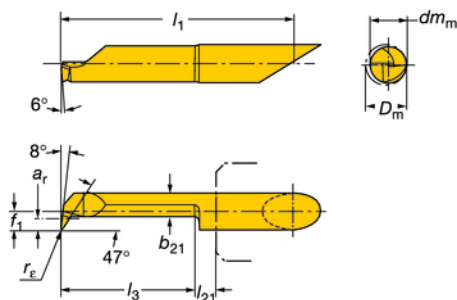
Tolerances, mm (inch):

$r_e = \pm 0.02$ (± 0.0008)


$l_1 = \pm 0.02$ (± 0.0008)

Centre height:

+0.05/-0 (+.002/-0)



Right hand style shown

	Insert size ¹⁾		Selection criteria, millimeter, inch (mm, in.)	Dimensions, millimeter, inch (mm, in.)																P	M	N	S
				a_r max		D_m min		l_3		r_e		b_{21}		f_1		l_1		l_{21}		GC	GC	GC	GC
				mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	1025	1025	1025	1025
	dm_m	Ordering code																					
	04	CXS-04TE98-15-4220L	0.8	.032	4.2	.165	20	.787	0.15	.006	2.95	.116	1.95	.077	37.26	1.467	3	.118	★	★	★	★	
		CXS-04TE98-15-4220R	0.8	.032	4.2	.165	20	.787	0.15	.006	2.95	.116	1.95	.077	37.26	1.467	3	.118	★	★	★	★	
	05	CXS-05TE98-15-5225L	1	.039	5.2	.205	25	.984	0.15	.006	3.75	.148	2.45	.096	47.25	1.860	3	.118	★	★	★	★	
		CXS-05TE98-15-5225R	1	.039	5.2	.205	25	.984	0.15	.006	3.75	.148	2.45	.096	47.25	1.860	3	.118	★	★	★	★	
	06	CXS-06TE98-15-6230L	1.8	.071	6.2	.244	30	1.181	0.15	.006	3.95	.156	2.95	.116	52.25	2.057	3	.118	★	★	★	★	
		CXS-06TE98-15-6230R	1.8	.071	6.2	.244	30	1.181	0.15	.006	3.95	.156	2.95	.116	52.25	2.057	3	.118	★	★	★	★	
																			P25	M15	M20	N25	
																				N20	S15	S15	

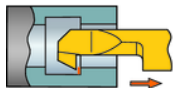
¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand

★ = First choice

Back boring

B090



Entering angle:

90°

Lead angle:

0°

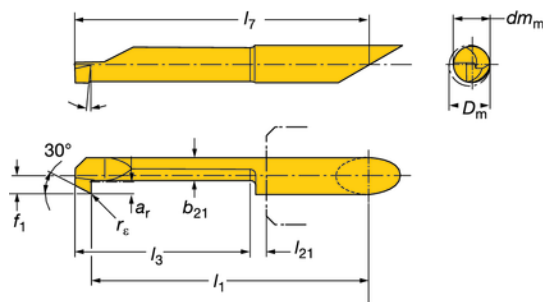
Tolerances, mm (inch):

$r_e = \pm 0.02$ (± 0.0008)


$l_1 = \pm 0.02$ (± 0.0008)

Centre height:

+0.05 (+.002/-0)



Right hand style shown

	Insert size ¹⁾		Selection criteria, millimeter, inch (mm, in.)								Dimensions, millimeter, inch (mm, in.)																P	M	N	S
			a_r max		D_m min		l_3		r_e		b_{21}		f_1		l_1		l_{21}		GC	GC	GC	GC								
			mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	1025	1025	1025	1025								
	dm_m	Ordering code																												
	04	CXS-04B090-15-4225R	0.8	.032	4.2	.165	25	.984	0.15	.006	2.6	.102	1.95	.077	40.66	1.601	3	.118	★	★	★	★								
	05	CXS-05B090-15-5230R	1	.039	5.2	.205	30.3	1.193	0.15	.006	3.8	.150	2.45	.096	52.25	2.057	3	.118	★	★	★	★								
	06	CXS-06B090-15-6230R	1.8	.071	6.2	.244	30.3	1.193	0.15	.006	4	.157	2.95	.116	52.25	2.057	3	.118	★	★	★	★								
	07	CXS-07B090-15-7230R	2.5	.098	7.2	.284	30.3	1.193	0.15	.006	4.3	.169	3.45	.136	52.25	2.057	3	.118	★	★	★	★								
																			P25	M15	N25	S15								

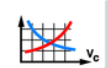
¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand

★ = First choice



A346



A499



A525

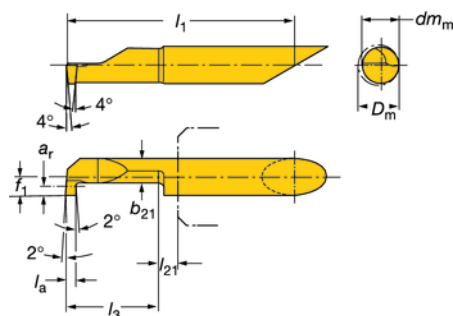
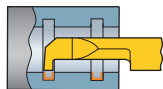


A3

CoroTurn® XS inserts

Grooving

CXS-..G




Tolerances, mm (inch):

 $l_a = +0.05 (+.002/-0)$ $l_1 = \pm 0.02 (\pm .0008)$

Centre height:

 $+0.05 (+.002/-0)$

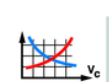
Right hand style shown

	Insert size	dm_m	Ordering code	Selection criteria, millimeter, inch (mm, in.)								Dimensions, millimeter, inch (mm, in.)								P	M	N	S																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
				a_r max		a_r max		D_m min		D_m min		l_a		l_a		l_3		l_3		b_{21}		b_{21}		f_1		f_1		l_1		l_1		l_{21}		l_{21}		GC	GC	GC	GC																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
				mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																															
04	CXS-04G078-4210R	0.8	.032	4.2	.165	0.78	.031	10	.394	2.95	.116	1.95	.077	27.4	1.079	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-04G078-4215R/L	0.8	.032	4.2	.165	0.78	.031	15	.591	2.95	.116	1.95	.077	32.5	1.280	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-04G078-4220R	0.8	.032	4.2	.165	0.78	.031	20	.787	2.95	.116	1.95	.077	37.6	1.480	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-04G100-4210R/L	0.8	.032	4.2	.165	1	.039	10	.394	2.95	.116	1.95	.077	27.3	1.075	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-04G100-4215R/L	0.8	.032	4.2	.165	1	.039	15	.591	2.95	.116	1.95	.077	32.3	1.272	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-04G100-4220R/L	0.8	.032	4.2	.165	1	.039	20	.787	2.95	.116	1.95	.077	37.3	1.468	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
05	CXS-05G078-5210R	1	.039	5.2	.205	0.78	.031	10	.394	3.75	.148	2.45	.096	32.4	1.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G078-5220R/L	1	.039	5.2	.205	0.78	.031	20	.787	3.75	.148	2.45	.096	42.5	1.673	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G078-5230R	1	.039	5.2	.205	0.78	.031	30	1.181	3.75	.148	2.45	.096	52.7	2.075	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G100-5210R	1	.039	5.2	.205	1	.039	10	.394	3.75	.148	2.45	.096	32.3	1.272	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G100-5220R/L	1	.039	5.2	.205	1	.039	20	.787	3.75	.148	2.45	.096	42.3	1.665	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G100-5230R	1	.039	5.2	.205	1	.039	30	1.181	3.75	.148	2.45	.096	52.3	2.059	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G117-5210R	1	.039	5.2	.205	1.17	.046	10	.394	3.75	.148	2.45	.096	32.4	1.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G117-5220R/L	1	.039	5.2	.205	1.17	.046	20	.787	3.75	.148	2.45	.096	42.5	1.673	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G117-5230R	1	.039	5.2	.205	1.17	.046	30	1.181	3.75	.148	2.45	.096	52.7	2.075	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G150-5210R	1	.039	5.2	.205	1.5	.059	10	.394	3.75	.148	2.45	.096	32.3	1.272	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G150-5215R/L	1	.039	5.2	.205	1.5	.059	15	.591	3.75	.148	2.45	.096	37.3	1.468	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G150-5220R/L	1	.039	5.2	.205	1.5	.059	20	.787	3.75	.148	2.45	.096	42.3	1.665	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G150-5230R	1	.039	5.2	.205	1.5	.059	30	1.181	3.75	.148	2.45	.096	52.3	2.059	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G157-5210R	1	.039	5.2	.205	1.57	.062	10	.394	3.75	.148	2.45	.096	32.4	1.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G157-5220R/L	1	.039	5.2	.205	1.57	.062	20	.787	3.75	.148	2.45	.096	42.5	1.673	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G157-5230R	1	.039	5.2	.205	1.57	.062	30	1.181	3.75	.148	2.45	.096	52.7	2.075	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G198-5210R	1	.039	5.2	.205	1.98	.078	10	.394	3.75	.148	2.45	.096	32.4	1.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G198-5220R/L	1	.039	5.2	.205	1.98	.078	20	.787	3.75	.148	2.45	.096	42.5	1.673	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G198-5230R	1	.039	5.2	.205	1.98	.078	30	1.181	3.75	.148	2.45	.096	52.7	2.075	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G200-5210R	1	.039	5.2	.205	2	.079	10	.394	3.75	.148	2.45	.096	32.3	1.272	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G200-5220R/L	1	.039	5.2	.205	2	.079	20	.787	3.75	.148	2.45	.096	42.3	1.665	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-05G200-5230R	1	.039	5.2	.205	2	.079	30	1.181	3.75	.148	2.45	.096	52.3	2.059	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
06	CXS-06G078-6210R	1.8	.071	6.2	.244	0.78	.031	10	.394	3.95	.156	2.95	.116	32.4	1.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G078-6215R/L	1.8	.071	6.2	.244	0.78	.031	15	.591	3.95	.156	2.95	.116	37.5	1.476	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G078-6225R	1.8	.071	6.2	.244	0.78	.031	25	.984	3.95	.156	2.95	.116	47.6	1.874	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G078-6235R/L	1.8	.071	6.2	.244	0.78	.031	35	1.378	3.95	.156	2.95	.116	57.8	2.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G100-6210R	1.8	.071	6.2	.244	1	.039	10	.394	3.95	.156	2.95	.116	32.3	1.272	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G100-6215L	1.8	.071	6.2	.244	1	.039	15	.591	3.95	.156	2.95	.116	37.3	1.468	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G100-6225R/L	1.8	.071	6.2	.244	1	.039	25	.984	3.95	.156	2.95	.116	47.3	1.862	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G100-6235R	1.8	.071	6.2	.244	1	.039	35	1.378	3.95	.156	2.95	.116	57.3	2.256	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G117-6210R	1.8	.071	6.2	.244	1.17	.046	10	.394	3.95	.156	2.95	.116	32.4	1.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G117-6215R/L	1.8	.071	6.2	.244	1.17	.046	15	.591	3.95	.156	2.95	.116	37.5	1.476	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G117-6225R	1.8	.071	6.2	.244	1.17	.046	25	.984	3.95	.156	2.95	.116	47.6	1.874	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G117-6235R/L	1.8	.071	6.2	.244	1.17	.046	35	1.378	3.95	.156	2.95	.116	57.8	2.276	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G150-6210R	1.8	.071	6.2	.244	1.5	.059	10	.394	3.95	.156	2.95	.116	32.3	1.272	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G150-6215L	1.8	.071	6.2	.244	1.5	.059	15	.591	3.95	.156	2.95	.116	37.3	1.468	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G150-6225R/L	1.8	.071	6.2	.244	1.5	.059	25	.984	3.95	.156	2.95	.116	47.3	1.862	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	CXS-06G150-6235R	1.8	.071	6.2	.244	1.5	.059	35	1.378	3.95	.156	2.95	.116	57.3	2.256	3	.118	☆	☆	☆	☆																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	

1) To correspond with insert size on holder.

R = Right hand, L = Left hand
Continued...

A346



A499



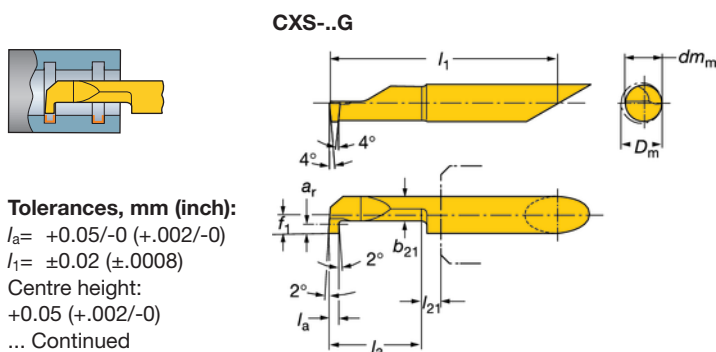
A525



A3

CoroTurn® XS inserts

Grooving



Right hand style shown

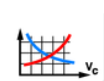
Insert size ¹⁾	dm _m	Ordering code	Selection criteria, millimeter, inch (mm, in.)						Dimensions, millimeter, inch (mm, in.)										P M N S H				
			a _r max mm	a _r max in.	D _m min mm	D _m min in.	l _a mm	l _a in.	l ₃ mm	l ₃ in.	b ₂₁ mm	b ₂₁ in.	f ₁ mm	f ₁ in.	l ₁ mm	l ₁ in.	l ₂₁ mm	l ₂₁ in.	1025 GC	1025 GC	1025 GC	1025 GC	7015 CB
06		CXS-06G157-6210R	1.8	.071	6.2	.244	1.57	.062	10	.394	3.95	.156	2.95	.116	32.4	1.276	3	.118	☆	☆	☆	☆	
		CXS-06G157-6215R/L	1.8	.071	6.2	.244	1.57	.062	15	.591	3.95	.156	2.95	.116	37.5	1.476	3	.118	☆	☆	☆	☆	
		CXS-06G157-6225R	1.8	.071	6.2	.244	1.57	.062	25	.984	3.95	.156	2.95	.116	47.6	1.874	3	.118	☆	☆	☆	☆	
		CXS-06G157-6235R/L	1.8	.071	6.2	.244	1.57	.062	35	1.378	3.95	.156	2.95	.116	57.8	2.276	3	.118	☆	☆	☆	☆	
		CXS-06G198-6210R	1.8	.071	6.2	.244	1.98	.078	10	.394	3.95	.156	2.95	.116	32.4	1.276	3	.118	☆	☆	☆	☆	
		CXS-06G198-6215R/L	1.8	.071	6.2	.244	1.98	.078	15	.591	3.95	.156	2.95	.116	37.5	1.476	3	.118	☆	☆	☆	☆	
		CXS-06G198-6225R	1.8	.071	6.2	.244	1.98	.078	25	.984	3.95	.156	2.95	.116	47.6	1.874	3	.118	☆	☆	☆	☆	
		CXS-06G198-6235R/L	1.8	.071	6.2	.244	1.98	.078	35	1.378	3.95	.156	2.95	.116	57.8	2.276	3	.118	☆	☆	☆	☆	
		CXS-06G200-6210R	1.8	.071	6.2	.244	2	.079	10	.394	3.95	.156	2.95	.116	32.3	1.272	3	.118	☆	☆	☆	☆	
		CXS-06G200-6215R/L	1.8	.071	6.2	.244	2	.079	15	.591	3.95	.156	2.95	.116	37.3	1.468	3	.118	☆	☆	☆	☆	
07		CXS-07G200-6225R/L	1.8	.071	6.2	.244	2	.079	25	.984	3.95	.156	2.95	.116	47.3	1.862	3	.118	☆	☆	☆	☆	
		CXS-07G078-7210R	2.5	.098	7.2	.284	0.78	.031	10	.394	4.25	.167	3.45	.136	32.4	1.276	3	.118	☆	☆	☆	☆	
		CXS-07G078-7215R/L	2.5	.098	7.2	.284	0.78	.031	15	.591	4.25	.167	3.45	.136	37.5	1.476	3	.118	☆	☆	☆	☆	
		CXS-07G078-7225R	2.5	.098	7.2	.284	0.78	.031	25	.984	4.25	.167	3.45	.136	47.6	1.874	3	.118	☆	☆	☆	☆	
		CXS-07G078-7235R/L	2.5	.098	7.2	.284	0.78	.031	35	1.378	4.25	.167	3.45	.136	57.8	2.276	3	.118	☆	☆	☆	☆	
		CXS-07G100-7210R/L	2.5	.098	7.2	.284	1	.039	10	.394	4.25	.167	3.45	.136	32.3	1.272	3	.118	☆	☆	☆	☆	
		CXS-07G100-7215R/L	2.5	.098	7.2	.284	1	.039	15	.591	4.25	.167	3.45	.136	37.3	1.468	3	.118	☆	☆	☆	☆	
		CXS-07G100-7225R/L	2.5	.098	7.2	.284	1	.039	25	.984	4.25	.167	3.45	.136	47.3	1.862	3	.118	☆	☆	☆	☆	
		CXS-07G100-7235R	2.5	.098	7.2	.284	1	.039	35	1.378	4.25	.167	3.45	.136	57.3	2.256	3	.118	☆	☆	☆	☆	
		CXS-07G117-7210R	2.5	.098	7.2	.284	1.17	.046	10	.394	4.25	.167	3.45	.136	32.4	1.276	3	.118	☆	☆	☆	☆	
		CXS-07G117-7215R/L	2.5	.098	7.2	.284	1.17	.046	15	.591	4.25	.167	3.45	.136	37.5	1.476	3	.118	☆	☆	☆	☆	
		CXS-07G117-7225R	2.5	.098	7.2	.284	1.17	.046	25	.984	4.25	.167	3.45	.136	47.6	1.874	3	.118	☆	☆	☆	☆	
		CXS-07G117-7235R/L	2.5	.098	7.2	.284	1.17	.046	35	1.378	4.25	.167	3.45	.136	57.8	2.276	3	.118	☆	☆	☆	☆	
		CXS-07G150-7210R	2.5	.098	7.2	.284	1.5	.059	10	.394	4.25	.167	3.45	.136	32.3	1.272	3	.118	☆	☆	☆	☆	
		CXS-07G150-7215R/L	2.5	.098	7.2	.284	1.5	.059	15	.591	4.25	.167	3.45	.136	37.3	1.468	3	.118	☆	☆	☆	☆	
		CXS-07G150-7225R/L	2.5	.098	7.2	.284	1.5	.059	25	.984	4.25	.167	3.45	.136	47.3	1.862	3	.118	☆	☆	☆	☆	
		CXS-07G150-7235R	2.5	.098	7.2	.284	1.5	.059	35	1.378	4.25	.167	3.45	.136	57.3	2.256	3	.118	☆	☆	☆	☆	
		CXS-07G157-7210R	2.5	.098	7.2	.284	1.57	.062	10	.394	4.25	.167	3.45	.136	32.4	1.276	3	.118	☆	☆	☆	☆	
		CXS-07G157-7215R/L	2.5	.098	7.2	.284	1.57	.062	15	.591	4.25	.167	3.45	.136	37.5	1.476	3	.118	☆	☆	☆	☆	
		CXS-07G157-7225R	2.5	.098	7.2	.284	1.57	.062	25	.984	4.25	.167	3.45	.136	47.6	1.874	3	.118	☆	☆	☆	☆	
		CXS-07G157-7235R/L	2.5	.098	7.2	.284	1.57	.062	35	1.378	4.25	.167	3.45	.136	57.8	2.276	3	.118	☆	☆	☆	☆	
		CXS-07G198-7210R	2.5	.098	7.2	.284	1.98	.078	10	.394	4.25	.167	3.45	.136	32.4	1.276	3	.118	☆	☆	☆	☆	
		CXS-07G198-7215R/L	2.5	.098	7.2	.284	1.98	.078	15	.591	4.25	.167	3.45	.136	37.5	1.476	3	.118	☆	☆	☆	☆	
		CXS-07G198-7225R	2.5	.098	7.2	.284	1.98	.078	25	.984	4.25	.167	3.45	.136	47.6	1.874	3	.118	☆	☆	☆	☆	
		CXS-07G198-7235R/L	2.5	.098	7.2	.284	1.98	.078	35	1.378	4.25	.167	3.45	.136	57.8	2.276	3	.118	☆	☆	☆	☆	
		CXS-07G200-7210R	2.5	.098	7.2	.284	2	.079	10	.394	4.25	.167	3.45	.136	32.3	1.272	3	.118	☆	☆	☆	☆	
		CXS-07G200-7215R/L	2.5	.098	7.2	.284	2	.079	15	.591	4.25	.167	3.45	.136	37.3	1.468	3	.118	☆	☆	☆	☆	
		CXS-07G200-7225R/L	2.5	.098	7.2	.284	2	.079	25	.984	4.25	.167	3.45	.136	47.3	1.862	3	.118	☆	☆	☆	☆	
		CXS-07G200-7235R	2.5	.098	7.2	.284	2	.079	35	1.378	4.25	.167	3.45	.136	57.3	2.256	3	.118	☆	☆	☆	☆	
																			P25	M15	N25	S15	H10

¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand



A346



A499



A525



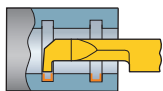
A3

CoroTurn® XS inserts

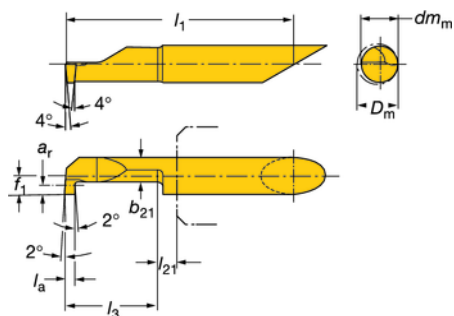
Grooving

For hardened materials

B



CXS-..G



Tolerances, mm (inch):

$l_a = +0.05/-0$ (+.002/-0)

$l_1 = \pm 0.02$ ($\pm .0008$)

Centre height:

$+0.05/-0$ (+.002/-0)

C

	Insert size ¹⁾	Ordering code	Selection criteria, millimeter, inch (mm, in.)										Dimensions, millimeter, inch (mm, in.)								H
			l_a mm	l_a in.	a_r , max mm	a_r , max in.	D_m min mm	D_m min in.	l_3 mm	l_3 in.	b_{21} mm	b_{21} in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	l_{21} mm	l_{21} in.			CB
	06	CXS-06G100-6215R	1	.039	1.8	.071	6.2	.244	15	.591	3.95	.156	2.95	.116	37.3	1.468	3	.118			7015
		CXS-06G150-6215R	1.5	.059	1.8	.071	6.2	.244	15	.591	3.95	.156	2.95	.116	37.3	1.468	3	.118			★
																					H10

¹⁾ To correspond with insert size on holder.

R = Right hand

★ = First choice

G

H

I

J



A346



A499



A525

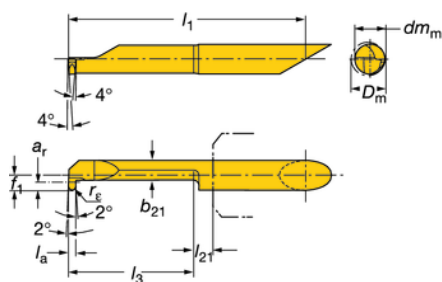
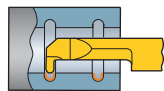


A3

CoroTurn® XS inserts

Profiling

CXS-..R




Tolerances, mm (inch):

 $l_a = +0.05 (+.002/-0)$ $r_e = \pm 0.02 (\pm .0008)$ $l_1 = \pm 0.02 (\pm .0008)$

Centre height:

 $+0.05 (+.002/-0)$

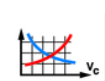
	Insert size ¹⁾		Selection criteria, millimeter, inch (mm, in.)										Dimensions, millimeter, inch (mm, in.)										P	M	N	S
			a_r		D_m		l_a		l_3		r_e		b_{21}		f_1		l_1		l_{21}		GC	GC	GC	GC		
			max mm	max in.	min mm	min in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	1025	1025	1025	1025		
	04	CXS-04R058-4215R	0.8	.032	4.2	.165	1.17	.046	15	.591	0.58	.023	2.95	.116	2.45	.096	32.5	1.280	3	.118	☆	☆	☆	☆		
		CXS-04R100-4215R/L	0.8	.032	4.2	.165	1	.039	15	.591	0.5	.020	2.95	.116	1.95	.077	32.3	1.272	3	.118	☆	☆	☆	☆		
	05	CXS-05R058-5220R/L	1	.039	5.2	.205	1.17	.046	20	.787	0.58	.023	3.75	.148	2.45	.096	42.5	1.673	3	.118	☆	☆	☆	☆		
		CXS-05R081-5220R/L	1	.039	5.2	.205	1.63	.064	20	.787	0.81	.032	3.75	.148	2.45	.096	42.5	1.673	3	.118	☆	☆	☆	☆		
		CXS-05R099-5220R/L	1	.039	5.2	.205	1.98	.078	20	.787	0.99	.039	3.75	.148	2.45	.096	42.5	1.673	3	.118	☆	☆	☆	☆		
		CXS-05R100-5220R/L	1	.039	5.2	.205	1	.039	20	.787	0.5	.020	3.75	.148	2.45	.096	42.3	1.665	3	.118	☆	☆	☆	☆		
		CXS-05R150-5220R	1	.039	5.2	.205	1.5	.059	20	.787	0.75	.030	3.75	.148	2.45	.096	42.3	1.665	3	.118	☆	☆	☆	☆		
		CXS-05R200-5220R	1	.039	5.2	.205	2	.079	20	.787	1	.039	3.75	.148	2.45	.096	42.3	1.665	3	.118	☆	☆	☆	☆		
	06	CXS-06R058-6225R/L	1.8	.071	6.2	.244	1.17	.046	25	.984	0.58	.023	3.95	.156	2.95	.116	47.6	1.874	3	.118	☆	☆	☆	☆		
		CXS-06R081-6225R/L	1.8	.071	6.2	.244	1.63	.064	25	.984	0.81	.032	3.95	.156	2.95	.116	47.6	1.874	3	.118	☆	☆	☆	☆		
		CXS-06R099-6225R/L	1.8	.071	6.2	.244	1.98	.078	25	.984	0.99	.039	3.95	.156	2.95	.116	47.6	1.874	3	.118	☆	☆	☆	☆		
		CXS-06R100-6225R/L	1.8	.071	6.2	.244	1	.039	25	.984	0.5	.020	3.95	.156	2.95	.116	47.3	1.862	3	.118	☆	☆	☆	☆		
		CXS-06R150-6225R/L	1.8	.071	6.2	.244	1.5	.059	25	.984	0.75	.030	3.95	.156	2.95	.116	47.3	1.862	3	.118	☆	☆	☆	☆		
		CXS-06R200-6225R/L	1.8	.071	6.2	.244	2	.079	25	.984	1	.039	3.95	.156	2.95	.116	47.3	1.862	3	.118	☆	☆	☆	☆		
	07	CXS-07R058-7230R/L	2.5	.098	7.2	.284	1.17	.046	30	1.181	0.58	.023	4.25	.167	3.45	.136	52.7	2.075	3	.118	☆	☆	☆	☆		
		CXS-07R081-7230R/L	2.5	.098	7.2	.284	1.63	.064	30	1.181	0.81	.032	4.25	.167	3.45	.136	52.7	2.075	3	.118	☆	☆	☆	☆		
		CXS-07R099-7230R/L	2.5	.098	7.2	.284	1.98	.078	30	1.181	0.99	.039	4.25	.167	3.45	.136	52.7	2.075	3	.118	☆	☆	☆	☆		
		CXS-07R100-7230R/L	2.5	.098	7.2	.284	1	.039	30	1.181	0.5	.020	4.25	.167	3.45	.136	52.3	2.059	3	.118	☆	☆	☆	☆		
		CXS-07R150-7230R/L	2.5	.098	7.2	.284	1.5	.059	30	1.181	0.75	.030	4.25	.167	3.45	.136	52.3	2.059	3	.118	☆	☆	☆	☆		
CXS-07R200-7230R/L		2.5	.098	7.2	.284	2	.079	30	1.181	1	.039	4.25	.167	3.45	.136	52.3	2.059	3	.118	☆	☆	☆	☆			
																					P25	M15	N25	S15		

1) To correspond with insert size on holder.

R = Right hand, L = Left hand



A346



A499



A524

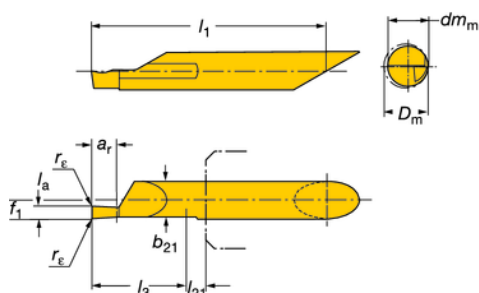
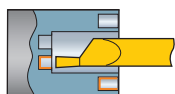


A3

CoroTurn® XS inserts

Face grooving

CXS-..F



Tolerances, mm (inch):

 $l_a = +0.05/-0$ (+.002/-0) $r_e = \pm 0.02$ ($\pm .0008$) $l_1 = \pm 0.02$ ($\pm .0008$)

Centre height:

 $+0.05/-0$ (+.002/-0)

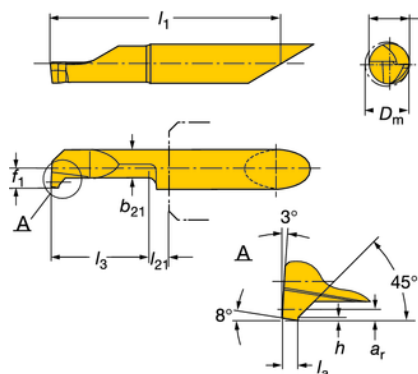
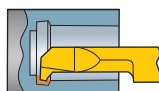
	Insert size ¹⁾	Selection criteria, mm, inch					Dimensions, mm, inch					P	M	N	S
												GC	GC	GC	GC
												1025	1025	1025	1025
	dm_m	l_a	a_r max	D_m min	l_3	Ordering code	b_{21}	f_1	l_1	l_{21}	r_e				
	06	1	2	6.2	15	CXS-06F100-6215AR/L	6	2.95	37.3	3	0.15	☆	☆	☆	☆
		.039	.079	.244	.591		.236	.116	1.468	.118	.006				
		1.5	3	6.2	15	CXS-06F150-6215AR/L	6	2.95	37.3	3	0.15	☆	☆	☆	☆
		.059	.118	.244	.591		.236	.116	1.468	.118	.006				
		2	4	6.2	15	CXS-06F200-6215AR/L	6	2.95	37.3	3	0.15	☆	☆	☆	☆
		.079	.157	.244	.591		.236	.116	1.468	.118	.006				
		2.5	5	6.2	15	CXS-06F250-6215AR/L	6	2.95	37.3	3	0.15	☆	☆	☆	☆
		.098	.197	.244	.591		.236	.116	1.468	.118	.006				
		3	6	6.2	15	CXS-06F300-6215AR/L	6	2.95	37.3	3	0.15	☆	☆	☆	☆
		.118	.236	.244	.591		.236	.116	1.468	.118	.006				
												P25	M15	N25	S15

¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand

Pre-parting

CXS-..GX



Tolerances, mm (inch):

 $l_a = +0.05/-0$ (+.002/-0) $l_1 = \pm 0.02$ ($\pm .0008$)

Centre height:

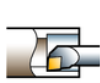
 $+0.05/-0$ (+.002/-0)

Right hand style shown

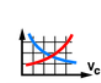
	Insert size ¹⁾	Selection criteria, mm, inch					Dimensions, mm, inch					P	M	N	S
												GC	GC	GC	GC
												1025	1025	1025	1025
	dm_m	l_a	a_r max	D_m min	l_3	Ordering code	b_{21}	f_1	h	l_1	l_{21}				
	05	1	0.7	5.2	15	CXS-05GX100-5215R/L	3.75	2.45	0.2	37.3	3	☆	☆	☆	☆
		.039	.028	.205	.591		.148	.096	.008	1.468	.118				
		1	0.7	5.2	20	CXS-05GX100-5220R	3.75	2.45	0.2	42.3	3	☆	☆	☆	☆
		.039	.028	.205	.787		.148	.096	.008	1.665	.118				
		1	0.7	5.2	25	CXS-05GX100-5225R/L	3.75	2.45	0.2	47.3	3	☆	☆	☆	☆
		.039	.028	.205	.984		.148	.096	.008	1.862	.118				
		1	0.7	5.2	30	CXS-05GX100-5230R	3.75	2.45	0.2	52.3	3	☆	☆	☆	☆
		.039	.028	.205	1.181		.148	.096	.008	2.059	.118				
												P25	M15	N25	S15

¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand



A346



A499



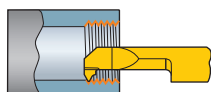
A524



A3

CoroTurn® XS inserts

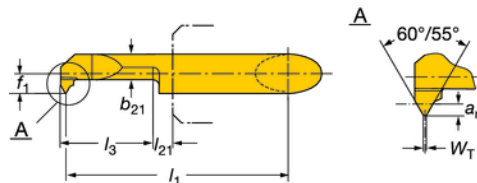
Threading

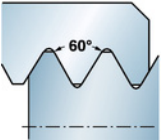
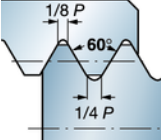
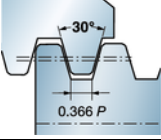


Tolerances, mm (inch):

 $l_a = +0.05$ (+.002/-0) $r_e = \pm 0.02$ (± 0.0008) $l_1 = \pm 0.02$ (± 0.0008)

Centre height:

 $+0.05$ (+.002/-0)

	Insert size ¹⁾	Pitch				Ordering code	Dimensions, mm, inch										P	M	N	S
		dm_m	mm	TPI min	TPI max		a_r max	b_{21}	D_m min	f_1	l_1	l_3	l_{21}	W_T	GC	GC	GC	GC		
															1025	1025	1025	1025		
					V-profile 60°															
	04	0.5	48	56	CXS-04TH050VM-4215R/L	0.27	2.95	4.2	1.95	32.3	15	3	0.06	☆	☆	☆	☆			
						.011	.116	.165	.077	1.272	.591	.118	.002							
	05	0.5	48	56	CXS-05TH050VM-5215R	0.27	3.75	5.2	2.45	37.3	15	3	0.06	☆	☆	☆	☆			
						.011	.148	.205	.096	1.468	.591	.118	.002							
		0.75	36	40	CXS-05TH070VM-5115R	0.4	3.65	5.1	2.35	37.3	15	3	0.09	☆	☆	☆	☆			
						.016	.144	.201	.092	1.468	.591	.118	.004							
		1	29	28	CXS-05TH100VM-4815R/L	0.55	3.55	4.8	2.25	37.3	15	3	0.12	☆	☆	☆	☆			
						.022	.140	.189	.089	1.468	.591	.118	.005							
	06	1	29	28	CXS-06TH100VM-6215L	0.55	3.55	6.2	2.95	37.3	15	3	0.12	☆	☆	☆	☆			
						.022	.140	.244	.116	1.468	.591	.118	.005							
					CXS-06TH100VM-6215R	0.55	3.55	6.2	2.95	37.3	15	3	0.12	☆	☆	☆	☆			
					Metric 60°															
	04	0.5			CXS-04TH050MM-4215R	0.27	3.45	4.2	1.95	32.3	15	3	0.06	☆	☆	☆	☆			
						.011	.136	.165	.077	1.272	.591	.118	.002							
		0.7			CXS-04TH070MM-4215R	0.38	3.25	4.2	1.9	32.3	15	3	0.08	☆	☆	☆	☆			
						.015	.128	.165	.075	1.272	.591	.118	.003							
		0.8			CXS-04TH080MM-4015R	0.43	3	4	1.85	32.3	15	3	0.1	☆	☆	☆	☆			
						.017	.118	.157	.073	1.272	.591	.118	.004							
	05	0.5			CXS-05TH050MM-5215R	0.27	4.45	5.2	2.45	37.3	15	3	0.06	☆	☆	☆	☆			
						.011	.175	.205	.096	1.468	.591	.118	.002							
		0.75			CXS-05TH075MM-5115R	0.41	4.15	5.1	2.4	37.3	15	3	0.09	☆	☆	☆	☆			
						.016	.163	.201	.094	1.468	.591	.118	.004							
		1			CXS-05TH100MM-4815R	0.54	3.55	4.8	2.25	37.3	15	3	0.12	☆	☆	☆	☆			
					Trapezoidal 30°															
	06	1.5			CXS-06TH150TR-6220R	0.9	4.9	6.2	2.95	37.6	20	3	0.47	☆	☆	☆	☆			
						.035	.193	.244	.116	1.480	.787	.118	.019							
		2			CXS-06TH200TR-6220R	1.25	4.55	6.2	2.95	37.6	20	3	0.6	☆	☆	☆	☆			
						.049	.179	.244	.116	1.480	.787	.118	.024							
	07	3			CXS-07TH300TR-7230R	1.75	4.55	7.2	3.45	52.25	30	3	0.96	☆	☆	☆	☆			
						.069	.179	.284	.136	2.057	1.181	.118	.038							

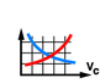
¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand

Continued ...



A346



A499



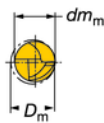
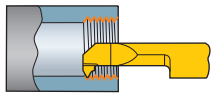
A524



A3

CoroTurn® XS inserts

Threading



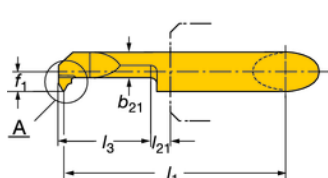
Tolerances, mm (inch):

 $l_a = +0.05 (+.002/-0)$ $r_e = \pm 0.02 (\pm .0008)$ $l_1 = \pm 0.02 (\pm .0008)$

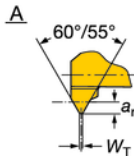
Centre height:

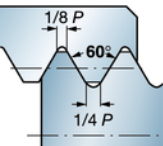
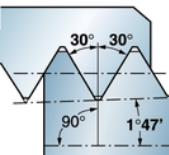
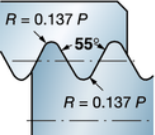
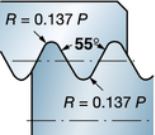
 $+0.05/-0 (+.002/-0)$

... Continued



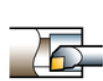
Right hand style shown



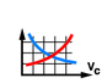
	Insert size ¹⁾		Pitch	Ordering code	Dimensions, mm, inch										P	M	N	S	H
	dm_m	mm	TPI		a_r max	b_{21}	D_m min	f_1	l_1	l_3	l_{21}	W_T	r_e	GC	GC	GC	GC	CB	
														1025	1025	1025	1025	7015	
	04		32	CXS-04TH320UN-4015R	0.43	2.95	4	1.85	32.3	15	3	0.1		☆	☆	☆	☆		
					.017	.116	.157	.073	1.272	.591	.118	.004		☆	☆	☆	☆		
			28	CXS-04TH280UN-4015R	0.49	2.95	4	1.85	32.3	15	3	0.11		☆	☆	☆	☆		
					.019	.116	.157	.073	1.272	.591	.118	.004		☆	☆	☆	☆		
	05		24	CXS-04TH240UN-4215R	0.57	3.05	4.2	1.95	32.3	15	3	0.13		☆	☆	☆	☆		
					.022	.120	.165	.077	1.272	.591	.118	.005		☆	☆	☆	☆		
	06		20	CXS-05TH200UN-5215R	0.69	3.95	5.2	2.45	37.3	15	3	0.16		☆	☆	☆	☆		
					.027	.156	.205	.096	1.468	.591	.118	.006		☆	☆	☆	☆		
	06		18	CXS-06TH180UN-6215R	0.76	4.85	6.2	2.45	37.3	15	3	0.18		☆	☆	☆	☆		
					.030	.191	.244	.096	1.468	.591	.118	.007		☆	☆	☆	☆		
	06		27	CXS-06TH27NT-6215R	1	3.95	6.2	2.95	37.3	15	3	0.07		☆	☆	☆	☆		
					.039	.156	.244	.116	1.468	.591	.118	.003		☆	☆	☆	☆		
			18	CXS-06TH18NT-6215R/L	1.35	3.95	6.2	2.95	37.3	15	3	0.1		☆	☆	☆	☆		
					.053	.156	.244	.116	1.468	.591	.118	.004		☆	☆	☆	☆		
	05		28	CXS-05TH28WH-5215R	0.58	3.75	5.2	2.45	37.3	15	3	0.12		☆	☆	☆	☆		
					.023	.148	.205	.096	1.468	.591	.118	.005		☆	☆	☆	☆		
			26	CXS-05TH26WH-5215R	0.62	3.75	5.2	2.45	37.3	15	3	0.13		☆	☆	☆	☆		
					.024	.148	.205	.096	1.468	.591	.118	.005		☆	☆	☆	☆		
	06		24	CXS-05TH24WH-5215R	0.68	3.75	5.2	2.45	37.3	15	3	0.14		☆	☆	☆	☆		
					.027	.148	.205	.096	1.468	.591	.118	.006		☆	☆	☆	☆		
	06		28	CXS-06TH28WH-6215R	0.58	3.95	6.2	2.95	37.3	15	3	0.12		☆	☆	☆	☆		
					.023	.156	.244	.116	1.468	.591	.118	.005		☆	☆	☆	☆		
			26	CXS-06TH26WH-6215R	0.63	3.95	6.2	2.95	37.3	15	3	0.13		☆	☆	☆	☆		
					.025	.156	.244	.116	1.468	.591	.118	.005		☆	☆	☆	☆		
	06		24	CXS-06TH24WH-6215R	0.68	3.95	6.2	2.95	37.3	15	3	0.14		☆	☆	☆	☆		
					.027	.156	.244	.116	1.468	.591	.118	.006		☆	☆	☆	☆		
	06		22	CXS-06TH22WH-6215R	0.74	3.95	6.2	2.95	37.3	15	3	0.16		☆	☆	☆	☆		
					.029	.156	.244	.116	1.468	.591	.118	.006		☆	☆	☆	☆		
	06		20	CXS-06TH20WH-6215R	0.81	3.95	6.2	2.95	37.3	15	3	0.17		☆	☆	☆	☆		
					.032	.156	.244	.116	1.468	.591	.118	.007		☆	☆	☆	☆		
	06		19	CXS-06TH19WH-6215R/L	0.86	3.95	6.2	2.95	37.3	15	3	0.18		☆	☆	☆	☆		
					.034	.156	.244	.116	1.468	.591	.118	.007		☆	☆	☆	☆		
	06													☆	☆	☆	☆		
														☆	☆	☆	☆		
	06													☆	☆	☆	☆		
														☆	☆	☆	☆		
	06													☆	☆	☆	☆		
														☆	☆	☆	☆		
	06													☆	☆	☆	☆		
														☆	☆	☆	☆		

¹⁾ To correspond with insert size on holder.

R = Right hand, L = Left hand



A346



A499



A524

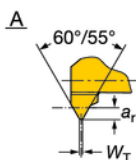
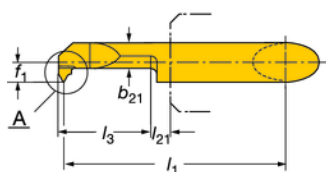
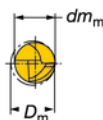
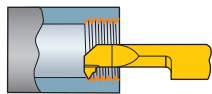


A3

CoroTurn® XS inserts

Threading

For hardened materials



Tolerances, mm (inch):

$l_1 = \pm 0.02 (\pm .0008)$

Centre height:

$+0.05/-0 (+.002/-0)$

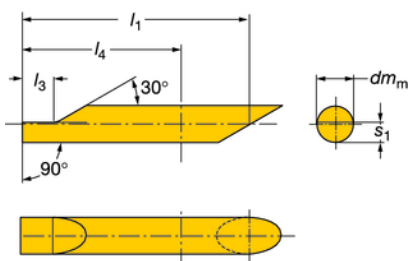
... Continued

	Insert size ¹⁾		Pitch	Ordering code	Dimensions, mm, inch								H
	dm_m	mm	TPI		a_r max	b_{21}	D_m min	f_1	l_1	l_3	l_{21}	W_T	
	06	1	28-24	V-Profile 60° CXS-06TH100VM-6215R	0.55	3.55	6.2	2.95	37.3	15	3	0.12	★
					.022	.140	.244	.116	1.468	.591	.118	0.0047	★
		1.5	20-16	CXS-06TH150VM-6215R	0.81	3.55	6.2	2.95	37.3	15	3	0.18	★
					.032	.140	.244	.116	1.468	.591	.118	0.0071	★
													H15

¹⁾ To correspond with insert size on holder.

R = Right hand

Blanks



Tolerances, mm (inch):

$l_1 = +0.25/+0.05 (+0.01/0.002)$

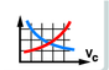
Insert size ¹⁾	Ordering code	Dimensions, mm, inch				P	M	K	N
		l_1	l_3	l_4	s_1	H10F	H10F	H10F	H10F
04	CXS-04B-50	50	3.5	35.75	2.25	★	★	★	★
		1.968	.138	1.408	.0886				
05	CXS-05B-65	65	4	45.75	2.750	★	★	★	★
		2.559	.157	1.8012	0.108				
06	CXS-06B-70	70	5	50.75	3.250	★	★	★	★
		2.756	.197	1.998	0.128				
07	CXS-07B-70	70	6	50.75	3.750	★	★	★	★
		2.756	.236	1.998	0.148				
						M20		N20	

¹⁾ To correspond with insert size on holder.

★ = First choice



A346



A499



A524



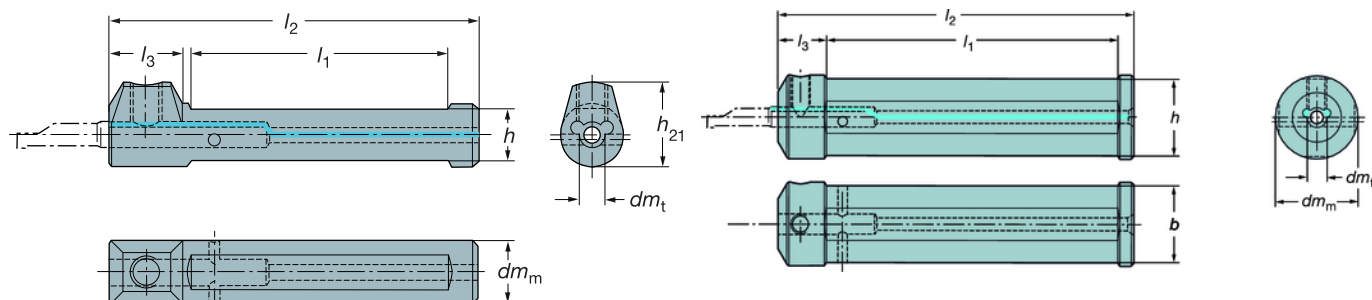
A3

CoroTurn® XS boring bars

With internal coolant supply

Cylindrical with two flats
CXS-A

Cylindrical with four flats
CXS-A...M



For machine type:	Insert size ¹⁾	Ordering code	Dimensions, mm							Nm ²⁾
	dm_t		dm_m	b	h	l_1	l_2	l_3	h_{21}	
Star	4	CXS-A22-04	22	21.0	20.0	90.0	110	14.0		3.0
			.866	.827	.787	3.543	4.331	.551		
	5	CXS-A22-05	22	21.0	20.0	90.0	110	14.0		3.0
			.866	.827	.787	3.543	4.331	.551		
	6	CXS-A22-06	22	21.0	20.0	90.0	110	14.0		3.0
Nomura	4	CXS-A23-04	23		21.0	90.0	110	14.0		3.0
			.906		.827	3.543	4.331	.551		
	5	CXS-A23-05	23		21.0	90.0	110	14.0		3.0
			.906		.827	3.543	4.331	.551		
	6	CXS-A23-06	23		21.0	90.0	110	14.0		3.0
Tsubaki/Miyano	4	CXS-A25-04	25		23.0	90.0	110	14.0		3.0
			.984		.906	3.543	4.331	.551		
	5	CXS-A25-05	25		23.0	90.0	110	14.0		3.0
			.984		.906	3.543	4.331	.551		
	6	CXS-A25-06	25		23.0	90.0	110	14.0		3.0
Traub	4	CXS-A28-04	28		23.0	90.0	110	14.0		3.0
			.984		.906	3.543	4.331	.551		
	5	CXS-A28-05	28		23.0	90.0	110	14.0		3.0
			.984		.906	3.543	4.331	.551		
	6	CXS-A28-06	28		23.0	90.0	110	14.0		3.0
Citizen	4	CXS-A0750-04	19.05		18.0	90.0	110	14.0	20	3.0
			.750		.709	3.543	4.331	.551	.787	
	5	CXS-A0750-05	19.05		18.0	90.0	110	14.0	20	3.0
			.750		.709	3.543	4.331	.551	.787	
	6	CXS-A0750-06	19.05		18.0	90.0	110	14.0	22	3.0
CXS-A1000	4	CXS-A1000-04M	25.4	23.4		90.0	110	15.0		3.0
			1.000	.921		3.543	4.331	.591		
	5	CXS-A1000-05M	25.4	23.4		90.0	110	15.0		3.0
			1.000	.921		3.543	4.331	.591		
	6	CXS-A1000-06M	25.4	23.4		90.0	110	15.0		3.0
CXS-A1000	4	CXS-A1000-04M	25.4	23.4		90.0	110	15.0		3.0
			1.000	.921		3.543	4.331	.591		
	5	CXS-A1000-05M	25.4	23.4		90.0	110	15.0		3.0
			1.000	.921		3.543	4.331	.591		
	6	CXS-A1000-06M	25.4	23.4		90.0	110	15.0		3.0
CXS-A1000	4	CXS-A1000-04M	25.4	23.4		90.0	110	15.0		3.0
			1.000	.921		3.543	4.331	.591		
	5	CXS-A1000-05M	25.4	23.4		90.0	110	15.0		3.0
			1.000	.921		3.543	4.331	.591		
	6	CXS-A1000-06M	25.4	23.4		90.0	110	15.0		3.0

¹⁾ To correspond with insert size on insert.

²⁾ Insert tightening torque Nm.

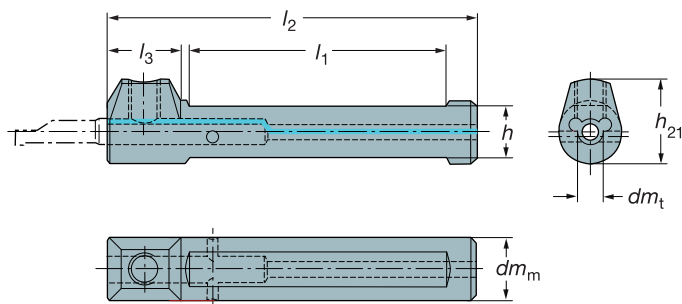
Continued ...



CoroTurn® XS boring bars

With internal coolant supply

Cylindrical with two flats
CXS-A



... Continued

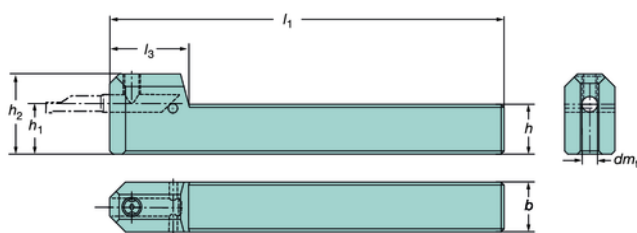
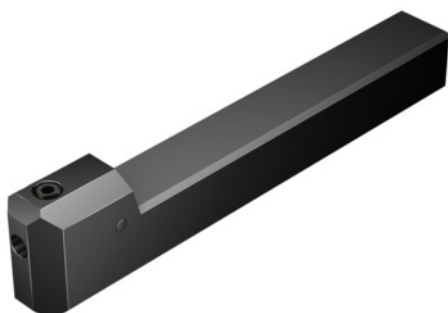
	Insert size ¹⁾		Dimensions, mm							Nm ²⁾
	dm _t	Ordering code	dm _m	b	h	l ₁	l ₂	l ₃	h ₂₁	
Other	4	CXS-A0500-04	12.7		10.0	45.0	70	14.0	15.5	3.0
			.500		.394	1.772	2.756	.551	.610	
	5	CXS-A0500-05	12.7		10.0	45.0	70	14.0	16	3.0
			.500		.394	1.772	2.756	.551	.630	
	6	CXS-A0500-06	12.7		10.0	45.0	70	14.0	16.5	3.0
			.500		.394	1.772	2.756	.551	.650	
	4	CXS-A0625-04	15.875		14.0	55.0	75	14.0	17.5	3.0
			.625		.551	2.165	2.953	.551	.689	
	5	CXS-A0625-05	15.875		14.0	55.0	75	14.0	18	3.0
			.625		.551	2.165	2.953	.551	.709	
	6	CXS-A0625-06	15.875		14.0	55.0	75	14.0	18.5	3.0
			.625		.551	2.165	2.953	.551	.728	
	7	CXS-A0625-07	15.875		14.0	55.0	75	14.0	19	3.0
			.625		.551	2.165	2.953	.551	.748	
	4	CXS-A10-04	10		8.0	45.0	65	14.0	14.5	3.0
			.394		.315	1.772	2.559	.551	.571	
	5	CXS-A10-05	10		8.0	45.0	65	14.0	15	3.0
			.394		.315	1.772	2.559	.551	.591	
	4	CXS-A12-04	12		10.0	50.0	70	14.0	15.5	3.0
			.472		.394	1.968	2.756	.551	.610	
	5	CXS-A12-05	12		10.0	50.0	70	14.0	16	3.0
			.472		.394	1.968	2.756	.551	.630	
	6	CXS-A12-06	12		10.0	50.0	70	14.0	16.5	3.0
			.472		.394	1.968	2.756	.551	.650	
	4	CXS-A16-04	16		14.0	55.0	75	14.0	17.5	3.0
			.630		.551	2.165	2.953	.551	.689	
	5	CXS-A16-05	16		14.0	55.0	75	14.0	18	3.0
			.630		.551	2.165	2.953	.551	.709	
	6	CXS-A16-06	16		14.0	55.0	75	14.0	18.5	3.0
			.630		.551	2.165	2.953	.551	.728	
	7	CXS-A16-07	16		14.0	55.0	75	14.0	19	3.0
			.630		.551	2.165	2.953	.551	.748	
	4	CXS-A20-04	20		18.0	70.0	90	14.0		3.0
			.787		.709	2.756	3.543	.551		
	5	CXS-A20-05	20		18.0	70.0	90	14.0		3.0
			.787		.709	2.756	3.543	.551		
	6	CXS-A20-06	20		18.0	70.0	90	14.0	22	3.0
			.787		.709	2.756	3.543	.551	.866	
	7	CXS-A20-07	20		18.0	70.0	90	14.0	22	3.0
			.787		.709	2.756	3.543	.551	.866	

¹⁾ To correspond with insert size on insert.

²⁾ Insert tightening torque Nm.



CoroTurn® XS square shank holder



Metric version

Insert size ¹⁾		Dimensions, mm						
dm_1	Ordering code	b	h	h_1	h_2	l_1	l_3	Nm ²⁾
04	CXS-1212-04FN	12	12	12	21	100	19.0	3.0
	CXS-1616-04FN	16	16	16	25	125	19.0	3.0
	CXS-2020-04FN	20	20	20	29	125	19.0	3.0
05	CXS-1212-05FN	12	12	12	21.5	100	25.0	3.0
	CXS-1616-05FN	16	16	16	25.5	125	25.0	3.0
	CXS-2020-05FN	20	20	20	29.5	125	25.0	3.0
	CXS-2525-05FN	25	25	25	34.5	150	25.9	3.0
06	CXS-1212-06FN	12	12	12	22	100	26.0	3.0
	CXS-1616-06FN	16	16	16	26	125	26.0	3.0
	CXS-2020-06FN	20	20	20	30	125	25.5	3.0
	CXS-2525-06FN	25	25	25	35	150	25.5	3.0
07	CXS-1616-07FN	16	16	16	26.5	125	26.5	3.0
	CXS-2020-07FN	20	20	20	30.5	125	26.5	3.0
	CXS-2525-07FN	25	25	25	35.5	150	26.5	3.0

Inch version

Insert size ¹⁾		Dimensions, inch						
dm_1	Ordering code	b	h	h_1	h_2	l_1	l_3	ft-lbs ³⁾
04	CXS-08-04FN	.500	.500	.500	.827	4.000	.748	2.2
	CXS-10-04FN	.625	.625	.625	.984	5.000	.748	2.2
	CXS-12-04FN	.750	.750	.750	1.142	5.000	.748	2.2
05	CXS-08-05FN	.500	.500	.500	.846	4.000	.984	2.2
	CXS-10-05FN	.625	.625	.625	1.004	5.000	.984	2.2
	CXS-12-05FN	.750	.750	.750	1.161	5.000	.984	2.2
	CXS-16-05FN	1.000	1.000	1.000	1.358	5.906	.984	2.2
06	CXS-08-06FN	.500	.500	.500	.866	4.000	1.024	2.2
	CXS-10-06FN	.625	.625	.625	1.024	5.000	1.004	2.2
	CXS-12-06FN	.750	.750	.750	1.181	5.000	1.004	2.2
	CXS-16-06FN	1.000	1.000	1.000	1.378	5.906	1.004	2.2
07	CXS-10-07FN	.625	.625	.625	1.378	5.000	1.043	2.2
	CXS-12-07FN	.750	.750	.750	1.201	5.000	1.043	2.2
	CXS-16-07FN	1.000	1.000	1.000	1.398	5.906	1.043	2.2

1) To correspond with insert size on insert.

2) Insert tightening torque Nm.

3) Insert tightening torque ft-lbs.

N = Neutral

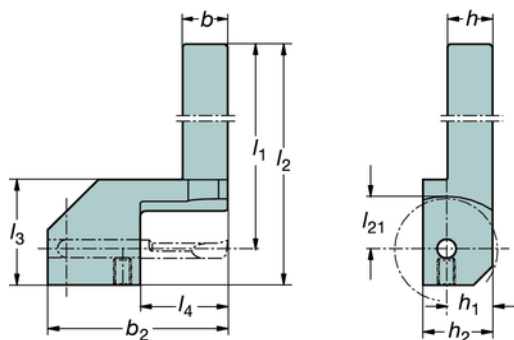
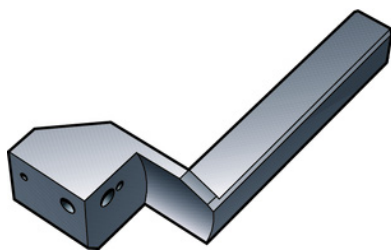
Main spare parts

Insert screw	Key (Torx Plus)
5514 013-01	5680 049-01 (15IP)



CoroTurn® XS square shank holder

For internal machining in sliding head machines



Right hand style shown

Metric version

Insert size ¹⁾		Dimensions, mm											
dm_t	Ordering code	b	b_2	h	h_1	h_2	l_1	l_2	l_3	l_4	l_{21}	Nm ²⁾	
04	CXS-1010-04R/L	10	36.5	10	10	16	89	99	29.0	18	13	3.0	
	CXS-1212-04R/L	12	36.5	12	12	18	89	99	29.0	18	13	3.0	
05	CXS-1010-05R/L	10	48	10	10	16	89	99	29.0	23	13	3.0	
	CXS-1212-05R/L	12	48	12	12	18	89	99	29.0	23	13	3.0	
	CXS-1616-05R/L	16	48	16	16	22	94	104	34.0	23	18	3.0	
06	CXS-1010-06R/L	10	53	10	10	16	89	99	29.0	28	13	3.0	
	CXS-1212-06R/L	12	53	12	12	18	89	99	29.0	28	13	3.0	
	CXS-1616-06R/L	16	53	16	16	22	94	104	34.0	28	18	3.0	

¹⁾ To correspond with seat size on insert.

²⁾ Insert tightening torque Nm.

R = Right hand, L = Left hand

Inch version

Insert size ¹⁾		Dimensions, inch										
dm_t	Ordering code	b	b_2	h	h_1	h_2	l_1	l_2	l_3	l_4	l_{21}	ft-lbs ²⁾
04	CXS-06-04R	.375	1.437	.375	.375	.630	3.504	3.898	1.142	.709	.512	2.2
	CXS-08-04R	.500	1.437	.500	.500	.748	3.504	3.898	1.142	.709	.512	2.2
05	CXS-08-05R	.500	1.890	.500	.500	.748	3.504	3.898	1.142	.906	.512	2.2
	CXS-10-05R	.625	1.890	.625	.625	.866	3.701	4.094	1.339	.906	.709	2.2
06	CXS-08-06R	.500	2.087	.500	.500	.748	3.504	3.898	1.142	1.102	.512	2.2
	CXS-10-06R	.625	2.087	.625	.625	.866	3.701	4.094	1.339	1.102	.709	2.2

¹⁾ To correspond with seat size on insert.

²⁾ Insert tightening torque ft-lbs.

R = Right hand

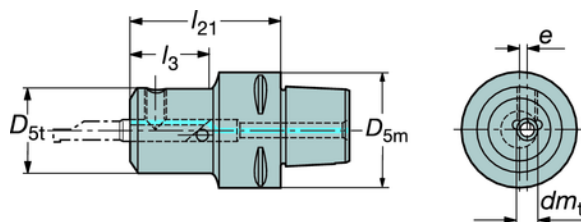
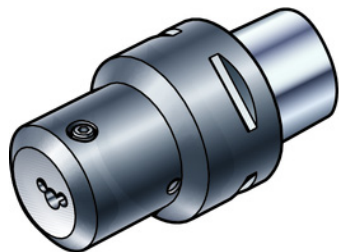
Main spare parts

Insert screw	Key
	(Torx Plus)
5514 013-01	5680 049-01 (15IP)



Coromant Capto® holder for CoroTurn® XS

For turning and rotating applications



Insert size ¹⁾		Dimensions, mm, inch						
dm_t	Ordering code	D_{5m}	D_{5t}	dm_t	e	l_3	l_{21}	Nm ²⁾
04	C3-CXS-42-04	32	21	4	1.05	22.0	42	3.0
		1.260	.827	.157	.041	.866	1.654	
	C4-CXS-47-04	40	21	4	1.05	22.0	47	3.0
		1.575	.827	.157	.041	.866	1.850	
	C5-CXS-49-04	50	21	4	1.05	22.0	49	3.0
		1.968	.827	.157	.041	.866	1.929	
05	C6-CXS-95-04	63	21	4	1.05	22.0	95	3.0
		2.480	.827	.157	.041	.866	3.740	
	C3-CXS-42-05	32	22	5	1.3	22.0	42	3.0
		1.260	.866	.197	.051	.866	1.654	
	C4-CXS-47-05	40	22	5	1.3	22.0	47	3.0
		1.575	.866	.197	.051	.866	1.850	
06	C5-CXS-49-05	50	22	5	1.3	22.0	49	3.0
		1.968	.866	.197	.051	.866	1.929	
	C6-CXS-95-05	63	22	5	1.3	22.0	95	3.0
		2.480	.866	.197	.051	.866	3.740	
	C3-CXS-42-06	32	23.5	6	1.95	22.0	42	3.0
		1.260	.925	.236	.077	.866	1.654	
07	C4-CXS-47-06	40	23.5	6	1.95	22.0	47	3.0
		1.575	.925	.236	.077	.866	1.850	
	C5-CXS-49-06	50	23.5	6	1.95	22.0	49	3.0
		1.968	.925	.236	.077	.866	1.929	
	C6-CXS-95-06	63	23.5	6	1.95	22.0	95	3.0
		2.480	.925	.236	.077	.866	3.740	
08	C3-CXS-42-07	32	25	7	2.9	22.0	42	3.0
		1.260	.984	.276	.114	.866	1.654	
	C4-CXS-47-07	40	25	7	2.9	22.0	47	3.0
		1.575	.984	.276	.114	.866	1.850	
	C5-CXS-49-07	50	25	7	2.9	22.0	49	3.0
		1.968	.984	.276	.114	.866	1.929	
09	C6-CXS-95-07	63	25	7	2.9	22.0	95	3.0
		2.480	.984	.276	.114	.866	3.740	

¹⁾ To correspond with insert size on insert.

²⁾ Insert tightening torque Nm.

Main spare parts

Insert screw	Key (Torx Plus)
5514 013-01	5680 049-01 (15IP)



A328

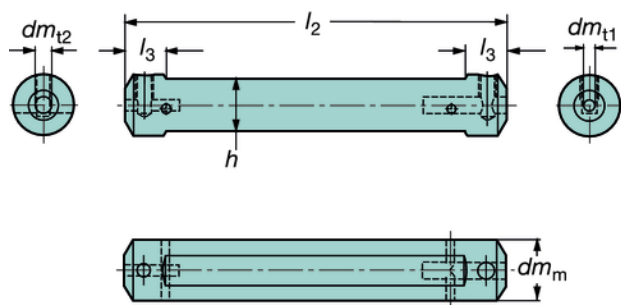


A2



G6

CoroTurn® XS double ended boring bar



For machine type:	Insert size ¹⁾		Ordering code	Dimensions, millimeter, inch (mm, in.)								
	Main spindle	Sub spindle		dm_m	dm_m	h	h	l_2	l_2	l_3	l_3	
Machine type	dm_{t1}	dm_{t2}		mm	in.	mm	in.	mm	in.	mm	in.	Nm ²⁾
Citizen	04	06	CXS-A075-04-06	19.05	.750	17	.669	140	5.512	15	.591	3.0
Star	04	04	CXS-A22-04-04	22	.866	20	.787	140	5.512	15	.591	3.0
	04	06	CXS-A22-04-06	22	.866	20	.787	140	5.512	15	.591	3.0
	06	06	CXS-A22-06-06	22	.866	20	.787	140	5.512	15	.591	3.0
Tsugami	04	06	CXS-A25-04-06	25	.984	23	.906	140	5.512	15	.591	3.0
Traub	04	06	CXS-A28-04-06	28	1.102	26	1.024	140	5.512	15	.591	3.0
Others	04	06	CXS-A20-04-06	20	.787	18	.709	140	5.512	15	.591	3.0

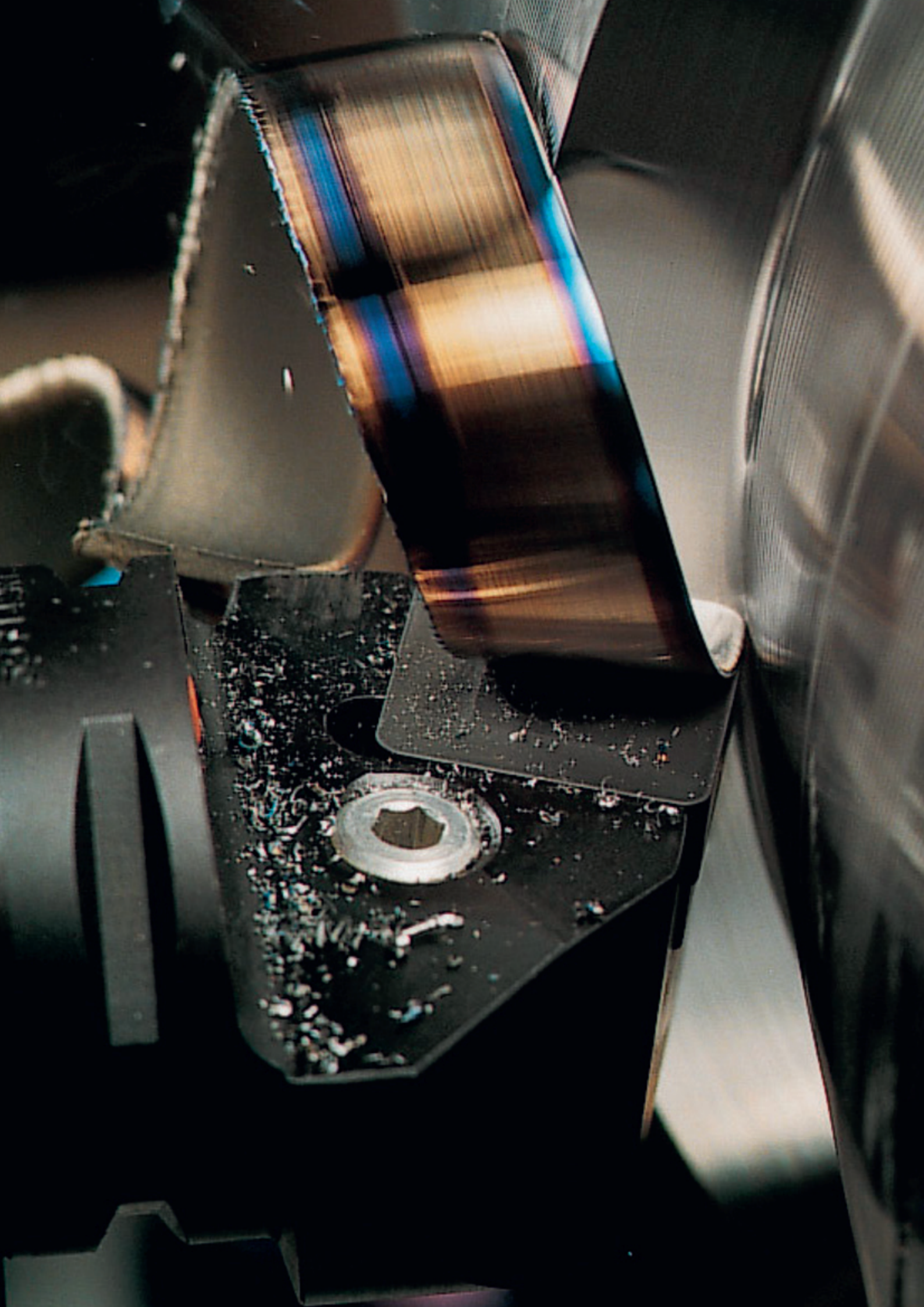
¹⁾ To correspond with insert size on insert.

²⁾ Insert tightening torque Nm.

Main spare parts

Screw	Key (Torx Plus)
5514 013-01	5680 049-01 (15IP)





GENERAL TURNING

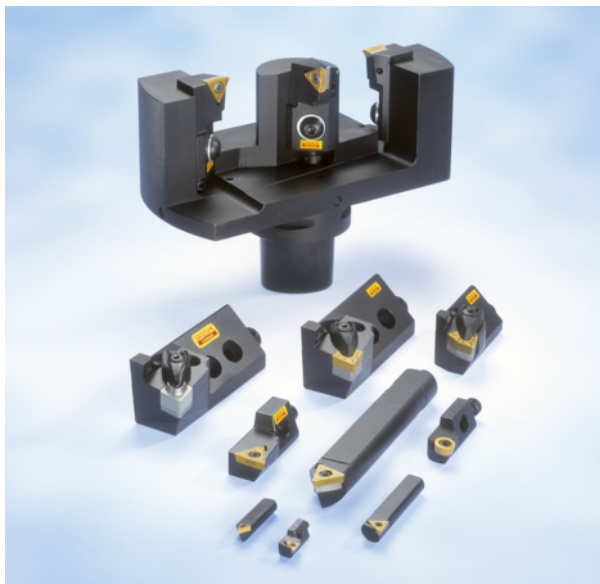
Cartridges for special tools

Introduction	A350
Tool holder overview	A351
Code key	A353
Cartridges for negative basic-shape inserts	
CoroTurn RC rigid clamping	A354
T-Max® P, lever clamping	A356
T-Max P wedge clamp design	A359
Mounting dimensions	A360
Cartridges for positive basic-shape inserts	
CoroTurn® 107 screw clamping	A362
Round shank tools CoroTurn® 107 screw clamp	A370
Mounting dimensions	A366
CoroThread 266 cartridges	C45
Spare parts	A438
Torque wrenches	A437

Build-in tools

Cartridges for both T-Max P and CoroTurn® 107 inserts

Used in multi cutting edge tools for flexibility



Multi cutting edge tools

Build-in tools are primarily used for multi cutting edge tools with following benefits:

- If insert breaks damage to an expensive tool is prevented
- If the workpiece design has a minor modification, the build in unit can be adjusted rather than the making a completely new tool
- Multiple operations can be done in one pass, saving valuable time

CoroTurn® RC a flexible system

By changing clamp set and/or shim, the tip seat on all CoroTurn® RC holders has been designed for total interchangeability between:

- Cemented carbide inserts
- Ceramic inserts with holes
- Ceramic inserts without holes
- Different insert thicknesses

For further information see page A114.

Build-in tools

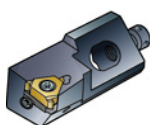
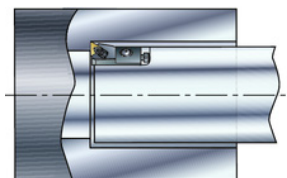
Cartridges according to ISO for different insert styles are available for both external and internal operations.

Adjustment accuracy, both radial and axial is ± 0.05 mm ($\pm .002$ inch)

- CoroTurn® RC for negative basic-shape inserts
- CoroTurn® 107 for positive basic-shape inserts

Round shank boring tools for boring individual workpieces or production in series involving only a few machining operations using:

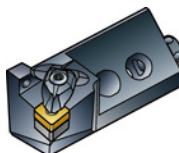
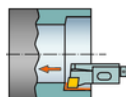

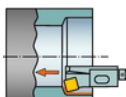

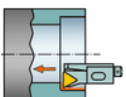

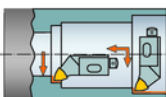

- CoroTurn® 107 for positive basic-shape inserts

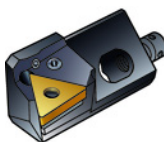
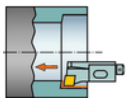

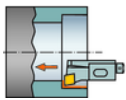

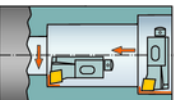

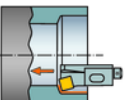

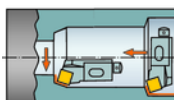

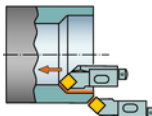



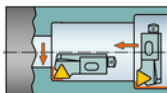

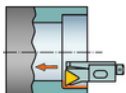

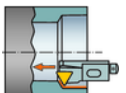

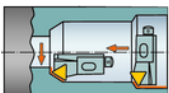

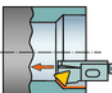

Further option


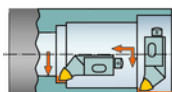

Cartridges for threading and circlip grooving with CoroThread 266, see page C45

Cartridges for negative basic-shape inserts

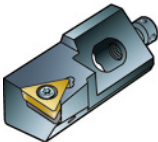
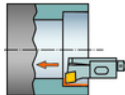

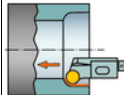

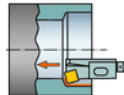

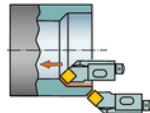

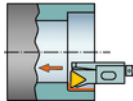
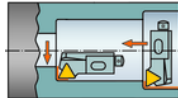
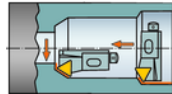
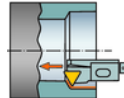
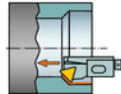





CoroTurn® RC rigid clamp design		Entering angle (Lead angle)			
		$\kappa_r 95^\circ (-5^\circ)$   DCLNR/L 12-16 (1/2-5/8) 25 (.984)	$\kappa_r 75^\circ (15^\circ)$   DSKNR/L 12 (1/2) 25 (.984)	$\kappa_r 90^\circ (0^\circ)$   DTFNR/L 16 (13/8) 16 (.630)	$\kappa_r 95^\circ (-5^\circ)$   DWLNRL 08 (1/2) 20 (.787)
Insert size, mm (iC, inch) Cutting edge height, mm, (inch)		A354	A354	A355	A355
Page					

T-Max® P lever design		Entering angle (Lead angle)					
		$\kappa_r 95^\circ (-5^\circ)$   PCLNR/L 12-19 (1/2-3/4) 16-25 (.630-.984)	$\kappa_r 90^\circ (0^\circ)$   PCFNR/L 12 (1/2) 16 (.630)	$\kappa_r 90^\circ (0^\circ)$   PCGNR/L 12 (1/2) 16 (.630)	$\kappa_r 75^\circ (15^\circ)$   PSKNR/L 12-15 (1/2-5/8) 12-20 (.472-.787)	$\kappa_r 75^\circ (15^\circ)$   PSRNR/L 12-15 (1/2-5/8) 16-20 (.630-.787)	$\kappa_r 45^\circ (45^\circ)$   PSSNR/L 12-15 (1/2-5/8) 12-20 (.472-.787)
Insert size, mm (iC, inch) Cutting edge height, mm, (inch)		A356	A356	A356	A357	A357	A357
Page							

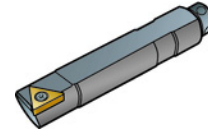
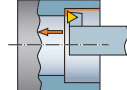
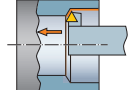
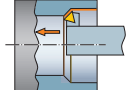



		Entering angle (Lead angle)				
		$\kappa_r 90^\circ (0^\circ)$   PTGNR/L 16-22 (3/8-1/2) 12-20 (.472-.787)	$\kappa_r 90^\circ (0^\circ)$   PTFNR/L 16-22 (3/8-1/2) 12-20 (.472-.787)	$\kappa_r 60^\circ (30^\circ)$   PTWNR/L 16 (3/8) 12 (.472)	$\kappa_r 60^\circ (30^\circ)$   PTTNR/L 16 (3/8) 12 (.472)	$\kappa_r 45^\circ (45^\circ)$   PTSNR/L 16 3/8 12-16 (.472-.630)
Insert size, mm (iC, inch) Cutting edge height, mm, (inch)		A358	A358	A358	A358	A358
Page						

T-Max P wedge clamp design		Entering angle (Lead angle)			
		$\kappa_r 95^\circ (-5^\circ)$   MWLNRL 06-08 (3/8-1/2) 16-25 (.630-.984)			
Insert size, mm (iC, inch) Cutting edge height, mm, (inch)		A359			
Page					

Cartridges for positive basic-shape inserts

CoroTurn® 107 screw clamp design 	Entering angle (Lead angle)					
	$\kappa_r 90^\circ (0^\circ)$   SCFCR/L	-   SRSCR/L	$\kappa_r 75^\circ (15^\circ)$   SSKCR/L	$\kappa_r 45^\circ (45^\circ)$   SSSCR/L		
	Insert size, mm (iC, inch) Cutting edge height, mm, (inch)	06-09 (1/4-3/8) 8-12 (.315-.472)	06-10 (.236-.394) 6-10 (.236-.394)	09-12 (3/8-1/2) 10-16 (.394-.630)	09-12 (3/8-1/2) 10-12 (.394-.472)	
	Page	A362	A362	A363	A363	
	Entering angle (Lead angle)					
	$\kappa_r 90^\circ (0^\circ)$ 	$\kappa_r 90^\circ (0^\circ)$ 	$\kappa_r 60^\circ (30^\circ)$ 	$\kappa_r 60^\circ (30^\circ)$ 	$\kappa_r 45^\circ (45^\circ)$ 	
	 STFCR/L	 STGCR/L	 STTCR/L	 STWCR/L	 STSCR/L	
	Insert size, mm (iC, inch) Cutting edge height, mm, (inch)	06-16 (5/32-3/8) 6-16 (.236-.630)	06-16 (5/32-3/8) 6-16 (.236-.630)	06-16 (5/32-3/8) 6-12 (.236-.472)	06-16 (5/32-3/8) 6-16 (.236-.630)	
	Page	A364	A364	A365	A364	A365

Round shank boring tools for positive basic-shape inserts

CoroTurn® 107 screw clamp design 	Entering angle (Lead angle)		
	$\kappa_r 90^\circ (0^\circ)$	$\kappa_r 60^\circ (30^\circ)$	$\kappa_r 45^\circ (45^\circ)$
			
			
Insert size, mm (iC, inch) Cutting edge height, mm, (inch) Page	R/L 141.0	R/L 140.0	R/L 142.0
	06-16 (5/32-3/8)	06-16 (5/32-3/8)	06-16 (5/32-3/8)
	7-17 (.276-.699)	7-17 (.276-.699)	7-17 (.276-.699)
	A370	A370	A370

Code key for cartridges

D	C	L	N	R	25	C	A	-	12
1	2	3	4	5	6	7	8	9	10

1 Clamping system		2 Insert shape		3 Cartridge style, entering angle (lead angle)		
D Top and hole clamping (RC)		C	T	F 90° (0°)	G 90° (0°)	K 75° (15°)
P Hole clamping		R	W	L 95° (-5°)	R 75° (15°)	S 45° (45°)
S Screw clamping		S		T 60° (30°)	W 60° (30°)	
M Top and hole clamping						

4 Clearance angle on major cutting edge		5 Hand of tool		6 Cutting edge height, h_1 mm
C	N	R		
		L		

7 Type of tool		8 Type of design
C = cartridge		A = letter for alternative designs according to ISO 5611.

9 Tool length		10 Cutting edge length, l mm
The dash means tool length according to ISO 5611.		

Cartridges

CoroTurn® RC rigid clamp

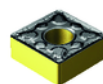
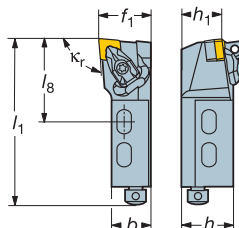
Entering angle:

DCLNR/L $\kappa_r 95^\circ$

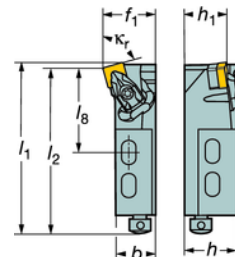
Lead angle:

 -5° **DSKNR/L** $\kappa_r 75^\circ$ 15° 

CNMM, CNGP
 CNMG
 CNMA, CNGA


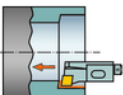



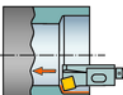
SNMM
 SNMG
 SNMA, SNGA



For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch										Gauge insert		
				b	D_{m1}^{min}	f_1	h	h_1	l_1	l_8	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾	
	12	1/2	DCLNR/L 25CA-12	25	100	32	38	25	100	50	-8°	-8°	CNMG 12 04 08	CNMG 432	3.9	
				.984	3.937	1.260	1.496	.984	3.937	1.968						
			DCLNR/L 25CA-16	25	100	32	38	25	100	50	-8°	-8°	CNMG 16 06 12	CNMG 543	6.4	
				.984	3.937	1.260	1.496	.984	3.937	1.968						

Main application		iC	Ordering code	Dimensions, mm, inch										Gauge insert		
				b	D_{m1}^{min}	f_1	h	h_1	l_1	l_2	l_8	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾
	12	1/2	DSKNR/L 25CA-12	25	100	32	38	25	100	96.9	50	-6°	-6°	SNMG 12 04 08	SNMG 432	3.9
				.984	3.937	1.260	1.496	.984	3.937	3.815	1.968					

1) γ = Rake angle.2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

Mounting dimensions, see page A360

Dimensions on master insert with r_e . For other nose radii, see page A368.

Main spare parts

Insert size								
	iC		iC	Shim	Shim screw	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
12	1/2			5322 234-01	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-02 (15IP)
16	5/8			5322 234-03	5513 020-07	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
		12	1/2	5322 425-01	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.

A9



A493



A2

Cartridges

CoroTurn® RC rigid clamp

Entering angle:

DTFNR/L $\kappa_r 90^\circ$

Lead angle:

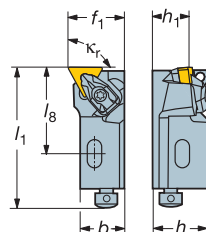
0°

DWLNR/L $\kappa_r 95^\circ$

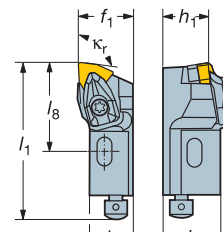
-5°



TNMM, TNMX
TNMG
TNMA, TNGA

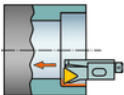



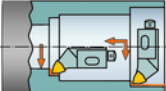

WNMM,
WNMG
WNGA, WNMA



For Dm-dimensions, see mounting dimensions.

Right hand style shown

<div>Main application</div> 		iC	Ordering code	Dimensions, mm, inch										Gauge insert		
				b	D_{m1} min	f_1	h	h_1	l_1	l_8	$\gamma^{(1)}$	$\lambda_s^{(2)}$	ISO	ANSI	Nm ⁽³⁾	
				20	55	25	25	16	63	39	-6°	-8°	TNMG 16 04 08	TNMG 332	1.7	
				.787	2.165	.984	.984	.630	2.480	1.535						

<div>Main application</div> 		iC	Ordering code	Dimensions, mm, inch										Gauge insert		
				b	D_{m1} min	D_{m2} min	f_1	h	h_1	l_1	l_8	$\gamma^{(1)}$	$\lambda_s^{(2)}$	ISO	ANSI	Nm ⁽³⁾
				20	70	90	25	25	20	70	40	-8°	-10°	WNMG 08 04 08	WNMG 432	3.9
				.787	2.756	3.543	.984	.984	.787	2.756	1.575					

1) γ = Rake angle.2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

Mounting dimensions, see page A360

R = Right hand, L = Left hand

Dimensions on master insert with r_e . For other nose radii, see page A368.

Main spare parts

Insert size								
	iC		iC	Shim	Shim screw	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
16	3/8			5322 316-01	5513 020-04	5680 051-03 (09IP)	5412 028-011	5680 051-03 (09IP)
		08	1/2	5322 331-12	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)

¹⁾To modify CoroTurn® RC holders for other inserts, see clamp sets on page A439.

Cartridges

T-Max® P lever design

Entering angle:

PCLNR/L
 $\kappa_r 95^\circ$

PCFNR/L
 $\kappa_r 90^\circ$

PCGNR/L
 $\kappa_r 90^\circ$

Lead angle:

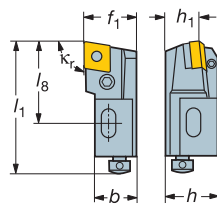
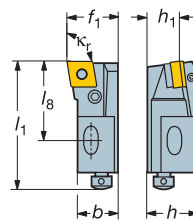
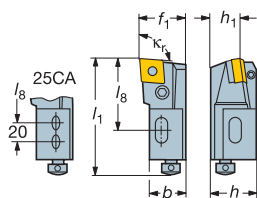
-5°

0°

0°


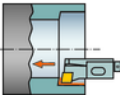

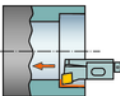

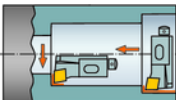



CNMM, CNGP
 CNMG
 CNMA, CNGA



For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch										Gauge insert		
				b	D _{m1} min	D _{m2} min	f ₁	h	h ₁	l ₁	l ₈	γ ⁽¹⁾	λ _s ⁽²⁾	ISO	ANSI	
		12	1/2	PCLNR/L 16CA-12	20	55		25	25	16	63	39	-8°	-8°	CNMG 12 04 08	CNMG 432
					.787	2.165		.984	.984	.630	2.480	1.535				
		19	3/4	PCLNR/L 25CA-19	25	100		32	38	25	100	50	-8°	-8°	CNMG 19 06 12	CNMG 643
					.984	3.937		1.260	1.496	.984	3.937	1.968				
		12	1/2	PCFNR/L 16CA-12	20	55		25	25	16	63	39	-6°	-8°	CNMG 12 04 08	CNMG 432
					.787	2.165		.984	.984	.630	2.480	1.535				
		12	1/2	PCGNR/L 16CA-12	20	60	75	25	25	16	63	39	-10°	-6°	CNMG 12 04 08	CNMG 432
					.787	2.362	2.953	.984	.984	.630	2.480	1.535				

¹⁾ γ = Rake angle.

²⁾ λ_s = Angle of inclination.

R = Right hand, L = Left hand

Mounting dimensions, see page A360

Dimensions on master insert with r_e . For other nose radii, see page A368.

Main spare parts

Insert size					
	iC	Lever	Screw	Key (mm)	Shim
12	1/2	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M
19	3/4	174.3-849M	174.3-835	3021 010-040 (4.0)	171.31-851M



A9



A494



A2

Cartridges

T-Max® P lever design

Entering angle:

PSKNR/L

 $\kappa_r 75^\circ$

PSRNR/L

 $\kappa_r 75^\circ$

PSSNR/L

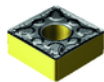
 $\kappa_r 45^\circ$

Lead angle:

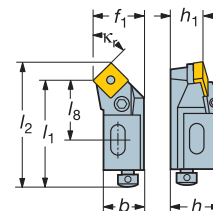
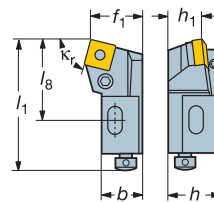
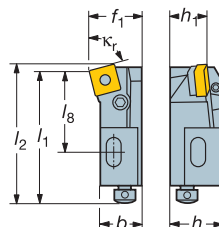
15°

15°

45°


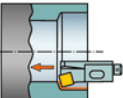

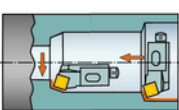

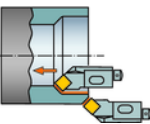

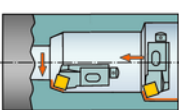



SNMM
 SNMG
 SNMA, SNGA



For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch												Gauge insert	
				b	D _{m1} min	D _{m2} min	f ₁	h	h ₁	l ₁	l ₂	l ₈	γ ¹	λ _s ²⁾	ISO	ANSI	
		12	1/2 PSKNR/L 12CA-12	15	50		20	20	12	55	58	35	-6°	-8°	SNMG 12 04 08	SNMG 432	
				.591 1.968		.787 .787 .472 2.165 2.284 1.378											
			PSKNR/L 16CA-12	20	55		25	25	16	63	66	39	-6°	-7°	SNMG 12 04 08	SNMG 432	
			.787 2.165		.984 .984 .630 2.480 2.598 1.535												
		15	5/8 PSKNR/L 20CA-15	20	70		25	30	20	70	73.7	40	-6°	-8°	SNMG 15 06 12	SNMG 543	
				.787 2.756		.984 1.181 .787 2.756 2.902 1.575											
		12	1/2 PSRNR/L 16CA-12	20	60	75	25	25	16	63		39	-10°	-6°	SNMG 12 04 08	SNMG 432	
				.787 2.362 2.953 .984 .984 .630 2.480 1.535													
		15	5/8 PSRNR/L 20CA-15	20	70	90	25	30	20	70		40	-10°	-6°	SNMG 15 06 12	SNMG 543	
				.787 2.756 3.543 .984 1.181 .787 2.756 1.575													
		12	1/2 PSSNR/L 12CA-12	15	50		20	20	12	47	55.3	27	-10°	-3°	SNMG 12 04 08	SNMG 432	
				.591 1.968		.787 .787 .472 1.850 2.177 1.063											
			PSSNR/L 16CA-12	20	55		25	25	16	53	61.3	29	-11°	0°	SNMG 12 04 08	SNMG 432	
			.787 2.165		.984 .984 .630 2.087 2.413 1.142												
		15	5/8 PSSNR/L 20CA-15	20	70		25	30	20	60	70.3	30	-10°	-3°	SNMG 15 06 12	SNMG 543	
				.787 2.756		.984 1.181 .787 2.362 2.768 1.181											

1) γ = Rake angle.2) λ_s = Angle of inclination.

Mounting dimensions, see page A360

R = Right hand, L = Left hand

Dimensions on master insert with r_6 . For other nose radii, see page A368.

Main spare parts

Insert size							
	iC	h ₁ mm	inch	Lever	Screw	Key (mm)	Shim
12	1/2	12	.472	438.3-841-1	438.3-832M	174.1-863 (2.5)	-
12	1/2	16	.630	174.3-848M	174.3-858	174.1-864 (3.0)	174.3-851M
15	5/8	20	.787	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857



A9



A494







A2

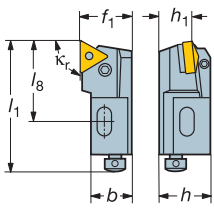
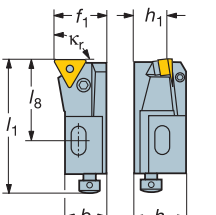
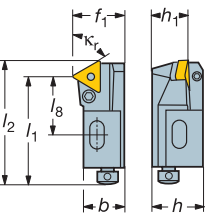
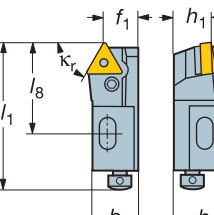
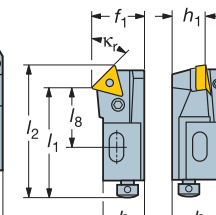
Cartridges

T-Max® P lever design

Entering angle:	PTG NR/L $\kappa_r 90^\circ$	PTF NR/L $\kappa_r 90^\circ$	PTW NR/L $\kappa_r 60^\circ$	PTT NR/L $\kappa_r 60^\circ$	PTS NR/L $\kappa_r 45^\circ$
Lead angle:	0°	0°	30°	30°	45°


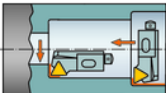



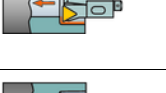

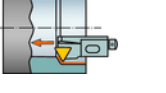

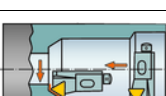



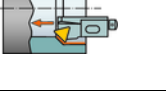

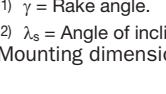



 TNMM, TNMX
 TNMG
 TNMA, TNGA

For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		i/C	Ordering code	Dimensions, mm, inch											Gauge insert	
				b	D _{m1} min	D _{m2} min	f ₁	h	h ₁	l ₁	l ₂	l ₈	γ ¹⁾	λ _s ²⁾	ISO	ANSI
		16 3/8	PTG NR/L 12CA-16	15	50	75	20	20	12	55		35	-10°	-6°	TNMG 16 04 08	TNMG 332
				.591	1.968	2.953	.787	.787	.472	2.165		1.378				
			PTG NR/L 16CA-16	20	60	75	25	25	16	63		39	-10°	-6°	TNMG 16 04 08	TNMG 332
		22 1/2	PTG NR/L 20CA-22	20	70	90	25	30	20	70		40	-8°	-6°	TNMG 22 04 08	TNMG 432
				.787	2.756	3.543	.984	1.181	.787	2.756		1.575				
				.787	2.362	2.953	.984	.984	.630	2.480		1.535				
		16 3/8	PTF NR/L 12CA-16	15	50		20	20	12	55		35	-6°	-9°	TNMG 16 04 08	TNMG 332
				.591	1.968		.787	.787	.472	2.165		1.378				
			PTF NR/L 16CA-16	20	55		25	25	16	63		39	-6°	-8°	TNMG 16 04 08	TNMG 332
		22 1/2	PTF NR/L 20CA-22	20	70		25	30	20	70		40	-6°	-8°	TNMG 22 04 08	TNMG 432
				.787	2.756		.984	1.181	.787	2.756		1.575				
				.787	2.165		.984	.984	.630	2.480		1.535				
		16 3/8	PTW NR/L 12CA-16	15	50		20	20	12	47	54.2	27	-6°	-7°	TNMG 16 04 08	TNMG 332
				.591	1.968		.787	.787	.472	1.850	2.134	1.063				
		16 3/8	PTT NR/L 12CA-16	15	50	75	13	20	12	55		35	-9°	-2°	TNMG 16 04 08	TNMG 332
				.591	1.968	2.953	.512	.787	.472	2.165		1.378				
		16 3/8	PTS NR/L 12CA-16	15	50		20	20	12	47	57.2	27	-10°	-3°	TNMG 16 04 08	TNMG 332
				.591	1.968		.787	.787	.472	1.850	2.252	1.063				
			PTS NR/L 16CA-16	20	55		25	25	16	53	63.2	29	-11°	0°	TNMG 16 04 08	TNMG 332
		22 1/2		.787	2.165		.984	.984	.630	2.087	2.488	1.142				

1) γ = Rake angle.2) λ_s = Angle of inclination.

Mounting dimensions, see page A360

R = Right hand, L = Left hand

Dimensions on master insert with r_e . For other nose radii, see page A368.

Main spare parts

Insert size							
	i/C	h ₁ mm	inch	Lever	Screw	Key (mm)	Shim
16	3/8	12	.472	5432 015-011	438.3-830	174.1-870 (1.98)	-
16	3/8	16	.630	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M
22	1/2	20	.787	174.3-841M	174.3-821	174.1-864 (3.0)	179.3-852M



Cartridges

T-Max P wedge clamp design

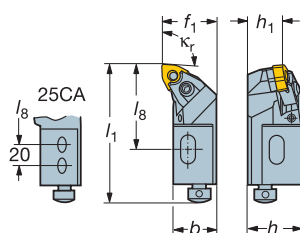


WNMM,
WNMG
WNGA, WNMA

Entering angle:
Lead angle:

MWLNRL

$\kappa_r 95^\circ$
 -5°



For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch										Gauge insert	
				b	D_{m1} min	D_{m2} min	f_1	h	h_1	l_1	l_8	$\gamma^{(1)}$	$\lambda_s^{(2)}$	ISO	ANSI
	06	3/8	MWLNRL 16CA-06	20	55	75	25	25	16	63	39	-8°	-10°	WNMG 06 04 08	WNMG 332
				.787	2.165	2.953	.984	.984	.630	2.480	1.535				
	08	1/2	MWLNRL 25CA-08	25	100	115	32	38	25	100	50	-8°	-10°	WNMG 08 04 08	WNMG 432
				.984	3.937	4.528	1.260	1.496	.984	3.937	1.968				

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

R = Right hand, L = Left hand

Mounting dimensions, see page A360

Dimensions on master insert with r_6 . For other nose radii, see page A368.

Main spare parts

Insert size				
	iC	Wedge clamp set	Key (mm)	Shim
06	3/8	5431 125-011	170.3-860 (2.5)	5322 331-06
08	1/2	5431 125-021	174.1-864 (3.0)	5322 331-09



A9



A494



A2

Mounting dimensions for CoroTurn® RC and T-MAX P cartridges

Metric dimensions

Calculation of D_{1a} , D_{α} and D_{1b} dimensions

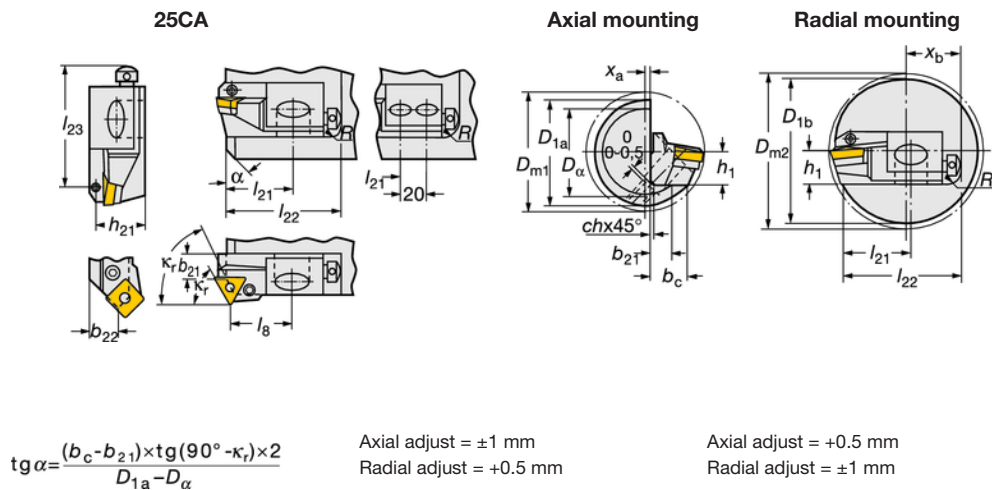
$$D_{1a\max} = 2\sqrt{h_1^2 + (b_{c\max} + (-)x_a)^2}$$

$$D_{\alpha\max} = 2\sqrt{h_1^2 + (b_{21\max} + (-)x)^2}$$

$$x_a = \frac{D_{m1}}{2} - f_1$$

$$D_{1b\max} = 2\sqrt{h_1^2 + (l_{22} - l(+))x_b)^2}$$

$$x_b = l_1 - \frac{D_{m2}}{2}$$



Cartridge size	Cartridge code	Dimensions, mm													
		Entering angle κ_r	b_c	$b_{21\max}$	b_{22}	h_1	h_{21}	l_8	l_{21}	l_{22}	l_{23}	$D_{m1\min}$	$D_{m2\min}$	R_{\max}	ch_{\max}
12CA 	PTFNR/L 12CA-16	90°	14.00	—	—	12.00	16.00	35.00	33.00	53.00	49.00	50.00	—	5.00	0.40
	PTWNR/L 12CA-16	60°	14.00	3.50	—	12.00	16.00	27.00	30.50	50.50	46.00	50.00	—	5.00	0.40
	PTSNR/L 12CA-16	45°	14.00	6.50	—	12.00	16.00	27.00	33.50	53.50	49.00	50.00	—	5.00	0.40
	PTTNR/L 12CA-16	60°	14.00	10.50	—	12.00	16.00	35.00	30.50	50.50	49.00	50.00	75.00	5.00	0.40
	PTGNR/L 12CA-16	90°	14.00	—	—	12.00	16.00	35.00	30.50	50.50	45.00	50.00	75.00	5.00	0.40
	PSKNR/L 12CA-12	75°	14.00	1.00	—	12.00	16.00	35.00	36.50	56.50	52.00	50.00	—	5.00	0.40
	PSSNR/L 12CA-12	45°	14.00	—	9.00	12.00	16.00	27.00	32.00	52.00	40.50	50.00	—	5.00	0.40
16CA 	DTFNR/L 16CA-16	90°	18.50	—	—	16.00	21.50	39.00	37.50	61.00	58.00	55.00	—	6.00	0.40
	PTFNR/L 16CA-16	90°	17.50	—	—	16.00	21.50	38.00	35.00	60.00	54.00	55.00	—	6.00	0.40
	PTSNR/L 16CA-16	45°	17.00	11.50	—	16.00	20.50	28.00	32.50	57.50	54.00	55.00	—	6.00	0.40
	PTGNR/L 16CA-16	90°	18.50	—	—	16.00	20.50	38.00	32.00	57.00	52.00	60.00	75.00	6.00	0.40
	PSKNR/L 16CA-12	75°	17.50	6.00	—	16.00	20.50	38.00	38.50	63.50	55.00	55.00	—	6.00	0.40
	PSSNR/L 16CA-12	45°	17.00	—	13.30	16.00	20.50	28.00	31.50	56.50	41.00	55.00	75.00	6.00	0.40
	PSRNR/L 16CA-12	75°	19.00	—	—	16.00	20.50	38.00	27.50	52.50	51.00	60.00	75.00	6.00	0.40
	PCLNR/L 16CA-12	95°	17.50	—	—	16.00	20.50	38.00	32.00	57.00	54.00	55.00	75.00	6.00	0.40
	PCFNR/L 16CA-12	90°	17.50	—	—	16.00	20.50	38.00	34.00	59.00	55.00	55.00	—	6.00	0.40
	PCGNR/L 16CA-12	90°	18.50	—	—	16.00	20.50	38.00	30.50	55.50	52.00	60.00	75.00	6.00	0.40
	MWLNR/L 16CA-06	95°	17.80	—	—	16.00	20.00	39.00	33.40	57.40	38.50	55.00	75.00	6.00	0.40
20CA 	DWLNR/L 20CA-08	95°	18.50	—	—	20.00	27.00	40.00	35.00	65.00	58.00	70.00	90.00	6.00	0.40
	PTFNR/L 20CA-22	90°	15.50	—	—	—	27.00	40.00	37.00	67.00	61.00	70.00	—	—	0.40
	PTSNR/L 20CA-22	45°	15.50	6.90	—	20.00	25.00	30.00	37.00	67.00	62.00	70.00	—	6.00	0.40
	PTGNR/L 20CA-22	90°	16.00	—	—	—	25.00	40.00	32.50	62.50	56.70	70.00	90.00	—	0.40
	PSKNR/L 20CA-15	75°	16.50	1.30	—	—	25.00	40.00	41.00	71.00	67.00	70.00	—	—	0.40
	PSSNR/L 20CA-15	45°	15.50	—	10.20	20.00	25.00	30.00	35.00	65.00	52.00	70.00	—	6.00	0.40
	PSRNR/L 20CA-15	75°	18.00	—	—	—	25.00	40.00	33.00	63.00	60.00	70.00	90.00	—	0.40
25CA 	DCLNR/L 25 CA-12	95°	24.30	—	—	25.00	33.00	50.00	43.60	93.50	93.50	100.00	115.00	8.00	0.70
	DCLNR/L 25 CA-16	95°	24.30	—	—	25.00	33.00	50.00	43.60	93.50	93.50	100.00	115.00	8.00	0.70
	DSKNR/L 25CA-12	95°	24.30	—	—	25.00	33.00	50.00	51.60	101.60	96.50	100.00	—	8.00	0.70
	PCLNR/L 25CA-19	95°	22.50	—	—	25.00	32.00	50.00	41.50	91.50	88.00	100.00	115.00	8.00	0.70
	MWLNR/L 25CA-08	95°	23.30	—	—	25.00	30.00	50.00	42.30	92.30	68.00	100.00	115.00	8.00	0.70

Mounting dimensions for CoroTurn® RC and T-MAX P cartridges

Inch dimensions

Calculation of D_{1a} , D_α and D_{1b} dimensions

$$D_{1a\max} = 2\sqrt{h_1^2 + (b_{c\max} + (-)x_a)^2}$$

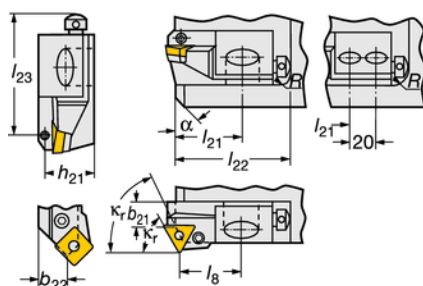
$$D_{\alpha\max} = 2\sqrt{h_1^2 + (b_{21\max} + (-)x)^2}$$

$$x_a = \frac{D_{m1}}{2} - f_1$$

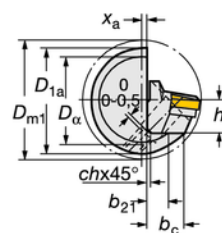
$$D_{1b\max} = 2\sqrt{h_1^2 + (l_{22} - l(+))x_b)^2}$$

$$x_b = l_1 - \frac{D_{m2}}{2}$$

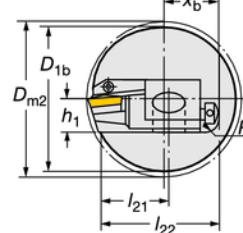
25CA



Axial mounting



Radial mounting



$$\tan \alpha = \frac{(b_c - b_{21}) \times \tan(90^\circ - \kappa_r) \times 2}{D_{1a} - D_\alpha}$$

Axial adjust = ± .039 inch
Radial adjust = + .020 inch

Axial adjust = + .020 inch
Radial adjust = ± .039 inch

Cartridge size	Cartridge code	Dimensions, inch														
		Lead angle	κ_r	b_c	$b_{21\max}$	b_{22}	h_1	h_{21}	l_8	l_{21}	l_{22}	l_{23}	$D_{m1\min}$	$D_{m2\min}$	R_{\max}	ch_{\max}
12CA	PTFNR/L 12CA-16	0°	90°	.551	—	—	.472	.630	1.378	1.299	2.087	1.929	1.969	—	.197	.016
	PTWNR/L 12CA-16	30°	60°	.551	.138	—	.472	.630	1.063	1.201	1.988	1.811	1.969	—	.197	.016
	PTSNR/L 12CA-16	45°	45°	.551	.256	—	.472	.630	1.063	1.319	2.106	1.929	1.969	—	.197	.016
	PTTNR/L 12CA-16	30°	60°	.551	.413	—	.472	.630	1.378	1.201	1.988	1.929	1.969	2.953	.197	.016
	PTGNR/L 12CA-16	0°	90°	.551	—	—	.472	.630	1.378	1.201	1.988	1.772	1.969	2.953	.197	.016
	PSKNR/L 12CA-12	15°	75°	.551	.039	—	.472	.630	1.378	1.437	2.224	2.047	1.969	—	.197	.016
16CA	PSSNR/L 12CA-12	45°	45°	.551	—	.354	.472	.630	1.063	1.260	2.047	1.594	1.969	—	.197	.016
	DTFNR/L 16CA-16	0°	90°	.728	—	—	.630	.846	1.535	1.476	2.402	2.283	2.165	—	.236	.016
	PTFNR/L 16CA-16	0°	90°	.689	—	—	.630	.807	1.496	1.378	2.362	2.126	2.165	—	.236	.016
	PTSNR/L 16CA-16	45°	45°	.669	.453	—	.630	.807	1.102	1.280	2.264	2.126	2.165	—	.236	.016
	PTGNR/L 16CA-16	0°	90°	.728	—	—	.630	.807	1.496	1.260	2.244	2.047	2.362	2.953	.236	.016
	PSKNR/L 16CA-12	15°	75°	.689	.236	—	.630	.807	1.496	1.516	2.500	2.165	2.165	—	.236	.016
	PSSNR/L 16CA-12	45°	45°	.669	—	.524	.630	.807	1.102	1.240	2.244	1.614	2.165	2.953	.236	.016
	PSRNR/L 16CA-12	15°	75°	.748	—	—	.630	.807	1.496	1.083	2.067	2.008	2.362	2.953	.236	.016
	PCLNR/L 16CA-12	-5°	95°	.689	—	—	.630	.807	1.496	1.260	2.244	2.126	2.165	2.953	.236	.016
	PCFNR/L 16CA-12	0°	90°	.689	—	—	.630	.807	1.496	1.339	2.323	2.165	2.165	—	.236	.016
20CA	PCGNR/L 16CA-12	0°	90°	.728	—	—	.630	.807	1.496	1.201	2.185	2.047	2.362	2.953	.236	.016
	MWLNR/L 16CA-06	-5°	95°	.701	—	—	.630	.787	1.535	1.315	2.260	1.516	2.165	2.953	.236	.016
	DWLNR/L 20CA-08	-5°	95°	.728	—	—	.787	1.063	1.575	1.378	2.559	2.283	2.756	3.543	.236	.016
	PTFNR/L 20CA-22	0°	90°	.610	—	—	.787	.984	1.575	1.457	2.638	2.402	2.756	—	.236	.016
	PTSNR/L 20CA-22	45°	45°	.610	.272	—	.787	.984	1.181	1.457	2.638	2.441	2.756	—	.236	.016
	PTGNR/L 20CA-22	0°	90°	.630	—	—	.787	.984	1.575	1.280	2.461	2.232	2.756	3.543	.236	.016
25CA	PSKNR/L 20CA-15	15°	75°	.650	.051	—	.787	.984	1.575	1.614	2.795	2.638	2.756	—	.236	.016
	PSSNR/L 20CA-15	45°	45°	.610	—	.402	.787	.984	1.181	1.378	2.559	2.047	2.756	—	.236	.016
	PSRNR/L 20CA-15	15°	75°	.709	—	—	.787	.984	1.575	1.299	2.480	2.362	2.756	3.543	.236	.016
	DCLNR/L 25 CA-12	-5°	95°	.957	—	—	.984	1.299	1.969	1.716	3.681	3.681	3.937	4.528	.315	.028
	DCLNR/L 25 CA-16	-5°	95°	.957	—	—	.984	1.299	1.969	1.716	3.681	3.681	3.937	4.528	.315	.028
	DSKNR/L 25CA-12	-5°	95°	.957	—	—	.984	1.181	1.969	2.031	4.000	3.799	3.937	—	.315	.028
	PCLNR/L 25CA-19	-5°	95°	.886	—	—	.984	1.260	1.969	1.634	3.602	3.465	3.937	4.528	.315	.028
	MWLNR/L 25CA-08	-5°	95°	.917	—	—	.984	1.181	1.969	1.665	3.634	2.677	3.937	4.528	.315	.028

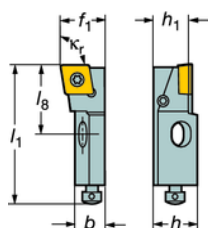
Cartridges

CoroTurn® 107 screw clamp design

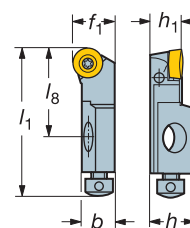
Entering angle:
Lead angle:

SCFCR/L

κ_r 90°
0°


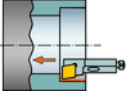



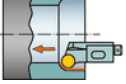
SRSCR/L



For D_m-dimensions, see mounting dimensions.

Right hand style shown

				Dimensions, mm, inch										Gauge insert		
Main application		iC	Ordering code	b	D _{m1} min	f ₁	h	h ₁	l ₁	l ₈	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾	
	06	1/4	SCFCR/L 08CA-06	8	25	10	10	8	32	15	0°	-6°	CCMT 06 02 04	CCMT 2(1.5)1	0.9	
				.315	.984	.394	.394	.315	1.260	.591						
	09	3/8	SCFCR/L 10CA-09	11	40	14	15	10	50	30	0°	-3°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				.433	1.575	.551	.591	.394	1.968	1.181						
			SCFCR/L 12CA-09	15	50	20	20	12	55	35	0°	-3°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0	
				.591	1.968	.787	.787	.472	2.165	1.378						

				Dimensions, mm, inch										Gauge insert		
Main application		iC	Ordering code	b	D _{m1} min	f ₁	h	h ₁	l ₁	l ₈	γ ¹⁾	λ _s ²⁾	ISO	ANSI	Nm ³⁾	
	06	.236	SRSCR/L 06CA-06	6.1	20	8	8.5	6	25	13	0°	-5°	RCMT 06 02 M0	RCMT 06 02 M0	0.9	
				.240	.787	.315	.335	.236	.984	.512	0°	-5°				
	08	.315	SRSCR/L 08CA-08	7	25	10	10	8	32	26	0°	-5°	RCMT 08 03 M0	RCMT 08 03 M0	1.4	
				.276	.984	.394	.394	.315	1.260	1.024	0°	-5°				
			SRSCR/L 10CA-10	11.3	40	14	14.9	10	50	30	0°	-5°	RCMT 10 T3 M0	RCMT 10 T3 M0	3.0	
				.445	1.575	.551	.587	.394	1.968	1.181	0°	-5°				

1) γ = Rake angle.

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

Mounting dimensions, see page A366

R = Right hand, L = Left hand

Dimensions on master insert with r_e. For other nose radii, see page A368.

Main spare parts

Insert size									
	iC	h ₁			iC	Insert screw	Shim	Shim screw	Key (Torx Plus)
06	1/4	8	.315			5513 020-03			5680 051-02 (7IP)
09	3/8	10	.394			5513 020-09			5680 049-01 (15IP)
09	3/8	12	.472			5513 020-09			5680 049-01 (15IP)
				06	.236	5513 020-03	-	-	5680 051-02 (7IP)
				08	.315	5513 020-04	-	-	5680 051-03 (9IP)
				10	.394	5513 020-09	5322 110-01	5512 090-01	5680 049-01 (15IP)



A9



A496



A2

Cartridges

CoroTurn® 107 screw clamp design

Entering angle:

SSKCR/L $\kappa_r 75^\circ$

Lead angle:

15°

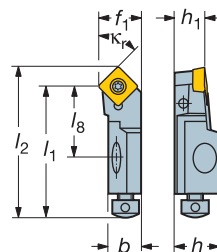
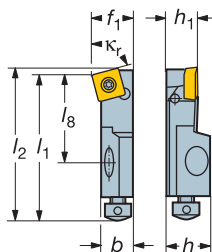
SSSCR/L $\kappa_r 45^\circ$

45°



SCMT, SCGX

SCMW



For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		iC	Ordering code	Dimensions, mm, inch										Gauge insert		
				b	D_{m1} min	f_1	h	h_1	l_1	l_2	l_8	γ^1	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾
	09	3/8	SSKCR/L 10CA-09-M	11	40	14	15	10	50	52.2	30	0°	-4°	SCMT 09 T3 08	SCMT 3(2.5)2	3.0
				.433	1.575	.551	.591	.394	1.968	2.055	1.181					
	12	1/2	SSKCR/L 12CA-12	15	50	20	20	12	55	58.1	35	0°	-4°	SCMT 12 04 08	SCMT 432	3.9
				.591	1.968	.787	.787	.472	2.165	2.287	1.378					
			SSKCR/L 16CA-12	20	55	25	21	16	63	66.1	38	0°	-7°	SCMT 12 04 08	SCMT 432	3.9
				.787	2.165	.984	.827	.630	2.480	2.602	1.496					
	09	3/8	SSSCR/L 10CA-09-M	11	40	14	15	10	44	50.1	24.5	-5°	0°	SCMT 09 T3 08	SCMT 3(2.5)2	3.0
				.433	1.575	.551	.591	.394	1.732	1.972	.965					
	12	1/2	SSSCR/L 12CA-12	15	50	20	20	12	47	55.3	27	-5°	0°	SCMT 12 04 08	SCMT 432	3.9
				.591	1.968	.787	.787	.472	1.850	2.177	1.063					

1) γ = Rake angle.2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

Mounting dimensions, see page A366

R = Right hand, L = Left hand

Dimensions on master insert with r_c . For other nose radii, see page A368.

Main spare parts

Insert size					
	iC	Insert screw	Shim	Shim screw	Key (Torx Plus)
09	3/8	5513 020-09	-	-	55680 049-01 (15IP)
12	1/2	5513 020-17	-	-	5680 049-02 (15IP)
12 ¹⁾	1/2 ¹⁾	5513 020-18	5322 420-02	5512 090-03	5680 049-02 (15IP)

1) Only for SSKCR/L



A9



A496



A2

Cartridges

CoroTurn® 107 screw clamp design

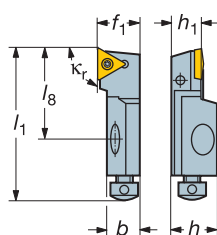


TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

Entering angle:
Lead angle:

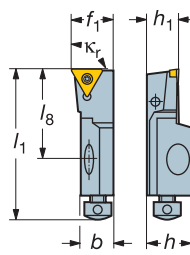
STGCR/L

κ_r 90°
0°



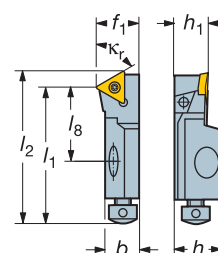
STFCR/L

κ_r 90°
0°




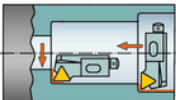
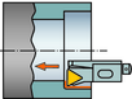
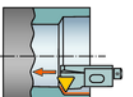
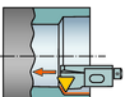
STWCR/L

κ_r 30°
60°



For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		iC	Ordering code ⁴⁾	Dimensions, mm, inch												Gauge insert		Nm ³⁾
				b	D _{m1} min	D _{m2} min	f ₁	h	h ₁	l ₁	l ₂	l ₈	γ ¹⁾	λ _s ²⁾	ISO	ANSI		
	06	5/32	STGCR/L 06CA-06	6	20	30	8	8.5	6	25		13	-10°	0°	TCMT 06 T1 02	TCMT 1.2(1.2)0	0.6	
				.236	.787	1.181	.315	.335	.236	.984		.512						
	09	7/32	STGCR/L 08CA-09	8	25	37	10	10	8	32		15	-8°	0°	TCMT 09 02 04	TCMT 1.8(1.5)1	0.9	
				.315	.984	1.457	.394	.394	.315	1.260		.591						
	11	1/4	STGCR/L 10CA-11	11	40	55	14	15	10	50		30	-3°	0°	TCMT 11 02 04	TCMT 2(1.5)1	0.9	
				.433	1.575	2.165	.551	.591	.394	1.968		1.181						
	11	1/4	STGCR/L 10CA-11-B1	11	40	55	14	15	10	50		30	-3°	0°	TCMT 11 03 04	TCMT 221	0.9	
				.433	1.575	2.165	.551	.591	.394	1.968		1.181						
	16	3/8	STGCR/L 12CA-16-M	15	50	75	20	20	12	55		35	-3°	0°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0	
				.591	1.968	2.953	.787	.787	.472	2.165		1.378						
			STGCR/L 16CA-16	20	60	75	25	21	16	63		38	-5°	-3°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0	
				.787	2.362	2.953	.984	.827	.630	2.480		1.496						
	06	5/32	STFCR/L 06CA-06	6	20		8	8.5	6	25		13	0°	-6°	TCMT 06 T1 02	TCMT 1.2(1.2)0	0.6	
				.236	.787		.315	.335	.236	.984		.512						
	09	7/32	STFCR/L 08CA-09	8	25		10	10	8	32		15	0°	-6°	TCMT 09 02 04	TCMT 1.8(1.5)1	0.9	
				.315	.984		.394	.394	.315	1.260		.591						
	11	1/4	STFCR/L 10CA-11	11	40		14	15	10	50		30	0°	-3°	TCMT 11 02 04	TCMT 2(1.5)1	0.9	
				.433	1.575		.551	.591	.394	1.968		1.181						
	11	1/4	STFCR/L 10CA-11-B1	11	40		14	15	10	50		30	0°	-3°	TCMT 11 03 04	TCMT 221	0.9	
				.433	1.575		.551	.591	.394	1.968		1.181						
	16	3/8	STFCR/L 12CA-16-M	15	50		20	20	12	55		35	0°	-3°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0	
				.591	1.968		.787	.787	.472	2.165		1.378						
			STFCR/L 16CA-16	20	55		25	21	16	63		38	0°	-6°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0	
				.787	2.165		.984	.827	.630	2.480		1.496						
	06	5/32	STWCR/L 06CA-06	6	20		8	8.5	6	21	24.2	9	-3°	-2°	TCMT 06 T1 02	TCMT 1.2(1.2)0	0.6	
				.236	.787		.315	.335	.236	.827	.953	.354						
	09	7/32	STWCR/L 08CA-09	8	25		10	10	8	28	32.3	11	-4°	-4°	TCMT 09 02 04	TCMT 1.8(1.5)1	0.9	
				.315	.984		.394	.394	.315	1.102	1.272	.433						
	11	1/4	STWCR/L 10CA-11	11	40		14	15	10	44	49	24	0°	-4°	TCMT 11 02 04	TCMT 2(1.5)1	0.9	
				.433	1.575		.551	.591	.394	1.732	1.929	.945						
	11	1/4	STWCR/L 10CA-11-B1	11	40		14	15	10	44	49	24	0°	-4°	TCMT 11 03 04	TCMT 221	0.9	
				.433	1.575		.551	.591	.394	1.732	1.929	.945						
	16	3/8	STWCR/L 12CA-16-M	15	50		20	20	12	47	54.4	28	-5°	0°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0	
				.591	1.968		.787	.787	.472	1.850	2.142	1.102						

1) γ = Rake angle.

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

Mounting dimensions, see page A366

Dimensions on master insert with r_c. For other nose radii, see page A368.

R = Right hand, L = Left hand

Main spare parts

Insert size							
	iC	h ₁ mm	inch	Insert screw	Shim	Shim screw	Key (Torx Plus)
06	5/32	6	.236	5513 020-27	-	-	5680 051-01 (6IP)
09	7/32	8	.315	5513 020-05	-	-	5680 051-02 (7IP)
11	1/4	10	.394	5513 020-03	-	-	5680 051-02 (7IP)
16	3/8	12	.472	5513 020-10	-	-	5680 049-01 (15IP)
16	3/8	16	.630	5513 020-01	5322 320-01	5512 090-01	5680 049-01 (15IP)



A9



A496



A2

Cartridges

CoroTurn® 107 screw clamp design

Entering angle:
Lead angle:

STTCR/L

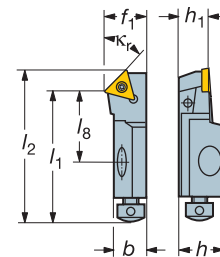
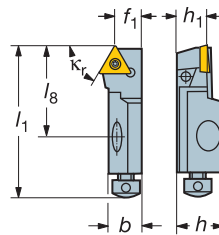
$\kappa_r 60^\circ$
 30°

STSCR/L

$\kappa_r 45^\circ$
 45°


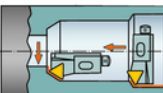
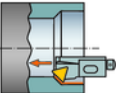


TCMT, TCMX,
TCGT, TCGX
TC EX
TCMW



For Dm-dimensions, see mounting dimensions.

Right hand style shown

Main application		iC	Ordering code ⁴⁾	Dimensions, mm, inch												Gauge insert		Nm ³⁾
				b	<i>D</i> _{m1}	<i>D</i> _{m2}	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₂	<i>l</i> ₈	γ ¹⁾	λ _s ²⁾	ISO	ANSI		
					min	min												
	06	5/32	STTCR/L 06CA-06	6	20	30	5.5	8.5	6	25	13	-9°	0°	TCMT 06 T1 02	TCMT 1.2(1.2)0	0.6		
				.236	.787	1.181	.216	.335	.236	.984	.512							
	09	7/32	STTCR/L 08CA-09	8	25	37	6	10	8	32	15	-8°	0°	TCMT 09 02 04	TCMT 1.8(1.5)1	0.9		
				.315	.984	1.457	.236	.394	.315	1.260	.591							
	11	1/4	STTCR/L 10CA-11	11	40	55	9	15	10	50	30	-5°	0°	TCMT 11 02 04	TCMT 2(1.5)1	0.9		
				.433	1.575	2.165	.354	.591	.394	1.968	1.181							
	11	1/4	STTCR/L 10CA-11-B1	11	40	55	9	15	10	50	30	-5°	0°	TCMT 11 03 04	TCMT 221	0.9		
				.433	1.575	2.165	.354	.591	.394	1.968	1.181							
	16	3/8	STTCR 12CA-16-M	15	50	75	13	20	12	55	35	-3°	0°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0		
				.591	1.968	2.953	.512	.787	.472	2.165	1.378							
			STTCR/L 16CA-16	20	60	75	15	21	16	63	38	-5°	0°	TCMT 16 T3 08	TCMT 3(2.5)2	3.0		
				.787	2.362	2.953	.591	.827	.630	2.480	1.496							

1) γ = Rake angle.

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) B1 in the end of the ordering code = For insert with thickness 03 = 3.18 mm (2 = 1/8").

Mounting dimensions, see page A366

R = Right hand, L = Left hand

Dimensions on master insert with r_c . For other nose radii, see page A368.

Main spare parts

Insert size							
iC	h_1 mm	inch	Insert screw	Shim	Shim screw	Key (Torx Plus)	
06	5/32	.236	5513 020-27	-	-	5680 051-01 (6IP)	
09	7/32	.315	5513 020-05	-	-	5680 051-02 (7IP)	
11	1/4	.394	5513 020-03	-	-	5680 051-02 (7IP)	
16	3/8	.472	5513 020-10	-	-	5680 049-01 (15IP)	
16	3/8	.630	5513 020-01	5322 320-01	5512 090-01	5680 049-01 (15IP)	



A9



A496



A2

Mounting dimensions for CoroTurn® 107 cartridges

Metric dimensions

Calculation of D_{1a} , D_α and D_{1b} dimensions

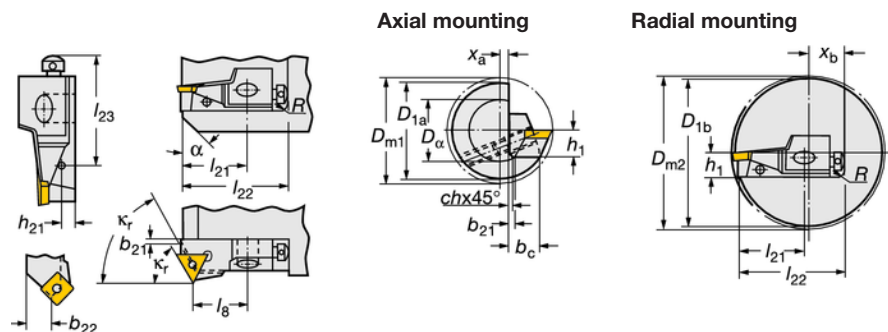
$$D_{1a\max} = 2\sqrt{h_1^2 + (b_{c\max} + /(-)x_a)^2}$$

$$D_{\alpha\max} = 2\sqrt{h_1^2 + (b_{21\max} + /(-)x)^2}$$

$$x_a = \frac{D_{m1}}{2} - f_1$$

$$D_{1b\max} = 2\sqrt{h_1^2 + (l_{22} - /(+)x_b)^2}$$

$$x_b = l_1 - \frac{D_{m2}}{2}$$



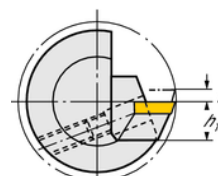
$$\tan \alpha = \frac{(b_c - b_{21}) \times \tan(90^\circ - \kappa_r) \times 2}{D_{1a} - D_\alpha}$$

Axial adjust = ± 1 mm
Radial adjust = ± 0.5 mm

Axial adjust = ± 0.5 mm
Radial adjust = ± 1 mm

Cartridge size	Cartridge code	Dimensions, mm													
		Entering angle κ_r	b_c max	b_{21} max	b_{22}	h_1	h_{21}	l_8	l_{21}	l_{22}	l_{23}	D_{m1} min	D_{m2} min	R max	ch max
06CA 	SRSCR/L 06CA-06	—	5.5	—	—	6	1.9	—	11.5	23.5	18.0	20	—	—	—
	STFCR/L 06CA-06	90°	5.5	—	—	6	1.9	13	12.0	24.0	18.0	20	—	1.5	0.3
	STWCR/L 06CA-06	60°	5.5	1.2	—	6	1.9	9	10.5	22.5	18.0	20	—	1.5	0.3
	STSCR/L 06CA-06	45°	5.0	2.5	—	6	2.2	9	11.0	23.0	17.5	20	—	1.5	0.3
	STTCR/L 06CA-06	60°	5.0	3.4	—	6	2.2	13	11.0	23.0	17.5	20	30	1.5	0.3
	STGCR/L 06CA-06	90°	5.0	—	—	6	2.2	13	11.0	23.0	17.5	20	30	1.5	0.3
08CA 	SCFCR/L 08CA-06	90°	6.0	—	—	8	2.2	15	13.5	30.5	24.2	25	—	1.5	0.3
	SRSCR/L 08CA-08	—	6.5	—	—	8	2.2	—	12.7	29.7	24.2	25	—	—	—
	STFCR/L 08CA-09	90°	6.5	—	—	8	2.2	15	13.5	30.5	24.2	25	—	2.5	0.3
	STWCR/L 08CA-09	60°	6.5	0.8	—	8	2.2	11	13.0	30.0	24.2	25	—	2.5	0.3
	STSCR/L 08CA-09	45°	6.0	2.4	—	8	2.5	11	13.5	30.5	21.5	25	—	2.5	0.3
	STTCR/L 08CA-09	60°	6.0	2.7	—	8	2.5	15	12.2	29.2	21.5	25	37	2.5	0.3
10CA 	STGCR/L 08CA-09	90°	6.0	—	—	8	2.5	11	12.2	29.2	21.5	25	37	2.5	0.3
	SCFCR/L 10CA-09	90°	9.0	—	—	10	3.0	30	27.5	47.5	39.5	40	—	2.5	0.3
	SRSCR/L 10CA-10	—	10.6	—	—	10	3.0	—	28.0	48.0	39.5	40	—	—	—
	STFCR/L 10CA-11	90°	10.6	—	—	10	3.0	30	27.5	47.5	39.5	40	—	4.0	0.4
	STWCR/L 10CA-11	60°	10.6	1.2	—	10	3.0	24	27.0	47.0	39.5	40	—	4.0	0.4
	STSCR/L 10CA-11	45°	9.0	3.0	—	10	3.0	24	29.0	49.0	39.5	40 ¹⁾	—	4.0	0.4
	STTCR/L 10CA-11	60°	9.0	6.1	—	10	3.0	30	28.0	48.0	39.5	40 ¹⁾	55	4.0	0.4
	STGCR/L 10CA-11	90°	9.0	—	—	10	3.0	30	26.5	46.5	39.5	40 ¹⁾	55	4.0	0.4
	STFCR/L 10CA-11-B1	90°	9.0	—	—	10	3.0	30	27.5	47.5	39.5	40 ¹⁾	—	4.0	0.4
	STWCR/L 10CA-11-B1	60°	9.0	1.2	—	10	3.0	24	27.0	47.0	39.5	40 ¹⁾	—	4.0	0.4
	STSCR/L 10CA-11-B1	45°	9.0	3.0	—	10	3.0	24	29.0	49.0	39.5	40 ¹⁾	—	4.0	0.4
	STTCR/L 10CA-11-B1	60°	9.0	6.1	—	10	3.0	30	28.0	48.0	39.5	40 ¹⁾	55	4.0	0.4
12CA 	STGCR/L 10CA-11-B1	90°	9.0	—	—	10	3.0	30	26.5	46.5	39.5	40 ¹⁾	55	4.0	0.4
	SSKCR/L 10CA-09-M	75°	9.0	0.9	—	10	3.0	30	30.5	50.5	41.5	40 ¹⁾	—	4.0	0.4
	SSSCR/L 10CA-09-M	45°	9.0	—	6.00	10	3.0	24	27.0	47.0	38.0	40 ¹⁾	—	4.0	0.4
	SCFCR/L 12CA-09	90°	13.0	—	—	12	5.0	35	33.0	53.0	40.0	50	—	4.0	0.4
	STFCR/L 12CA-16-M	90°	13.0	—	—	12	5.0	35	33.2	53.2	40.0	—	—	4.0	0.4
	STWCR/L 12CA-16-M	60°	13.0	4.2	—	12	5.0	27	32.0	52.0	40.0	—	—	4.0	0.4
	STSCR/L 12CA-16-M	45°	13.0	5.4	—	12	5.0	27	35.0	55.0	43.0	50	—	5.0	0.4
	STTCR/L 12CA-16-M	60°	13.0	9.8	—	12	5.0	35	33.0	53.0	40.0	—	75	5.0	0.4
16CA 	STGCR/L 12CA-16-M	90°	15.0	—	—	12	5.0	35	31.0	51.0	40.0	—	75	5.0	0.4
	SSKCR/L 12CA-12	75°	13.5	3.1	—	12	5.0	35	36.0	56.0	40.0	50	—	5.0	0.4
	SSSCR/L 12CA-12	45°	13.0	—	9.40	12	5.0	27	31.5	51.5	39.0	—	75	5.0	0.4
	STFCR/L 16CA-16	90°	17.0	—	—	—	38	36.0	61.0	52.0	55	—	—	5.0	0.4
	STSCR/L 16CA-16	45°	16.5	7.1	—	16	5.0	28	35.5	60.5	48.0	55	—	6.0	0.4
	STTCR/L 16CA-16	60°	17.5	11.5	—	16	5.0	38	35.5	60.5	48.0	60	75	6.0	0.4
	STGCR/L 16CA-16	90°	18.5	—	—	16	5.0	38	32.0	57.0	48.0	60	75	6.0	0.4
16CA 	SSKCR/L 16CA-12	75°	16.5	6.0	—	16	5.0	38	34.0	60.0	49.0	55	—	6.0	0.4

¹⁾According to ISO the min hole diameter is 40 mm but by mounting the cartridge 1 mm above centre, as shown in the sketch, a 32 mm diameter hole can be machined.



Mounting dimensions for CoroTurn® 107 cartridges

Inch dimensions

Calculation of D_{1a} , D_α and D_{1b} dimensions

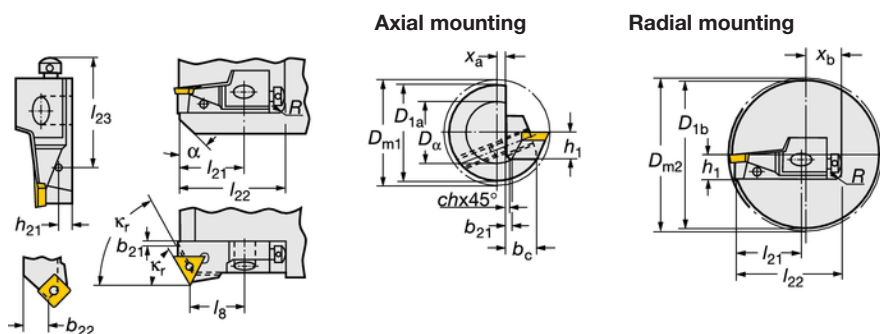
$$D_{1a\max} = 2\sqrt{h_1^2 + (b_{c\max} + /(-)x_a)^2}$$

$$D_{\alpha \max} = 2\sqrt{h_1^2 + (b_{21\max} + /(-)x)^2}$$

$$x_a = \frac{D_{m1}}{2} - f_1$$

$$D_{1b\max} = 2\sqrt{h_1^2 + (I_{22} - I_{(+)})x_b^2}$$

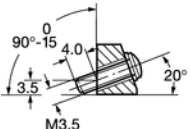
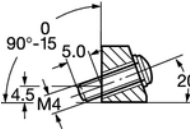
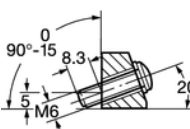
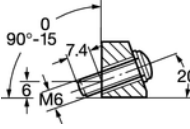
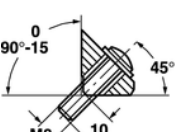
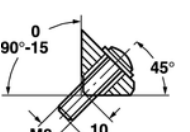
$$x_b = l_1 - \frac{D_{m2}}{2}$$



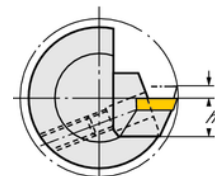
$$\operatorname{tg} \alpha = \frac{(b_c - b_{21}) \times \operatorname{tg}(90^\circ - \kappa_r) \times 2}{D_{12} - D_\alpha}$$

Axial adjust = $\pm .039$ inch
Radial adjust = $\pm .020$ inch

Axial adjust = +.020 inch
 Radial adjust = $\pm .039$ inch

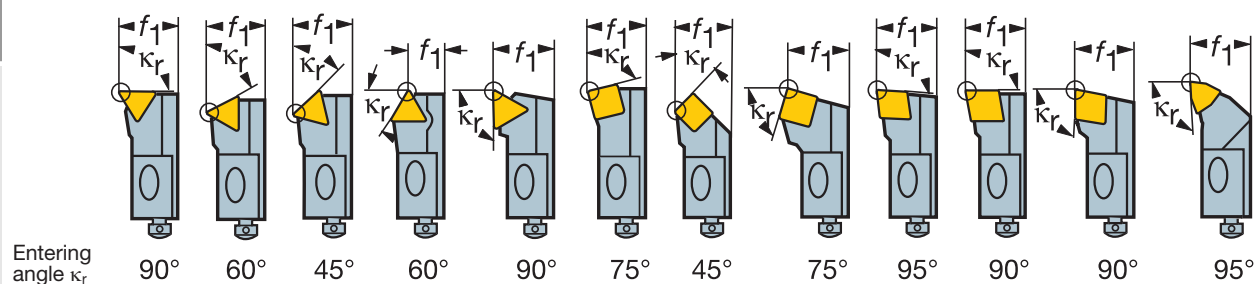
Cartridge size	Cartridge code	Dimensions														
		Lead angle	κ_r	b_c max	b_{21} max	b_{22}	h_1	h_{21}	l_8	l_{21}	l_{22}	l_{23}	D_{m1} min	D_{m2} min	R max	ch max
06CA 	SRSCR/L 06CA-06	–	–	.217	–	–	.236	.075	–	.453	.925	.708	.787	–	–	–
	STFCR/L 06CA-06	0°	90°	.197	–	–	.236	.087	.512	.472	.945	.689	.787	–	.059	.012
	STWCR/L 06CA-06	60°	30°	.197	.047	–	.236	.087	.354	.413	.884	.689	.787	–	.059	.012
	STSCR/L 06CA-06	45°	45°	.197	.098	–	.236	.087	.354	.433	.906	.689	.787	–	.059	.012
	STTCR/L 06CA-06	30°	60°	.197	.134	–	.236	.087	.512	.433	.906	.689	.787	1.181	.059	.012
	STGCR/L 06CA-06	0°	90°	.197	–	–	.236	.087	.512	.433	.906	.689	.787	1.181	.059	.012
08CA 	SCFCR/L 08CA-06	0°	90°	.236	–	–	.315	.087	.591	.531	1.201	.953	.984	–	–	–
	SRSCR/L 08CA-08	–	–	.256	–	–	.315	.087	–	.500	1.169	.953	.984	–	–	–
	STFCR/L 08CA-09	0°	90°	.236	–	–	.315	.098	.591	.531	1.201	.846	.984	–	.098	.012
	STWCR/L 08CA-09	60°	30°	.236	.031	–	.315	.098	.433	.512	1.181	.846	.984	–	.098	.012
	STSCR/L 08CA-09	45°	45°	.236	.094	–	.315	.098	.433	.531	1.201	.846	.984	–	.098	.012
	STTCR/L 08CA-09	30°	60°	.236	.106	–	.315	.098	.591	.408	1.150	.846	.984	1.457	.098	.012
10CA 	STGCR/L 08CA-09	0°	90°	.236	–	–	.315	.098	.591	.408	1.150	.846	.984	1.457	.098	.012
	SCFCR/L 10CA-09	0°	90°	.354	–	–	.394	.118	1.181	1.083	1.870	1.555	1.575	–	–	–
	SRSCR/L 10CA-10	–	–	.417	–	–	.394	.118	–	1.102	1.890	1.555	1.575	–	–	–
	STFCR/L 10CA-11	0°	90°	.354	–	–	.394	.118	1.181	1.083	1.870	1.555	1.575 ¹⁾	–	.157	.016
	STWCR/L 10CA-11	60°	30°	.354	.047	–	.394	.118	.945	1.063	1.850	1.555	1.575 ¹⁾	–	.157	.016
	STSCR/L 10CA-11	45°	45°	.354	.118	–	.394	.118	.945	1.142	1.929	1.555	1.575 ¹⁾	–	.157	.016
	STTCR/L 10CA-11	30°	60°	.354	.240	–	.394	.118	1.181	1.102	1.890	1.555	1.575 ¹⁾	2.165	.157	.016
	STGCR/L 10CA-11	0°	90°	.354	–	–	.394	.118	1.181	1.043	1.831	1.555	1.575 ¹⁾	2.165	.157	.016
	STFCR/L 10CA-11-B1	0°	90°	.354	–	–	.394	.118	1.181	1.083	1.870	1.555	1.575 ¹⁾	–	.157	.016
	STWCR/L 10CA-11-B1	60°	30°	.354	.047	–	.394	.118	.945	1.063	1.850	1.555	1.575 ¹⁾	–	.157	.016
	STSCR/L 10CA-11-B1	45°	45°	.354	.118	–	.394	.118	.945	1.142	1.929	1.555	1.575 ¹⁾	–	.157	.016
	STTCR/L 10CA-11-B1	30°	60°	.354	.240	–	.394	.118	1.181	1.102	1.890	1.555	1.575 ¹⁾	2.165	.157	.016
12CA 	STGCR/L 10CA-11-B1	0°	90°	.354	–	–	.394	.118	1.181	1.043	1.831	1.555	1.575 ¹⁾	2.165	.157	.016
	SSKCR/L 10CA-09-M	15°	75°	.354	.035	–	.394	.118	1.181	1.201	1.988	1.634	1.575 ¹⁾	–	.157	.016
	SSSKCR/L 10CA-09-M	45°	45°	.354	–	.236	.394	.118	.945	1.063	1.850	1.496	1.575 ¹⁾	–	.157	.016
	SCFCR/L 12CA-09	0°	90°	.512	–	–	.471	.197	1.378	1.299	2.087	1.575	1.969	–	.197	.016
	STFCR/L 12CA-16-M	0°	90°	.512	–	–	.472	.197	1.378	1.307	2.094	1.575	1.969	–	.197	.016
	STWCR/L 12CA-16-M	60°	30°	.512	.165	–	.472	.197	1.063	1.260	2.047	1.575	1.969	–	.197	.016
16CA 	STSCR/L 12CA-16-M	45°	45°	.512	.213	–	.472	.197	1.063	1.378	2.165	1.693	1.969	–	.197	.016
	STTCR/L 12CA-16-M	30°	60°	.512	.386	–	.472	.197	1.378	1.299	2.087	1.575	1.969	2.953	.197	.016
	STGCR/L 12CA-16-M	0°	90°	.591	–	–	.472	.197	1.378	1.220	2.008	1.575	1.969	2.953	.197	.016
	SSKCR/L 12CA-12	15°	75°	.531	.122	–	.472	.197	1.378	1.417	2.205	1.575	1.969	–	.197	.016
	SSSKCR/L 12CA-12	45°	45°	.512	–	.370	.472	.197	1.063	1.240	2.028	1.535	1.969	2.953	.197	.016
	STFCR/L 16CA-16	0°	90°	.669	–	–	.630	.197	1.497	1.417	2.402	2.047	2.165	–	.236	.016
16CA 	STWCR/L 16CA-16	60°	30°	.650	.193	–	.630	.197	1.102	1.280	2.264	1.811	2.165	–	.236	.016
	STSCR/L 16CA-16	45°	45°	.650	.280	–	.630	.197	1.102	1.398	2.382	1.890	2.165	–	.236	.016
	STTCR/L 16CA-16	30°	60°	.689	.453	–	.630	.197	1.497	1.398	2.382	1.890	2.362	2.953	.236	.016
	STGCR/L 16CA-16	0°	90°	.728	–	–	.630	.197	1.497	1.260	2.244	1.890	2.362	2.953	.236	.016
	SSKCR/L 16CA-12	15°	75°	.650	.236	–	.630	.197	1.497	1.339	2.362	1.929	2.165	–	.236	.016

1)According to ISO the min hole diameter is 1.575 in. but by mounting the cartridge .040 in. above centre, as shown in the sketch, a 1.260 in. diameter hole can be machined.



f_1 -dimensions for ISO cartridges

Metric dimensions

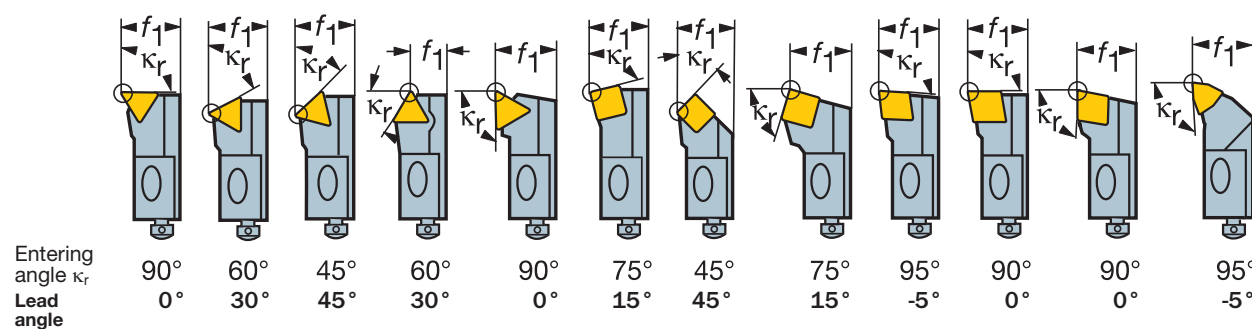


κ_r	Cartridge		f_1 -dimensions, mm						
	CoroTurn® RC T-MAX P	CoroTurn® 107	$r_e^{1)} = 0.00$	$r_e = 0.20$	$r_e = 0.40$	$r_e = 0.80$	$r_e = 1.20$	$r_e = 1.60$	$r_e = 2.40$
90°	–	STFCR/L 06CA-06	8.40	8.00	7.90	7.60	–	–	–
60°	–	STWCR/L 06CA-06	8.20	8.00	7.80	7.40	–	–	–
45°	–	STSCR/L 06CA-06	8.20	8.00	7.80	7.40	–	–	–
60°	–	STTCR/L 06CA-06	5.40	5.50	5.60	5.80	–	–	–
90°	–	STGCR/L 06CA-06	8.00	8.00	8.00	8.00	–	–	–
90°	–	STFCR/L 08CA-09	10.30	10.10	10.00	9.70	–	–	–
60°	–	STWCR/L 08CA-09	10.40	10.20	10.00	9.60	–	–	–
45°	–	STSCR/L 08CA-09	10.40	10.20	10.00	9.60	–	–	–
60°	–	STTCR/L 08CA-09	5.80	5.90	6.00	6.20	–	–	–
90°	–	STGCR/L 08CA-09	10.00	10.00	10.00	10.00	–	–	–
90°	–	STFCR/L 10CA-11/-B1	14.29	14.14	14.0	13.71	–	–	–
60°	–	STWCR/L 10CA-11/-B1	14.40	14.20	14.00	13.60	–	–	–
45°	–	STSCR/L 10CA-11/-B1	14.37	14.19	14.0	13.63	–	–	–
60°	–	STTCR/L 10CA-11/-B1	8.77	8.89	9.0	9.23	–	–	–
90°	–	STGCR/L 10CA-11/-B1	14.00	14.00	14.00	14.00	–	–	–
75°	–	SSKCR/L 10CA-09-M	14.18	14.13	14.09	14.00	–	–	–
45°	–	SSSCR/L 10CA-09-M	14.33	14.25	14.16	14.00	–	–	–
90°	PTFNR/L 12CA-16	–	20.56	–	20.28	20.00	19.72	19.44	–
–	–	STFCR/L 12CA-16-M	20.58	–	20.29	20.00	19.71	–	–
60°	PTWNR/L 12CA-16	–	20.78	–	20.39	20.00	19.61	19.22	–
–	–	STWCR/L 12CA-16	20.80	–	20.40	20.00	19.60	–	–
45°	PTSNR/L 12CA-16	–	20.76	–	20.38	20.00	19.62	19.24	–
–	–	STSCR/L 12CA-16-M	20.74	–	20.37	20.00	19.63	–	–
60°	PTTNR/L 12CA-16	STTCR/L 12CA-16-M	12.54	–	12.77	13.00	13.23	13.46	–
90°	PTGNR/L 12CA-16	STGCR/L 12CA-16-M	20.01	–	20.00	20.00	20.00	19.99	–
75°	PSKNR/L 12CA-12	SSKCR/L 12CA-12	20.18	20.13	20.09	20.00	19.91	19.82	19.64
45°	PSSNR/L 12CA-12	–	20.32	–	20.16	20.00	19.84	19.68	19.35
–	–	SSSCR/L 12CA-12	20.33	20.25	20.16	20.00	19.84	–	–
90°	DTFNR/L 16CA-16	–	25.52	–	25.24	24.96	24.68	24.40	–
90°	PTFNR/L 16CA-16	–	25.56	–	25.28	25.00	24.72	24.44	–
–	–	STFCR/L 16CA-16	25.57	–	25.29	25.00	24.71	–	–
60°	–	STWCR/L 16CA-16	25.79	–	25.40	25.00	24.60	–	–
45°	PTSNR/L 16CA-16	STSCR/L 16CA-16	25.74	–	25.37	25.00	24.63	24.26	–
90°	PTGNR/L 16CA-16	STGCR/L 16CA-16	25.01	–	25.00	25.00	25.00	24.99	–
75°	PSKNR/L 16CA-12	–	25.17	–	25.09	25.00	24.91	24.83	24.66
–	–	SSKCR/L 16CA-12	25.78	–	25.09	25.00	24.91	–	–
45°	PSSNR/L 16CA-12	–	25.33	–	25.16	25.00	24.84	24.67	24.35
75°	PSRNR/L 16CA-12	–	24.96	–	24.98	25.00	25.02	25.04	25.08
95°	MWLNRL/L 16CA-06	–	25.07	–	25.03	25.00	–	–	–
95°	PCLNR/L 16CA-12	–	25.07	–	25.03	25.00	24.97	24.93	–
90°	PCFNR/L 16CA-12	–	25.14	–	25.07	25.00	24.93	24.86	–
90°	PCGNR/L 16CA-12	–	25.00	–	25.00	25.00	25.00	25.00	–
95°	DWLNRL/L 20CA-08	–	25.03	–	25.00	24.96	24.92	24.89	–
90°	PTFNR/L 20CA-22	–	25.56	–	25.28	25.00	24.72	24.44	–
45°	PTSNR/L 20CA-22	–	25.74	–	25.37	25.00	24.63	24.26	–
90°	PTGNR/L 20CA-22	–	25.01	–	25.00	25.00	25.00	24.99	–
75°	PSKNR/L 20CA-15	–	25.25	–	25.17	25.08	25.00	24.92	24.75
45°	PSSNR/L 20CA-15	–	25.49	–	25.32	25.16	25.00	24.84	24.51
75°	PSRNR/L 20CA-15	–	24.93	–	24.95	24.98	25.00	25.02	25.07
95°	DCLNR/L 25CA-12	–	32.03	–	32.00	31.96	31.92	31.89	31.81
95°	DCLNR/L 25CA-16	–	32.07	–	32.03	32.00	31.96	32.92	31.85
75°	DSKNR/L 25CA-12	–	32.13	–	32.05	31.96	31.87	31.79	31.61
95°	MWLNRL/L 25CA-08	–	32.07	–	32.03	32.00	31.97	31.93	–
95°	PCLNR/L 25CA-19	–	32.11	–	–	32.04	32.00	31.96	31.89

1) r_e = Insert nose radius mm

f_1 -dimensions for ISO cartridges

Inch dimensions



Lead angle	Cartridge		f_1 dimension, inch							
	CoroTurn® RC		$r_{\epsilon}^1 = 0.000$	$r_{\epsilon} = .008$	$r_{\epsilon} = .016$	$r_{\epsilon} = .031$	$r_{\epsilon} = .047$	$r_{\epsilon} = .063$	$r_{\epsilon} = .094$	
0°	T-MAX P	CoroTurn® 107								
0°	–	STFCR/L 06CA-06	.326	.320	.315	.304	–	–	–	
60°	–	STWCR/L 06CA-06	.331	.323	.315	.299	–	–	–	
45°	–	STSCR/L 06CA-06	.329	.322	.315	.300	–	–	–	
30°	–	STTCR/L 06CA-06	.207	.212	.217	.226	–	–	–	
0°	–	STGCR/L 06CA-06	.315	.315	.315	.315	–	–	–	
0°	–	STFCR/L 08CA-09	.405	.399	.394	.382	–	–	–	
60°	–	STWCR/L 08CA-09	.409	.402	.394	.378	–	–	–	
45°	–	STSCR/L 08CA-09	.408	.401	.394	.379	–	–	–	
30°	–	STTCR/L 08CA-09	.227	.232	.236	.245	–	–	–	
0°	–	STGCR/L 08CA-09	.394	.394	.394	.394	–	–	–	
0°	–	STFCR/L 10CA-11/-B1	.563	.557	.551	.540	–	–	–	
60°	–	STWCR/L 10CA-11/-B1	.567	.559	.551	.536	–	–	–	
45°	–	STSCR/L 10CA-11/-B1	.566	.559	.551	.537	–	–	–	
30°	–	STTCR/L 10CA-11/-B1	.345	.350	.354	.363	–	–	–	
0°	–	STGCR/L 10CA-11/-B1	.551	.551	.551	.551	–	–	–	
15°	–	SSKCR/L 10CA-09-M	.558	.556	.555	.551	–	–	–	
45°	–	SSSCR/L 10CA-09-M	.564	.561	.557	.551	–	–	–	
0°	PTFNR/L 12CA-16	–	.809	–	.798	.787	.776	.765	–	
0°	–	STFCR/L 12CA-16-M	.810	–	.799	.787	.776	–	–	
30°	PTWNR/L 12CA-16	–	.818	–	.803	.787	.772	.757	–	
60°	–	STWCR/L 12CA-16	.819	–	.803	.787	.772	–	–	
45°	PTSNR/L 12CA-16	–	.817	–	.802	.787	.772	.757	–	
45°	–	STSCR/L 12CA-16-M	.817	–	.802	.787	.773	–	–	
30°	PTTNR/L 12CA-16	STTCR/L 12CA-16-M	.494	–	.503	.512	.512	.530	–	
0°	PTGNR/L 12CA-16	STGCR/L 12CA-16-M	.788	–	.787	.787	.787	.787	–	
15°	PSKNR/L 12CA-12	SSKCR/L 12CA-12	.794	.793	.791	.787	.784	.780	.773	
45°	PSSNR/L 12CA-12	–	.800	–	.794	.787	.781	.775	.762	
45°	–	SSSCR/L 12CA-12	.800	.797	.794	.787	.781	–	–	
0°	DTFNR/L 16CA-16	–	1.005	–	.994	.983	.972	.961	–	
0°	PTFNR/L 16CA-16	–	1.006	–	.995	.984	.973	.962	–	
0°	–	STFCR/L 16CA-16	1.007	–	.996	.984	.973	–	–	
60°	–	STWCR/L 16CA-16	1.015	–	1.000	.984	.969	–	–	
45°	PTSNR/L 16CA-16	STSCR/L 16CA-16	1.013	–	.999	.984	.970	.955	–	
0°	PTGNR/L 16CA-16	STGCR/L 16CA-16	.985	–	.984	.984	.984	.984	–	
15°	PSKNR/L 16CA-12	–	.991	–	.988	.984	.981	.978	.971	
15°	–	SSKCR/L 16CA-12	1.015	–	.988	.984	.981	–	–	
45°	PSSNR/L 16CA-12	–	.997	–	.991	.984	.987	.971	.959	
15°	PSRNR/L 16CA-12	–	.983	–	.983	.984	.985	.986	.987	
-5°	MWLNRL 16CA-06	–	.987	–	.985	.984	–	–	–	
-5°	PCLNR/L 16CA-12	–	.987	–	.985	.984	.983	.981	–	
0°	PCFNR/L 16CA-12	–	.990	–	.987	.984	.981	.979	–	
0°	PCGNR/L 16CA-12	–	.984	–	.984	.984	.984	.984	–	
-5°	DWLNRL 20CA-08	–	.985	–	.984	.983	.981	.980	–	
0°	PTFNR/L 20CA-22	–	1.006	–	.995	.984	.973	.962	–	
45°	PTSNR/L 20CA-22	–	–	–	.999	.984	.970	.955	–	
0°	PTGNR/L 20CA-22	–	.985	–	.984	.984	.984	.984	–	
15°	PSKNR/L 20CA-15	–	.994	–	.991	.987	.984	.981	.974	
45°	PSSNR/L 20CA-15	–	1.004	–	.997	.991	.984	.978	.965	
15°	PSRNR/L 20CA-15	–	.981	–	.982	.983	.984	.985	.987	
-5°	DCLNR/L 25CA-12	–	1.261	–	1.260	1.258	1.257	1.256	1.252	
-5°	DCLNR/L 25CA-16	–	1.263	–	1.261	1.260	1.258	1.296	1.254	
15°	DSKNR/L 25CA-12	–	1.265	–	1.262	1.258	1.255	1.252	1.244	
-5°	MWLNRL 25CA-08	–	1.263	–	1.261	1.260	1.259	1.257	–	
-5°	PCLNR/L 25CA-19	–	1.264	–	–	1.261	1.260	1.258	1.256	

1) r_{ϵ} = Insert nose radius inch

Round shank boring tools

CoroTurn® 107 screw clamp design

Entering angle: κ_r 90°

Lead angle: 0°

Insert size, mm (iC, inch) 06/09 (5/32-7/32) 11/16 (1/4-3/8)

R/L140.0 κ_r 60°

30°

06/09 (5/32-7/32) 11/16 (1/4-3/8)

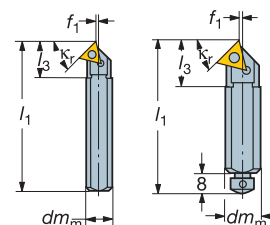
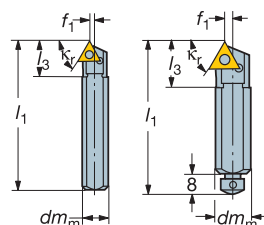
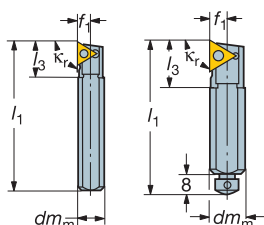
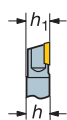
R/L142.0 κ_r 45°

45°


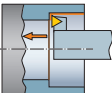
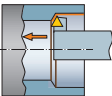
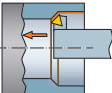
06/09 (5/32-7/32) 11/16 (1/4-3/8)



TCMT, TCMX, TCGT, TCGX TCEX TCMW



Right hand style shown

				Dimensions, mm, inch								Gauge inserts	
Main application		iC	Ordering code	dm _m	f ₁	h	h ₁	l ₁	l ₃	γ ⁽¹⁾	λ _s ⁽²⁾	ISO	ANSI
	06	5/32	R/L141.0-8-06	8	4	7	7	30	10.5	0°	0°	TCMT 06 T1 02	TCMT 1.2(1.2)0
				.315	.157	.276	.276	1.181	.413				
	09	7/32	R/L141.0-10-09	10	5.1	8.5	8.5	50	14	0°	0°	TCMT 09 02 04	TCMT 1.8(1.5)1
				.394	.201	.335	.335	1.968	.551				
	11	1/4	R/L141.0-12-11	12	6	10.5	10.5	68	15.3	0°	0°	TCMT 11 02 04	TCMT 2(1.5)1
				.472	.236	.413	.413	2.677	.602				
			R/L141.0-16-11	16	7.5	14	14	98	15.3	0°	0°	TCMT 11 02 04	TCMT 2(1.5)1
				.630	.295	.551	.551	3.858	.602				
	16	3/8	R/L141.0-20-16	20	10.7	17	17	128	19	0°	0°	TCMT 16 T3 08	TCMT 3(2.5)2
				.787	.421	.669	.669	5.039	.748				
	06	5/32	R/L140.0-8-06	8	1.47	7	7	30	10.6	0°	0°	TCMT 06 T1 02	TCMT 1.2(1.2)0
				.315	.058	.276	.276	1.181	.417				
	09	7/32	R/L140.0-10-09	10	1.7	8.5	8.5	50	13.4	0°	0°	TCMT 09 02 04	TCMT 1.8(1.5)1
				.394	.067	.335	.335	1.968	.528				
	11	1/4	R/L140.0-12-11	12	2.2	10.5	10.5	68	15.4	0°	0°	TCMT 11 02 04	TCMT 2(1.5)1
				.472	.087	.413	.413	2.677	.606				
			R/L140.0-16-11	16	2.2	14	14	98	15.4	0°	0°	TCMT 11 02 04	TCMT 2(1.5)1
				.630	.087	.551	.551	3.858	.606				
	16	3/8	R/L140.0-20-16	20	2.4	17	17	128	19	0°	0°	TCMT 16 T3 08	TCMT 3(2.5)2
				.787	.094	.669	.669	5.039	.748				
	06	5/32	R/L142.0-8-06	8	0.39	7	7	30	10.6	0°	0°	TCMT 06 T1 02	TCMT 1.2(1.2)0
				.315	.015	.276	.276	1.181	.417				
	09	7/32	R/L142.0-10-09	10	-0.23	8.5	8.5	50	13.4	0°	0°	TCMT 09 02 04	TCMT 1.8(1.5)1
				.394	-0.009	.335	.335	1.968	.528				
	11	1/4	R/L142.0-12-11	12	0.5	10.5	10.5	68	15.4	0°	0°	TCMT 11 02 04	TCMT 2(1.5)1
				.472	.020	.413	.413	2.677	.606				
			R/L142.0-16-11	16	0.5	14	14	98	15.4	0°	0°	TCMT 11 02 04	TCMT 2(1.5)1
				.630	.020	.551	.551	3.858	.606				
	16	3/8	R/L142.0-20-16	20	-0.7	17	17	128	19	0°	0°	TCMT 16 T3 08	TCMT 3(2.5)2
				.787	-0.028	.669	.669	5.039	.748				

1) γ = Rake angle.

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size						
iC		Insert screw	Shim	Shim screw	Key (Torx Plus)	Length adjusting screw
06	5/32	5513 020-27	-	-	5680 051-01 (6IP)	-
09	7/32	5513 020-05	-	-	5680 051-02 (7IP)	-
11	1/4	5513 020-03	-	-	5680 051-02 (7IP)	438.3-824
16	3/8	5513 020-01	5322 320-01	5512 090-01	5680 049-01 (15IP)	434.9-825



A9



A497



A2

HEAVY MACHINING

Heavy Turning

Introduction	A372
Negative basic-shape inserts	
T-Max P lever clamp design	A373
Engineered inserts	A379
Positive basic-shape inserts	
Engineered inserts	A381
Holders for negative basic-shape inserts	
CoroTurn® RC, rigid clamping, Coromant Capto® cutting units	A382
T-Max® P, lever clamping, Coromant Capto® cutting units	A385
CoroTurn® RC, rigid clamping, shank holders	A390
T-Max® P, lever clamping, shank holders	A394
T-Max® P, wedge clamping, shank holders	A394
Holders for positive basic-shape inserts	
CoroTurn® 107, screw clamp, Coromant Capto® cutting units	A400
Parting and grooving	
Bear Paw, grooving inserts	A401
Bear Paw, shank tools for grooving	A403
Bear Par, double ended grooving blade	A403
Tool blocks for grooving blade	A404
Cutting data	
Cutting depth, feed recommendations and geometry descriptions	A405
Cutting speed recommendations	A516
Bar peeling	
Introduction	A409
Negative basic-shape inserts	
Screw clamping	A410
Engineered inserts	A412
Precisions bar peeling tool holders	A414
Spare parts	A416
Machining example	A419
Cutting depth, feed recommendations and geometry descriptions	A421
Railway wheel re-turning	
Introduction	A424
Inserts	
Inserts for railway wheel re-turning	A425
T-Max P inserts	A426
Engineered inserts	A427
Holders for negative basic-shape inserts	
T-MAX P cutting units	A428
Holders for cutting units	A429
Spare parts	A430
Grade and cutting data recommendations	A431

Heavy turning

Coromant Capto® units and conventional shank holders, together with the single and double-sided inserts are mainly used for external turning operations, from roughing to finishing.

A typical heavy turning application is turning of large components with uneven surfaces in combination with very large and varying cutting depth. The time in cut is normally very long which leads to high temperatures. The cutting speed and no. of revolutions is often limited to the size and clamping of the component. Machining is often performed in dry conditions as the machines are open and not suited to wet machining. Examples of components are big shafts for Power energy, propellor shafts and shields for nuclear and big containers.

Sandvik Coromant's T-Max P, lever clamping and CoroTurn 107 Screw clamping system are mainly used for external turning operations, from roughing to finishing. The total insert assortment is presented in the General Turning chapter where large-size inserts are also included.

T-Max P inserts comply with ISO standards and have a negative basic shape which gives them very strong cutting edges. We also offer a positive round insert RCMT for use in our T-Max P holders.

CoroTurn 107 with positive shape inserts for heavy turning gives even more opportunities in applications with internal turning.

To effectively meet the requirements in costly, heavy operations, use T-Max P and CoroTurn 107 inserts in rigid Coromant Capto and shank holders.

Sandvik Coromant engineered inserts

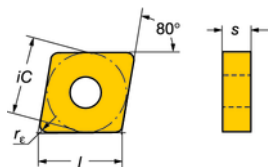
In addition to our extensive standard programme we can also offer engineered inserts. These inserts are not available from stock and have to be quoted for price and delivery. Delivery time is about 4 to 6 weeks after order. For quotation please contact your Sandvik Coromant representative.








Negative basic-shape inserts

T-MAX P

Rhombic 80°

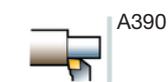


For dimensions, see code key on page A16.

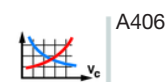
Roughing					P				M	
					GC	GC	GC	GC		
		ISO		iC	4215	4225	4235	2025	ANSI	
		CNMG 25 09 24-PR	25	1	☆	☆	☆		CNMG 866-PR	
		CNMM 25 09 24-MR	25	1		☆	☆	☆	CNMM 866-MR	
		CNMM 25 09 32-MR						☆	CNMM 868-MR	
		CNMM 25 09 24-QR	25	1	☆	☆			CNMM 866-QR	
		CNMM 25 09 24-HR	25	1	☆	☆	☆		CNMM 866-HR	
		CNMM 25 09 32-HR				☆	☆		CNMM 868-HR	
					P15	P25	P35	M25		



A382



A390



A406



A405



A524

Negative basic-shape inserts

T-MAX P

Round

negative insert

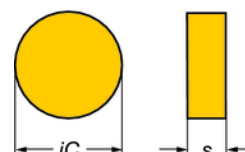
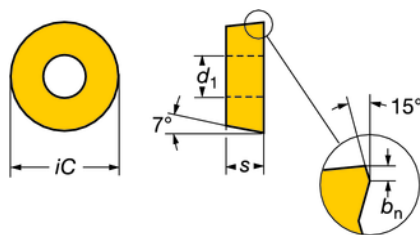
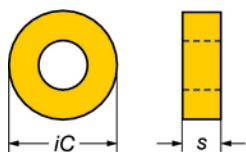
positive insert

negative insert

RNMG

RCMX

RNGN



For dimensions, see code key on page A16.

		ISO	IO	iC	P				K		N		S		ANSI
					GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
					4205	4215	4225	4235	3215	H13A	H13A	H13A	H13A	H13A	
Medium	RNMG	RNMG 25 09 00	25	1			☆	☆	☆						RNMG 86
	RCMX	RCMX 25 07 00	25	1	☆	☆	☆	☆		☆	☆	☆			RCMX 25 07 00
		RCMX 32 09 00	32	1.25	☆	☆	☆	☆							RCMX 32 09 00
					P05	P15	P25	P35	K15	K20	N15	S15			

T-Max ceramic

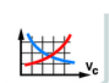
		ISO	IO	iC	K		S		H		ANSI
					CC	CC	CC	CC	CC	CC	
					650	650	670	650	670	670	
Finishing	RNGN	RNGN250700E	25	1			☆				RNG85A
		RNGN 25 07			☆	☆		☆			RNG85T8015
		RNGN 25 07			☆	☆	☆	☆	☆		RNG85K8015
					K01	S05	S15	H05	H10		



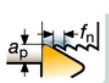
A386



A391



A406



A405

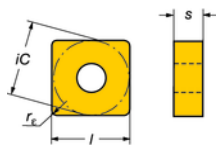


A524

Negative basic-shape inserts

T-MAX P

Square



For dimensions, see code key on page A16.

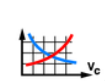
					P				M			K			
					GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
		ISO		iC	4205	4215	4225	4235	2025	2035	235	3205	3210	3215	ANSI
Medium	 SNMG-HM	SNMG 25 09 24-HM	25	1	☆	☆	☆	☆	☆						SNMG 866-HM
					P05	P15	P25	P35	M25	M35	M35	K05	K10	K15	



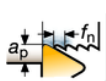
A383



A392



A406



A405

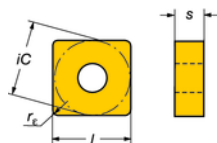


A524










Negative basic-shape inserts

T-MAX P

Square



For dimensions, see code key on page A16.

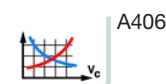
		ISO		iC	P			M			K			ANSI		
					GC	GC	GC	GC	GC	GC	GC	GC	GC			
Roughing	 SNMG-PR	SNMG 25 07 16-PR SNMG 25 07 24-PR SNMG 25 09 24-PR	25	1	4205	4215	4225	4235	2025	2035	235	3205	3210	3215	SNMG 854-PR SNMG 856-PR SNMG 866-PR	
	 SNMM-MR	SNMM 25 07 24-MR SNMM 25 07 32-MR SNMM 25 09 24-MR SNMM 25 09 32-MR	25	1		☆	☆	☆	☆	☆					SNMM 856-MR SNMM 858-MR SNMM 866-MR SNMM 868-MR	
	 SNMG-KR	SNMG 25 07 24-KR	25	1								☆	☆	☆	SNMG 856-KR	
	 SNMA-KR	SNMA 25 07 24-KR	25	1								☆		☆	SNMA 856-KR	
	 SNMM-QR	SNMM 25 07 24-QR	25	1		☆	☆									SNMM 856-QR
	 SNMM-HR	SNMM 25 07 24-HR SNMM 25 07 32-HR SNMM 25 09 24-HR SNMM 25 09 32-HR	25	1		☆	☆	☆			☆					SNMM 856-HR SNMM 858-HR SNMM 866-HR SNMM 868-HR
	 SNMG-MR*	SNMG 25 07 24-MR SNMG 25 09 24-MR	25	1							☆					SNMG 856-MR SNMG 866-MR
	 SNMM	SNMM 25 07 24	25	1				☆								SNMM 856



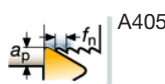
A383



A392



A406



A405

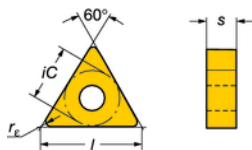


A524

Negative basic-shape inserts

T-MAX P

Triangular



For dimensions, see code key on page A16.

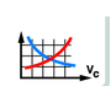
					P				M				K		
					GC	GC	GC	-	GC	GC	GC	GC	GC	GC	
		ISO		iC	4205	4215	4225	4235	S6	2025	2035	2035	3210	3215	ANSI
Medium	 TNMG-QM	TNMG 27 06 08-QM	27	5/8			☆					☆			TNMG 542-QM
		TNMG 27 06 12-QM			☆	☆						☆			TNMG 543-QM
	 TNMG-HM	TNMG 27 06 12-HM	27	5/8	☆	☆	☆	☆		☆					TNMG 543-HM
		TNMG 27 06 16-HM			☆	☆	☆	☆		☆					TNMG 544-HM
		TNMG 33 09 24-HM	33	3/4	☆	☆	☆	☆		☆					TNMG 666-HM
	 TNMG	TNMG 27 06 16	27	5/8	☆				☆						TNMG 544
Roughing	 TNMG-PR	TNMG 27 06 08-PR	27	5/8	☆	☆	☆								TNMG 542-PR
		TNMG 27 06 12-PR			☆	☆	☆								TNMG 543-PR
		TNMG 27 06 16-PR			☆	☆	☆								TNMG 544-PR
		TNMG 33 07 16-PR	33	3/4		☆	☆								TNMG 654-PR
		TNMG 33 09 24-PR			☆	☆	☆								TNMG 666-PR
	 TNMM-MR	TNMM 27 06 12-MR	27	5/8			☆								TNMM 543-MR
		TNMM 27 06 16-MR				☆				☆					TNMM 544-MR
		TNMM 27 06 24-MR								☆					TNMM 546-MR
	 TNMG-KR	TNMG 27 06 16-KR	27	5/8								☆			TNMG 544-KR
	 TNMA-KR	TNMA 27 06 16-KR	27	5/8								☆			TNMA 544-KR
	 TNMM-QR	TNMM 27 06 12-QR	27	5/8			☆								TNMM 543-QR
		TNMM 27 06 16-QR				☆									TNMM 544-QR
	 TNMM-HR	TNMM 27 06 16-HR	27	5/8	☆	☆	☆								TNMM 544-HR
		TNMM 27 06 24-HR				☆	☆								TNMM 546-HR
					P05	P15	P25	P35	P40	M25	M35	M35	K10	K15	



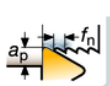
A384



A393



A406



A405

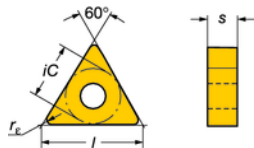


A524

Negative basic-shape inserts

T-MAX P

Triangular



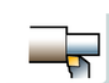
For dimensions, see code key on page A16.

					P				M				K		
					GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
					4205	4215	4225	4235	S6	2025	2035	235	3210	3215	
C	Roughing	ISO		iC											ANSI
			TNMG-MR*	27	5/8		☆	☆	☆			☆			TNMG 542-MR
						☆	☆	☆				☆			TNMG 543-MR
						☆	☆	☆				☆			TNMG 544-MR
				33	3/4		☆					☆			TNMG 666-MR
			TNMM	27	5/8		☆								TNMM 548
G						P05	P15	P25	P35	P40	M25	M35	M35	K10	K15

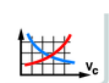
* Dedicated geometry for steel and stainless steel roughing.



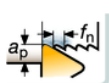
A384



A393



A406



A405

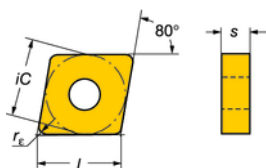
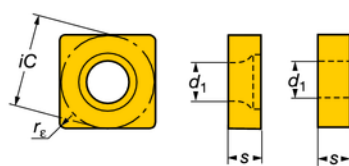


A524

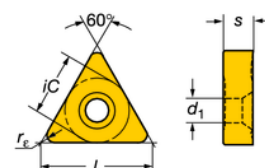
Negative basic-shape inserts

Engineered inserts

S-CNMM

S-SNMT S-SNMM
S-SNMX

S-TNMH



Code key

S-CCMT 38 09 32-

R1







Engineered inserts

R = Roughing

1 = Chip breaker version

TO BE QUOTED

For dimensions, see code key on page A16.

				Dimensions, mm, inch					P	M	K
Ordering code				iC	d_1	l	iW	s	r_e		
 S-CNMM	S-CNMM 25 09 24-R1	25	1	9.12 .359	-	-	-	9.52 .375	2.38 .094		
 S-SNMM	S-SNMM 25 07 24-R1	25	1	9.12 .359	-	-	-	7.938 .313	2.4 .094		
 S-SNMT	S-SNMT 25 09 24-R1	25	1	9.12 .359	-	-	-	9.525 .375	2.4 .094		
 S-SNMM	S-SNMM 25 09 24-R1	25	1	9.12 .359	-	-	-	9.525 .375	2.4 .094		
	S-SNMM 25 09 24-R2	25	1	9.12 .359	-	-	-	9.525 .375	9.525 .375		
	S-SNMM 25 09 24-R3	25	1	9.12 .359	-	-	-	9.525 .375	9.525 .375		
 S-SNMX	S-SNMX 32 09 24-R1	32	1 1/4	8.75 .344	-	-	-	9.525 .375	2.4 .094		
 S-TNMH	S-TNMH 44 11 32-HR	25	1	9.19 .362	43.99 1.732	-	-	11.13 .438	3.18 .125		

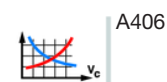
For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.



A382



A390



A406



A405

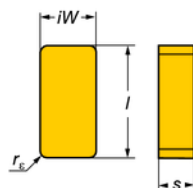
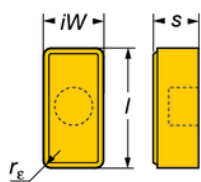


A524

Negative basic-shape inserts

Engineered inserts

S-LNMX

S-LNUN
S-LNUR

Code key

S-CCMT 38 09 32-

R1


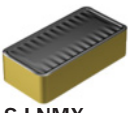


Engineered inserts

R = Roughing

1 = Chip breaker version

TO BE QUOTED

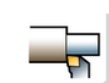
For dimensions, see code key on page A16.

			Dimensions, mm, inch				P	M	K
Ordering code				<i>l</i>	<i>iW</i>	<i>s</i>	<i>r_e</i>		
 S-LNMX	S-LNMX 50 14 32-R1	50		50.80 2.000	25.4 1.000	14 .551	3.2 .125		
 S-LNUN	S-LNUN 38 12 32-R1	38		38.10 1.500	19.05 .750	12.7 .500	3.2 .125		
 S-LNUR	S-LNUR 38 12 32-R1	38		38.10 1.500	19.05 .750	12.7 .500	3.2 .125		

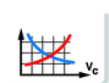
For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.



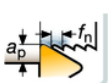
A389



A390



A406



A405

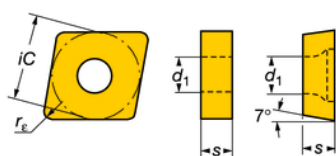


A524

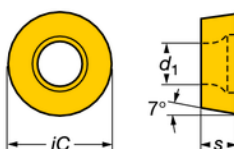
Positive basic-shape inserts

Engineered inserts

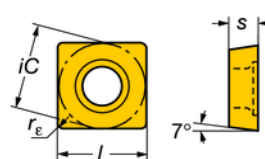
S-CCMT



S-RCMT/S-RCMX



S-SCMT



For dimensions, see code key on page A16.

Code key

S-CCMT 38 09 32-

R1

Engineered inserts

R = Roughing

1 = Chip breaker version

TO BE QUOTED

	Ordering code		iC	Dimensions, mm, inch			P	M	K
				d ₁	s	r _ε			
 S-CCMT	S-CCMT 38 09 32-R1	38	1½	9.12 .359	9.52 .375	3.2 .126			
 S-RCMT	S-RCMT 25 07 M0-R1	25	1	7.60 .299	7.938 .313				
 S-RCMX	S-RCMX 32 09 M0-R1	32	1¼	9.70 .382	9.525 .375				
 S-SCMT	S-SCMT 25 09 24-R1	25	1	9.12 .359	9.525 .375	2.4 .094			
	S-SCMT 38 09 32-R1	38	1½	9.12 .359	9.525 .375	3.2 .125			
 S-SCMT	S-SCMT 38 09 32-R5	38	1½	9.12 .359	9.525 .375	3.2 .125			

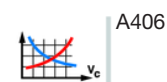
For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.



A400



A390



A406



A405



A524

Holders for negative basic-shape inserts

Coromant Capto®

CoroTurn® RC rigid clamp

B

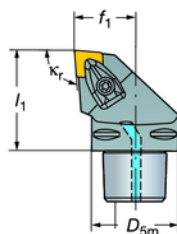
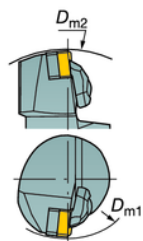


CNMM, CNGP
 CNMG
 CNMA, CNGA

Entering angle:
Lead angle:

DCLNR/L


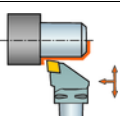
$\kappa_r 95^\circ$
 -5°



C

Coolant inlet: Axial through the center

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)										Gauge inserts			
				D_{5m}	D_{m1} min mm ⁴⁾	D_{m1} min in. ⁴⁾	D_{m2} min mm ⁴⁾	D_{m2} min in. ⁴⁾	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾
	25	1	C8-DCLNR/L-55080-25	80	150	5.906	250	9.842	55.0	2.165	80.0	3.150	-6°	-6°	CNMG 25 09 24	CNMG 866	9.5

G

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

H

Insert size			Shim (for insert thickness mm/inch)			Key (Torx Plus)			Complete clamp set		Key (Torx Plus)		Nozzle
	iC	Coupling size	Shim screw										
25	1	C8	5513 020-08	5322 234-05 (9.52/.374)		5680 043-15 (25IP)			5412 028-051 ¹⁾		5680 043-15 (25IP)		5691 045-01

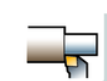
1) For CoroTurn RC clamp set parts, see page A445.

I

J



A373



A439

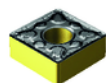


J2

Holders for negative basic-shape inserts

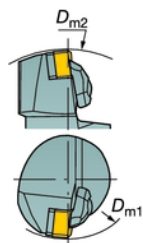
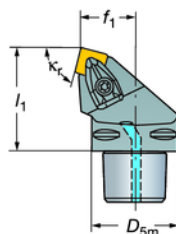
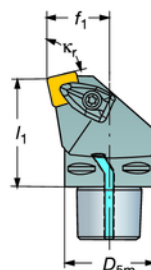
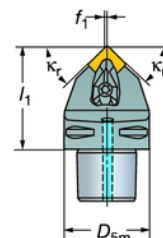
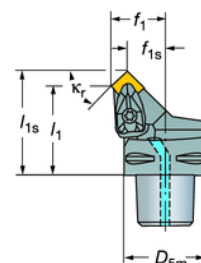
Coromant Capto®

CoroTurn® RC rigid clamp



SNMM
SNMG
SNMA, SNGA


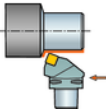
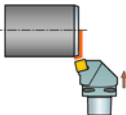
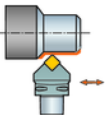
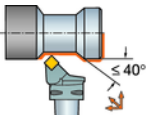
Entering angle:
Lead angle:

**DSRNR/L**
 $\kappa_r 75^\circ$
 15°
**DSKNR/L**
 $\kappa_r 75^\circ$
 15°
**DSDNN**
 $\kappa_r 45^\circ$
 45°
**DSSNR/L**
 $\kappa_r 45^\circ$
 45°


Neutral

Coolant inlet: Axial through the center

Right hand style shown unless otherwise stated

				Dimensions, millimeter, inch (mm, in.)										Gauge inserts		
Main application		iC	Ordering code	D_{5m}	D_{m1} min ⁴⁾	D_{m2} min ⁴⁾	f_1	f_{1s}	l_1	l_{1s}	γ^1	$\lambda_s^{2)}$	ISO	ANSI	Nm ³⁾	
	25	1	C8-DSRNR/L-45080-25	80		250 9.842	45 1.772		80 3.150		-6°	-6°	SNMG 25 07 24	SNMG 856	9.5	
	25	1	C8-DSKNR/L-55080-25	80	150 5.906		55 2.165		80 3.150		-6°	-6°	SNMG 25 07 24	SNMG 856	9.5	
	25	1	C8-DSDNN-00080-25	80		250 9.842	1 .039		80 3.150		-6°	-6°	SNMG 25 07 24	SNMG 856	9.5	
	25	1	C8-DSSNR/L-55070-25	80	150 5.906	256 10.079	55 2.165	39.0 1.535	70 2.756	86.0 3.386	-8°	0°	SNMG 25 07 24	SNMG 856	9.5	

1) γ = Rake angle (valid with flat insert).

R = Right hand, L = Left hand

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

Main spare parts

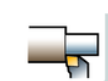
Insert size			Shim (for insert thickness mm/inch)			Key (Torx Plus)			Complete clamp set			Key (Torx Plus)			Nozzle		
<input type="checkbox"/>	iC	Coupling size	Shim screw														
25	1	C8	5513 020-08	5322 425-07(7.94/.313)		5680 043-15 (25IP)			5412 028-051 ¹⁾			5680 043-15 (25IP)			5691 045-01		
				5322 425-08(9.52/.374) ²⁾													

1) For CoroTurn RC clamp set parts, see page A445.

2) Optional part delivered to separate order.



A375



A439



J2

Holders for negative basic-shape inserts

Coromant Capto®

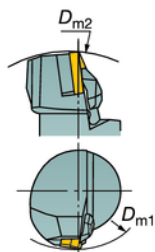
CoroTurn® RC rigid clamp

B



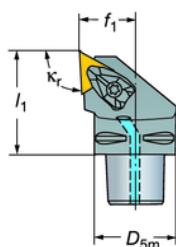
TNMM, TNMX
TNMG
TNMA, TNGA

Entering angle:
Lead angle:



DTJNR/L

κ_r 93°
-3°



C

Coolant inlet: Axial through the center

Right hand style shown unless otherwise stated

Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)							Gauge inserts		
				D_{5m}	D_{m1} min ⁴⁾	D_{m2} min ⁴⁾	f_1	l_1	$\gamma^1)$	$\lambda_s^2)$	ISO	ANSI	Nm ³⁾
	27	5/8	C6-DTJNR/L-45065-27	63	110	190	45	65	-6°	-6°	TNMG 27 06 12	TNMG 543	6.4
					4.331	7.480	1.772	2.559					

G

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Valid in combination with clamping unit R/LC2090.

R = Right hand, L = Left hand

Main spare parts

H

Insert size			Shim (for insert thickness mm/inch)					Key (Torx Plus)		Complete clamp set	Key (Torx Plus)	Nozzle
	iC	Coupling size	Shim screw									
27	5/8	C6	5513 020-07	5322 315-05(6.35/.250)		5680 043-14 (25IP)		5412 028-031 ¹⁾		5680 043-14 (25IP)		5691 045-01

1) For CoroTurn RC clamp set parts, see page A445.

I

J



A377



A439



J2

Holders for negative basic-shape inserts

Coromant Capto®

T-Max® P lever design

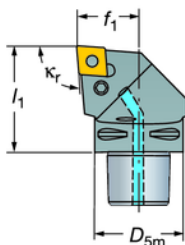
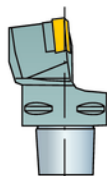


 CNMM, CNGP
 CNMG
 CNMA, CNGA

Entering angle:
Lead angle:


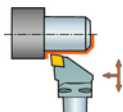
PCLNR/L

$\kappa_r 95^\circ$
 -5°



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated


Main application		iC	Ordering code	Dimensions, millimeter, inch (mm, in.)						Gauge inserts	
				D_{5m}	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^{1)}$ $\lambda_s^{2)}$	ISO	ANSI
	25	1	C8-PCLNR/L-55080-25	80	55.0	2.165	80.0	3.150	-6° -6°	CNMG 25 09 24	CNMG 866
			C10-PCLNR/L-68110-25	100	68.0	2.677	110.	.433			

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size									
	iC	Coupling size	Lever	Screw	Key (mm)	Shim (for radius mm/inch)	Shim pin	Shim pin punch	Nozzle (hole dia. mm)
25	1	C8	174.3-844M	174.3-827	3021 010-050 (5.0)	5322 230-01 (2.4-3.2/.094-.126)	174.3-865	174.3-874	5691 029-10
25	1	C10	174.3-844M	174.3-827	3021 010-050 (5.0)	5322 230-01 (2.4-3.2/.094-.126)	174.3-865	174.3-874	5691 034-03 (3.5) ¹⁾

1) When changing nozzle use key 5680 019-01 and bits 5680 021-04



A373



A446

Holders for negative basic-shape inserts

Coromant Capto®

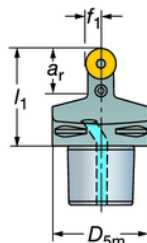
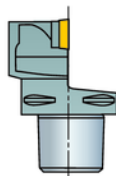
T-Max® P lever design

PRDCN

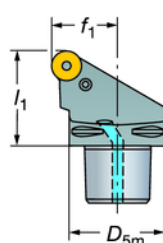
PRSCR/L



RCMX
RCMT
RCGX AL



Neutral



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application	$\frac{\circ}{\text{mm}}$	iC	Ordering code	Dimensions, mm, inch						Gauge inserts	
				D_{5m}	a_r	f_1	l_1	$\gamma^1)$	$\lambda_s^2)$	ISO	ANSI
	25	1	C6-PRDCN-00065-25A	63	40	12.5	65.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
					1.575	.492	2.559				
			C8-PRDCN-00080-25A	80	40	12.5	80.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
					1.575	.492	3.150				
			C10-PRDCN-00110-25	100	60	12.5	110.0	0°	0°	RCMT 25 07 00	RCMT 85
					2.362	.492	4.331				
	32	1 1/4	C8-PRDCN-00080-32A	80	45	16.0	80.0	0°	0°	RCMX 32 09 00	RCMX 32 09 00
					1.772	.630	3.150				
			C10-PRDCN-00110-32	100	65	16	110	0°	0°	RCMX 32 09 00	RCMX 32 09 00
					2.559	.630	4.331				
	25	1	C6-PRSCR/L-45065-25	63		45.0	65.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
						1.772	2.559				
			C8-PRSCR/L-55080-25	80		55.0	80.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
						2.165	3.150				
			C10-PRSCR/L-68110-25	100		68.0	110.0	0°	0°	RCMX 25 07 00	RCMX 25 07 00
						2.677	4.331				
	32	1 1/4	C8-PRSCR/L-55080-32	80		55.0	80.0	0°	0°	RCMX 32 09 00	RCMX 32 09 00
						2.165	3.150				
			C10-PRSCR/L-68110-32	100		68.0	110.0	0°	0°	RCMX 32 09 00	RCMX 32 09 00
						2.677	4.331				

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Insert size										
$\frac{\circ}{\text{mm}}$	iC	Coupling size	Lever	Screw	Key (mm)	Shim (for insert thickness mm/inch)	Shim pin	Shim pin punch	Nozzle (hole dia. mm)	
25	1	C6-C8	176.39-844	174.3-832	3021 010-040 (4.0)	176.39-854 (7.94/.313)	174.3-862	174.3-874	-	
25	1	C10	176.39-844	174.3-832	3021 010-040 (4.0)	176.39-854 (7.94/.313)	174.3-862	174.3-874	5691 034-03 (3.5) ¹⁾	
32	1 1/4	C6-C8	176.39-845	174.3-827	3021 010-050 (5.0)	176.39-855 (9.52/.374)	174.3-865	174.3-874	-	
32	1 1/4	C10	176.39-845	174.3-827	3021 010-050 (5.0)	176.39-855 (9.52/.374)	174.3-865	174.3-874	5691 034-03 (3.5) ¹⁾	

1) When changing nozzle use key 5680 019-01 and bits 5680 021-04



A374

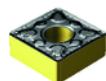


A446

Holders for negative basic-shape inserts

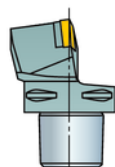
Coromant Capto®

T-Max® P lever design



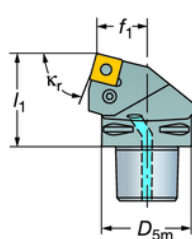
SNMM
 SNMG
 SNMA, SNGA

Entering angle:
Lead angle:



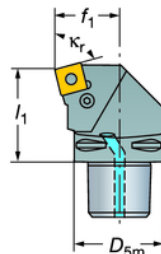
PSRNR/L

κ_r 75°
15°



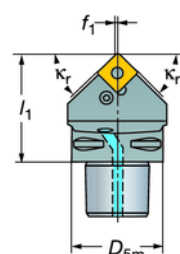
PSKNR/L

κ_r 75°
15°



PSDNN

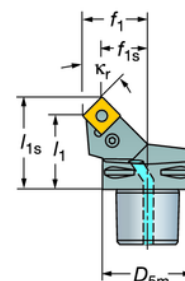
κ_r 45°
45°



Neutral



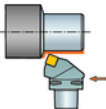
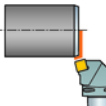
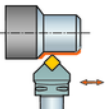
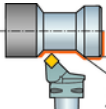
PSSNR/L

κ_r 45°
45°



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Right hand style shown unless otherwise stated				Dimensions, mm, inch								Gauge inserts	
Main application		iC	Ordering code	D_{5m}	f_1	f_{1s}	l_1	l_{1s}	$\gamma^{1)}$	$\lambda_{s^{2)}$		ISO	ANSI
	25	1	C8-PSRNR/L-45080-25	80	45		80		-6°	-6°	3.0	SNMG 25 07 24	SNMG 856
			C10-PSRNR/L-58110-25	100	58		110		-6°	-6°		SNMG 25 07 24	SNMG 856
	25	1	C8-PSKNR/L-55080-25	80	55		80		-6°	-6°	3.4	SNMG 25 07 24	SNMG 856
			C10-PSKNR/L-68110-25	100	68		110		-6°	-6°		SNMG 25 07 24	SNMG 856
	25	1	C6-PSDNN-00065-25	63	1		65		-6°	-6°	1.3	SNMG 25 07 24	SNMG 856
			C8-PSDNN-00080-25	80	.039		80		-6°	-6°	2.5		
			C10-PSDNN-00110-25	100	.039		110		-6°	-6°	4.8		
	25	1	C10-PSSNR/L-68092-25	100	68	51.0	92	108.0	-8°	0°	4.58	SNMG 25 07 24	SNMG 856

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Insert size										
	iC	Coupling size	Lever	Screw	Key (mm)	Shim (for insert thickness mm/inch)	For insert nose radius mm/inch	Shim pin	Shim pin punch	Nozzle (hole dia. mm)
25	1	C8	174.3-844M	174.3-827	3021 010-050 (5.0)	174.3-853M (7.94/.313)	1.6-3.2/.063-.126	174.3-865	174.3-874	5691 029-10
25	1	C10	174.3-844M	174.3-827	3021 010-050 (5.0)	174.3-853M (7.94/.313)	1.6-3.2/.063-.126	174.3-865	174.3-874	5691 034-(3.5) ¹⁾

1) When changing nozzle use key 5680 019-01 and bits 5680 021-04



A375



A446

Holders for negative basic-shape inserts

Coromant Capto®

T-Max P wedge clamp design

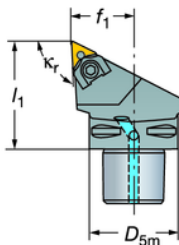
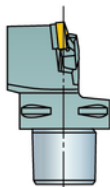


TNMM, TNMX
TNMG
TNMA, TNGA

Entering angle:
Lead angle:


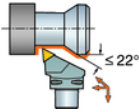
MTJNR/L

κ_r 93°
-3°



Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated


Main application		iC	Ordering code	Dimensions, mm, inch					Gauge inserts	
				D_{5m}	f_1	l_1	γ^1	λ_{s2}	ISO	ANSI
	27	5/8	C6-MTJNR/L-45065-27	63	45	65	-6°	-6°	TNMG 27 06 12	TNMG 543
					1.772	2.559				

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size		Coupling size	Wedge clamp set		Key (mm)	Shim (for insert thickness mm/inch)		For insert nose radius mm/inch		Pin		Screw		Key (mm)
	iC													
27	5/8	C6	170.38-822-1	174.1-864 (3.0)		170.3-854 (6.35/.250)		0.8-1.6/.032-.063		5313 021-04	3212 100-307			3021 010-040 (4.0)
						170.3-857 (6.35/.250) ¹⁾		2.4/.095						

1) Optional part delivered to separate order.



A377

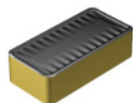


A446

Holders for negative basic-shape inserts

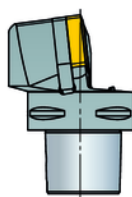
Coromant Capto®

T-Max® P lever design



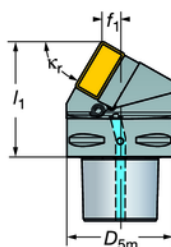
S-LNMX

Entering angle:
Lead angle:



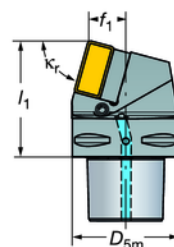
PLTNR/L

κ_r 60°
30°



PLRNR/L

κ_r 75°
15°



Neutral

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

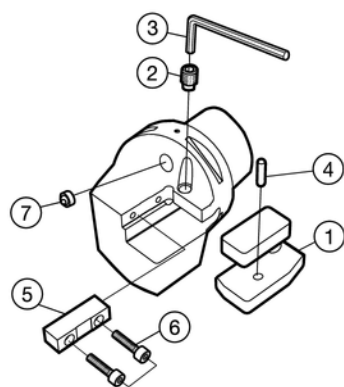
Main application		Ordering code	Dimensions, mm, inch					Gauge inserts
			D_{5m}	l_1	f_1	γ^1	λ_s^2	
	50	C10-PLTNR/L-18110-50	100	110	18	6°	6°	S-LNMX 50 14 32-R1
	2			4.331	.709			
	50	C10-PLRNR/L-35110-50	100	110	35	6°	6°	S-LNMX 50 14 32-R1
	2			4.331	1.378			

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts



Right hand shim	Left hand shim	Screw	Key (mm)	Parallell pin	Support	Screw (thread)	Nozzle (hole dia. mm)
5321 235-01	5321 235-02	5514 046-01	3021 010-060 (6.0)	3111 020-560	5323 015-01	3212 010-310 (M5x20)	5691 034-03 (3.5) ¹⁾

1) When changing nozzle use key 5680 019-01 and bits 5680 021-04



A380



A439



J2

Holders for negative basic-shape inserts

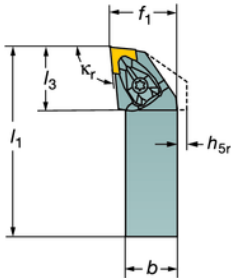
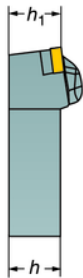
CoroTurn® RC rigid clamp design
Shank tools



- CNMM, CNGP
- CNMG
- CNMA, CNGA

Entering angle:
Lead angle:

DCLNR/L
κ_r 93°
-3°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	25	DCLNR/L 4040S 25	40	50	40	40	250	53.2	-6°	-6°	CNMG 25 09 24	9.5
		DCLNR/L 5050T 25	50	60	50	50	300	53.2	-6°	-6°	CNMG 25 09 24	9.5

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
	1	DCLNR/L 24 8E	1.500	2.000	1.500	1.500	7.000	2.090	-6°	-6°	CNMG 866	7.0

- 1) γ = Rake angle (valid with flat insert).
- 2) λ_s = Angle of inclination.
- 3) Insert tightening torque Nm.
- 4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Shim screw	Shim (for insert thickness mm/inch)	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
25	1	5513 020-08	5322 234-05 (9.52/.374)	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)



Holders for negative basic-shape inserts

CoroTurn® RC rigid clamp design

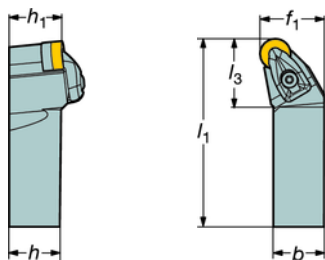
Shank tools

Neg.

DRSNR/L

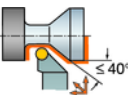


RNMG
RNGA



Right hand style shown unless otherwise stated

Metric version

Main application	25	Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
			b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾		
		DRSNR/L 4040S 25	40	50	40	40	250	50.5	-6°	-6°	RNMG 25 09 00	9.5

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size						
25	iC	Shim screw	Shim (for insert thickness mm/inch)	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
25	1	5513 020-08	5322 155-07 (9.52/.375)	5680 043-15 (25IP)	5412 028-051	5680 043-15 (25IP)



A374



A439

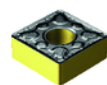


J2

Holders for negative basic-shape inserts

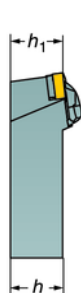
CoroTurn® RC rigid clamp design

Shank tools

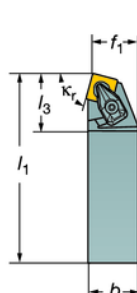
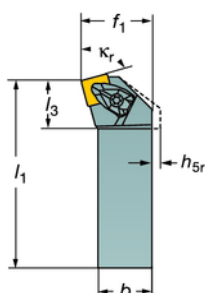


SNMM
SNMG
SNMA, SNGA

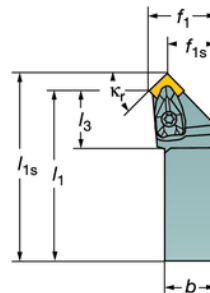
DSKNR/L
Entering angle: $\kappa_r 75^\circ$
Lead angle: 15°



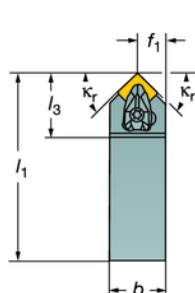
DSBNR/L, DSRNR/L
 $\kappa_r 75^\circ$
 15°



DSSNR/L
 $\kappa_r 45^\circ$
 45°



DSDNN
 $\kappa_r 45^\circ$
 45°



Right hand style shown unless otherwise stated

Neutral

Metric version

Main application		Ordering code	Dimensions, mm										Gauge inserts	Nm ³⁾
	25	DSKNR/L 5050T 25	50	60	50	50	300	35.2	-6°	-6°			SNMG 25 07 24	9.5
	25	DSBNR/L 4040S 25	40	35	40	40	250	56.6	-6°	-6°			SNMG 25 07 24	9.5
		DSBNR/L 5050T 25	50	43	50	50	300	56.6	-6°	-6°			SNMG 25 07 24	9.5
	25	DSSNR/L 4040S 25	40	50	34.0	40	40	250	41.1	266.0	-8°	0°	SNMG 25 07 24	9.5
	25	DSDNN 4040S 25	40	21	40	40	250	57.2	-6°	-6°			SNMG 25 07 24	9.5

Inch version

Main application	iC	Ordering code	Dimensions, inch										Gauge inserts	ft-lbs ⁴⁾
	1	DSKNR/L 32 8F	2.000	2.500	2.000	2.000	8.000	1.390	-6°	-6°			SNMG 856	7.0
	1	DSRNR/L 24 8E	1.500	1.697	1.500	1.500	7.000	2.220	-6°	-6°			SNMG 856	7.0
		DSRNR/L 32 8F	2.000	2.268	2.000	2.000	8.000	2.230	-6°	-6°			SNMG 856	7.0
	1	DSDNN 24 8D	1.500	.791	1.500	1.500	6.000	2.260	-6°	-6°			SNMG 856	7.0

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

4) Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

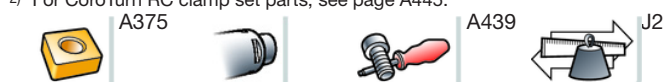
N = Neutral

Main spare parts

Insert size						
	iC	Shim screw	Shim (for insert thickness mm/inch)	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
25	1	5513 020-08	5322 425-07 (7.94/.312) 5322 425-08 (9.52/.375) ¹⁾	5680 043-15 (25IP)	5412 028-051 ²⁾	5680 043-15 (25IP)

1) Optional spare part delivered to separate order

2) For CoroTurn RC clamp set parts, see page A445.



Holders for negative basic-shape inserts

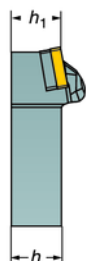
CoroTurn® RC rigid clamp design

Shank tools

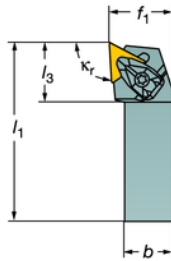


TNMM, TNMX
TNMG
TNMA, TNGA

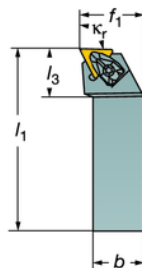
Entering angle:
Lead angle:



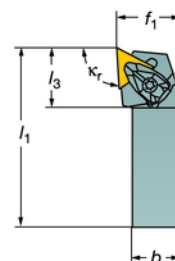
DTJNR/L
 $\kappa_r 93^\circ$
 -3°



DTFNR/L
 $\kappa_r 91^\circ$
 -1°



DTGNR/L
 $\kappa_r 91^\circ$
 -1°



Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm								Gauge inserts	Nm ³⁾
	27	DTJNR/L 3232P 27	32	40	32	32	170	49.8	-6°	-6°	TNMG 27 06 12	6.4
		DTJNR/L 4040S 27	40	50	40	40	250	38.4	-6°	-6°	TNMG 27 06 12	6.4
	27	DTFNR/L 3232P 27	32	40	32	32	170	38.1	-6°	-6°	TNMG 27 06 12	6.4
		DTFNR/L 4040S 27	40	50	40	40	250	37.4	-6°	-6°	TNMG 27 06 12	6.4
	33	DTFNR/L 4040S 33	40	50	40	40	250	41.4	-6°	-6°	TNMG 33 07 12	6.4
	27	DTGNR/L 3232P 27	32	40	32	32	170	40.6	-6°	-6°	TNMG 27 06 12	6.4
		DTGNR/L 4040S 27	40	50	40	40	250	39.3	-6°	-6°	TNMG 27 06 12	6.4

Inch version

Main application	iC	Ordering code	Dimensions, inch								Gauge inserts	ft-lbs ⁴⁾
	5/8	DTJNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.570	-6°	-6°	TNMG 543	4.7
		DTJNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.520	-6°	-6°	TNMG 543	4.7
	5/8	DTFNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.500	-6°	-6°	TNMG 543	4.7
		DTFNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.470	-6°	-6°	TNMG 543	4.7
	3/4	DTFNR/L 24 6D	1.500	2.000	1.500	1.500	6.000	1.630	-6°	-6°	TNMG 653	4.7
	5/8	DTGNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.590	-6°	-6°	TNMG 543	4.7
		DTGNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.550	-6°	-6°	TNMG 543	4.7
	3/4	DTGNR/L 24 6D	1.500	2.000	1.500	1.500	6.000	1.740	-6°	-6°	TNMG 653	4.7

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ Insert tightening torque ft-lbs.

R = Right hand, L = Left hand

Main spare parts

Insert size						
	iC	Shim screw	Shim (for insert thickness mm/inch)	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
27	5/8	5513 020-07	5322 315-05 (6.35/.250)	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)
33	3/4	5513 020-07	5322 315-06 (7.94/.313)	5680 043-14 (20IP)	5412 028-041 ¹⁾	5680 043-14 (20IP)

¹⁾ For CoroTurn RC clamp set parts, see page A445.


A377



A439



J2

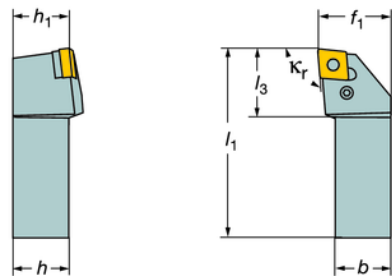
Holders for negative basic-shape inserts

T-Max® P lever design
Shank tools

Entering angle: **PCLNR/L**
 $\kappa_r 93^\circ$
Lead angle: -3°



- CNMM, CNGP
- CNMG
- CNMA, CNGA



Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm								Gauge inserts
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	
	25	1	PCLNR/L 4040S 25	40	50	40	40	250	50	-6°	-6°	CNMG 25 09 24
			PCLNR/L 5050T 25	50	60	50	50	300	50	-6°	-6°	CNMG 25 09 24

1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.
R = Right hand, L = Left hand

Main spare parts

Insert size								
	iC	Lever	Screw	Key (mm)	Shim (for insert thickness mm/inch)	For insert nose radius mm/inch	Shim pin	Shim pin punch
25	1	174.3-844M	174.3-827	3021 010-050 (5.0)	5322 230-01 (9.52/.374)	2.4-3.2/.063-.126	174.3-865	174.3-874



Holders for negative basic-shape inserts

T-Max® P lever design

Shank tools

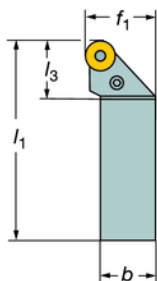
Neg.



RNMG
RNGA



PRGNR/L

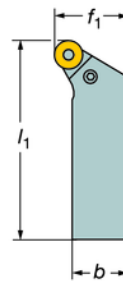


Pos.

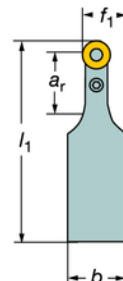


RCMX
RCMT
RCGX AL

PRGCR/L




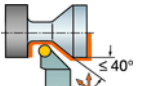
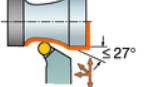
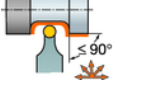
PRDCN



Neutral

Right hand style shown unless otherwise stated

Metric version

Main application		Ordering code	Dimensions, mm									Gauge inserts
			a_r	b	f_1	h	h_1	l_1	l_3	$\gamma^{1)}$	$\lambda_s^{2)}$	
	25	PRGNR/L 4040S 25		40	50	40	40	250	41.9	-6°	-6°	RNMG 25 09 00
	25	PRGCR/L 4040S 25		40	50	40	40	250		0°	0°	RCMX 25 07 00
	32	PRGCR/L 5050T 32		50	63	50	50	300		0°	0°	RCMX 32 09 00
	25	PRDCN 4040S 25	50	40	32.5	40	40	250		0°	0°	RCMX 25 07 00
	32	PRDCN 5050U 32	55	50	41	50	50	350		0°	0°	RCMX 32 09 00

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

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

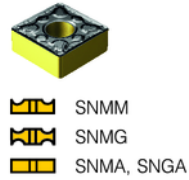
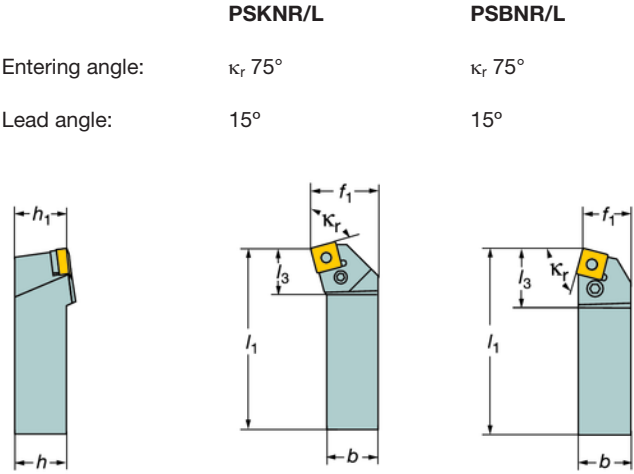
Main spare parts

Insert size								
Neg	Pos							
		Lever	Screw	Key (mm)	Shim (for insert thickness mm/inch)	Shim pin	Shim pin punch	
25		174.39-844M	174.3-827	3021 010-050 (5.0)	176.3-853M (9.52/.375)	174.3-865	174.3-874	
	25	174.39-844	174.3-832	3021 010-040 (4.0)	176.39-854 (7.94/.312)	174.3-862	174.3-872	
	32	174.39-845	174.3-827	3021 010-050 (5.0)	176.39-855 (9.52/.375)	174.3-865	174.3-874	






Holders for negative basic-shape inserts

T-Max® P lever design
Shank tools



Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm								Gauge inserts
				<i>b</i>	<i>f</i> ₁	<i>h</i>	<i>h</i> ₁	<i>l</i> ₁	<i>l</i> ₃	<i>γ</i> ¹⁾	<i>λ</i> _s ²⁾	
	25	1	PSKNR/L 5050T 25	50	60	50	50	300	37.5	-6°	-6°	SNMG 25 07 24
	25	1	PSBNR/L 4040S 25	40	35	40	40	250	47.5	-6°	-6°	SNMG 25 07 24
			PSBNR/L 5050T 25	50	43	50	50	300	47.5	-6°	-6°	SNMG 25 07 24

1) γ = Rake angle (valid with flat insert).

2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

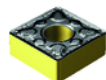
Insert size							
	iC	Lever	Screw	Key (mm)	Shim (for insert thickness mm/inch)	Shim pin	Shim pin punch
25	1	174.3-844M	174.3-827	3021 010-050 (5.0)	5322 230-01 (9.52/.374)	174.3-865	174.3-874



Holders for negative basic-shape inserts

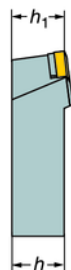
T-Max® P lever design

Shank tools



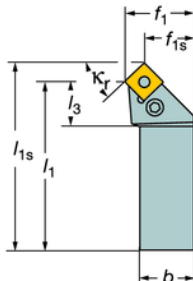
-  SNMM
-  SNMG
-  SNMA, SNGA

Entering angle:
Lead angle:



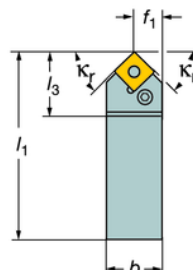
PSSNR/L

$\kappa_r 45^\circ$
 45°



PSDNN




$\kappa_r 45^\circ$
 45°



Neutral


Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm										Gauge inserts
				b	f ₁	f _{1s}	h	h ₁	l ₁	l ₃	l _{1s}	γ^1	$\lambda_s^{2)}$	
	25	1	PSSNR/L 4040S 25	40	50	34.4	40	40	250	48.8	266.0	-8°	0°	SNMG 25 07 24
	25	1	PSDNN 4040S 25	40	21		40	40	250	48.8		-6°	-6°	SNMG 25 07 24

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.R = Right hand, L = Left hand
N = Neutral

Main spare parts

Insert size				
	iC	Lever	Screw	Shim
25	1	174.3-844M	174.3-827	174.3-853M



A375



J2

Holders for negative basic-shape inserts

T-Max® P lever design
Shank tools

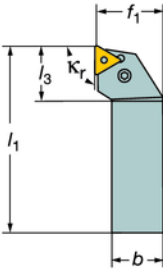
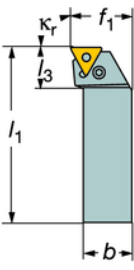
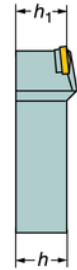


- TNMM, TNMX
- TNMG
- TNMA, TNGA

Entering angle:
Lead angle:

PTFNR/L
 $\kappa_r 91^\circ$
 -1°

PTGNR/L
 $\kappa_r 91^\circ$
 -1°



Right hand style shown unless otherwise stated

Metric version

Main application		iC	Ordering code	Dimensions, mm								Gauge inserts
				b	f ₁	h	h ₁	l ₁	l ₃	γ ¹⁾	λ _s ²⁾	
	27	5/8	PTFNR/L 3232P 27	32	40	32	32	170	34.4	-6°	-6°	TNMG 27 06 12
			PTFNR/L 4040S 27	40	50	40	40	250	33.2	-6°	-6°	TNMG 27 06 12
	33	3/4	PTFNR/L 4040S 33	40	50	40	40	250	38.2	-6°	-6°	TNMG 33 07 12
	27	5/8	PTGNR/L 3232P 27	32	40	32	32	170	35.2	-6°	-6°	TNMG 27 06 12
			PTGNR/L 4040S 27	40	50	40	40	250	34	-6°	-6°	TNMG 27 06 12

- 1) γ = Rake angle (valid with flat insert).
- 2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size								
	iC	Lever	Screw	Key (mm)	Shim (for insert thickness mm/inch)	For insert nose radius mm/inch	Shim pin	Shim pin punch
27	5/8	174.3-843M	174.3-825	174.1-864 (3.0)	179.3-854M (6.35/.250) 179.3-857M (6.35/.250) ¹⁾	0.8-1.2/.031-.047 1.6-2.4/.061-.094	174.3-864	174.3-873
33	3/4	174.3-842M	174.3-822M	3021 010- 040 (4.0)	179.3-855M (7.94/.313)		174.3-865	174.3-874

- 1) Optional part delivered to separate order.



Holders for negative basic-shape inserts

T-Max P wedge clamp design

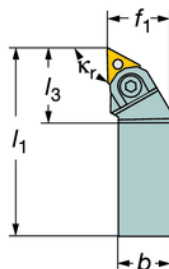
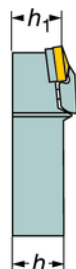
Shank tools



TNMM, TNMX
 TNMG
 TNMA, TNGA

Entering angle:
Lead angle:

WTJNR/L
 $\kappa_r 93^\circ$
 -3°



Right hand style shown unless otherwise stated

Inch version

Main application		iC	Ordering code	Dimensions, inch								Gauge inserts
				b	f ₁	h	h ₁	l ₁	l ₃	$\gamma^{1)}$	$\lambda_s^{2)}$	
	27	5/8	WTJNR/L 20 5D	1.250	1.500	1.250	1.250	6.000	1.750	-4°	-13°	TNMG 543
			WTJNR/L 24 5D	1.500	2.000	1.500	1.500	6.000	1.750	-4°	-13°	TNMG 543

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size								
	iC	Wedge clamp set	Key (inch)	Shim (for insert thickness mm/inch)	For insert nose radius mm/inch	Pin	Key (mm/inch)	
27	5/8	A170.38-822-1	174.1-871 (1/8)	170.3-858 (6.35/.250)	0.8-1.6/.031-.063	170.3-848M-1	3021 010-040 (4.0) (5/32)	



A377



J2

Holders for positive basic-shape inserts

Coromant Capto®

CoroTurn® 107 screw clamp design

Entering angle: $\kappa_r 95^\circ$

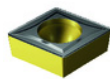
Lead angle: -5°

SSRCR/L
 $\kappa_r 75^\circ$

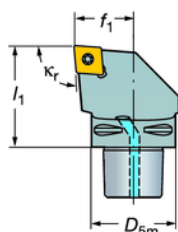
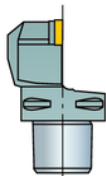
15°

SSDCN
 $\kappa_r 45^\circ$

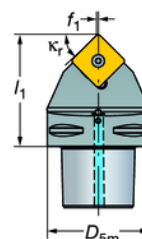
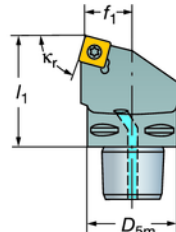
45°



CCMT



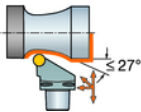

SCMT

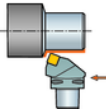



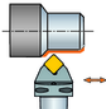

Neutral

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

				Dimensions, millimeter, inch (mm, in.)						Gauge inserts					
<div>Main application</div> 		iC	Ordering code	D_{5m}	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_{s^{2)}$	ISO	Nm ³⁾			
				38	1 1/2	C10-SCLCR/L-68110-38	100	68	2.677	110	4.331	0°	0°	CCMT380932	3.0

				Dimensions, millimeter, inch (mm, in.)						Gauge inserts					
<div>Main application</div> 		iC	Ordering code	D_{5m}	f_1 mm	f_1 in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_{s^{2)}$	ISO	Nm ³⁾			
				38	1 1/2	C10-SSRCR/L-58110-38	100	58	2.283	110	4.331	0°	0°	SCMT380932	3.0

<div>Main application</div> 		iC	Ordering code	D_{5m}			110	4.331	0°	0°	SCMT380932	3.0		
				38	1 1/2	C10-SSDCN-00110-38	100							

1) γ = Rake angle (valid with flat insert).2) λ_s = Angle of inclination.

3) Insert tightening torque Nm.

R = Right hand, L = Left hand

N = Neutral

Main spare parts

Ordering code	Insert screw	Key (Torx)	Shim	Shim screw	Key (mm)	Nozzle (hole dia. mm)
C10-SCLCR/L	5513 028-01	5680 042-03 (T30)	5322 232-03	5512 089-01	5680 042-03 (6.0)	5691 034-03 (3.5) ¹⁾
C10-SSRCR/L	5513 028-01	5680 042-03 (T30)	5322 465-01	5512 089-01	5680 042-03 (6.0)	5691 034-03 (3.5) ¹⁾
C10-SSDCN						

1) When changing nozzle use key 5680 019-01 and bits 5680 021-04



A381

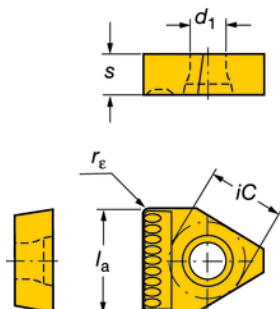
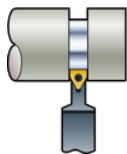



J2

Parting and grooving

Bear Paw

For external grooving



	iC		Ordering code	Dimensions, millimeter, inch (mm, in.)								P	M	S
	mm	inch		l_a mm	l_a in.	d_1 mm	d_1 in.	s mm	s in.	r_e mm	r_e in.	GC	GC	GC
												235	235	235
 BP	9.52	.375	BP-500030	12.7	.500	4.39	.173	4.77	.188	0.76	.030	☆	☆	☆
	12.70	.500	BP 625030	15.88	.625	4.39	.173	4.77	.188	0.76	.030	☆	☆	☆
	15.87	.625	BP-750030	19.05	.750	5.49	.216	6.35	.250	0.76	.030	☆	☆	☆
												P45	M35	S30

Feed recommendations and geometry descriptions



BP

For heavy duty external grooving

Excellent accuracy and repeatability.
Chip breaker that performs well in most materials at moderate to heavy feeds.

Width tolerance:
 $l_a = \pm 0.025$ mm
 $\pm .001$ inch

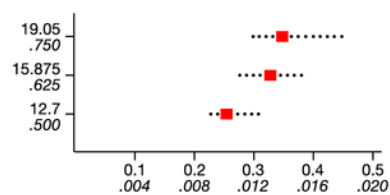
■ = Feed starting value

.... = Feed, approx, range

Radial feed

Starting values

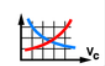
Insert width (l_a), mm, inch



Feed (f_n) mm/r
inch/r



A403



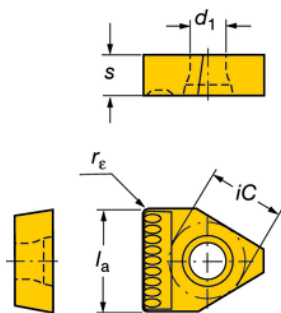
A406



J2


Parting and grooving

Bear Paw inserts



TO BE QUOTED

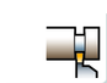
Inch version

	Ordering code	Dimensions, mm, inch										P	M	K
		iC mm	iC in.	lA mm	lA in.	d1 mm	d1 in.	s mm	s in.	rε mm	rε in.			
 BP	BP-476 050	9.52	.375	12.09	.476	4.39	.173	4.77	.188	1.27	.050			
	BP-500 010	9.52	.375	12.7	.500	4.39	.173	4.77	.188	0.25	.010			
	BP-500 030	9.52	.375	12.7	.500	4.39	.173	4.77	.188	0.76	.030			
	BP-500 060	9.52	.375	12.7	.500	4.39	.173	4.77	.188	1.51	.060			
	BP-503 118	9.52	.375	12.78	.503	4.39	.173	4.77	.188	3.00	.118			
	BP-512 118	9.52	.375	13.00	.512	4.39	.173	4.77	.188	3.00	.118			
	BP-530 080	9.52	.375	13.46	.530	4.39	.173	4.77	.188	1.51	.080			
	BP-580 090	9.52	.375	14.73	.580	4.39	.173	4.77	.188	2.29	.090			
	BP-592 080	9.52	.375	15.04	.592	4.39	.173	4.77	.188	1.51	.080			
	BP-594 060	9.52	.375	15.09	.594	4.39	.173	4.77	.188	1.51	.060			
	BP-601 030	9.52	.375	15.27	.601	4.39	.173	4.77	.188	0.76	.030			
	BP-604 060	9.52	.375	15.34	.604	4.39	.173	4.77	.188	1.51	.060			
	BP-620 090	12.7	.500	15.75	.620	4.39	.173	4.77	.188	2.29	.090			
	BP-625 010	12.7	.500	15.875	.625	4.39	.173	4.77	.188	0.25	.010			
	BP-625 030	12.7	.500	15.875	.625	4.39	.173	4.77	.188	0.76	.030			
	BP-645 075	12.7	.500	16.38	.645	4.39	.173	4.77	.188	1.91	.075			
	BP-650 080	12.7	.500	16.51	.650	4.39	.173	4.77	.188	2.03	.080			
	BP-655 125	12.7	.500	16.64	.655	4.39	.173	4.77	.188	3.18	.125			
	BP-660 090	12.7	.500	16.76	.660	4.39	.173	4.77	.188	2.29	.090			
	BP-670 090	12.7	.500	17.02	.670	4.39	.173	4.77	.188	2.29	.090			
	BP-685 060	12.7	.500	17.40	.685	4.39	.173	4.77	.188	1.51	.060			
	BP-708 075	12.7	.500	17.98	.780	4.39	.173	4.77	.188	2.29	.090			
	BP-750 010	15.87	.625	19.05	.750	5.51	.217	6.35	.250	0.25	.010			
	BP-750 030	15.87	.625	19.05	.750	5.51	.217	6.35	.250	0.76	.030			
	BP-840 080	15.87	.625	21.34	.840	5.51	.217	6.35	.250	2.03	.080			
	BP-893 080	19.05	.750	22.68	.893	6.50	.256	6.35	.250	2.03	.080			
	BP-919 060	22.22	.875	23.34	.919	7.59	.299	6.35	.250	1.51	.060			
	BP-1429 080	25.4	1.000	36.30	1.429	7.75	.305	9.525	.375	2.03	.080			

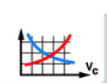
For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.



A401



A403



A406



J2

Parting and grooving

Bear Paw

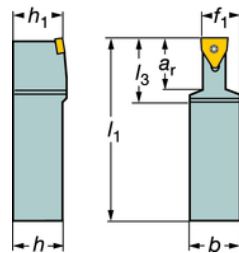
Shank tools for grooving

Screw design



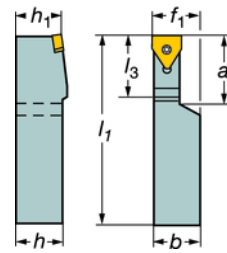
BP

BPGN



Neutral

BPGR/L



Right hand style shown unless otherwise stated

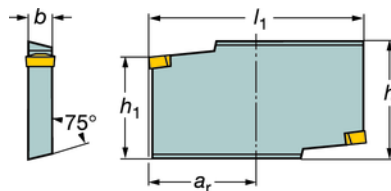
Main application	<i>iC</i>		<i>a_r</i> max mm	<i>a_r</i> max inch	Ordering code	Dimensions, millimeter, inch (mm, in.)														Gauge inserts
	mm	inch				<i>b</i> mm	<i>b</i> in.	<i>f</i> ₁ mm	<i>f</i> ₁ in.	<i>h</i> mm	<i>h</i> in.	<i>h</i> ₁ mm	<i>h</i> ₁ in.	<i>l</i> ₁ mm	<i>l</i> ₁ in.	<i>l</i> ₃ mm	<i>l</i> ₃ in.			
	9.525	.375	28.5	1.120	BPGN 50020	31.75	1.250	22.225	.875	31.75	1.250	31.75	1.250	152.4	6.000	35.05	1.380	BP 500030		
	12.7	.500	30.05	1.380	BPGN 62520	31.75	1.250	23.80	.937	31.75	1.250	31.75	1.250	152.4	6.000	41.40	1.630	BP 625030		
	15.875	.625	41.5	1.630	BPGN 75024	38.1	1.500	28.575	1.125	38.1	1.500	38.1	1.500	190.5	7.500	47.50	1.870	BP 750030		
	9.525	.375	31.75	1.250	BPGR/L 50024	38.1	1.500	38.1	1.500	38.1	1.500	38.1	1.500	152.4	6.000	28.96	1.140	BP 500030		
	12.7	.500	38.1	1.500	BPGR/L 62524	38.1	1.500	38.1	1.500	38.1	1.500	38.1	1.500	152.4	6.000	36.07	1.420	BP 625030		
	15.875	.625	44.45	1.750	BPGR/L 75024	38.1	1.500	38.1	1.500	38.1	1.500	38.1	1.500	177.8	7.000	41.91	1.650	BP 750030		

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

Double ended grooving blade

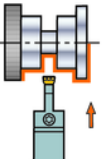
Bear Paw

Screw clamp



Right hand style shown unless otherwise stated

For tool blocks, see page .

Main application	Cutting edge height, mm	<i>iC</i>		<i>a_r</i> max mm	<i>a_r</i> max in.	Ordering code	Dimensions, millimeter, inch (mm, in.)										Gauge inserts
		mm	inch				<i>b</i> mm	<i>b</i> in.	<i>h</i> mm	<i>h</i> in.	<i>h</i> ₁ mm	<i>h</i> ₁ in.	<i>l</i> ₁ mm	<i>l</i> ₁ in.			
	45	9.52	.375	100	3.937	BPR/L151.2-45 500	11.05	.435	52.50	2.067	45.00	1.772	259.9	10.236	BP 500030		

R = Right hand, L = Left hand

Main spare parts

Shank tool	For insert thickness		Insert screw	Key (Torx Plus)
	mm	inch		
BP-500030	4.77	.188	5513 020-29	5680 049-01 (15IP)
BP-625030	4.77	.188	5513 020-29	5680 049-01 (15IP)
BP-750030	6.35	.250	5513 020-26	5680 043-14 (20IP)
Blade				
BPR/L 151.2-45 500			5513 020-29	5680 043-13 (9IP)



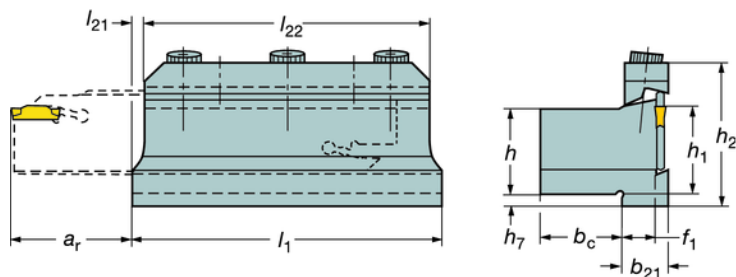
A401



J2

Parting and grooving

Tool blocks for blades



Metric version

Cutting edge height on blades, mm	ar max	Ordering code	Dimensions, mm									
			b ₂₁	b _c	f ₁	h	h ₁	h ₂	h ₇	l ₁	l ₂₁	l ₂₂
45	100	151.2-3232-45	20.4	31.6	13.4	32	32	82.5	29.7	160	5	150
45	100	151.2-4040-45	20.4	39.6	13.4	40	40	82.5	21.7	160	5	150

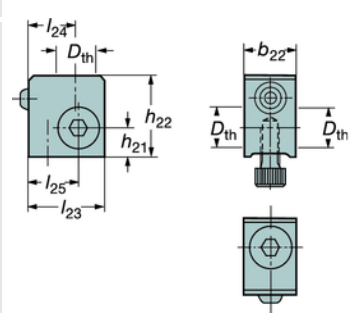
Inch version

Cutting edge height on blades, mm	ar max	Ordering code	Dimensions, inch									
			b ₂₁	b _c	f ₁	h	h ₁	h ₂	h ₇	l ₁	l ₂₁	l ₂₂
45	3.93	151.2-20-45	.800	1.230	.5299	1.250	1.250	3.250	1.181	6.299	.197	5.906
45	3.93	151.2-24-45	.800	1.480	.5299	1.500	1.500	3.250	1.929	6.299	.197	5.906

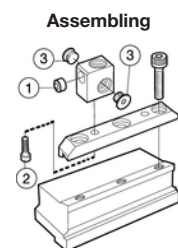
Main spare parts

Tool block mm	Inch	Clamp	Clamp screw	Key (mm)
151.2-3232-45	151.2-20-45	5412 120-03	3212 010-412	3021 010-060 (6.0)
151.2-4040-45	151.2-24-45	5412 120-03	3212 010-412	3021 010-060 (6.0)

Coolant adaptor for tool blocks and adaptors



Cutting edge height on blades, mm	Ordering code	Dimensions, mm, inch						
		b ₂₂	h ₂₁	h ₂₂	l ₂₃	l ₂₄	l ₂₅	D _{th}
45	5691 050-011	17	10	28	26	16.2	17.2	G1/4"
		.669	.394	1.102	1.024	.638	.677	



Ordering example: 2 pieces 5691 050-011

Main spare parts

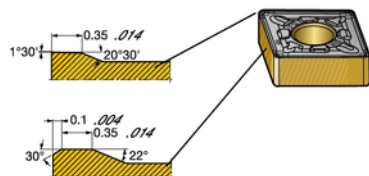
1	2	3		
Nozzle	Mounting screw	Plug	Key (mm) for plug	Key (mm) for mounting screw
5691 029-02	3212 010-358	5519 055-01	3021 010-060 (6.0)	3021 010-050 (5.0)

Insert geometries for heavy turning

PR

Double sided

For light roughing



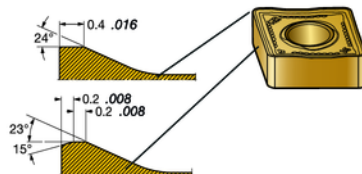
P

$a_p = 3.0$ (1.0-8.0) mm
 $.118$ (.039-.315) inch
 $f_n = 0.35$ (0.25-0.60) mm/r
 $.014$ (.010-.024) inch/r

.NMM-MR

Single sided

For roughing of stainless steel



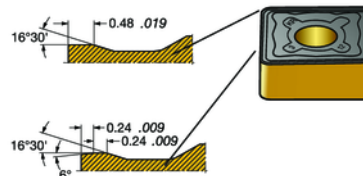
M

$a_p = 9.00$ (2.50-15.00) mm
 $.354$ (.098-.591) inch
 $f_n = 0.65$ (0.45-1.20) mm/r
 $.026$ (.018-.047) inch/r

KR

Double sided

Roughing of cast iron



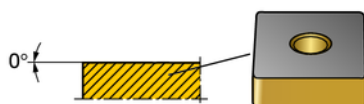
K

$a_p = 7.00$ (2.00-4.00) mm
 $.276$ (.079-.551) inch
 $f_n = 0.86$ (0.43-1.19) mm/r
 $.034$ (.017-.047) inch/r

KR

Double sided

Roughing of cast iron



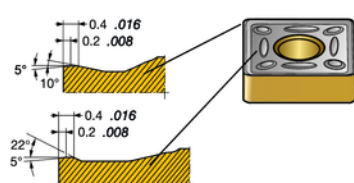
K

$a_p = 6.00$ (0.40-12.00) mm
 $.236$ (.016-.472) inch
 $f_n = 0.60$ (0.20-1.19) mm/r
 $.024$ (.008-.047) inch/r

HM

Double sided

Medium turning to roughing of steel and stainless steel



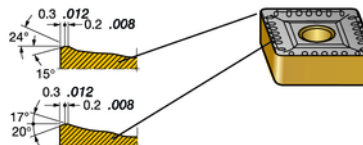
M

$a_p = 4.00$ (1.50-10.00) mm
 $.157$ (.059-.394) inch
 $f_n = 0.60$ (0.30-0.90) mm/r
 $.024$ (.012-.035) inch/r

HR

Single sided

For heavy roughing



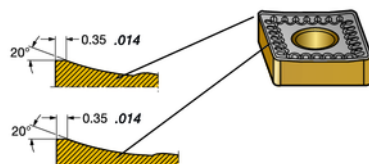
P

$a_p = 10.00$ (3.20-17.00) mm
 $.394$ (.126-.669) inch
 $f_n = 1.00$ (0.60-1.60) mm/r
 $.039$ (.024-.063) inch/r

QR

Single sided

Roughing in mixed production



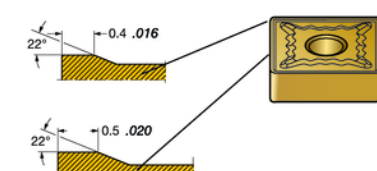
P

$a_p = 8.00$ (2.50-15.00) mm
 $.315$ (.098-.591) inch
 $f_n = 0.65$ (0.40-1.20) mm/r
 $.026$ (.016-.047) inch/r

.NMG-MR

Double sided

Dedicated geometry for roughing.



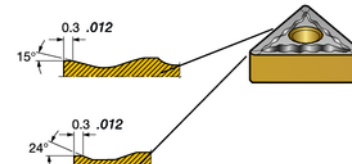
M

$a_p = 5.00$ (0.40-12.00) mm
 $.197$ (.016-.472) inch
 $f_n = 0.50$ (0.20-0.80) mm/r
 $.020$ (.008-.031) inch/r

QM

Double sided

For semi-finishing, medium to light roughing in mixed production.



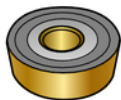
P

$a_p = 3.00$ (1.00-8.00) mm
 $.118$ (.039-.315) inch
 $f_n = 0.35$ (0.25-0.60) mm/r
 $.014$ (.010-.024) inch/r

Insert geometries for heavy turning

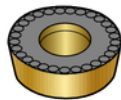
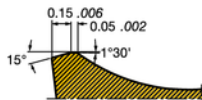
RCMX

Positive, single sided
For finishing to roughing.



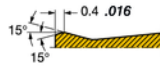
RCMT

Positive, single sided
Medium



RNMG

Positive, single sided
For finishing to roughing.



P

$a_p = 6.30$ (2.50-10.00) mm
.246 (.098-.394) inch
 $f_n = 0.79$ (0.25-2.50) mm/r
.031 (.010-.098) inch/r

P

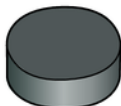
$a_p = 5.00$ (2.50-10.00) mm
.197 (.098-.394) inch
 $f_n = 1.25$ (0.25-2.50) mm/r
.049 (.010-.098) inch/r

K

$a_p = 6.30$ (2.50-10.00) mm
.246 (.098-.394) inch
 $f_n = 0.79$ (0.25-2.50) mm/r
.031 (.010-.098) inch/r

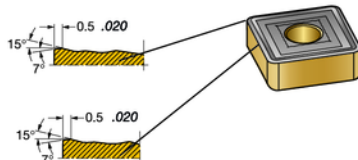
RNGN (Ceramic)

Double sided
For finishing to roughing.



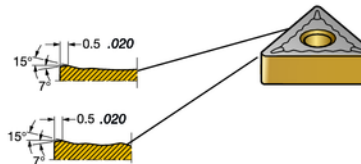
.NMM

Single sided



.NMG

Double sided



S

$a_p = 3.80$ (1.20-7.50) mm
.148 (.047-.295) inch
 $f_n = 0.20$ (0.10-0.20) mm/r
.008 (.004-.008) inch/r

M

$a_p = 6.00$ (2.00-12.00) mm
.236 (.079-.472) inch
 $f_n = 0.60$ (0.30-0.90) mm/r
.024 (.012-.035) inch/r

K

$a_p = 3.00$ (1.50-8.00) mm
.118 (.059-.315) inch
 $f_n = 0.40$ (0.40-0.65) mm/r
.016 (.016-.026) inch/r

Nominal cutting speed

Cutting speed v_c m/min (ft/min)

ISO P Steel	ISO M Stainless steel	ISO K Extra hard steel	ISO K Cast iron
120-30 (394-98)	100-15 (328-49)	50-15 (164-49)	100-50 (328-164)

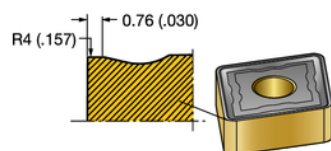
For grade description, see page A525

Insert geometries for heavy turning

Engineered inserts

S-CNMM 25 09 24-R1

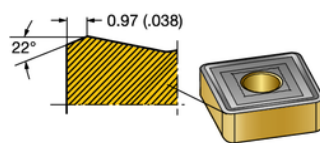
Negative, single sided
Roughing to medium roughing



$a_p = 3-17$ mm
.118-.699 inch
 $f_n = 1.0$ (0.6-1.5) mm/r
.039 (.024-.059) inch/r

S-SNMM 25 07 24-R1

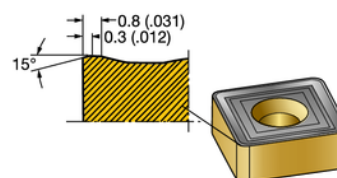
Negative, single sided
Roughing



$a_p = 3-17$ mm
.118-.669 inch
 $f_n = 0.9$ (0.7-1.4) mm/r
.035 (.028-.055) inch/r

S-SNMT 25 09 24-R1

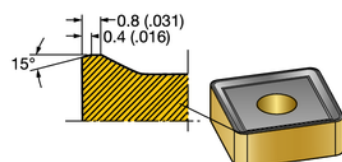
Negative, single sided
Roughing



$a_p = 3-17$ mm
.118-.669 inch
 $f_n = 0.9$ (0.7-1.4) mm/r
.035 (.028-.055) inch/r

S-SNMM 25 09 24-R1

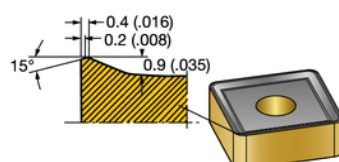
Negative, single sided
Medium roughing



$a_p = 3-17$ mm
.118-.699 inch
 $f_n = 0.8$ (0.5-1.4) mm/r
.031 (.020-.055) inch/r

S-SNMM 25 09 24-R2

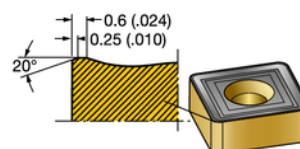
Negative, single sided
Medium



$a_p = 3-17$ mm
.118-.699 inch
 $f_n = 0.7$ (0.5-1.0) mm/r
.028 (.020-.039) inch/r

S-SNMM 25 09 24-R3

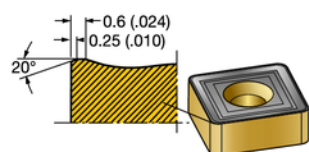
Negative, single sided
Medium roughing



$a_p = 3-17$ mm
.118-.699 inch
 $f_n = 0.8$ (0.5-1.4) mm/r
.031 (.020-.055) inch/r

S-SNMX 32 09 24-R1

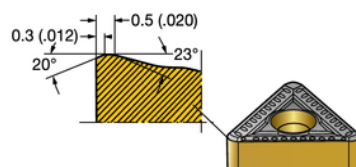
Negative, single sided
Roughing to medium roughing



$a_p = 3-22$ mm
.118-.866 inch
 $f_n = 1.1$ (0.8-1.8) mm/r
.043 (.031-.071) inch/r

S-TNMH 44 11 32-HR

Negative
Medium roughing



$a_p = 3.5-22$ mm
.138-.866 inch
 $f_n = 1.0$ (0.8-1.7) mm/r
.039 (.031-.067) inch/r

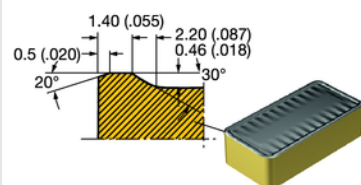
For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.

Insert geometries for heavy turning

Engineered inserts

S-LNMX 50 14 32-R1

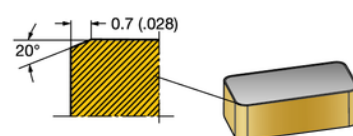
Negative, single sided
Heavy roughing to roughing



$a_p = 5-34$ mm
.197-1.339 inch
 $f_n = 1.7 (1.5-2.5)$ mm/r
.067 (.059-.098) inch/r

S-LNUN 38 12 32-R1

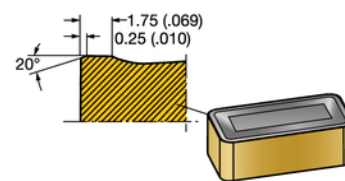
Double sided
Roughing to medium roughing



$a_p = 5-25$ mm
.197-.987 inch
 $f_n = 1.1 (0.6-1.6)$ mm/r
.043 (.024-.055) inch/r

S-LNUR 38 12 32-R1

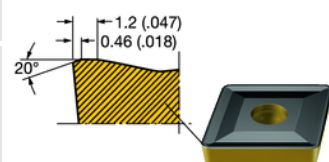
Negative, single sided
Roughing to medium roughing



$a_p = 5-25$ mm
.197-.984 inch
 $f_n = 1.0 (0.6-1.4)$ mm/r
.039 (.024-.055) inch/r

S-CCMT 38 12 32-R1

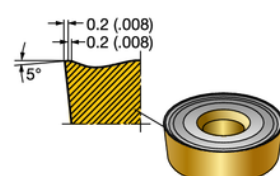
Positive, single sided
Heavy roughing



$a_p = 5-25$ mm
.197-.984 inch
 $f_n = 1.4 (1.2-2.0)$ mm/r
.055 (.047-.079) inch/r

S-RCMT 25 07 M0-R1

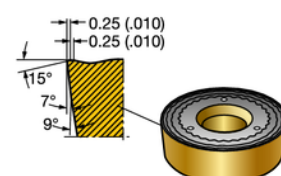
Positive, single sided
Medium roughing to finishing



$a_p = 2.5-10$ mm
.098-.394 inch
 $f_n = 1.25 (0.3-2.5)$ mm/r
.049 (.012-.098) inch/r

S-RCMX 32 09 M0-R1

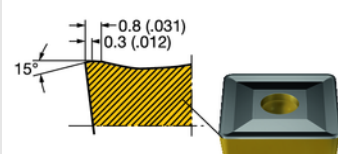
Positive, single sided
Roughing to finishing



$a_p = 3-12.8$ mm
.118-.504 inch
 $f_n = 1.6 (0.5-3.0)$ mm/r
.063 (.020-.118) inch/r

S-SCMT 25 09 24-R1

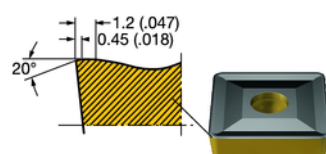
Positive, single sided
Roughing to medium roughing



$a_p = 3-17$ mm
.118-.669 inch
 $f_n = 1.1 (0.9-1.6)$ mm/r
.043 (.035-.063) inch/r

S-SCMT 38 09 32-R1

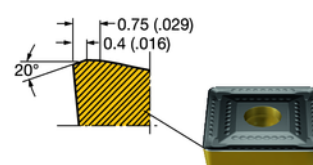
Positive, single sided
Heavy roughing



$a_p = 5-25$ mm
.197-.984 inch
 $f_n = 1.7 (1.4-2.3)$ mm/r
.067 (.055-.091) inch/r

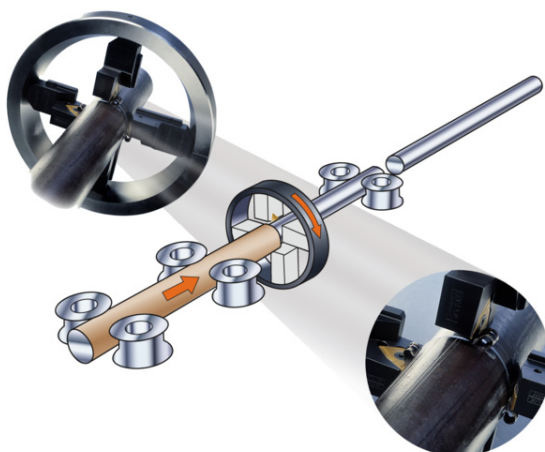
S-SCMT 38 09 32-R5

Positive, single sided
Roughing to medium roughing



$a_p = 5-25$ mm
.197-.984 inch
 $f_n = 1.3 (1.0-1.8)$ mm/r
.051 (.039-.071) inch/r

For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.



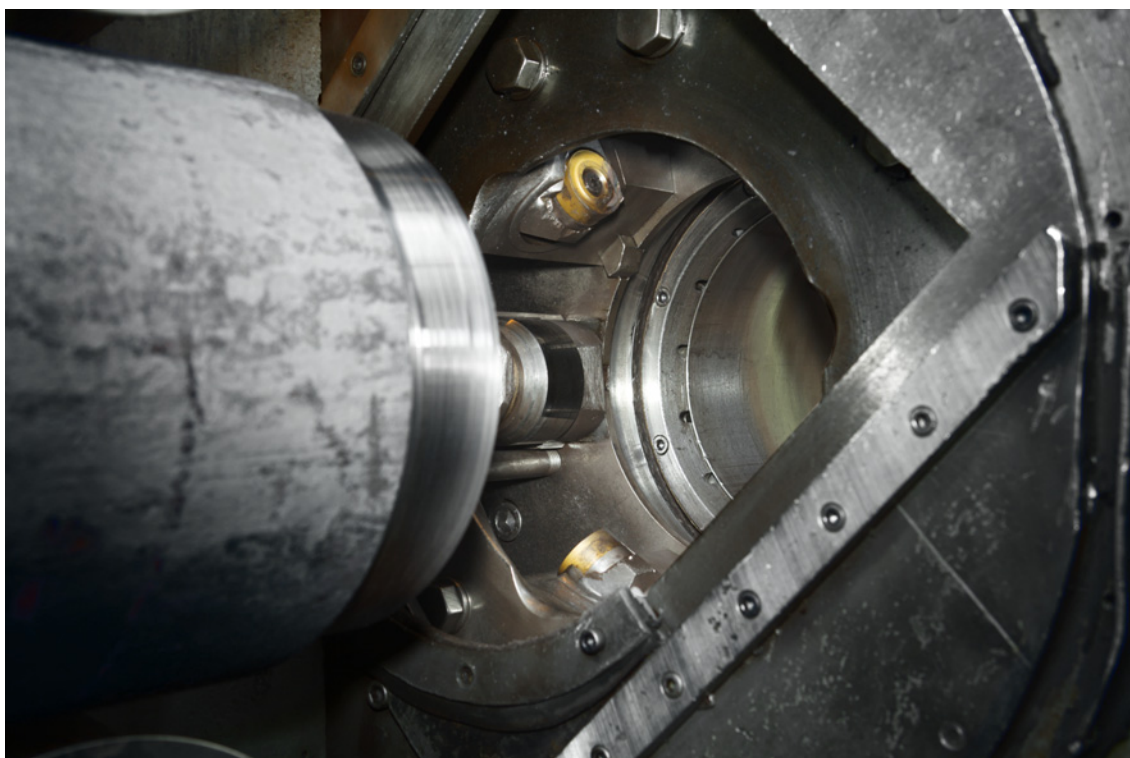
Bar peeling

Bar peeling is a method which is used to remove oxide scale, mill scale, surface cracks etc. from hot-rolled and forged blanks. Bar peeling is also applied to thick walled tubes.

The most common materials which are peeled are carbon steel, spring steel and stainless steels.

Application areas vary, but bar-peeled blanks are often used as an intermediate stage in the production of products which are to be processed further. Examples of these are extrusion blanks for tube manufacturing and axle components for the automobile industry.

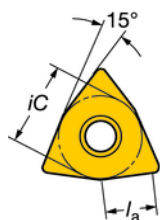
Compared with conventional turning, bar peeling is a method of machining which provides high productivity and low production costs due to the shorter throughput times. The surface quality and dimensional tolerances are also high, which in turn leads to less machining at subsequent stages.



Negative basic-shape inserts

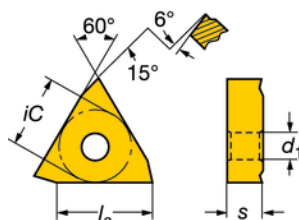
For screw clamping

Double sided



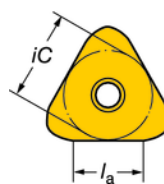
TNMX 11 06-2
TNMX 15 09-2

Single sided



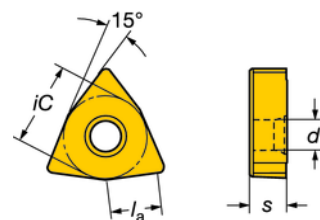
TNMX 24 07-1
TNMT 33 09 31-PF
TNMX 33 09 32-PF
TNMX 33 09 31-MM

Double sided



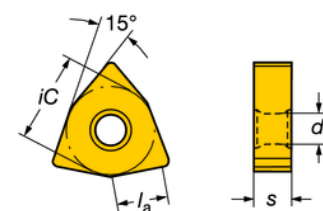
TNMX 49 10 51-MM

Single sided



WNMT 15 09 31-PM
WNMX 15 09 31-MM

Double sided



WNMX 21 12 51-MM

For dimensions, see code key on page A16.

WNMX 15 09 31 — 1 = Chip breaker version
|
3 = 3° angle of support chamfer.

Max a_p = max cutting depth

		ISO		iC	Max a_p mm	P				M				K	ANSI
						GC	GC	GC	GC	GC	GC	GC	GC		
Finishing		TNMX 11 06-2 ¹⁾	11	1/4	2				☆						TNMX 11 06-2
		TNMX 24 07-1 ¹⁾	24	3/4	1.2				☆						TNMX 24 07-1
		TNMT 33 09 31-PF	33	3/4	1.3				☆						TNMT 33 09 31-PF
		TNMX 33 09 31-MM	33	3/4	1.3					☆		☆			TNMX 33 09 31-MM
		TNMX 33 09 32-PF	33	3/4	1.3	☆		☆					☆		TNMX 33 09 32-PF
		TNMX 49 10 51-MM	49	1 1/8	2.5				☆						TNMX 49 10 51-MM
Medium		TNMX 15 09-2 ¹⁾²⁾	15	7/8	3	☆	☆	☆			☆		☆		TNMX 15 09-2
		WNMT 15 09 31-PM	15	7/8	3				☆	☆				☆	WNMT 15 09 31-PM
		WNMX 15 09 31-MM			3					☆	☆	☆			WNMX 15 09 31-MM
		WNMX 21 12 51-MM	21	1 1/4	5				☆	☆		☆	☆		WNMX 21 12 51-MM
						P10	P15	P25	P35	M15	M25	M30	K10		

¹⁾ Can also be used for lever clamping.

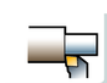
²⁾ Double sided insert, can be used in the same holder as WNMT 150931-PM and WNMX 150931-MM.



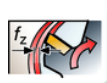
J2



A422



A415



A421

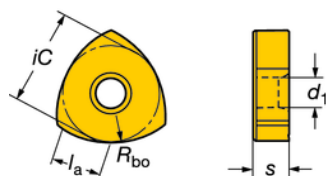


A423

Negative basic-shape inserts

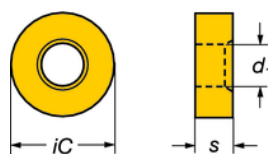
For screw clamping

Single sided



TNMX 44 09 01-MR

Single sided





RNMX 190.1-38 12 00
RNMX 38 12 00-MR
RNMX 50 18 M0-MR

For dimensions, see code key on page A16.

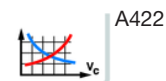
TNMX 44 09 01 — 1 = Chip breaker version

0 = No support chamfer.

Roughing		ISO		iC	P				M				K	ANSI
					GC	GC	GC	GC	GC	GC	GC	GC		
					3005	4215	4225	2015	2025	2135	3005			
		TNMX 44 09 01-MR	44	1					☆	☆		TNMX 44 09 01-MR		



J2



A422



A415



A421

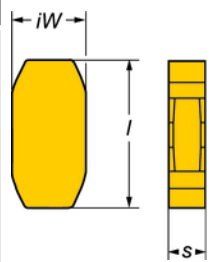


A423

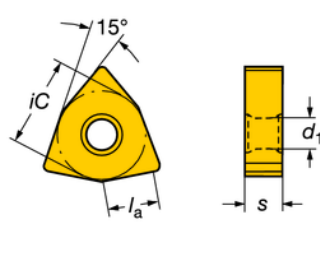
Negative basic-shape inserts

Engineered inserts

LNGF



TNMX



For dimensions, see code key on page A16.

S-LNGF 30 08 51- F1 — 1 = Chip breaker version

F = Finishing
M = Medium

R = Roughing

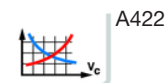
TO BE QUOTED

Max a_p = max cutting depth

			iC	Ordering code	Dimensions, mm, inch						P	M	K
					d_1	l	l_a	iW	s	Max a_p			
FINISHING		30	-	S-LNGF 30 08 51-F1		30.5 1.200		12.0 .472	8.0 .315	1.3 .051			
		40	-	S-LNGF 40 10 51-F1		40.0 1.575		20.0 .787	10.0 .394	2.5 .098			
		40	-	S-LNGF 40 12 51-F1		40.0 1.575		20.0 .787	12.0 .472	2.5 .098			
		49	1 1/8	S-TNMX 49 10 61-MF	7.93 .312		21.0 .827		10.0 .394	2.5 .098			
		15	7/8	TNMX 15 09-2	7.93 .312		13.0 .512		9.52 .375	3.0 .118			
		15	7/8	TNMX 15 09-2 MOD	7.93 .312		13.0 .512		9.52 .375	3.0 .118			
		33	3/4	S-TNMX 33 09 31-F1	7.93 .312		21.0 .827		9.52 .375	1.3 .051			
		33	3/4	S-TNMX 33 09 31-F2	7.93 .312		21.0 .827		9.52 .375	1.3 .051			
		06	3/8	S-TNMX 06 03-11)	3.81 .150		5.0 .197		3.18 .125	1.3 .051			

1) Only for lever clamping

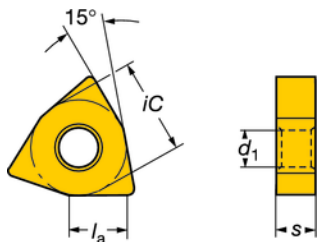
For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.



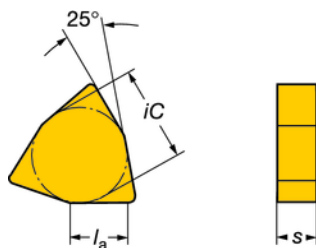
Negative basic-shape inserts

Engineered inserts

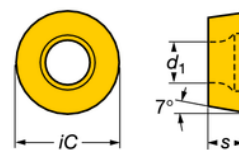
WNGX



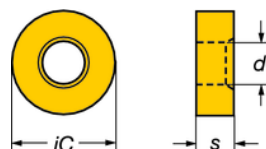
WNGF/WNMF



RCMT



RNMX



For dimensions, see code key on page A16.

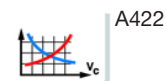
S - RCMT 25 07 M0- R1 — 1 = Chip breaker version
|
R = Roughing

TO BE QUOTED

			Ordering code	Dimensions, mm, inch				P	M	K
				d_1	l_a	s	Max a_p			
MEDIUM		15 7/8	S-WNGX 15 09 31-MM	7.93 .312	13 .512	9.525 .375	3.0 .118			
		15 7/8	S-WNGX 15 09 31-M1	7.93 .312	13 .512	9.525 .375	3.0 .118			
		21 1 1/4	S-WNGF 21 13 51-MM	-	15 .591	13 .512	5.0 .197			
		21 1 1/4	S-WNGF 21 13 51-M1	-	15 .591	13.0 .512	5.0 .197			
		1 1/8	WNMF 96	-	14.78 .582	8.885 .350	6.6 .260			
ROUGHING		25 .984	S-RCMT 25 07 M0-R ¹⁾	7.6 .299	-	7.94 .312	-			
		.984	S-RCMT 25 07 M0-R1	7.6 .299	-	7.94 .312	-			
		38 1 1/2	S-RNMX 38 12 00-MR	12.8 .504		12.0 .472	8.0 .315			

1) Only for lever clamping

For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.

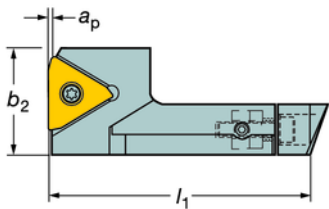


Precision bar peeling holders

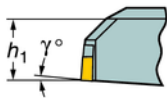
Suitable for Kieserling machine types
WDH..75, WDH..80 and 35

Insert type

T33



Example T33 = TNMX 33 09 31-PF



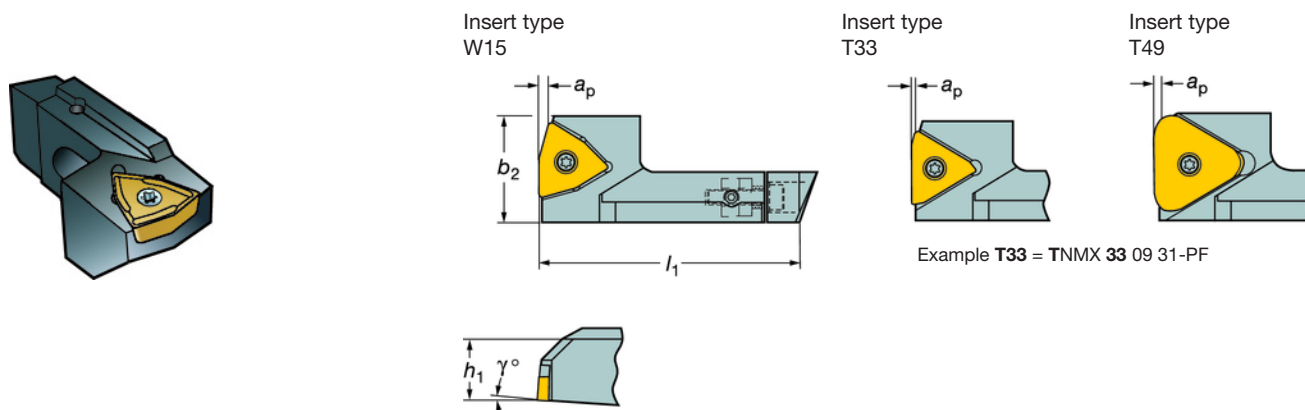
Ordering code	Bar diameter		Dimensions, millimeter, inch (mm, in.)							Adjustable stop		
	mm	inch	h ₁ mm	h ₁ in.	b ₂ mm	b ₂ in.	γ	Max a _p mm	Max a _p in.	To be ordered separately		Adjustment range ± 0.5 mm ± .020 inch
										Ordering code	l ₁ mm	
WDH..75												
L190.1-K075J008-T33	8 - 20	.315 - .787	24.5	.965	40	1.575	3°	1.3	.051	5331 050-04	106.6	4.197
	19 - 32	.748 - 1.260	24.5	.965	40	1.575	3°	1.3	.051	5331 050-03	100.6	3.961
WDH..80 and 35												
L190.1-K080J008-T33	8 - 20	.315 - .787	34	1.339	40	1.575	3°	1.3	.051	5331 050-02	106.6	4.197
	19 - 32	.748 - 1.260	34	1.339	40	1.575	3°	1.3	.051	5331 050-01	100.6	3.961

Ordering example: 4 pieces L190.1-K075J008-T33
Ordering example: 4 pieces 5331 050-04



Precision bar peeling holders

Suitable for Kieserling machine types WDH..75,
WDH..80 and 35



Example T33 = TNMX 33 09 31-PF

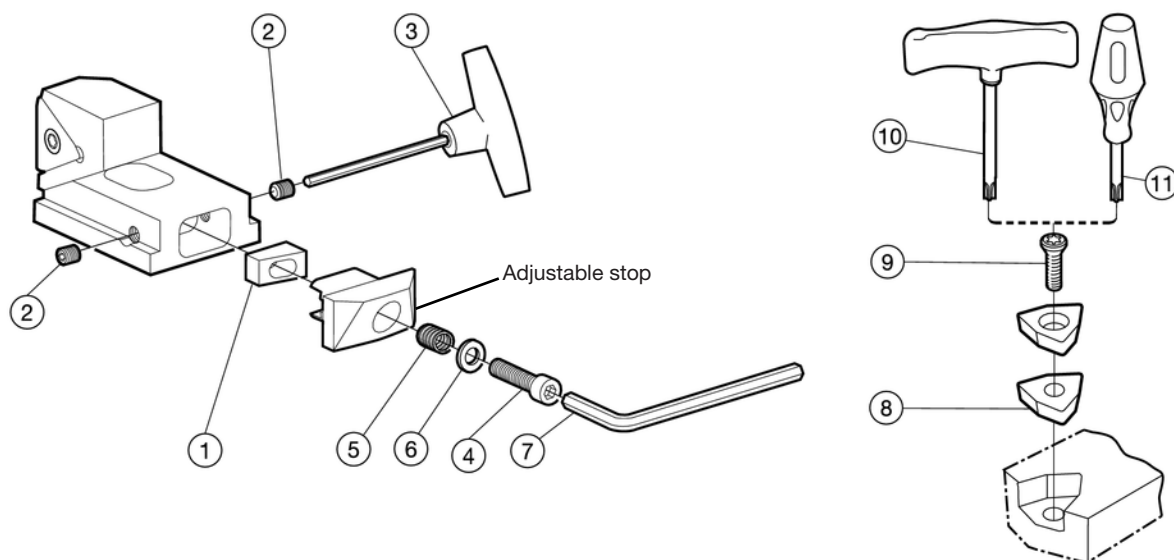
TO BE QUOTED

Ordering code	Bar diameter		Dimensions, millimeter, inch (mm, in.)							Adjustable stop			
	mm	inch	h_1 mm	h_1 in.	b_2 mm	b_2 in.	γ	Max a_p mm	Max a_p in.	To be ordered separately	Ordering code	l_1 mm	l_1 in.
Adjustment range ± 0.5 mm ± .020 inch													
WDH..75													
L190.1-K075J008-W15	8 - 20	.315 - .787	24.5	.965	42.5	1.673	3°	3	.118	5331 050-04	106.6	4.197	
	19 - 32	.748 - 1.260	24.5	.965	42.5	1.673	3°	3	.118	5331 050-03	100.6	3.961	
L190.1-K075J031-W15	31 - 44	1.220 - 1.732	24.5	.965	42.5	1.673	3°	3	.118	5331 050-04	94.6	3.724	
	43 - 56	1.693 - 2.205	24.5	.965	42.5	1.673	3°	3	.118	5331 050-03	88.6	3.488	
L190.1-K075J055-W15	55 - 68	2.165 - 2.677	24.5	.965	42.5	1.673	3°	3	.118	5331 050-04	82.6	3.252	
	67 - 80	2.638 - 3.150	24.5	.965	42.5	1.673	3°	3	.118	5331 050-03	76.6	3.016	
L190.1-K075J031-T33	31 - 44	1.220 - 1.732	24.5	.965	40.0	1.575	3°	1.3	.051	5331 050-04	94.6	3.724	
	43 - 56	1.693 - 2.205	24.5	.965	40.0	1.575	3°	1.3	.051	5331 050-03	88.6	3.488	
L190.1-K075J055-T33	55 - 68	2.165 - 2.677	24.5	.965	40.0	1.575	3°	1.3	.051	5331 050-04	82.6	3.252	
	67 - 80	2.638 - 3.150	24.5	.965	40.0	1.575	3°	1.3	.051	5331 050-03	76.6	3.016	
L190.1-K075L008-T49	8 - 20	.315 - .787	24.5	.965	43.0	1.693	5°	2.5	.098	5331 050-04	106.6	4.197	
	19 - 32	.748 - 1.260	24.5	.965	43.0	1.693	5°	2.5	.098	5331 050-03	100.6	3.061	
L190.1-K075L031-T49	31 - 44	1.220 - 1.732	24.5	.965	43.0	1.693	5°	2.5	.098	5331 050-04	94.6	3.724	
	43 - 56	1.693 - 2.205	24.5	.965	43.0	1.693	5°	2.5	.098	5331 050-03	88.6	3.488	
L190.1-K075L055-T49	55 - 68	2.165 - 2.677	24.5	.965	43.0	1.693	5°	2.5	.098	5331 050-04	82.6	3.252	
	67 - 80	2.638 - 3.150	24.5	.965	43.0	1.693	5°	2.5	.098	5331 050-03	76.6	3.016	
WDH..80 and 35													
L190.1-K080J008-W15	8 - 20	.315 - .787	34	1.339	42.5	1.673	3°	3	.118	5331 050-02	106.6	4.197	
	19 - 32	.748 - 1.260	34	1.339	42.5	1.673	3°	3	.118	5331 050-01	100.6	3.961	
L190.1-K080J031-W15	31 - 44	1.220 - 1.732	34	1.339	42.5	1.673	3°	3	.118	5331 050-02	94.6	3.724	
	43 - 56	1.693 - 2.205	34	1.339	42.5	1.673	3°	3	.118	5331 050-01	88.6	3.488	
L190.1-K080J055-W15	55 - 68	2.165 - 2.677	34	1.339	42.5	1.673	3°	3	.118	5331 050-02	82.6	3.252	
	67 - 80	2.638 - 3.150	34	1.339	42.5	1.673	3°	3	.118	5331 050-01	76.6	3.016	
L190.1-K080J031-T33	31 - 44	1.220 - 1.732	34	1.339	40.0	1.575	3°	1.3	.051	5331 050-02	94.6	3.724	
	43 - 56	1.693 - 2.205	34	1.339	40.0	1.575	3°	1.3	.051	5331 050-01	88.6	3.488	
L190.1-K080J055-T33	55 - 68	2.165 - 2.677	34	1.339	40.0	1.575	3°	1.3	.051	5331 050-02	82.6	3.252	
	67 - 80	2.638 - 3.150	34	1.339	40.0	1.575	3°	1.3	.051	5331 050-01	76.6	3.016	
L190.1-K080L008-T49	8 - 20	.315 - .787	34	1.339	43.0	1.693	5°	2.5	.098	5331 050-02	106.6	4.197	
	19 - 32	.748 - 1.260	34	1.339	43.0	1.693	5°	2.5	.098	5331 050-01	100.6	3.961	
L190.1-K080L031-T49	31 - 44	1.220 - 1.732	34	1.339	43.0	1.693	5°	2.5	.098	5331 050-02	94.6	3.724	
	43 - 56	1.693 - 2.205	34	1.339	43.0	1.693	5°	2.5	.098	5331 050-01	88.6	3.488	
L190.1-K080L055-T49	55 - 68	2.165 - 2.677	34	1.339	43.0	1.693	5°	2.5	.098	5331 050-02	82.6	3.252	
	67 - 80	2.638 - 3.150	34	1.339	43.0	1.693	5°	2.5	.098	5331 050-01	76.6	3.016	

To order, please contact your Sandvik Coromant representative.



Spare parts for holders

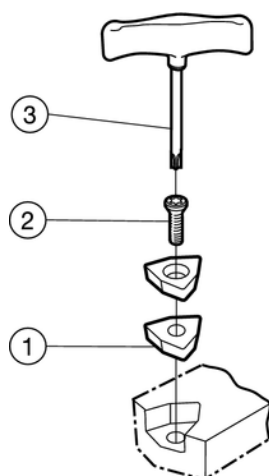


Holder	Standard parts Delivered with the tool						
	1	2	3	8	9	10	11
	Wedge	Adjustment Screw	Key (mm)	Shim	Insert screw	Key (Torx Plus)	Key (Torx Plus)
L190.1-Kxxxxxxx-W15	5332 055-01	3214 010-355	265.2-817 (3.0)	5322 333-03	5513 021-02	5680 048-05 (25IP)	5680 046-07 (25IP)
L190.1-Kxxxxxxx-T33	5332 055-01	3214 010-355	265.2-817 (3.0)	5322 338-02	5513 021-02	5680 048-05 (25IP)	5680 046-07 (25IP)
L190.1-Kxxxxxxx-T49	5332 055-01	3214 010-355	265.2-817 (3.0)	5322 354-01	5513 021-06	5680 048-05 (25IP)	5680 046-07 (25IP)

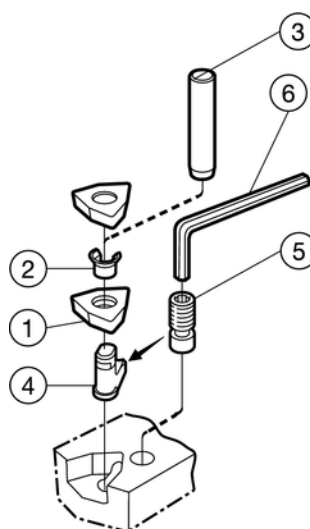
Adjustable stop	Standard parts Delivered with the stop			
	4	5	6	7
	Locking screw	Spring	Washer	Key (mm)
5331 050-01	3212 010-361	5561 001-48	3411 011-064	3021 010-050 (5.0)
5331 050-02	3212 010-361	5561 001-48	3411 011-064	3021 010-050 (5.0)
5331 050-03	3212 010-361	5561 001-48	3411 011-064	3021 010-050 (5.0)
5331 050-04	3212 010-361	5561 001-48	3411 011-064	3021 010-050 (5.0)

Spare parts for holders

Screw clamping tools



Lever clamping tools



Screw clamping tools with insert

Standard parts
Delivered with the tool

	1	2	3	Torque	
	Shim	Insert screw	Key (Torx plus/mm)	Nm	ft-lbs
TNMT 33 09 31-PF	5322 338-02	5513 021-02	5680 048-05 (25IP)	9.5	7.0
33 09 31-MF	5322 338-02	5513 021-02	5680 048-05 (25IP)	9.5	7.0
49 10 51-MF	5322 354-01	5513 021-06	5680 048-05 (25IP)	9.5	7.0
WNMT 15 09 31-PM	5322 333-03	5513 021-02	5680 048-05 (25IP)	9.5	7.0
WNMX 15 09 31-MM	5322 333-03	5513 021-02	5680 048-05 (25IP)	9.5	7.0
21 12 51-MM	5322 352-01	5513 021-01	3021 010-050 (5.0)		
TNMX 44 09 01-MR	5322 345-01	5513 021-02	5680 048-05 (25IP)	9.5	7.0
RNMX 38 12 00-MR	190.1-850	5513 019-01	3021 010-060 (6.0)		
50 18 M0-MR	5322 120-09	3213 010-463	3021 010-060 (6.0)		
TNMX 11 06-2	5322 333-01	5513 021-01	5680 043-15 (25IP)	9.5	7.0
15 09-2	5322 333-03	5513 021-02	5680 043-15 (25IP)	9.5	7.0
24 07-2	5322 338-01	5513 021-02	5680 043-15 (25IP)	9.5	7.0
190.1-38 12 00	190.1-850	3213 010-462	3021 010-060 (6.0)		
RNMG 25 09 00	5322 120-08	5513 021-03	5680 043-17 (30IP)		

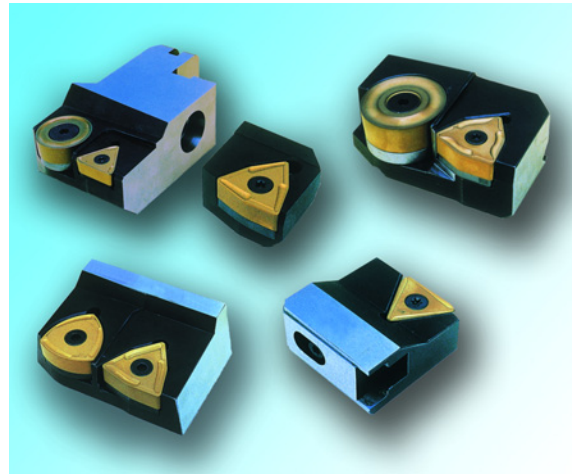
Lever clamping tools with insert

Standard parts
Delivered with the tool

	1	2	3	4	5	6
	Shim	Shim pin	Shim pin Punch	Lever	Clamping Screw	Key (mm/Torx Plus)
TNMX 06 03-01	-	-	-	174.3-845-1 174.3-840M	174.3-829 174.3-820	174.1-870 (1.98) 174.1-863 (2.5)
TNMX 11 06-2	179.3-841	174.3-864	174.3-872	174.3-843M	174.3-821	174.1-864 (3.0)
15 09-2	179.3-842	174.3-866	174.3-872	174.3-842M	174.3-822M	3021 010-040 (4.0)
24 07-1	179.3-843	174.3-866	174.3-872	174.3-842M	174.3-822M	3021 010-040 (4.0)
RNMG 25 09 00	176.3-853M	174.3-865	174.3-874	174.3-844M	174.3-827	5680 043-17 (30IP)

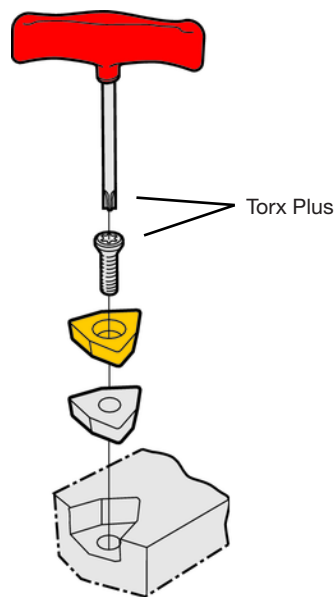
Bar peeling holders

Bar peeling holders can be supplied to special order to suit the machines of individual machine tool manufacturers. And in order to improve handling, adjustable holders and cassettes are also available. In this way the surface finish and dimensional tolerances are improved and higher cutting data can be used.

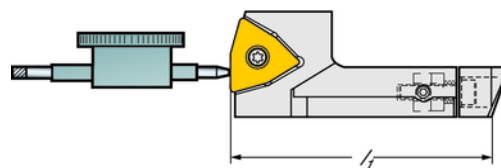


Screw clamping provides:

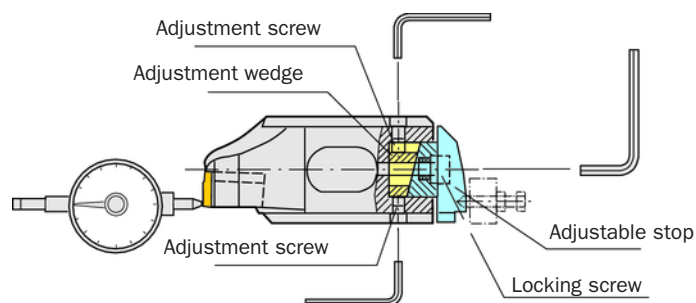
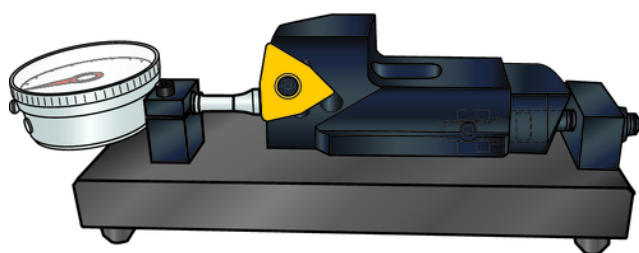
- Axial and radial clamping
- Few spare parts
- Economic solution
- No problems with chip removal



Presetting of the holder length, l_1

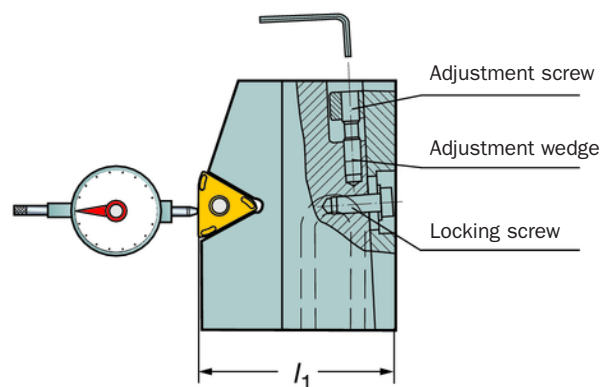


Adjustable standard tool holder for Kieserling WDH 75, 80 and 35 lathes

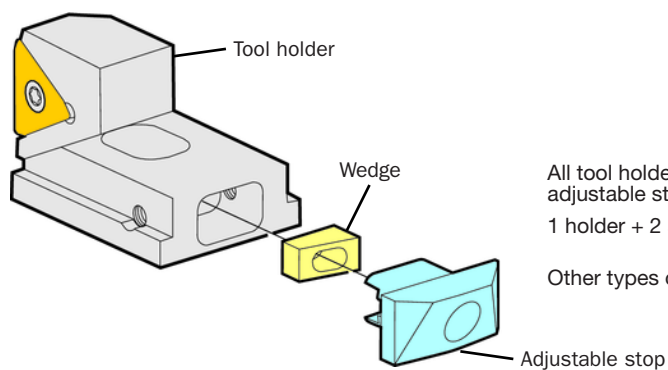


Fixture for presetting of a bar peeling holder

When setting the length, it is important that the tip of the dial indicator is positioned at the centre of the insert's ground support chamfer.



Adjustment of tool holders



All tool holders can be adjusted to the same length by using an adjustable stop.

1 holder + 2 adjustable stops cover 2 dimension areas in the machine.

Other types of tool holders can be ordered as special.

Machining example

Finishing

Max $a_p = 1.3 \text{ mm}$ (.051 inch)

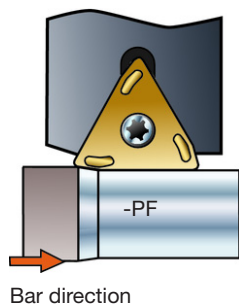
Bar dia. = 25 mm (.984 inch)

Material: CMC 01.2

Insert: TNMT 33 09 31-PF

$f_n = 25 \text{ mm/r}$ (.984 inch/r)

$v_c = 125 \text{ m/min}$ (410 ft/min)



Medium

Max $a_p = 3 \text{ mm}$ (.118 inch)

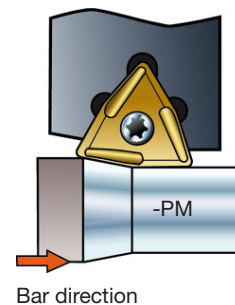
Bar dia. = 80 mm (3.150 inch)

Material: CMC 02.1

Insert: WNMT 15 09 31-PM

$f_n = 15 \text{ mm/r}$ (.591 inch/r)

$v_c = 125 \text{ m/min}$ (410 ft/min)



Roughing/medium

Rec. $a_p = 3.5 + 1.5 \text{ mm} = 5 \text{ mm}$
(.138 + .059 inch = .197 inch)

Bar dia. = 170 mm (6.693 inch)

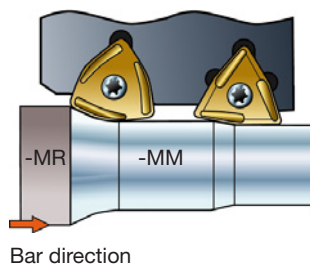
Material: CMC 05.51

Insert: TNMX 44 09 31-MR

WNMX 15 09 31-MM

$f_n = 12 \text{ mm/r}$ (.472 inch/r)

$v_c = 50 \text{ m/min}$ (164 ft/min)



Insert geometries

Double sided inserts

Double sided inserts are ground to 3° or 5° support chamfer (not TNMX1106-2).



TNMX 49 10 51-MF

Single sided inserts

A single sided insert has the advantage that the geometry can be optimized to provide the best chipbreaking. In addition, the insert must also be firmly fixed in the tip seat. Single sided inserts, with a flat base, provide stability in the tip seat. If the insert has a support chamfer, chamfer is 3°.



TNMX 33 09 31-MF

Support chamfer

Support chamfers are ground in two versions, 3° and 5°. The insert is inclined in the holder at the same angle.



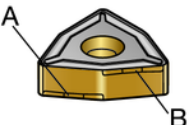
Finishing and medium inserts have support chamfer, for example:

3° angle of support chamfer.
|
TNMX 33 09 31-MF
|
Chip breaker
version

Insert geometries for bar peeling

FINISHING

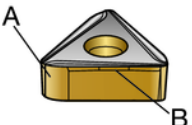
P K



TNMX 11 06-2
 a_p 0.2-1.3 mm
.008-.051 inch
 f_n 6.0 mm/r
.236 inch/r
 v_c 40-200 m/min
130-650 ft/min

Double sided


P K



TNMX 33 09 32-PF
 a_p 0.2-1.3 mm
.008-.051 inch
 f_n 16.0 mm/r
.630 inch/r
 v_c 40-200 m/min
130-650 ft/min

Single sided

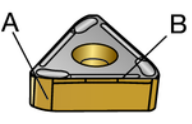
P



TNMX 24 07-1
 a_p 0.2-1.3 mm
.008-.051 inch
 f_n 16.5 mm/r
.650 inch/r
 v_c 40-200 m/min
130-650 ft/min

Single sided

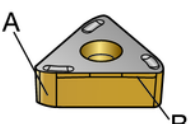
M



TNMX 33 09 31-MF
 a_p 0.2-1.3 mm
.008-.051 inch
 f_n 16.0 mm/r
.630 inch/r
 v_c 40-200 m/min
130-650 ft/min

Single sided

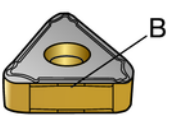
P



TNMT 33 09 31-PF
 a_p 0.2-1.3 mm
.008-.051 inch
 f_n 16.0 mm/r
.630 inch/r
 v_c 40-200 m/min
130-650 ft/min

Single sided

M P

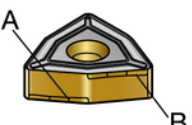


TNMX 49 10 51-MF
 a_p 0.3-2.5 mm
.012-.098 inch
 f_n 16.0 mm/r
.630 inch/r
 v_c 40-150 m/min
130-490 ft/min

Double sided

MEDIUM

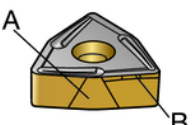
P M K



TNMX 15 09-2
 a_p 0.5-5.0 mm
.020-.197 inch
 f_n 10.0 mm/r
.394 inch/r
 v_c 40-150 m/min
130-490 ft/min

Double sided

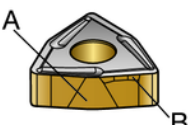
M P



WNMX 15 09 31-MM
 a_p 0.5-5.0 mm
.020-.197 inch
 f_n 10.0 mm/r
.394 inch/r
 v_c 40-150 m/min
130-490 ft/min

Single sided

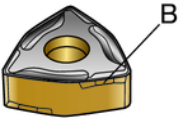
P K



WNMT 15 09 31-PM
 a_p 0.5-3.0 mm
.020-.118 inch
 f_n 10.0 mm/r
.394 inch/r
 v_c 40-150 m/min
130-490 ft/min

Single sided

M P

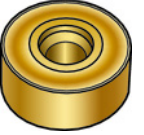


WNMX 21 12 51-MM
 a_p 0.5-5.0 mm
.020-.197 inch
 f_n 11.0 mm/r
.433 inch/r
 v_c 40-150 m/min
130-490 ft/min

Double sided

ROUGHING

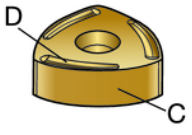
M



RNMX 38 12 00-MR
 190.1-38 12 00
 a_p 1.5-8.0 mm
.059-.315 inch
 f_n 16 mm/r
.276-.709 inch/r
 v_c 40-120 m/min
130-390 ft/min

Ø 38.1 mm
1.500 inch

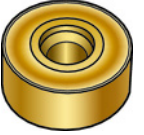
M



TNMX 44 09 01-MR
 a_p 0.7-5.0 mm
.028-.197 inch
 f_n 11 mm/r
.433 inch/r
 v_c 40-120 m/min
130-390 ft/min

Single sided

M



RNMX 50 18 MO-MR
 a_p 2.0-12.0 mm
.079-.472 inch
 f_n 7-18 mm/r
.276-.709 inch/r
 v_c 40-120 m/min
130-390 ft/min

Ø 50 mm
2.000 inch

 a_p = Cutting depth f_n = Max feed/insert v_c = Cutting speed**A** Positive clearance in cutting part of the edge.**B** Negative support chamfer along the support edge eliminates vibration.**C** Polygon shape 25 mm, .984 inch, radius.**D** Chip breaker width increases with depth of cut.

Grade description

Bar peeling

	ISO	ANSI		
P Steel	01	C8		▲
	10	C7	GC 4215	
	20	C6	GC 4225	
	30	C6	GC 4235	
	40	C5		
	50	C5		▼
			GC 3005	
M Stainless steel	10	–	GC 2015	▲
	20	–	GC 2025	
	30	–	GC 2135	
	40	–	GC 235	▼
K Cast iron	01	C4		▲
	10	C3	GC 3005	
	20	C2		
	30	C1		
	40	C1		▼

K

GC3005 (HC) - K10 (K01-K20)

CVD-coated carbide consisting of a wear resistant coating with very good adhesion to a hard substrate, capable of withstanding high temperatures. For finishing to roughing of nodular iron, high strength malleable iron and "gummy" (alloyed) grey iron.

P

GC4215 (HC) – P15 (P05–P25)

CVD-coated carbide grade for finishing to roughing in applications with continuous cut to light intermittence of steel and steel castings. A gradient substrate optimized in hardness and toughness with a wear resistant coating. Is able to withstand high temperatures without sacrificing edge line security in wet and dry applications.

GC4225 (HC) - P25 (P15 - P35)

CVD-coated carbide grade for finishing to roughing of steel and steel castings. A gradient substrate with optimized hardness and toughness for steel turning in combination with a thick wear resistant coating. This grade can handle continuous cuts as well as interrupted, a grade for a broad application area.

GC4235 (HC) – P35 (P20–P45)

CVD-coated carbide grade for roughing of steel and steel castings under unfavorable conditions. A gradient substrate with optimized hardness and toughness for steel turning in combination with a thick wear resistant coating. The edge line security enables the grade to handle interrupted cuts at high metal removal rates.

GC3005 (HC) - P10 (P01-P25)

CVD-coated carbide consisting of a wear resistant coating with very good adhesion to a hard substrate and capable of withstanding high cutting speed. For finishing and semi-finishing at high cutting speed of high alloy steels with high surface demands.

M

GC2015 (HC) – M15 (M05-M25)

CVD-coated carbide grade for finishing and light roughing of stainless steels. A substrate, which can handle high temperatures, combined with a wear resistant coating makes this grade a first choice for continuous cuts at moderate to high cutting speeds.

GC2025 (HC) – M25 (M15-M35)

CVD-coated carbide optimized for semi-finishing to roughing of austenitic stainless and duplex stainless steels at moderate cutting speeds. Good resistance to thermal shock and mechanical shock provides excellent edge security also for interrupted cuts.

GC2135 (HC) – M35 (M25–M40)

First choice CVD-coated carbide grade for stainless steel and other toughens demanding operations. Very good bulk and edge-line toughness. To be used at low to medium cutting speeds.

GC235 (HC) – M40 (M25-M40)

CVD-coated carbide grade for roughing of stainless steels and stainless steel castings with difficult skin. The tough substrate provides extremely good edge security which allows the grade to handle heavy interrupted cuts at low to moderate speeds.



Railway wheel re-turning

Sandvik's tool system for the re-turning of railway wheels consists of holders with replaceable tip seats for tangential inserts. This type of insert withstands the stresses which large cutting depths at high temperatures produce.

When choosing tools and inserts, it is important to bear in mind the type of wheel to be turned, the condition of the predominant part of the worn wheel, as well as the machine power which is available.

It is desirable to be able to choose a cutting depth which is as large as possible in order to achieve short machining times. This is not always possible.

In certain cases the profile can be turned in one single pass. With other machines it may be necessary to divide the machining into several stages in order to produce the right profile and diameter dimensions for the wheel.

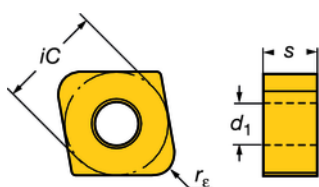
Dividing the machining into several stages is common with under floor lathes where friction force is used to drive the wheel.

Depending on the type of machining, there are various options of insert geometries and grades.

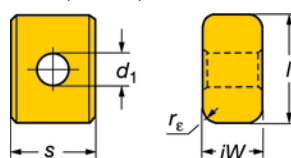
Turning of new railway wheels, see page A435.

Inserts for railway wheel re-turning

CNMX



LNUX, LNMX, 175.32



For dimensions, see code key on page A16.

						P				
						GC	GC	GC	-	
Finishing	ISO				iC	3015	4215	4225	SH	ANSI
	CNMX 19 11 40-PF	19		3/4	☆	☆				CNMX 19 11 40-PF
Medium	LNUX 19 19 40-PF		19	3/4	☆	☆	☆			LNUX 19 19 40-PF
Medium	LNUX 19 19 40-PM		19	3/4	☆	☆	☆			LNUX 19 19 40-PM
Medium	LNMX 19 19 40-PM		19	3/4	☆	☆	☆			LNMX 19 19 40-PM
Medium	LNMX 30 19 40-PM		30	1.181	☆	☆	☆			LNMX 30 19 40-PM
Medium	175.32-19 19 40-25		19	3/4	☆	☆	☆			175.32-19 19 40-25
Roughing	LNUX 30 19 40-PR		30	1.181	☆	☆	☆			LNUX 30 19 40-PR
Roughing	LNMX 30 19 40-PR		30	1.181	☆	☆				LNMX 30 19 40-PR
						P10	P15	P25	P20	



A433



J2



A428

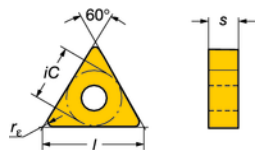


A432





Inserts for railway wheel re-turning

T-Max® P

Triangular



For dimensions, see code key on page A16.

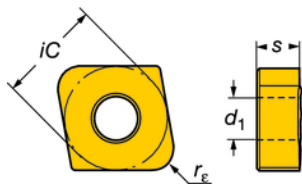
						P				M		K			
						GC	GC	GC	GC	-	GC	GC	GC		GC
Medium		TNMG 22 04 12-PM TNMG 22 04 16-PM		iC	4205	4215	4225	4235	S6	2025	2035	235	3210	3215	ANSI
					☆	☆	☆	☆							TNMG 433-PM
					☆	☆	☆	☆							TNMG 434-PM
Roughing		TNMG 22 04 12-PR TNMG 22 04 16-PR			☆	☆	☆	☆							TNMG 433-PR
					☆	☆	☆	☆							TNMG 434-PR
		TNMM 22 04 12-PR TNMM 22 04 16-PR				☆	☆	☆							TNMM 433-PR
						☆	☆	☆							TNMM 434-PR
					P05	P15	P25	P35	P40	M25	M35	M35	K10	K15	



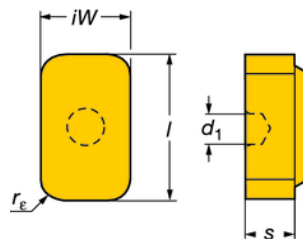
Inserts for railway wheel re-turning

Engineered inserts

CNMX



LNUX



For dimensions, see code key on page A16.

Code key

S-CNMX 19 07 40-



Engineered inserts

M1

M = Medium

1 = Chip breaker version

TO BE QUOTED

				Ordering code	Dimensions, mm, inch						P	M	K
					d ₁	l	iW	s	r _ε	Max a _p			
MEDIUM		19		S-CNMX 19 07 40-M1	7.93	-	-	7.94	4.0	1.3			
					.312	-	-	.313	.157	.051			
ROUGHING		32		S-LNUX 32 12 48-R1	7.92	31.75	19.05	12.7	4.75	2.5			
					.312	1.250	.750	.500	.187	.098			

For grade choice, see grade information on page A524 and contact your Sandvik Coromant representative for an offer.



A433



J2



A428

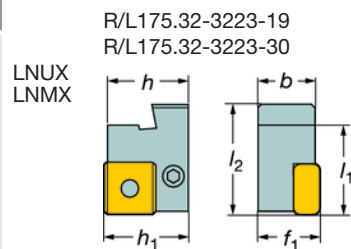


A432

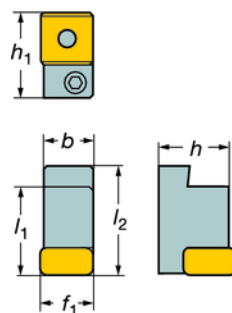
Cutting units for negative basic-shape inserts

T-Max® P

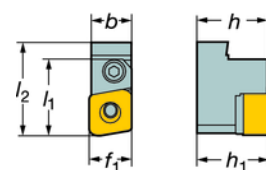
B

LNMX
LNMX

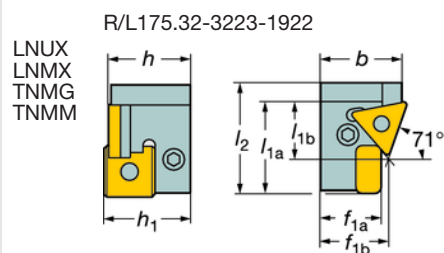
R/L177.32-3219-19

CNMX
191140-PF

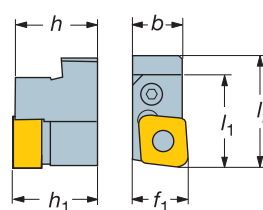
R/L177.32-3219-1911



C


CNMX
191140-PF

R/L175.32-3223-1911



G

Right hand style shown when nothing else is stated

			Dimensions, mm, inch											Gauge insert	
	iC	Ordering code	b	f ₁	f _{1a}	f _{1b}	h	h ₁	l ₁	l _{1a}	l _{1b}	l ₂	ISO	ANSI	
19	3/4	R/L175.32-3223-19	22.6	23			31	32	35			42.2	LNMX 19 19 40	LNMX 19 19 40	
			.890	.906			1.220	1.260	1.378			1.661			
	3/4	R/L175.32-3223-1911	20.5	23			31.5	32	35.9			43.5	CNMX 19 11 40	CNMX 19 11 40	
			.807	.906			1.240	1.260	1.413			1.713			
19	3/4	R/L175.32-3223-1922	31.5		23	25.4	31.4	32			35	20.5	42.2	LNMX 19 19 40	LNMX 19 19 40
22			1.240		.906	1.000	1.236	1.260		1.378	.807	1.661	TNMG 22 04 08	TNMG 22 04 08	
30	1.181	R/L175.32-3223-30	22.6	23			31	32	35			42.2	LNMX 30 19 40	LNMX 30 19 40	
			.890	.906			1.220	1.260	1.378			1.661			
19	3/4	R/L177.32-3219-19	18.6	19.1			31	32	35			42.2	LNMX 19 19 40	LNMX 19 19 40	
			.732	.752			1.220	1.260	1.378			1.661			
	3/4	R/L177.32-3219-1911	18.1	19.1			31.5	32	35			42.2	CNMX 19 11 40	CNMX 19 11 40	
			.713	.752			1.240	1.260	1.378			1.661			

R = Right hand, L = Left hand

I

J

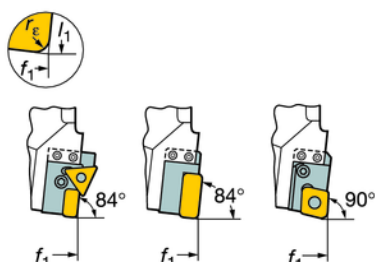
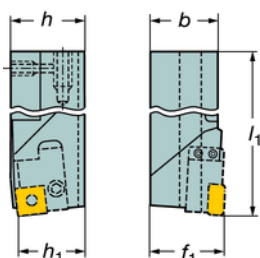


Holders for cutting units

T-MAX P cutting units

For one cutting unit

cutting units

R/L175.32
-3223-1922R/L175.32
-3223-19/-3223-30R/L175.32
-3223-1911

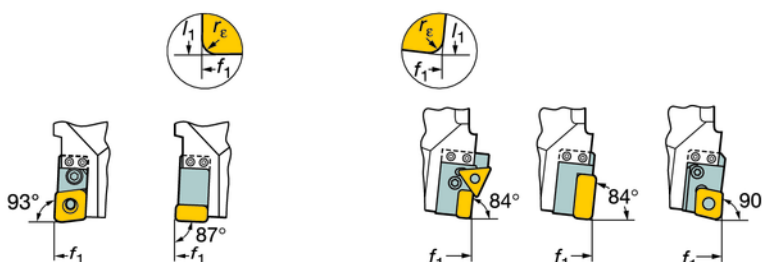
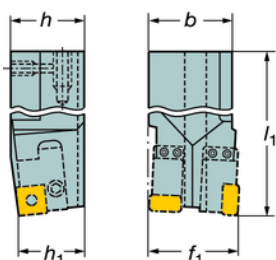
Right hand style shown unless otherwise stated

Ordering code	Dimensions, mm, inch					
	h	h_1	b	l_1	f_1	r_ϵ
R/L175.32-5047M	50	44	47	275	44	4.0
	1.969	1.732	1.850	10.827	1.732	.157

R = Right hand, L = Left hand

For two cutting units

cutting units

R/L177.32
-3219-1911R/L177.32
-3219-19R/L175.32
-3223-1922R/L175.32
-3223-19R/L175.32
-3223-1911

Right hand style shown unless otherwise stated

Ordering code	Dimensions, mm, inch					
	h	h_1	b	l_1	f_1	r_ϵ
R/L175.32-5055M	50	44	55	210	55	4.0
	1.969	1.732	2.165	8.268	2.165	.157

R = Right hand, L = Left hand

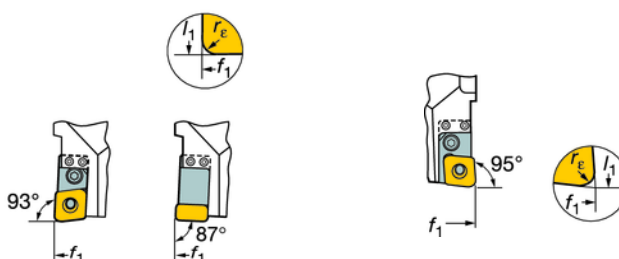
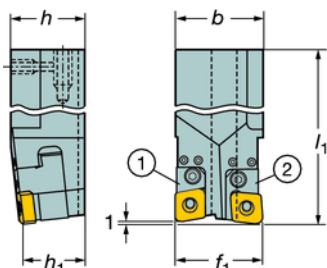
For two cutting units

1.

cutting units

R/L177.32
-3219-1911R/L177.32
-3219-19

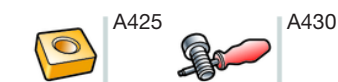
2.

R/L175.32
-3223-1911

Right hand style shown unless otherwise stated

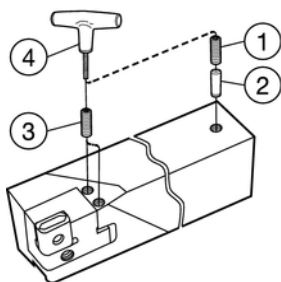
Ordering code	Dimensions, mm, inch					
	h	h_1	b	l_1	f_1	r_ϵ
R/L175.33-5055	50	44	55	210	55	4.0
	1.969	1.732	2.165	8.268	2.165	.157

R = Right hand, L = Left hand

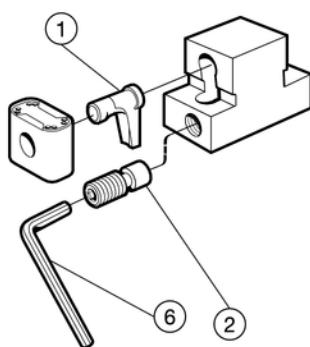
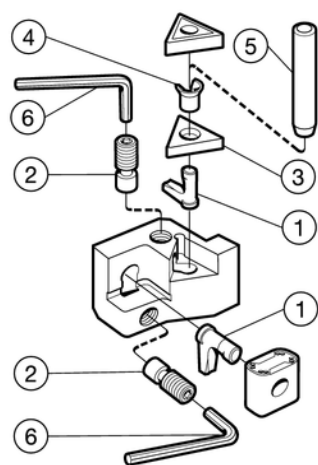






Spare parts

Holders for cutting units

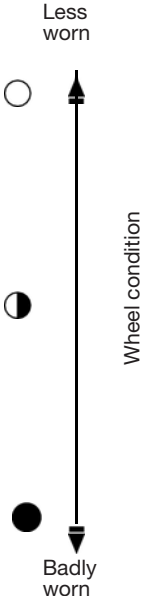


	1	2	3	4
Tool holders	Screw	Locking pin	Screw	Key (mm)
R/L175.32-5047M	3214 010-359	175.32-820	174.32-831	265 2-817 (3.0)
R/L175.32-5055M	3214 010-359	175.32-820	174.32-831	265 2-817 (3.0)
R/L175.32-5055	3214 010-359	175.32-820	174.32-831	265 2-817 (3.0)



	1	2	3	4	5	6
Cutting edge length	Lever	Screw	Shim	Shim pin	Shim pin Punch	Key (mm)
 19	174.3-843M	174.3-825	-	-	-	265.2-817 (3.0)
 30	174.3-843M	174.3-825	-	-	-	265.2-817 (3.0)
 22	174.3-841M	174.3-821	179.3-852M	174.3-861	174.3-871	265.2-817 (3.0)
 19	5432 005-02	5516 020-01	5322 230-03	174.3-862	174.3-872	5680 010-06 (4.0)

Grade recommendations

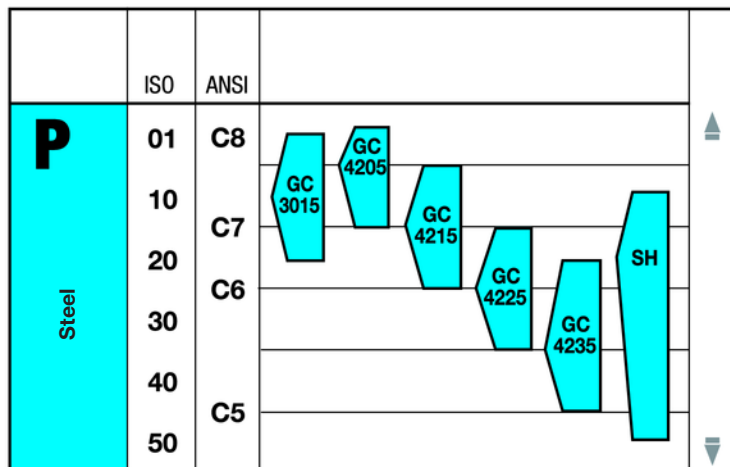
Wheel condition		Wheel condition	
	ISO-P	Various tough wheel conditions require effective grades.	
	GC 3015	Wheels with less worn out profiles are machined with higher cutting data for maximum productivity. Use the harder grade GC3015.	
	GC4215	The majority of worn out wheels with some skid flats, shelled tread or thermal cracks are machined with the overall first choice grade GC4215.	
	GC4225	Wheels with heavier damage as well as low speed machines that require a tougher tool shall be machined with grade GC4225.	
	SH	Badly damaged wheels are machined at low cutting speed. Use the uncoated grade SH.	

First choice

The choice of cutting speed is always a combination of the type of grade you choose to work with and the condition of the wheel. However, it is recommended that you choose a lower cutting speed when turning hard wheels with brake plates and similar, plus a higher cutting speed with softer wheels in better condition.

Grade description

Railway wheel re-turning



P

GC3015 (HC) – P10 (P01-P20)

CVD-coated carbide consisting of a thick, wear resistant coating and a hard substrate, capable of withstanding high temperatures. For finishing and light roughing at high cutting speeds under favorable conditions.

GC4205 (HC) – P05 (P01-P15)

A CVD coated grade with excellent resistance against craterwear and plastic deformation. Recommended for stable conditions when higher metal removal rate is needed in medium to rough steel applications. Is able to withstand high temperatures without sacrificing edge line security in wet and dry machining.

GC4215 (HC) – P15 (P05–P25)

CVD-coated carbide grade for finishing to roughing in applications with continuous cut to light intermittence of steel and steel castings. A gradient substrate optimized in hardness and toughness with a wear resistant coating. Is able to withstand high temperatures without sacrificing edge line security in wet and dry applications.

GC4225 (HC) - P25 (P10 - P40)

CVD-coated carbide grade for finishing to roughing of steel and steel castings. A gradient substrate with optimized hardness and toughness for steel turning in combination with a thick wear resistant coating. This grade can handle continuous cuts as well as interrupted cuts at high metal removal rates. A grade for a broad application area.

GC4235 (HC) – P35 (P20–P45)

CVD-coated carbide grade for roughing of steel and steel castings under unfavorable conditions. A gradient substrate with optimized hardness and toughness for steel turning in combination with a thick wear resistant coating. The edge line security enables the grade to handle interrupted cuts at high metal removal rates.

SH (HW) – P20 (P10–P50)

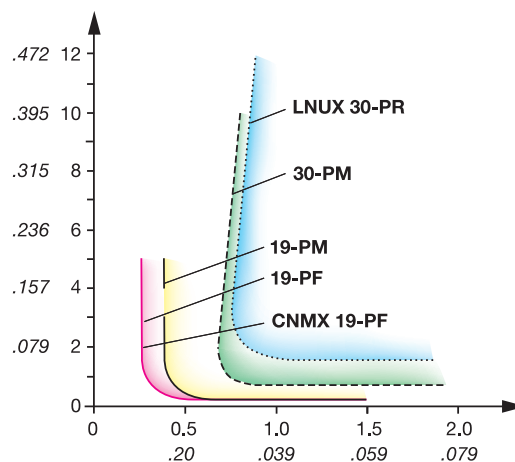
A tough, uncoated grade for re-machining of badly damaged wheels at low cutting speed.

Cutting data recommendations

Cutting feed

Material: Alloy steel

Cutting speed: $v_c = 25\text{--}90\text{ m/min}$ (82-300 ft/min)



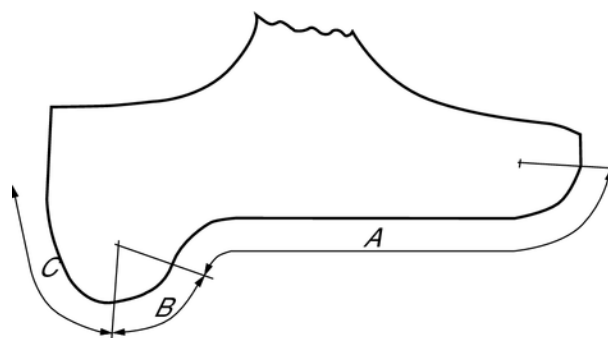
Cutting data

The chipbreaking performance is dependent on many factors such as material quality, cutting speed and entering angle. The cutting data table only gives a general indication of how and where different geometries can be used.

The cutting data shown is recommended for the type of material normally used for railway wheels.

This cutting data is valid for the grades SH, GC4015, GC4025 and GC3015. When extreme skid flats, shelled tread, or heavy build-up on the tread has occurred, the lower cutting speeds are recommended. The lower cutting speeds (v_{c1}) are also recommended when re-turning wheels with a high carbon content. If any adjustment in the feed rate is necessary, it should be kept to a minimum.

Machine type	Cutting speed, m/min (ft/min)		Feed, mm/r (inch/r)	
Under-floor lathe ¹⁾	v_{c1} 50	v_{c2} 90	f_n 0.3-1.5	GC4215/ GC4225
Portal lathe	(164)	(295)	(.012-.059)	
	50 (164)	90 (295)	0.5-2.0 (.020-.079)	GC4215/ GC4225
-	50 (164)	90 (295)	0.3-2.0 (.012-.079)	GC3015
-	50 (164)	70 (295)	0.5-2.0 (.012-.079)	SH
Cutting depth (a_p), mm, inch and chipbreaking capacity	Insert geometry -PF 0.3-3.0 mm (.012-.118 inch) -PM 1.5-6.0 mm (.059-.236 inch) -PR 2.0-12.0 mm (.079-.472 inch)			



The cutting speed recommendations (v_{c1}) in the table are valid when turning the tread (section A of the wheel profile). The flange copying operation will normally be made with the higher cutting speeds (v_{c2}) and feeds given (section B and C of the wheel profile).

¹⁾ Restricted by power supply and friction drive installed.

Practical tips

The illustrations below are one example of re-turning of a worn wheel with skid flats, shelled tread or thermal cracks.

Re-turning of badly damaged railway wheels

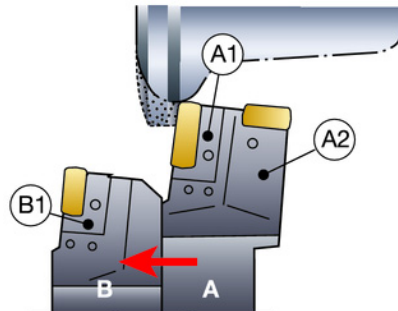
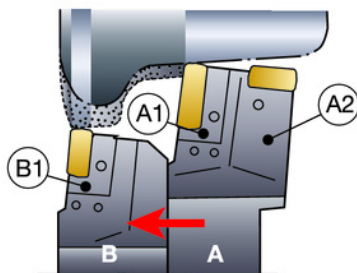
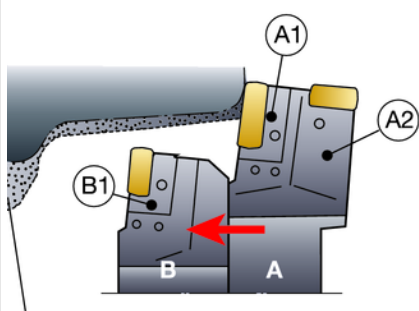
Copy machining of tread

Cutting speed v_c : 40 m/min, 130 ft/min

Feed f_n : 0.3 - 1.5 mm/r, .012 - .059 inch/r

Lower v_c when:

- extreme skid flats
- shelled tread
- high carbon content



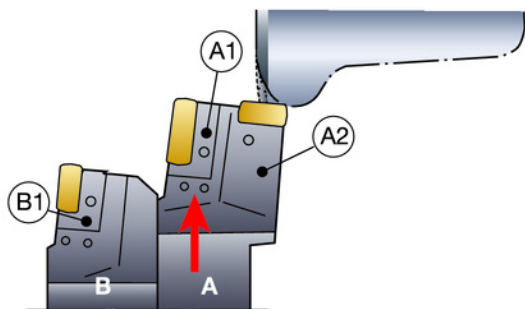
Material to be removed

Copy machining of back side of flange

Less worn with higher cutting speed (v_c) and feed (f_n)

$v_c = 70-90$ m/min, 230-300 ft/min

$f_n = 2$ mm/r, .080 inch/r



Cutting units/insert used

Tool holder A: R175.32-5055M

Cutting unit A1: R175.32-3223-30

Insert: LNMX 30 19 40-PM

Cutting unit A2: L177.32-3219-19

Insert: LNMX 19 19 40-PM

Tool holder B: R175.32-5047M

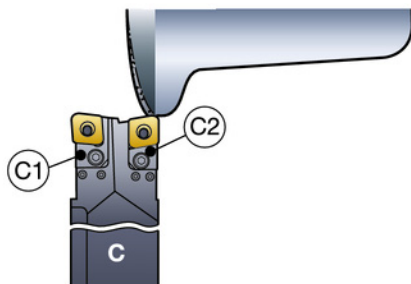
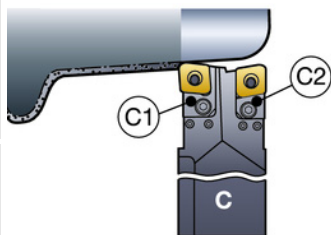
Cutting unit B1: R175.32-3223-19

Insert: LNMX 19 19 40-PM

Re-turning of less worn railway wheels

$v_c = 70-90$ m/min, 230-300 ft/min

$f_n = 1-2$ mm/r, .039-.080 inch/r



Cutting units/insert used

Tool holder C: R175.33-5050

Cutting unit C1: R175.32-3223-1911

Insert: CNMX 19 11 40-PF

Cutting unit C2: R177.32-3219-1911

Insert: CNMX 19 11 40-PF

Turning of new railway wheels

Sandvik Coromant, with many years of experience with re-turning of worn railway wheels, can also offer tooling and machining solutions for turning of new wheels.

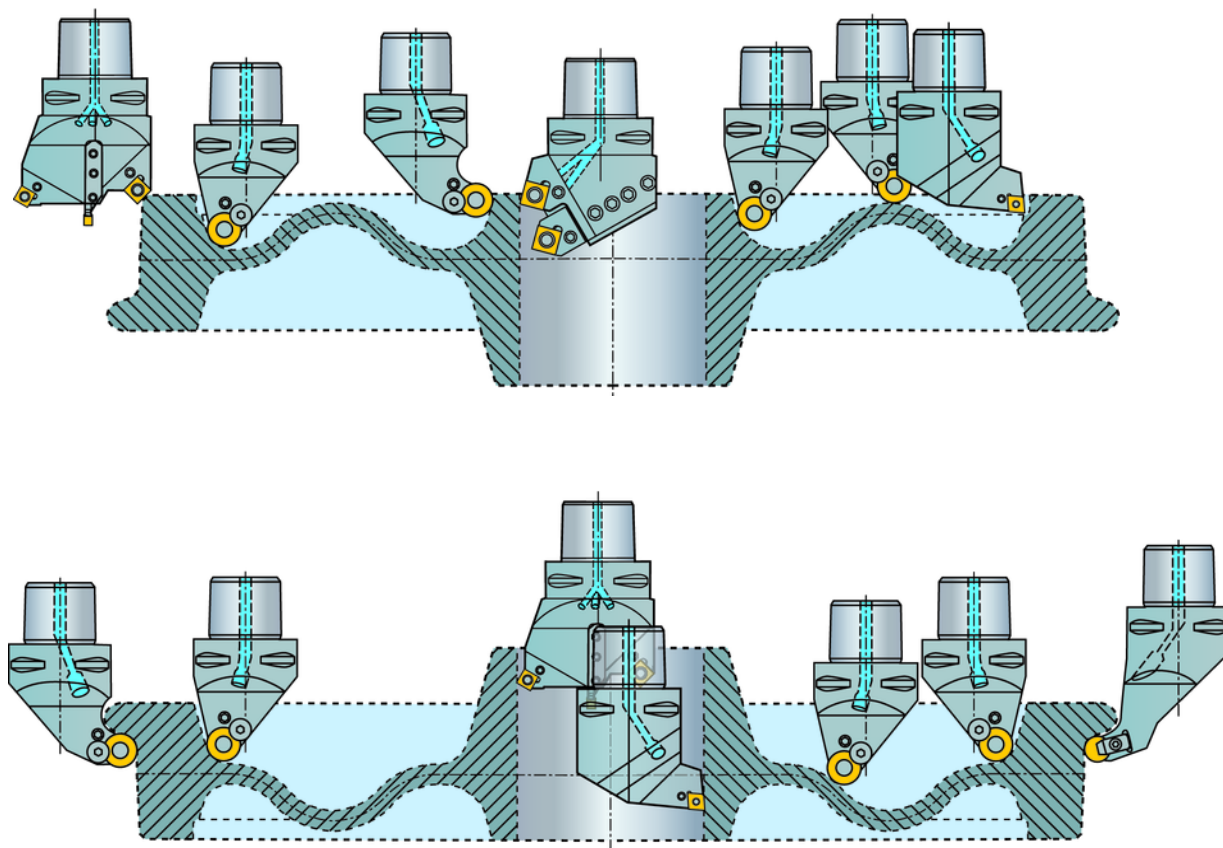
Most of the tools are unique solutions, based on machining conditions such as design of the wheel and type of machine used. One common factor is that the tools are based on Coromant Capto, the most flexible and rigid modular clamping system on the market.

As clamping system for the insert in the Coromant Capto cutting unit, a combination of lever and top clamping is used in order to achieve an undisturbed evacuation of the large volumes of chips.

Inserts and insert geometries are standard and together with modern carbide grades, Sandvik Coromant can offer a highly productive machining solution.

Please contact your local Sandvik Coromant representative for more information.

Tooling example





Torx Plus® torque wrench

Correct torque when mounting of inserts in milling cutters is a prerequisite for a well functioning tool. Together with the Torx Plus screws the new wrench is a guarantee for improved and secure insert clamping.

The wrenches, available in several sizes and tested to withstand 10 000 insert tightenings, are each calibrated for the torque needed for correct insert clamping of Sandvik Coromant milling cutters.

A torque wrench is always recommended for cutters with Torx plus screw. The new wrench must be ordered separately, except for CoroMill® Century, CoroMill® 790 and CoroMill® 390 long edge milling cutters, see spare parts tables.



Note! Torx Plus is a registered trademark of Camcar Textron (USA).

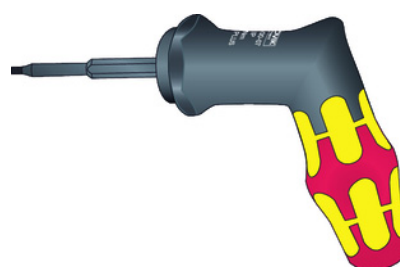
Note!

We want to point out to all our customers that the new Torx Plus keys and screwdrivers do NOT fit into the standard Torx screws.

However, the standard Torx keys and screwdrivers will fit the new Torx Plus screws.

Torx Plus® torque wrench

New torque wrench	Size	Torque in-lbs	Torque Nm	Old torque wrench
5680 100-01	6IP	4	0.6	5680 086-01
5680 100-02	7IP	8	0.9	5680 086-02
5680 100-03	8IP	10	1.2	5680 086-03
5680 100-04	9IP	12	1.4	5680 086-04
5680 100-05	10IP	18	2.0	5680 086-05
5680 100-06	15IP	26	3.0	5680 086-06
5680 100-07	20IP	44	5.0	-
5680 100-08	25IP	66	7.5	-



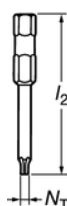
5680 100-07 (20IP) and 5680 100-08 (25IP)

Torx Plus® torque wrench with bits

5680 105-01
5680 105-02
5680 105-03
5680 105-04



5680 105-05
5680 105-06
5680 105-07
5680 105-08



Torque wrench	Torque range		Handle
	Nm	In-lbs	
5680 105-01	0.3 - 1.2		Straight
5680 105-02	1.2 - 3.0		Straight
5680 105-05	3.0 - 6.0		Angled
5680 105-06	4.0 - 8.8		Angled
5680 105-03		2.5 - 11.5	Straight
5680 105-04		11.0 - 26.0	Straight
5680 105-07		26.0 - 55.0	Angled
5680 105-08		35.4 - 78.0	Angled

Bit	l ₂		N _T
	mm	Inch	
5680 084-01	50	1.969	8IP
5680 084-02	50	1.969	15IP
5680 084-03	89	3.504	15IP
5680 084-04	50	1.969	7IP
5680 084-05	50	1.969	9IP
5680 084-06	50	1.969	10IP
5680 084-07	50	1.969	20IP
5680 084-08	89	3.504	20IP
5680 084-09	89	3.504	25IP
5680 084-10	89	3.504	30IP
5680 084-11	50	1.969	6IP
5680 084-12	80	3.150	27IP
5680 084-13	35	1.378	50IP

Spare parts

External machining

Shank tools and Coromant Capto® units

Holders for negative inserts

CoroTurn® RC rigid clamp	A439
T-Max® P Lever clamp	A446
T-Max® P screw and top clamp	A452
T-Max® P wedge clamp	A454
CoroTurn® HP lever design	A464

Holders for positive inserts

CoroTurn® 107 screw clamp	A456
CoroTurn® HP screw clamp	A466
CoroTurn® TR screw clamp	A468

Holders for ceramic inserts

CoroTurn® RC rigid clamp	A470
T-Max® top clamp	A474

Internal machining

Shank tools and Coromant Capto® units

Boring bars for negative basic-shape inserts

CoroTurn® RC rigid clamp	A476
T-Max® P Lever clamp	A477
T-Max® P screw and top clamp	A479
T-Max® P wedge clamp	A480

Boring bars for positive basic-shape inserts

CoroTurn® 107 screw clamp	A482
CoroTurn® 111 screw clamp	A490

Boring bars for ceramic inserts

T-Max® top clamp	A492
------------------	------

CoroTurn® SL

Cutting heads and boring bars

Cutting heads for negative basic-shape inserts

CoroTurn® RC rigid clamp	I110
T-Max® P Lever clamp	I111
CoroTurn® HP lever design	I111

Cutting heads for positive basic-shape inserts

CoroTurn® 111 screw clamp	I112
CoroTurn® 107 screw clamp	I113
CoroTurn® TR screw clamp design	I114

Boring bars and adaptors

Boring type 570-2C and 570-3C	I115
Reduction adaptor	I117

CoroTurn® SL quick change

Page

Boring bars and adaptors

Boring bar	I118
580 Boring bar adaptor	I118
Adaptor for CoroTurn® SL cutting heads	I119
Adaptor for square shank tools	I119
Adaptor for cutting heads, diameter 32 mm	I119

Build-in tools

Cartridges for negative basic-shape inserts

CoroTurn® RC rigid clamp	A493
T-Max® P Lever clamp	A494
T-Max® P wedge clamp	A495

Cartridges for positive basic-shape inserts

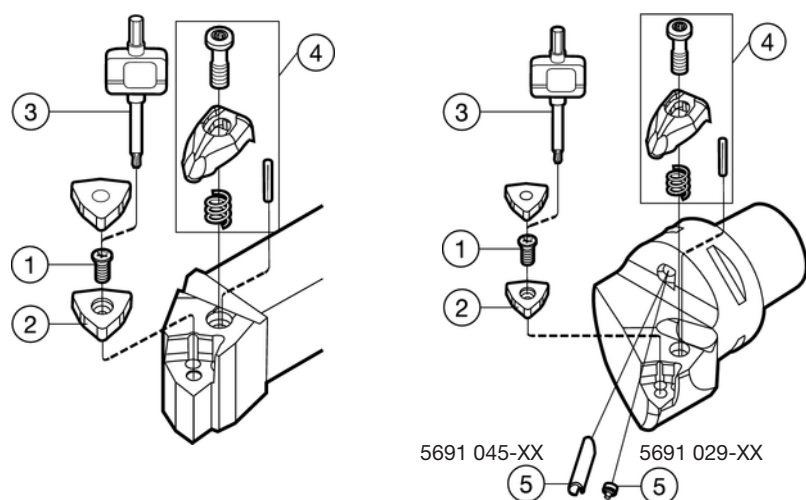
CoroTurn® 107 screw clamp	A496
Round shank boring tools, screw clamp	A497


Torque wrenches for correct insert clamping

A437

For spare parts for Coromant Capto® multi-task machining tools, see chapter H

CoroTurn® RC rigid clamp design



Inch	Metric	Coromant Capto®	1 Shim screw	2 Shim (for insert thickness mm/inch)	3 Key (Torx Plus)	4) ²⁾ Complete clamp set	5 Coolant nozzle ⁵⁾
							
DCFNR/L 164D			5513 020-02	5322 234-01 (4.76/.187) 5322 234-02 (7.94/.312) ¹⁾	5680 049-01 (15IP)	5412 028-021 5412 034-021 ³⁾ 5412 032-021 ⁴⁾	-
DCGNR/L 164D DCGNR/L 204D			5513 020-02	5322 234-01 (4.76/.187) 5322 234-02 (7.94/.312) ¹⁾	5680 049-01 (15IP)	5412 028-021 5412 034-021 ³⁾ 5412 032-021 ⁴⁾	-
DCLNR/L 103A DCLNR/L 123C DCLNR/L 163D DCLNR/L 104A	DCLNR/L 1616H09 DCLNR/L 2020K09 DCLNR/L 2525M09 DCLNR/L 1616H12	C3-DCLNR/L-22040-09 C4-DCLNR/L-27050-09 - C3-DCLNR/L-22045-12	5513 020-04 5513 020-02	5322 236-04 (3.18/.125) 5322 236-03 (4.76/.187)	5680 051-03 (9IP) 5680 049-01 (15IP)	5412 028-011 5412 034-021 ³⁾ 5412 032-021 ⁴⁾	-
DCLNR/L 124B DCLNR/L 164C DCLNR/L 164D DCLNR/L 204D DCLNR/L 244DM1 DCLNR/L 854D	DCLNR/L 2020K12 DCLNR/L 2525M12 DCLNR/L 3225P12 DCLNR/L 3232P12 DCLNR/L 4040S12 DCLNR/L 4040S12	C4-DCLNR/L-27050-12 C5-DCLNR/L-35060-12 C6-DCLNR/L-45065-12 C8-DCLNR/L-55080-12 - -	5513 020-02	5322 234-01 (4.76/.187) 5322 234-02 (7.94/.312) ¹⁾	5680 049-01 (15IP)	5412 028-021 5412 034-021 ³⁾ 5412 032-021 ⁴⁾	5691 045-01 5691 045-01 5691 045-01 5691 045-01 -
DCLNR/L 165D DCLNR/L 205D DCLNR/L 245D DCLNR/L 855D	DCLNR/L 2525M16 DCLNR/L 3225P16 DCLNR/L 3232P16 DCLNR/L 4040S19	C4-DCLNR/L-27055-16 C5-DCLNR/L-35060-16 C6-DCLNR/L-45065-16 C8-DCLNR/L-55080-16	5513 020-07	5322 234-03 (6.35/.250) 5322 234-04 (7.94/.312) ¹⁾	5680 043-14 (20IP)	5412 028-031 5412 034-031 ³⁾ 5412 032-031 ⁴⁾	5691 045-01 5691 045-01 5691 045-01 5691 045-01
DCLNR/L 166D DCLNR/L 206D DCLNR/L 246D DCLNR/L 856D	DCLNR/L 2525M19 DCLNR/L 3232P19 DCLNR/L 3225P19 DCLNR/L 4040S19	C5-DCLNR/L-35060-19 C6-DCLNR/L-45065-19 C8-DCLNR/L-55080-19 -	5513 020-07	5322 236-01 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	5691 045-01 5691 045-01 5691 045-01 5691 045-01
DCLNR/L 248E	DCLNR/L 4040S25 DCLNR/L 5050T25	C8-DCLNR/L-55080-25 -	5513 020-08	5322 234-05 (9.52/.374)	5680 043-15 (25IP)	5412 028-051	5691 045-01 -
DCRNR/L 124BM1 DCRNR/L 164DM1 DCRNR/L 204DM1 DCRNR/L 244DM1 DCRNR/L 854D	DCBNR/L 2020K12 DCBNR/L 2525M12 DCBNR/L 3225P12 DCBNR/L 3232P12 DCBNR/L 4040S12	C4-DCRNR/L-22050-12 C5-DCRNR/L-27060-12 C6-DCRNR/L-35065-12 - -	5513 020-02	5322 234-01 (4.76/.187) 5322 234-02 (7.94/.312) ¹⁾	5680 049-01 (15IP)	5412 028-021 5412 034-021 ³⁾ 5412 032-021 ⁴⁾	5691 029-08 5691 045-01 5691 045-01 -
DCRNR/L 165D DCRNR/L 205D DCRNR/L 245D DCRNR/L 855D	DCBNR/L 2525M16 DCBNR/L 3225P16 DCBNR/L 3232P16 DCBNR/L 4040S16	C5-DCRNR/L-27060-16 C6-DCRNR/L-35065-16 C8-DCRNR/L-55080-16 -	5513 020-07	5322 234-03 (6.35/.250) 5322 234-04 (7.94/.312) ¹⁾	5680 043-14 (20IP)	5412 028-031 5412 034-031 ³⁾ 5412 032-031 ⁴⁾	5691 045-01 5691 045-01 5691 045-01 -
DCRNR/L 206D DCRNR/L 246D	DCBNR/L 3232P19 DCBNR/L 4040S19	C5-DCRNR/L-27060-19 C6-DCRNR/L-35065-19 C8-DCRNR/L-55080-19	5513 020-07	5322 236-01 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	5691 029-09 5691 045-01 5691 045-01

1) Optional part delivered to separate order.



2) For clamp set parts, see page A445.

3) Clamp sets for ceramic inserts without hole

4) Clamp sets for ceramic inserts with hole

5) For optional nozzles, see page A445.

CoroTurn® RC rigid clamp design

			1	2	3	4 ¹⁾²⁾	5
Inch	Metric	Coromant Capto®	Shim screw	Shim (for insert thickness mm/inch)	Key (Torx Plus)	Complete clamp set	Coolant nozzle ⁶⁾
							
DCKNR/L 124B	DCKNR/L 2020K12	C4-DCKNR/L-27050-12	5513 020-02	5322 234-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-08
DCKNR/L 164D	DCKNR/L 2525M12	C5-DCKNR/L-35060-12		5322 234-02 (7.94/.312) ¹⁾		5412 034-021 ³⁾	5691 029-09
DCKNR/L 854D	DCKNR/L 3225P12	C6-DCKNR/L-45065-12				5412 032-021 ⁴⁾	5691 029-09
DCKNR/L 205D	DCKNR/L 3232P16	C4-DCKNR/L-27050-16	5513 020-07	5322 234-03 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	5691 045-01
	DCKNR/L 4040S16	C5-DCKNR/L-35060-16		5322 234-04 (7.94/.312) ¹⁾		5412 034-031 ³⁾	5691 029-09
		C6-DCKNR/L-45065-16				5412 032-031 ⁴⁾	5691 029-09
		C6-DCKNR/L-45065-19	5513 020-07	5322 236-01 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	5691 029-09
		C8-DCKNR/L-55080-19					5691 029-09
DCGNR/L 164D			5513 020-02	5322 234-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	
DCGNR/L 204D				5322 234-02 (7.94/.312) ¹⁾		5412 034-021 ³⁾	
						5412 032-021 ⁴⁾	
DCGNR/L 206D			5513 020-07	5322 236-01 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	
DCGNR/L 246D							
		C5-DCMNN-00105-12	5513 020-02	5322 234-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-09
		C6-DCMNN-00090-12		5322 234-02 (7.94/.312) ¹⁾		5412 034-021 ³⁾	-
		C6-DCMNN-00115-12				5412 032-021 ⁴⁾	5691 029-10
		C6-DCMNN-00090-16	5513 020-07	5322 234-03 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	-
		C8-DCMNN-00150-16		5322 234-04 (7.94/.312) ¹⁾		5412 034-031 ³⁾	5691 029-10
						5412 032-031 ⁴⁾	
							
	DDHNR/L 2020K15	C4-DDHNR/L-27055-15	5513 020-02	5322 266-01(4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 045-01
	DDHNR/L 2525M15	C5-DDHNR/L-35060-15		5322 266-02 (6.35/.250) ¹⁾		5412 034-021 ³⁾	5691 045-01
	DDHNR/L 3225P15	C6-DDHNR/L-45065-15		5322 266-03 (7.94/.312) ¹⁾		5412 032-021 ⁴⁾	5691 045-01
	DDHNR/L 3232P15	C8-DDHNR/L-55080-15					5691 045-01
DDJNR/L 103A	DDJNR/L 1616H11	C3-DDJNR/L-22045-11	5513 020-04	5322 267-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	5691 045-01
DDJNR/L 123C	DDJNR/L 2020K11	C4-DDJNR/L-27050-11					5691 029-08
DDJNR/L 163D	DDJNR/L 2525M11	C5-DDJNR/L-35060-11					5691 029-09
DDJNR/L 203D	DDJNR/L 3225P11	C6-DDJNR/L-45065-11					5691 029-09
DDJNR/L 243D	DDJNR/L 3232P11	-					-
DDJNR/L 853D							
DDJNR/L 124B			5513 020-02	5322 266-01(4.76/.187)	5680 049 (15IP)	5412 028-021	
DDJNR/L 164C				5322 266-02 (6.35/.250) ¹⁾		5412 034-021 ³⁾	
DDJNR/L 164D				5322 266-03 (7.94/.312) ¹⁾		5412 032-021 ⁴⁾	
DDJNR/L 204D				5322 266-04 (4.76/.187) ⁵⁾			
DDJNR/L 244D							
DDJNR/L 854D							
	DDJNR/L 2020K15	C4-DDJNR/L-27055-15	5513 020-02	5322 266-02 (6.35/.250)	5680 049-01 (15IP)	5412 028-021	5691 029-08
	DDJNR/L 2525M15	C5-DDJNR/L-35060-15		5322 266-01 (4.76/.187) ¹⁾		5412 034-021 ³⁾	5691 045-01
	DDJNR/L 3225P15	C6-DDJNR/L-45065-15		5322 266-03 (7.94/.312) ¹⁾		5412 032-021 ⁴⁾	5691 029-09
	DDJNR/L 3232P15	C8-DDJNR/L-55080-15					5691 029-10
	DDJNR/L 4040S15	-					-
		C4-DDJNR/L-27055-15	5513 020-02	5322 266-02 (6.35/.250)	5680 049-01 (15IP)	5412 028-021	5691 029-09
		C5-DDJNR/L-35060-15		5322 266-01 (4.76/.187) ¹⁾		5412 034-021 ³⁾	5691 029-09
		C6-DDJNR/L-45065-15		5322 266-03 (7.94/.312) ¹⁾		5412 032-021 ⁴⁾	5691 029-10
		C8-DDJNR/L-55080-15					5691 029-10
DDPNN 123B	DDNNN 2020K11	C4-DDNNN-00050-11	5513 020-04	5322 267-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	5691 029-08
DDPNN 163C	DDNNN 2525M11	C5-DDNNN-00060-11					5691 045-01
DDPNN 124B	DDNNN 2525M15	C4-DDNNN-00055-15	5513 020-02	5322 266-02 (6.35/.250)	5680 049-01 (15IP)	5412 028-021	5691 029-08
DDPNN 164D	DDNNN 3225P15	C5-DDNNN-00060-15		5322 266-01 (4.76/.187) ¹⁾		5412 034-021 ³⁾	5691 045-01
DDPNN 204D	DDNNN 3232P15	C6-DDNNN-00065-15		5322 266-03 (7.94/.312) ¹⁾		5412 032-021 ⁴⁾	5691 045-01
	DDNNN 4040S15	C8-DDNNN-00080-15					5691 045-01
		C5-DDMNL-00115-15	5513 020-02	5322 266-02 (6.35/.250)	5680 049-01 (15IP)	5412 028-021	5691 029-09
		C6-DDMNL-00130-15		5322 266-01 (4.76/.187) ¹⁾		5412 034-021 ³⁾	5691 029-10
		C6-DDMNL-33120-15		5322 266-03 (7.94/.312) ¹⁾		5412 032-021 ⁴⁾	-
		C8-DDMNL-00160-15					5691 029-10
DDQNR/L 123B			5513 020-04	5322 267-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	
DDQNR/L 164D			5513 020-02	5322 266-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	
DDQNR/L 204D				5322 266-02 (6.35/.250) ¹⁾		5412 034-021 ³⁾	
DDQNR/L 244D				5322 266-03 (7.94/.312) ¹⁾		5412 032-021 ⁴⁾	
				5322 266-04 (4.76/.187) ⁵⁾			

1) Optional part delivered to separate order.

2) For clamp set parts, see page A445.


3) Clamp sets for ceramic inserts without hole

4) Clamp sets for ceramic inserts with hole

5) For inserts with nose radius .016-.031

6) For optional nozzles, see page A445.

CoroTurn® RC rigid clamp design

		1	2	3	4 ¹⁾²⁾	5	
Metric	Coromant Capto®	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Coolant nozzle ⁶⁾	Coolant sealing cover
							
DDHNR/L 2525M 1504	C4-DDHNR/L-27055-1504	5513 020-02	5322 266-01	5680 049-01 (15IP)	5412 028-021	5691 045-01	
DDJNR/L 2020K 1504	C5-DDHNR/L-35060-1504				5412 034-021 ³⁾	5691 045-01	
DDJNR/L 2525M 1504	C6-DDHNR/L-45065-1504				5412 032-021 ⁴⁾	5691 045-01	
DDJNR/L 3225P 1504	C8-DDHNR/L-55080-1504					5691 045-01	
DDNNN 2525M 1504	C4-DDJNR/L-27055-1504					5691 029-08	
DDNNN 3225P 1504	C5-DDJNR/L-35060-1504					5691 045-01	
	C6-DDJNR/L-45065-1504					5691 029-09	5643 020-09
	C8-DDJNR/L-55080-1504					5691 029-10	
	C4-DDUNR/L-27050-1504					5691 029-08	
	C5-DDUNR/L-35060-1504					5691 029-09	5643 020-09
	C6-DDUNR/L-45065-1504					5691 029-09	5643 020-09
	C8-DDUNR/L-55080-1504					5691 029-10	
	C4-DDNNN-00055-1504					5691 029-08	
	C5-DDNNN-00060-1504					5691 045-01	
	C6-DDNNN-00065-1504					5691 045-01	
	C8-DDNNN-00080-1504					5691 045-01	

1) Optional part delivered to separate order.

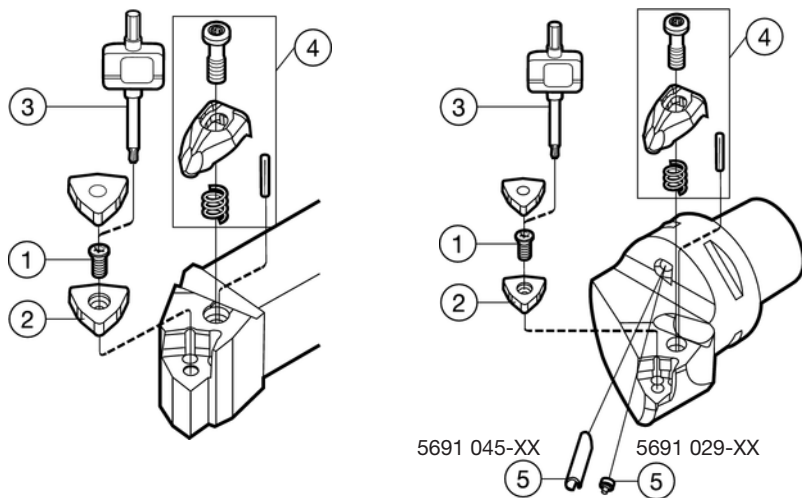
2) For clamp set parts, see page A445.



3) Clamp sets for ceramic inserts without hole

4) Clamp sets for ceramic inserts with hole

5) For inserts with nose radius .016-.031

CoroTurn® RC rigid clamp design



Inch	Metric	Coromant Capto®	1 Shim screw	2 Shim (for insert thickness mm/inch)	3 Key (Torx Plus)	4 ¹⁾²⁾ Complete clamp set	5 Coolant nozzle ⁵⁾
							
DRSNR/L 123B	DRSNR/L 2020K09	–	5513 020-04	5322 156-01 (3.18/.125)	5680 051-03 (9IP)	5412 028-011	–
DRSNR/L 164D	DRSNR/L 2525M12	C4-DRSNR/L-27050-12	5513 020-02	5322 155-02 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-08
DRSNR/L 204D		C5-DRSNR/L-35060-12				5412 034-021 ³⁾	5691 045-01
		C6-DRSNR/L-45065-12				5412 032-021 ⁴⁾	5691 045-01
	DRSNR/L 3225P15	–	5513 020-07	5322 155-04 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	–
	DRSNR/L 3232P19	–	5513 020-07	5322 155-06 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	–
	DRSNR/L 4040S25	–	5513 020-08	5322 155-07 (9.52/.375)	5680 043-15 (25IP)	5412 028-051	–
							
DSDNN103A	DSDNN 1616H09	–	5513 020-04	5322 426-01 (3.18/.125)	5680 051-03 (9IP)	5412 028-011	–
		C3-DSDNN-00048-12	5513 020-02	5322 426-02 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	–
						5412 034-021 ³⁾	5691 045-01
						5412 032-021 ⁴⁾	5691 045-01
DSDNN 124B	DSDNN 2020K12	C4-DSDNN-00050-12	5513 020-02	5322 425-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-08
DSDNN 164D	DSDNN 2525M12	C5-DSDNN-00060-12		5322 425-02 (7.94/.312) ¹⁾		5412 034-021 ³⁾	5691 045-01
DSDNN 204D	DSDNN 3225P12	C6-DSDNN-00065-12				5412 032-021 ⁴⁾	5691 045-01
DSDNN 244D	DSDNN 3232P12	–					–
DSDNN 854D							
DSDNN 165D	DSDNN 2525M15	C5-DSDNN-00060-15	5513 020-07	5322 425-03 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	5691 045-01
DSDNN 205D		C6-DSDNN-00065-15		5322 425-05 (7.94/.312) ¹⁾		5412 034-031 ³⁾	5691 045-01
DSDNN 245D						5412 032-031 ⁴⁾	5691 045-01
DSDNN 206D	DSDNN 3225P19	C5-DSDNN-00065-19	5513 020-07	5322 425-04 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	5691 045-01
DSDNN 856D	DSDNN 3232P19	C6-DSDNN-00070-19					5691 045-01
DSDNN 248D	DSDNN 4040S25	C8-DSDNN-00080-25	5513 020-08	5322 425-07 (7.94/.312)	5680 043-15 (25IP)	5412 028-051	5691 045-01
				5322 425-08 (9.52/.375) ¹⁾			
	DSKNR/L 2020K09	–	5513 020-04	5322 426-01 (3.18/.125)	5680 051-03 (9IP)	5412 028-011	–
DSKNR/L 123B		C3-DSKNR/L-22040-12	5513 020-02	5322 426-02 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-08
						5412 034-021 ³⁾	5691 045-01
						5412 032-021 ⁴⁾	5691 045-01
DSKNR/L 124B	DSKNR/L 2020K12	C4-DSKNR/L-27050-12	5513 020-02	5322 425-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-08
DSKNR/L 164D	DSKNR/L 2525M12	C5-DSKNR/L-35060-12		5322 425-02 (7.94/.312) ¹⁾		5412 034-021 ³⁾	5691 029-09
DSKNR/L 854D	DSKNR/L 3225P12	C6-DSKNR/L-45065-12				5412 032-021 ⁴⁾	5691 029-09
DSKNR/L 205D	DSKNR/L 3232P15	C5-DSKNR/L-35060-15	5513 020-07	5322 425-03 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	5691 029-09
		C6-DSKNR/L-45065-15		5322 425-05 (7.94/.312) ¹⁾		5412 034-031 ³⁾	5691 029-09
						5412 032-031 ⁴⁾	5691 029-09
DSKNR/L 206B	DSKNR/L 3232P19	C6-DSKNR/L-45065-19	5513 020-07	5322 425-04 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	5691 029-09
DSKNR/L 246D	DSKNR/L 4040S19	C6-DSKNR/L-45065-19					5691 045-01
		C8-DSKNR/L-55080-19					5691 045-01
DSKNR/L 328F	DSKNR/L 5050T25	C8-DSKNR/L-55080-25	5513 020-08	5322 425-07 (7.94/.312)	5680 043-15 (25IP)	5412 028-051	5691 045-01
				5322 425-08 (9.52/.375) ¹⁾			

1) Optional part delivered to separate order.


2) For clamp set parts, see page A445.

3) Clamp sets for ceramic inserts without hole

4) Clamp sets for ceramic inserts with hole

5) For optional nozzles, see page A445.

CoroTurn® RC rigid clamp design

Inch	Metric	Coromant Capto®	1	2	3	4 ¹⁾²⁾	5
			Shim screw	Shim (for insert thickness mm/inch)	Key (Torx Plus)	Complete clamp set	Coolant nozzle ⁵⁾
DSRNR/L 103B	DSBNR/L 1616H09	–	5513 020-04	5322 426-01 (3.18/.125)	5680 051-03 (9IP)	5412 028-011	–
DSRNR/L 123B	DSBNR/L 2020K09	–					–
DSRNR/L 163C	DSBNR/L 2525M09	–					–
	C3-DSRNR/L-19048-12		5513 020-02	5322 426-02 (4.76/.187)	5680 049-01 (15IP)	5412 028-021 5412 034-021 ³⁾ 5412 032-021 ⁴⁾	–
DSRNR/L 124BM1	DSBNR/L 2525M12	C4-DSRNR/L-22050-12	5513 020-02	5322 425-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 045-01
DSRNR/L 164DM1	DSBNR/L 2020K12	C5-DSRNR/L-27060-12		5322 425-02 (7.94/.312) ¹⁾		5412 034-021 ³⁾	5691 045-01
DSRNR/L 204DM1	DSBNR/L 3225P12	C6-DSRNR/L-35065-12				5412 032-021 ⁴⁾	5691 045-01
DSRNR/L 244DM1	DSBNR/L 3232P12	–					–
DSRNR/L 854D	DSBNR/L 4040S12	–					–
DSRNR/L 165D	DSBNR/L 2525M15	C5-DSRNR/L-27060-15	5513 020-07	5322 425-03 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	5691 045-01
DSRNR/L 205D	DSBNR/L 3225P15	C6-DSRNR/L-35065-15		5322 425-05 (7.94/.312) ¹⁾		5412 034-031 ³⁾ 5412 032-031 ⁴⁾	5691 045-01
DSRNR/L 855D	DSBNR/L 3232P15	–					–
DSRNR/L 166DM1	DSBNR/L 3232P19	C6-DSRNR/L-35065-19	5513 020-07	5322 425-04 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	5691 045-01
DSRNR/L 206DM1	DSBNR/L 4040S19	C5-DSRNR/L-27060-19					5691 045-01
DSRNR/L 246D	DSBNR/L 4040S19	C8-DSRNR/L-45080-19					5691 045-01
DSRNR/L 248E	DSBNR/L 4040S25	C8-DSRNR/L-45080-25	5513 020-08	5322 425-07 (7.94/.312)	5680 043-15 (25IP)	5412 028-051	5691 045-01
DSRNR/L 328F	DSBNR/L 5050T25	–		5322 425-08 (9.52/.375) ¹⁾			–
DSSNR/L 103B	DSSNR/L 1616H09		5513 020-04	5322 426-01 (3.18/.125)	5680 051-03 (9IP)	5412 028-011	–
DSSNR/L 123B	DSSNR/L 2020K09						–
DSSNR/L 163D	DSSNR/L 2525M09						–
	C3-DSSNR/L-22040-12		5513 020-02	5322 426-02 (4.76/.187)	5680 049-01 (15IP)	5412 028-021 5412 034-021 ³⁾ 5412 032-021 ⁴⁾	–
DSSNR/L 124B	DSSNR/L 2020K12	C4-DSSNR/L-27042-12	5513 020-02	5322 425-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-08
DSSNR/L 164D	DSSNR/L 2525M12	C5-DSSNR/L-35052-12		5322 425-02 (7.94/.312) ¹⁾		5412 034-021 ³⁾	5691 029-09
DSSNR/L 854D	DSSNR/L 3225P12	C6-DSSNR/L-45056-12				5412 032-021 ⁴⁾	5691 045-01
	DSSNR/L 3232P12						–
DSSNR/L 165D	DSSNR/L 2525M15	C4-DSSNR/L-27045-15	5513 020-07	5322 425-03 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	5691 029-08
DSSNR/L 205D	DSSNR/L 3225P15	C5-DSSNR/L-35050-15		5322 425-05 (7.94/.312) ¹⁾		5412 034-031 ³⁾ 5412 032-031 ⁴⁾	5691 029-09
DSSNR/L 855D	DSSNR/L 3232P15	C6-DSSNR/L-45054-15					5691 045-01
DSSNR/L 206D	DSSNR/L 3232P19	C5-DSSNR/L-35048-19	5513 020-07	5322 425-04 (6.35/.250)	5680 043-14 (20IP)	5412 028-041	5691 029-09
DSSNR/L 246E	DSSNR/L 4040S19	C6-DSSNR/L-45052-19					5691 029-09
DSSNR/L 866D							
DSSNR/L 248E	DSSNR/L 4040S25	C8-DSSNR/L-55070-25	5513 020-08	5322 425-07 (7.94/.312)	5680 043-15 (25IP)	5412 028-051	5691 045-01
				5322 425-08 (9.52/.375) ¹⁾			
							
DTFNR/L 103A	DTFNR/L 1616H16		5513 020-04	5322 316-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	–
DTFNR/L 123B	DTFNR/L 2020K16	C4-DTFNR/L-27050-16	5513 020-04	5322 315-02 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	5691 045-01
DTFNR/L 163D	DTFNR/L 2525M16	C5-DTFNR/L-35060-16					5691 045-01
	DTFNR/L 3225P16	C6-DTFNR/L-45065-16					5691 045-01
DTFNR/L 164D	DTFNR/L 2525M22	C4-DTFNR/L-27050-22	5513 020-02	5322 315-04 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 045-01
DTFNR/L 204D	DTFNR/L 3225P22	C5-DTFNR/L-35060-22				5412 034-021 ³⁾	5691 045-01
DTFNR/L 244D	DTFNR/L 3232P22	C6-DTFNR/L-45065-22				5412 032-021 ⁴⁾	5691 045-01
DTFNR/L 854D							
DTFNR/L 205D	DTFNR/L 3232P27		5513 020-07	5322 315-05 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	–
DTFNR/L 245D	DTFNR/L 4040S27						–
DTFNR/L 248D	DTFNR/L 4040S33		5513 020-07	5322 315-06 (7.94/.312) 5522 315-07 (9.52/.375)	5680 043-14 (20IP)	5412 028-041	–
DTGNR/L 103A	DTGNR/L 1616H16		5513 020-04	5322 316-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	–
DTGNR/L 123B	DTGNR/L 2020K16	C4-DTGNR/L-27050-16	5513 020-04	5322 315-02 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	5691 045-01
DTGNR/L 163D	DTGNR/L 2525M16	C5-DTGNR/L-35060-16					5691 045-01
DTGNR/L 853D	DTGNR/L 3225P16	C6-DTGNR/L-45065-16					5691 045-01
DTGNR/L 164D	DTGNR/L 2525M22	C4-DTGNR/L-27050-22	5513 020-02	5322 315-04 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 045-01
DTGNR/L 204D	DTGNR/L 3225P22	C5-DTGNR/L-35060-22				5412 034-021 ³⁾ 5412 032-021 ⁴⁾	5691 045-01
DTGNR/L 854D	DTGNR/L 3232P22	C6-DTGNR/L-45065-22					5691 045-01
DTGNR/L 205D	DTGNR/L 3232P27		5513 020-07	5322 315-05 (6.35/.250)	5680 043-14 (20IP)	5412 028-031	–
DTGNR/L 245D	DTGNR/L 4040S27						–
DTGNR/L 246D			5513 020-07	5322 315-06 (7.94/.312)	5680 043-14 (20IP)	5412 028-041	
	DTJNR/L 1616H16		5513 020-04	5322 316-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	–
DTJNR/L 123B	DTJNR/L 2020K16	C3-DTJNR/L-22040-16	5513 020-04	5322 315-02 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	–
DTJNR/L 163D	DTJNR/L 2525M16	C4-DTJNR/L-27050-16					5691 045-01
DTJNR/L 203D	DTJNR/L 3225P16	C5-DTJNR/L-35060-16					5691 045-01

1) Optional part delivered to separate order.

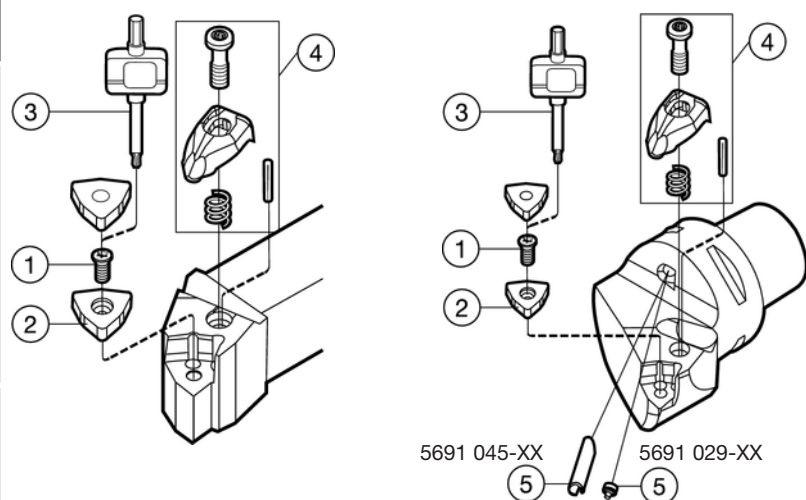
5) For optional nozzles, see page A324.

2) For clamp set parts, see page A445.

3) Clamp sets for ceramic inserts without hole

4) Clamp sets for ceramic inserts with hole

CoroTurn® RC rigid clamp design



Inch	Metric	Coromant Capto®	1 Shim screw	2 Shim (for insert thickness mm/inch)	3 Key (Torx Plus)	4)2) Complete clamp set	5 Coolant nozzle ⁵⁾
DTJNR/L 164D	DTJNR/L 2525M22	C6-DTJNR/L-45065-16	5513 020-02	5322 315-04 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 045-01
DTJNR/L 204D	DTJNR/L 3225P22	C4-DTJNR/L-27050-22				5412 034-021 ³⁾	5691 045-01
DTJNR/L 854D	DTJNR/L 3232P22	C5-DTJNR/L-35060-22				5412 032-021 ⁴⁾	5691 045-01
		C6-DTJNR/L-45065-22					
DTJNR/L 205D	DTJNR/L 3232P27	C6-DTJNR/L-45065-27	5513 020-07	5322 315-05 (6.35/.250)	5680 043-14 (20IP)	5412 028-31	5691 045-01
DTJNR/L 245D	DTJNR/L 4040S27						
DTRNR/L 123B			5513 020-04	5322 316-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	–
DTRNR/L 163D			5513 020-02	5322 315-04 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	–
DTRNR/L 164D						5412 034-021 ³⁾	–
						5412 032-021 ⁴⁾	–
DTTNR/L 103B	DTTNR/L 1616H16		5513 020-04	5322 316-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	–
DTTNR/L 123B	DTTNR/L 2020K16	C4-DTTNR/L-22050-16	5513 020-04	5322 315-02 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	5691 029-08
		C5-DTTNR/L-27060-16					5691 029-09
DTTNR/L 164D	DTTNR/L 2525M22	C5-DTTNR/L-27060-22	5513 020-02	5322 315-04 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-09
	DTTNR/L 3225P22	C6-DTTNR/L-35065-22				5412 034-021 ³⁾	5691 029-09
						5412 032-021 ⁴⁾	–
DVTNR/L 163D	DVPCR/L 2525M16		5513 020-09	5322 269-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-061	–
DVTNR/L 203D	DVPCR/L 3225P16						–
DVTNR/L 243D	DVPCR/L 3232P16						–
	DVPCR/L 4040S16						–
DVJNR/L 123B	DVJNR/L 2020K16	C4-DVJNR/L-27062-16	5513 020-09	5322 269-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-061	5691 029-08
DVJNR/L 163D	DVJNR/L 2525M16	C5-DVJNR/L-35065-16					5691 029-09
DVJNR/L 203D	DVJNR/L 3225P16	C6-DVJNR/L-45065-16					5691 029-09
DVJNR/L 243D	DVJNR/L 3232P16	C8-DVJNR/L-55080-16					5691 029-10
	DVJNR/L 4040S16						–
DVVNN 103B	DVVNN 2020K16	C4-DVVNN-00062-16	5513 020-09	5322 269-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-061	5691 029-08
DVVNN 163D	DVVNN 2525M16	C5-DVVNN-00065-16					5691 045-01
DVVNN 203D	DVVNN 3225P16	C6-DVVNN-00065-16					5691 045-01
DVVNN 243D	DVVNN 3232P16	C8-DVVNN-00080-16					5691 045-01
	DVVNN 4040S16						–
		C8-DVMNL-00160-16	5513 020-09	5322 269-01 (4.76/.187)	5680 049-01 (15IP)	5412 028-061	5691 029-10
DWLNR/L 103B	DWLNR/L 1616H06	C3-DWLNR/L-22040-06	5513 020-04	5322 328-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011	–
DWLNR/L 123C	DWLNR/L 2020K06	C4-DWLNR/L-27050-06					5691 029-08
DWLNR/L 163D	DWLNR/L 2525M06	C5-DWLNR/L-35060-06					5691 045-01
DWLNR/L 203D	DWLNR/L 3225P06	C6-DWLNR/L-45065-06					5691 045-01
DWLNR/L 124C	DWLNR/L 2020K08	C4-DWLNR/L-27050-08	5513 020-02	5322 331-12 (4.76/.187)	5680 049-01 (15IP)	5412 028-021	5691 029-08
DWLNR/L 164D	DWLNR/L 2525M08	C5-DWLNR/L-35060-08		5322 331-13 (6.35/.250)		5412 034-021 ³⁾	5691 045-01
DWLNR/L 204D	DWLNR/L 3225P08	C6-DWLNR/L-45065-08				5412 032-021 ⁴⁾	5691 045-01
	DWLNR/L 3232P08	C8-DWLNR/L-55080-08					5691 045-01
	DWLNR/L 4040S08						–

1) For clamp set parts, see page A445.

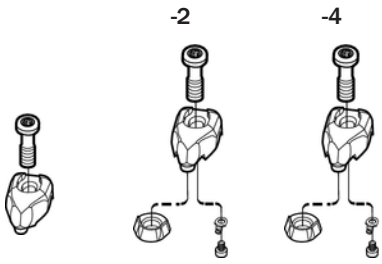






2) Optional part delivered to separate order.

3) Clamp sets for ceramic inserts without hole

4) Clamp sets for ceramic inserts with hole

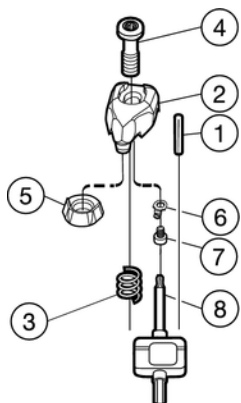
5) For optional nozzles, see page A324.

CoroTurn® RC clamp set parts

Insert Type/size									Optional clamp for carbide inserts
						Standard clamp set for carbide inserts	Clamp set for ceramic insert with hole	Clamp set for ceramic flat insert without hole	For heavy machining
CNM.09 (3/8)	DNM.11 (3/8)	SNM.09 (3/8)	TNM.16 (3/8)	WNM.06 (3/8)	–	5412 028-011	–	–	5412 029-02
CNM.12 (1/2)	DNM.15 (1/2)	SNM.12 (1/2)	TNM.22 (1/2)	WNM.08 (1/2)	–	5412 028-021	5412 032-021	5412 034-021	5412 029-02
CNM.16 (5/8)	–	SNM.15 (5/8)	TNM.27 (5/8)	–	–	5412 028-031	5412 032-031	5412 034-031	5412 029-03
CNM.19 (3/4)	–	SNM.19 (3/4)	TNM.33 (3/4)	–	–	5412 028-041	–	–	5412 029-04
CNM.25 (1)	–	SNM.25 (1)	–	–	–	5412 028-051	–	–	–
–	–	–	–	–	VNM.16 (3/8)	5412 028-061	–	–	–

Note!

Going from one insert thickness to another, means that the cutting edge height also changes. In order to compensate for that, the shim must be replaced.

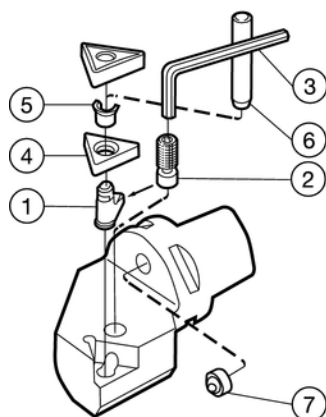
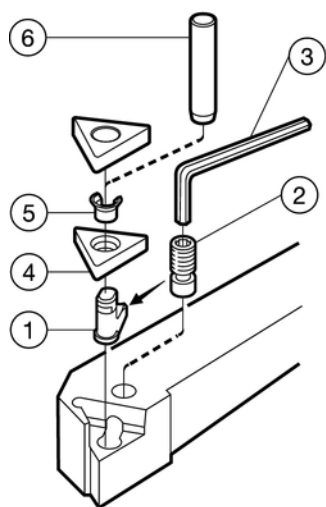


	1	2	3	4	5	6	7	8
Complete clamp set	Pin	Clamp	Compression spring	Screw	Pressure plate	Hook	Screw	Key (Torx Plus)
5412 028-011	3113 030-255	5412 028-01	5561 001-57	5512 086-01	–	–	–	–
5412 028-021	3113 030-307	5412 028-02	5561 001-58	5512 086-02	–	–	–	–
5412 028-031	3113 030-307	5412 028-03	5561 001-59	5512 086-03	–	–	–	–
5412 028-041	3113 030-307	5412 028-04	5561 001-59	5512 086-03	–	–	–	–
5412 028-051	3113 030-307	5412 028-05	5561 001-61	5512 086-04	–	–	–	–
5412 028-061	3113 030-307	5412 028-06	5561 001-58	5512 086-02	–	–	–	–
5412 032-021	3113 030-307	5412 032-02	5561 001-58	5512 086-02	5192 030-02	5411 012-01	5512 097-01	5680 051-02 (7IP)
5412 032-031	3113 030-307	5412 032-03	5561 001-59	5512 086-03	5192 030-03	5411 012-01	5512 097-01	5680 051-02 (7IP)
5412 034-021	3113 030-307	5412 034-02	5561 001-58	5512 086-02	5192 030-02	5411 012-01	5512 097-01	5680 051-02 (7IP)
5412 034-031	3113 030-307	5412 034-03	5561 001-59	5512 086-03	5192 030-03	5411 012-01	5512 097-01	5680 051-02 (7IP)

Optional full metal nozzles for cutting fluid pressure up to 80 bars
To be ordered separately

Standard nozzle	Nozzle for up to 80 bar pressure
5691 029-08	5691 034-01
5691 029-09	5691 034-02
5691 029-10	5691 034-03

T-Max® P lever design



Nozzle for Coromant Capto® cutting units

Cutting unit size	Nozzle (hole dia.)
C3–C4	5691 029-08
C5–C6	5691 029-09
C8	5691 029-10
C10	5691 034-03(3.5) ²⁾

²⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04

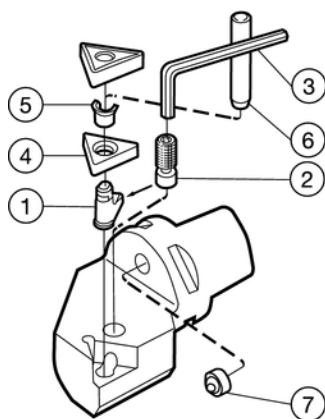
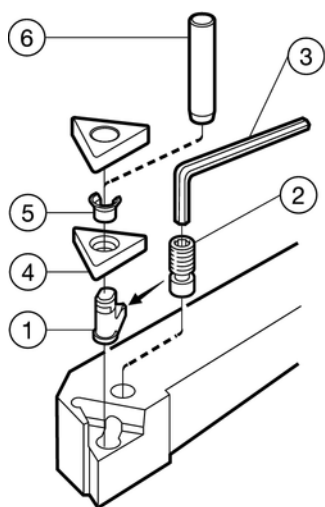
		1	2
Shank holders	Coromant Capto®	Lever	Screw
	PCBNR/L 2525M12	174.3-841M	174.3-821
	PCBNR/L 2525M16	438.3-840	438.3-831
	PCBNR/L 3225P16		
	PCBNR/L 3232P16		
	PCBNR/L 3232P19	174.3-842M	174.3-822M
	PCBNR/L 4040S19		
	PCLNR/L 1616H09	C3-PCLNR/L-22040-09	174.3-840M
	PCLNR/L 2020K09	C4-PCLNR/L-27050-09	174.3-820M
	PCLNR/L 2525M09	C5-PCLNR/L-35060-09	
	PCLNR/L 1616H12-M	174.3-848M	174.3-858
	PCLNR/L 2020K12	C3-PCLNR/L-22040-12	174.3-841M
	PCLNR/L 2525M12	C4-PCLNR/L-27050-12	174.3-821
	PCLNR/L 3225P12	C5-PCLNR/L-35060-12	
		C6-PCLNR/L-45065-12	
		C8-PCLNR/L-55080-12	
	PCLNR/L 2525M16	C4-PCLNR/L-27050-16	438.3-840
	PCLNR/L 3225P16	C5-PCLNR/L-35060-16	438.3-831
	PCLNR/L 3232P16	C6-PCLNR/L-45065-16	
		C8-PCLNR/L-55080-16	
	PCLNR/L 2525M19	C5-PCLNR/L-35060-19	174.3-842M
	PCLNR/L 3225P19	C6-PCLNR/L-45065-19	174.3-822M
	PCLNR/L 3232P19	C8-PCLNR/L-55080-19	
	PCLNR/L 4040S19		
	PCLNR/L 4040S25	C8-PCLNR/L-55080-25	174.3-844M
	PCLNR/L 5050T25		174.3-827
		C3-PCRNRL/L-17040-12	174.3-841M
		C4-PCRNRL/L-22050-12	174.3-821
		C5-PCRNRL/L-27060-12	
		C6-PCRNRL/L-35065-12	
		C4-PCRNRL/L-22050-16	438.3-840
		C5-PCRNRL/L-27060-16	438.3-831
		C6-PCRNRL/L-35065-16	
		C5-PCRNRL/L-27060-19	174.3-842M
		C6-PCRNRL/L-35065-19	174.3-822M
		C10-PCLNR/L-68110-25	174.3-844M
			174.3-827
	PDJNR/L 1616H11	5432 001-01	174.3-820M
	PDJNR/L 2020K11		
	PDJNR/L 2525M11		
	PDJNR/L 3225P11		
	C3-PDJNR/L 22045-11	5432 001-01	5322 255-01
	C4-PDJNR/L 27050-11		
	C5-PDJNR/L 35060-11		
	C6-PDJNR/L 45065-11		
	PDJNR/L 2020K15	174.3-847M	174.3-830
	PDJNR/L 2525M15		
	PDJNR/L 3225P15		
	PDJNR/L 3232P15		
	C4-PDJNR/L 27065-15	174.3-847M	171.35-851M
	C5-PDJNR/L 35060-15		
	R/L171.35-4025-15	174.3-847M	174.3-830
	R/L171.35-5032-15		
Negative			
	PRGNR/L 2020K09	174.3-840M	174.3-820M
	PRGNR/L 2525M12	174.3-841M	174.3-821
	PRGNR/L 3225P15	174.3-843M	174.3-825
	PRGNR/L 3232P19	174.3-842M	174.3-822M
	PRGNR/L 4040S25	174.3-844M	174.3-827

1) Optional part delivered to separate order.

T-Max® P lever design

3	4	5	6
Key (mm)	Shim (for insert thickness mm/inch)	Radius mm/inch	Shim pin Shim pin punch
174.1-864 (3.0)	171.31-850M (4.76/.187)	0.4-1.6/.016-.063	174.3-861 174.3-871
174.1-864 (3.0)	171.31-852 (6.35/.250)	0.4-2.4/.016-.094	174.3-864 174.3-873
3021 010-040 (4.0)	171.31-851M (6.35/.250)	0.4-2.4/.016-.094	174.3-862 174.3-872
170.3-860 (2.5)	5322 230-02 (3.18/.125)	0.4-1.2/.016-.047	174.3-863 174.3-870
174.1-864 (3.0)	171.31-850M (4.76/.187)	0.4-1.6/.016-.063	174.3-861 174.3-871
174.1-864 (3.0)	171.31-850M (4.76/.187)	0.4-1.6/.016-.063	174.3-861 174.3-871
174.1-864 (3.0)	171.31-852 (6.35/.250)	0.4-2.4/.016-.094	174.3-864 174.3-873
3021 010-040 (4.0)	171.31-851M (6.35/.250)	0.4-2.4/.016-.094	174.3-862 174.3-872
3021 010-050 (5.0)	5322 230-01 (9.52/.375)	2.4-3.2/.094-.126	174.3-865 174.3-874
174.1-864 (3.0)	171.31-850M (4.76/.187)	0.4-1.6/.016-.063	174.3-861 174.3-871
174.1-864 (3.0)	171.31-852 (6.35/.250)	0.4-2.4/.016-.094	174.3-864 174.3-873
3021 010-040 (4.0)	171.31-851M (6.35/.250)	0.4-2.4/.016-.094	174.3-862 174.3-872
3021 010-050(5.0)	5322 230-01 (9.52/.375)	2.4-3.2/.094-.125	174.3-865 174.3-874
174.1-863 (2.5)	5322 255-01 (4.76/.187) 5322 255-02 (4.76/.187) ¹⁾	0.4-0.8/.016-.031 0.4-1.6/.016-.063	174.3-860 174.3-870
174.1-863 (2.5)	–	–	174.3-860 174.3-870
174.1-864 (3.0)	171.35-851M (6.35/.250) 171.35-850M (6.35/.250) ¹⁾ 171.35-856 (4.76/.187) ¹⁾ 171.35-855 (4.76/.187) ¹⁾	0.4-0.8/.016-.031 1.2-1.6/.047-.063 0.4-0.8/.016-.031 1.2-1.6/.047-.063	174.3-861 174.3-871
174.1-864 (3.0)	–	–	174.3-861 174.3-871
174.1-864 (3.0)	171.35-851M (6.35/.250) 171.35-850M (6.35/.250) ¹⁾ 171.35-856 (4.76/.187) ¹⁾ 171.35-855 (4.76/.187) ¹⁾	0.4-0.8/.016-.031 1.2-1.6/.047-.063 0.4-0.8/.016-.031 1.2-1.6/.047-.063	174.3-861 174.3-871
170.3-860 (2.5)	176.3-850 (3.18/.125)	–	174.3-863 174.3-870
174.1-864 (3.0)	176.3-851M (4.76/.187)	–	174.3-861 174.3-871
174.1-864 (3.0)	176.3-854M (6.35/.250)	–	174.3-864 174.3-873
3021 010-040 (4.0)	176.3-852M (6.35/.250)	–	174.3-862 174.3-872
3021 010-050 (5.0)	176.3-853M (9.52/.375)	–	174.3-865 174.3-874



T-Max® P lever design



Nozzle for Coromant Capto® cutting units

Cutting unit size	Nozzle (hole dia.)
C3–C4	5691 029-08
C5–C6	5691 029-09
C8	5691 029-10
C10	5691 034-03(3.5) ³⁾

³⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04

		1	2
Shank holders	Coromant Capto®	Lever	Screw
Positive			
			
PRGCR/L 2020K10		176.39-840	174.3-834
PRGCR/L 2525M10			
PRGCR/L 2020K12		5432 005-01	174.3-820M
PRGCR/L 2525M12			
PRGCR/L 3225P12			
PRGCR/L 2525M16		176.39-842	174.3-833
PRGCR/L 3225P16			
PRGCR/L 3232P20	C8-PRSCR/L-55080-20	176.39-843	174.3-825
PRGCR/L 4040S25	C6-PRSCR/L-45065-25	176.39-844	174.3-832
	C8-PRSCR/L-55080-25		
	C10-PRSCR/L-68110-25		
PRGCR/L 5050T32	C8-PRSCR/L-55080-32	176.39-845	174.3-827
	C10-PRSCR/L-68110-32		
PRDCN-2020K 10		176.39-840	174.3-834
PRDCN-2525M 12		5432 005-01	174.3-820M
PRDCN-3225P 12			
PRDCN-3225P 16		176.39-842	174.3-833
PRDCN-3232P 20		176.39-843	174.3-825
PRDCN-4040S 25	C6-PRDCN-00065-25A	176.39-844	174.3-832
	C8-PRDCN-00080-25A		
	C10-PRDCN-0110-25		
PRDCN-5050U 32	C8-PRDCN-00065-32A	176.39-845	174.3-827
	C10-PRSCR/L 001100-32		
			
PSBNR/L 1212F09		174.3-845-1	174.3-829
PSBNR/L 1616H09	C3-PSNRN/L-17040-09	174.3-840M	174.3-820M
PSBNR/L 2020K09	C4-PSNRN/L-22050-09		
PSBNR/L 2525M09			
PSBNR/L 2020K12	C3-PSNRN/L-17040-12	174.3-841M	174.3-821
PSBNR/L 2525M12	C4-PSNRN/L-22050-12		
PSBNR/L 3225P12	C5-PSNRN/L-27060-12		
	C6-PSNRN/L-35065-12		
PSBNR/L 2525M15	C4-PSNRN/L-22050-15	438.3-840	438.3-831
PSBNR/L 3225P15	C5-PSNRN/L-27060-15		
PSBNR/L 3232P15	C6-PSNRN/L-35065-15		
PSBNR/L 3232P19	C5-PSNRN/L-27060-19	174.3-842M	174.3-822M
PSBNR/L 4040S19	C6-PSNRN/L-35065-19		
	C8-PSNRN/L-45080-19		
PSBNR/L 4040S25			
PSBNR/L 5050T25	C8-PSNRN/L-45080-25	174.3-844M	174.3-827
	C10-PSNRN/L-58110-25		
PSSNR/L 1616H09		174.3-840M	174.3-820M
PSSNR/L 2020K09			
PSSNR/L 2525M09			
PSSNR/L 2020K12	C3-PSSNR/L-22032-12	174.3-841M	174.3-821
PSSNR/L 2525M12	C4-PSSNR/L-27042-12		
PSSNR/L 3225P12	C5-PSSNR/L-35052-12		
	C6-PSSNR/L-45065-12		
PSSNR/L 2525M15	C4-PSSNR/L-27040-15	438.3-840	438.3-831
PSSNR/L 3225P15	C5-PSSNR/L-35050-15		
PSSNR/L 3232P15	C6-PSSNR/L-45054-15		
PSSNR/L 3232P19	C6-PSSNR/L-35048-19	174.3-842M	174.3-822M
PSSNR/L 4040S19	C8-PSSNR/L-45052-19		
PSSNR/L 4040S25	C10-PSSNR/L-68092-25	174.3-844M	174.3-827
PSDNN 1010E09		174.3-845-1	174.3-829
PSDNN 1212F09			
PSDNN 1616H09		174.3-840M	174.3-820M
PSDNN 2020K12	C3-PSDNN- 00040-12	174.3-841M	174.3-821
PSDNN 2525M12	C4-PSDNN- 00050-12		
PSDNN 3225P12	C5-PSDNN- 00060-12		
	C6-PSDNN- 00065-12		
	C4-PSDNN- 00050-15	438.3-840	438.3-831
	C5-PSDNN- 00060-15		
	C6-PSDNN- 00065-15		

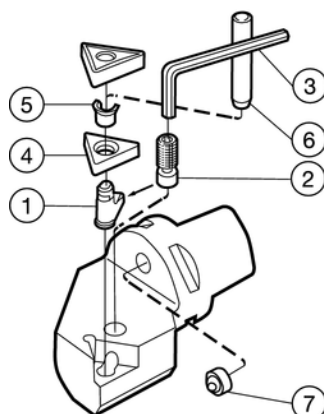
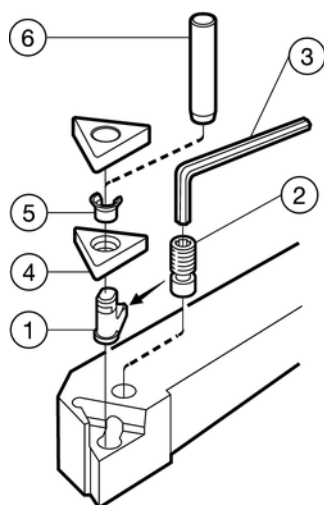
1) For insert RMCT 10T3M0

2) Optional part delivered to separate order.

T-Max® P lever design

3	4		5	6
Key (mm)	Shim (for insert thickness mm/inch)	Radius mm/inch	Shim pin (for insert thickness mm/inch)	Shim pin punch
170.3-864 (1.98)	176.39-850 (3.18/.125) 5322 150-01 (3.97/.157) ¹⁾	– –	174.3-860 174.3-860 (3.97/.156)	174.3-870
170.3-860 (2.5)	176.39-851 (4.76/.187)	–	174.3-863	174.3-870
170.3-860 (2.5)	176.39-852 (6.35/.250)	–	174.3-867	174.3-871
174.1-864 (3.0)	176.39-853 (6.35/.250)	–	174.3-864	174.3-873
3021 010-040 (4.0)	176.39-854 (7.94/.313)	–	174.3-862	174.3-872
3021 010-050 (5.0)	176.39-855 (9.52/.374)	–	174.3-865	174.3-874
170.3-864 (1.98)	176.39-850 (3.18/.125) 5322 150-01 (3.97/.156) ¹⁾	–	174.3-860 174.3-860 (3.97/.156)	174.3-870
170.3-860 (2.5)	176.39-851 (4.76/.187)	–	174.3-863	174.3-870
170.3-860 (2.5)	176.39-852 (6.35/.250)	–	174.3-867	174.3-871
174.1-864 (3.0)	176.39-853 (6.35/.250)	–	174.3-864	174.3-873
3021 010-040 (4.0)	176.39-854 (7.94/.313)	–	174.3-862	174.3-872
3021 010-050 (5.0)	176.39-855 (9.52/.374)	–	174.3-865	174.3-874
174.1-870 (1.98)	–	–	–	–
170.3-860 (2.5)	174.3-850 (3.18/.125)	0.4-1.2/.016 – .047	174.3-863	174.3-870
174.1-864 (3.0)	174.3-851M (4.76/.187) 174.3-856 (4.76/.187) ²⁾	0.4-1.2/.016 – .047 1.6-2.4/.063 – .094	174.3-861	174.3-871
174.1-864 (3.0)	174.3-857 (6.35/.250)	0.4-2.4/.016 – .094	174.3-864	174.3-873
3021 010-040 (4.0)	174.3-852M (6.35/.250)	0.8-2.4/.031 – .094	174.3-862	174.3-872
3021 010-050 (5.0)	174.3-853M (7.94/.313)	1.6-3.2/.063 – .126	174.3-865	174.3-874
170.3-860 (2.5)	174.3-850 (3.18/.125)	.04-1.2/.016 – .047	174.3-863	174.3-870
174.1-864 (3.0)	174.3-851M (4.76/.187) 174.3-856 (4.76/.187) ²⁾	0.4-1.2/.016 – .047 1.6-2.4/.063 – .094	174.3-861	174.3-871
174.1-864 (3.0)	174.3-857 (6.35/.250)	0.4-2.4/.016 – .094	174.3-864	174.3-873
3021 010-040 (4.0)	174.3-852M (6.35/.250)	0.8-2.4/.031 – .094	174.3-862	174.3-872
3021 010-050 (5.0)	174.3-853M (7.94/.313)	1.6-3.2/.063 – .126	174.3-865	174.3-874
174.1-870 (1.98)	–	–	–	–
170.3-860 (2.5)	174.3-850 (3.18/.125)	0.4-1.2/.016 – .047	174.3-863	174.3-870
174.1-864 (3.0)	174.3-851M (4.76/.187) 174.3-856 (4.76/.187) ²⁾	0.4-1.2/.016 – .047 1.6-2.4/.063 – .094	174.3-861	174.3-871
174.1-864 (3.0)	174.3-857 (6.35/.250)	0.4-2.4/.016 – .094	174.3-864	174.3-873
3021 010-040 (4.0)	174.3-852M (6.35/.250)	0.8-2.4/.031 – .094	174.3-862	174.3-872
3021 010-050 (5.0)	174.3-853M (7.94/.313)	1.6-3.2/.063 – .126	174.3-865	174.3-874
174.1-870 (1.98)	–	–	–	–
170.3-860 (2.5)	174.3-850 (3.18/.125)	0.4-1.2/.016 – .047	174.3-863	174.3-870
174.1-864 (3.0)	174.3-851M (4.76/.187) 174.3-856 (4.76/.187) ²⁾	0.4-1.2/.016 – .047 1.6-2.4/.063 – .094	174.3-861	174.3-871
174.1-864 (3.0)	174.3-857 (6.35/.250)	0.4-2.4/.016 – .094	174.3-864	174.3-873






T-Max® P lever design



Nozzle for Coromant Capto® cutting units

Cutting unit size	Nozzle (hole dia.)
C3-C4	5691 029-08
C5-C6	5691 029-09
C8	5691 029-10
C10	5691 034-03(3.5) ²⁾

²⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04

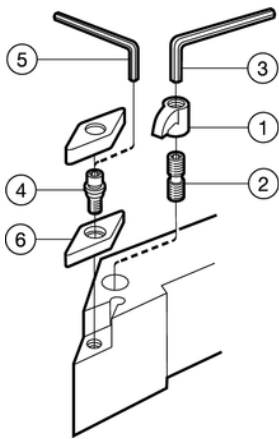
		1	2
Shank holders		Lever	Screw
 PSDNN 3225P19 PSDNN 3232P19 PSDNN 4040S25	Coromant Capto®		
	C5-PSDNN- 00060-19 C6-PSDNN- 00065-19	174.3-842M	174.3-822M
	C6-PSDNN- 00065-25 C8-PSDNN- 00080-25 C10-PSDNN-00110-25	174.3-844M	174.3-827
	PSKNR/L 1616H09 PSKNR/L 2020K09 PSKNR/L 2020K12 PSKNR/L 2525M12 PSKNR/L 3225P12	C3-PSKNR/L- 22040-09 C4-PSKNR/L- 27050-09 C3-PSKNR/L- 22040-12 C4-PSKNR/L- 27050-12 C5-PSKNR/L- 35060-12 C6-PSKNR/L- 45065-12	174.3-840M 174.3-820M 174.3-841M 174.3-821
 PTDNR/L 2525M22	PSKNR/L 2525M15	C4-PSKNR/L- 27050-15 C5-PSKNR/L- 35060-15 C6-PSKNR/L- 45065-15	438.3-840 438.3-831
	PSKNR/L 3232P19 PSKNR/L 4040S19	C5-PSKNR/L- 35060-19 C6-PSKNR/L- 45065-19 C8-PSKNR/L- 55080-19	174.3-842M 174.3-822M
	PSKNR/L 5050T25	C8-PSKNR/L- 55080-25 C10-PSKNR/L-0110-25	174.3-844M 174.3-827
 PTFNR/L 1212F11	PTFNR/L 1616H16 PTFNR/L 2020K16 PTFNR/L 2525M16	C3-PTFNR/L 22040-16 C4-PTFNR/L 27050-16 C5-PTFNR/L 35060-16 C6-PTFNR/L 45065-16	174.3-846-1 174.3-829 174.3-840M 174.3-820M
	PTFNR/L 2525M22 PTFNR/L 3225P22 PTFNR/L 3232P22 PTFNR/L 3232P27 PTFNR/L 4040S27 PTFNR/L 4040S33	C4-PTFNR/L 27050-22 C5-PTFNR/L 35060-22 C6-PTFNR/L 45065-22 C6-PTFNR/L 45065-27	174.3-841M 174.3-821 174.3-843M 174.3-825 174.3-842M 174.3-822M
	PTGNR/L 1010E11 PTGNR/L 1212F11 PTGNR/L 1616H11 PTGNR/L 2020K11 PTGNR/L 2525M11 PTGNR 1212K11-S PTGNR 1616K11-S PTGNR 082C-S PTGNR 102-S	C3-PTGNR/L 22040-11 C4-PTGNR/L 27050-11	174.3-846-1 174.3-829
	PTGNR/L 1616H16 PTGNR/L 2020K16 PTGNR/L 2525M16 PTGNR/L 3225P16	C3-PTGNR/L 22040-16 C4-PTGNR/L 27050-16 C5-PTGNR/L 35060-16 C6-PTGNR/L 45065-16	174.3-840M 174.3-820M
 PTTNR/L 1010E11	PTGNR/L 2525M22 PTGNR/L 3225P22 PTGNR/L 3232P22 PTGNR/L 3232P27 PTGNR/L 4040S27	C4-PTGNR/L 27050-22 C5-PTGNR/L 35060-22 C6-PTGNR/L 45065-22 C6-PTGNR/L 45065-27	174.3-841M 174.3-821 174.3-843M 174.3-825
		C3-PTJNR/L 22040-11 C4-PTJNR/L 27050-11	174.3-846-1 174.3-829
		C3-PTJNR/L 22040-16 C4-PTJNR/L 27050-16 C5-PTJNR/L 35060-16 C6-PTJNR/L 45065-16	174.3-840M 174.3-820M
		C4-PTJNR/L 27050-22 C4-PTJNR/L 27050-22 C5-PTJNR/L 35060-22 C6-PTJNR/L 45065-22	174.3-841M 174.3-821
 PTTNR/L 1010E11	PTTNR/L 1212F11 PTTNR/L 1616H16 PTTNR/L 2020K16 PTTNR/L 2525M22 PTTNR/L 3225P22 PTTNR/L 177.3-1010F-11	C4-PTTNR/L 22050-16 C5-PTTNR/L 27060-16 C5-PTTNR/L 27060-22 C6-PTTNR/L 35065-22	174.3-846-1 174.3-829 174.3-840M 174.3-820M 174.3-841M 174.3-821 174.3-846-1 174.3-829


1) Optional part delivered to separate order.

T-Max® P lever design

3	4	5	6
Key (mm)	Shim (for insert thickness mm/inch)	Radius mm/inch	Shim pin punch
3021 010-040 (4. 0)	174.3-852M (6.35/.250)	0.8-2.4/.031 – .094	174.3-862
3021 010-050 (5.0)	174.3-853M (7.94/.313)	1.6-3.2/.063 – .126	174.3-865
170.3-860 (2.5)	174.3-850 (3.18/.125)	0.4-1.2/.016 – .047	174.3-863
174.1-864 (3.0)	174.3-851M (4.76/.187) 174.3-856 (4.76/.187) ¹⁾	0.4-1.2/.016 – .047 1.6-2.4/.063 – .094	174.3-861
174.1-864 (3.0)	174.3-857 (6.35/.250)	0.4-2.4/.016 – .094	174.3-864
3021 010-040 (4.0)	174.3-852M (6.35/.250)	0.8-2.4/.031 – .094	174.3-862
3021 010-050 (5.0)	174.3-853M (7.94/.313)	1.6-3.2/.063 – .126	174.3-865
174.1-864 (3.0)	179.3-852M (4.76/.187) 179.3-853M (4.76/.187) ¹⁾	1.2-1.6/.047 – .063 0.4-0.8/.016 – .031	174.3-861
170.3-864 (1.98)	–	–	–
170.3-860 (2.5)	179.3-850M (4.76/.187) 179.3-858 (4.76/.187) ¹⁾	0.4-0.8/.016 – .031 1.2-1.6/.047 – .063	174.3-860
174.1-864 (3.0)	179.3-852M (4.76/.187) 179.3-853M (4.76/.187) ¹⁾	1.2-1.6/.047 – .063 0.4-0.8/.016 – .031	174.3-861
174.1-864 (3.0)	179.3-854M (6.35/.250) 179.3-857 (6.35/.250) ¹⁾	0.8-1.2/.031 – .047 1.6-2.4/.061 – .094	174.3-864
3021 010-040 (4.0)	179.3-855M (7.94/.313)	1.6-2.4/.061 – .094	174.3-866
170.3-864 (1.98)	–	–	–
170.3-860 (2.5)	179.3-850M (4.76/.187) 179.3-858 (4.76/.187) ¹⁾	0.4-0.8/.016 – .031 1.2-1.6/.047 – .063	174.3-860
174.1-864 (3.0)	179.3-852M (4.76/.187) 179.3-853M (4.76/.187) ¹⁾	1.2-1.6/.047 – .063 0.4-0.8/.016 – .031	174.3-861
174.1-864 (3.0)	179.3-854M (6.35/.250) 179.3-857 (6.35/.250) ¹⁾	0.8-1.2/.031 – .047 1.6-2.4/.061 – .094	174.3-864
170.3-864 (1.98)	–	–	–
170.3-860 (2.5)	179.3-850M (4.76/.187) 179.3-858M (4.76/.187) ¹⁾	0.4-0.8/.016 – .031 1.2-1.6/.047 – .061	174.3-860
174.1-864 (3.0)	179.3-852M (4.76/.187) 179.3-853M (4.76/.187) ¹⁾	1.2-1.6/.047 – .061 0.4-0.8/.016 – .031	174.3-861
170.3-864 (1.98)	–	–	–
170.3-860 (2.5)	179.3-850M (4.76/.187) 179.3-858M (4.76/.187) ¹⁾	0.4-0.8/.016 – .031 1.2-1.6/.047 – .061	174.3-860
174.1-864 (3.0)	179.3-852M (4.76/.187) 179.3-853M (4.76/.187) ¹⁾	0.4-0.8/.016 – .031	174.3-861
170.3-864 (1.98)	–	–	–

T-Max P screw and top clamp design

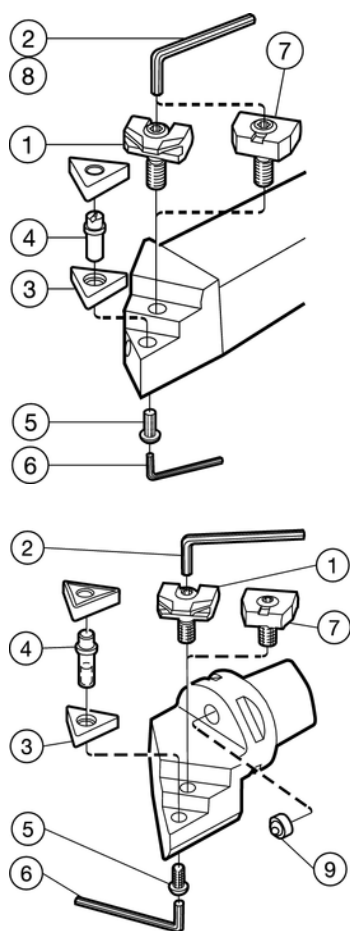


		1	2
Shank holders	Coromant Capto®	Clamp	Clamp screw
 MVJNR/L 2020K16 MVJNR/L 2525M16 MVJNR/L 3225P16	C4-MVJNR/L-27050-16 C5-MVJNR/L-35060-16	MC-12	MS-510

T-Max P screw and top clamp design

3	4	5	6	
Key (mm)	Lock pin	Key (mm)	Shim (for insert thickness mm/inch)	Radius mm/inch
3021 011-532 (3.96)	MN-34L	174.1-870 (1.98)	MVN-322 (4.76/.188)	0.4-1.2/.016-.047

T-Max P wedge clamp design



Nozzle for Coromant Capto® cutting units

Cutting unit size	Nozzle
C3-C4	5691 029-08
C5-C6	5691 029-09
C8	5691 029-10

Shank holders			1	2
Inch	Metric	Coromant Capto®	Wedge clamp set	Key (mm)
	MSSNR/L 2525M12		181.38-824-1	174.1-864 (3.0)
	MSSNR/L 3232P19		181.38-825-1	3021 010-040 (4.0)
	MSSNR/L 4040S25	–	181.38-826-1	3021 010-050 (5.0)
		C8-MSSNR/L 55070-25	181.38-826-1	3021 010-050 (5.0)
	MTJNR/L 2020K16M1		170.38-820-1	174.1-863 (2.5)
	MTJNR/L 2525M16M1			
	MTJNR/L 3225P16M1			
		C3-MTJNR/L 22040-16	170.38-820-1	174.1-863 (2.5)
		C4-MTJNR/L 27050-16		
		C5-MTJNR/L 35060-16		
	MTJNR/L 2525M22M1		170.38-821-1	174.1-864 (3.0)
	MTJNR/L 3225P22M1			
		C4-MTJNR/L 27050-22	170.38-821-1	174.1-864 (3.0)
		C5-MTJNR/L 35060-22		
		C6-MTJNR/L 45065-22		
		C6-MTJNR/L 45065-27	170.38-822-1	174.1-864 (3.0)
	MTGNR/L 2525M22M1		170.38-821-1	174.1-864 (3.0)
	MTGNR/L 3225P22M1			
	MTGNR/L 3232P22M1			
	MTENN 2525M22M1		170.38-821-1	174.1-864 (3.0)
	MTENN 3225P22M1			
	MTENN 3232P22M1			
	WTENN-164C		A170.38-821-1	174.1-871 (1/8)
	WTENN-164D			
	WTENN-854D			
	WTFNR/L-164D		A170.38-821-1	174.1-871 (1/8)
	WTGNR/L-164D		A170.38-821-1	174.1-871 (1/8)
	WTGNR/L-854D			
	WTJNR/L-123B		A170.38-820-1	265.2-818 (3/32)
	WTJNR/L-163D		A170.38-820-1	265.2-818 (3/32)
	WTJNR/L-203D			
	WTJNR/L-164C		A170.38-821-1	174.1-871 (1/8)
	WTJNR/L-164D			
	WTJNR/L-204D			
	WTJNR/L-854D			
	WTJNR/L-205D		A170.38-822-1	174.1-871 (1/8)
	WTENN-205D			
	WTJNR/L-245D			
		R/L 170.38-4025-16M1	170.38-820-1	174.1-863 (2.5)
		L 170.38-4025-22M1	170.38-821-1	174.1-864 (3.0)
		R 170.38-5032-22M1		
	MWLN/L-123C	MWLN/L 2020K06	C3-MWLN/L-22040-06	5431 125-011
	MWLN/L-123D	MWLN/L 2525M06	C4-MWLN/L-27050-06	170.3-860 (2.5)
	MWLN/L-163D			
	MWLN/L-203D			
	MWLN/L-243D			
	MWLN/L-124C	MWLN/L 2020K08	C4-MWLN/L-27050-08	5431 125-021
	MWLN/L-164D	MWLN/L 2525M08	C5-MWLN/L-35060-08	174.1-864 (3.0)
	MWLN/L-204D	MWLN/L 3225P08		
	MWLN/L-244D			

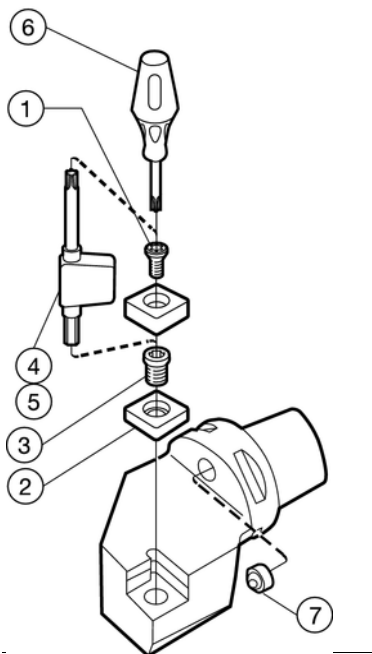
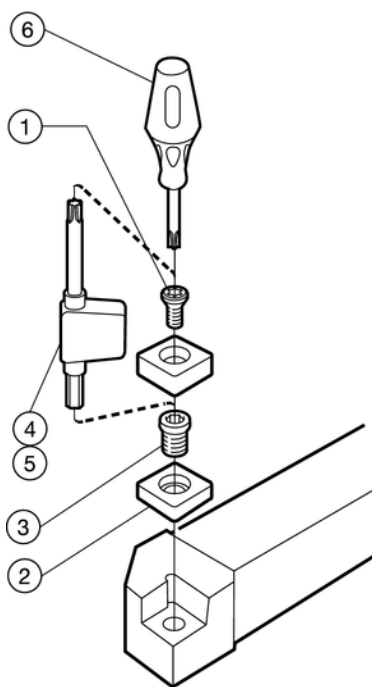
1) Optional part delivered to separate order.

T-Max P wedge clamp design

3		4	5	6	7 ¹⁾	8 ¹⁾
Shim (for insert thickness mm/inch)	Radius mm/inch	Pin	Screw	Key (mm)	Wedge set	Key (mm)
181.38-850 (4.76/.188)	0.4-0.8/.016 – .031	181.38-840	3212 010-255	174.1-864 (3.0)	181.38-820-1	–
181.38-851 (6.35/.250)	0.8-2.4/.031 – .094	181.38-841	3212 010-306	174.1-864 (3.0)	181.38-821-1	–
181.38-852 (7.94/.314)	1.6-2.4/.063 – .094	181.38-842	3212 100-357	3021 010-040 (4.0)	181.38-822-1	–
181.38-853 (9.52/.375) ¹⁾	2.4-3.2/.094 – .125					
181.38-852 (7.94/.314)	1.6-2.4/.063 – .094	181.38-842	3212 100-357	3021 010-040 (4.0)	–	–
181.38-853 (9.52/.375) ¹⁾	2.4/.094					
5322 420-04 (7.94/.314) ¹⁾	4.7/.125					
5322 420-03 (9.52/.375) ¹⁾	4.7/.125					
170.3-852 (4.76/.188)	0.4-1.6/.016 – .063	5313 021-02	3212 010-206	174.1-863 (2.5)	170.38-823-1	174.1-864 (3.0)
170.3-852 (4.76/.188)	0.4-1.6/.016 – .063	5313 021-02	3212 010-206	174.1-863 (2.5)	170.38-823-1	174.1-864 (3.0)
170.3-855 (4.76/.188)	1.2-1.6/.048 – .063	181.38-840	3212 010-255	174.1-864 (3.0)	170.38-824-1	3021 010-040 (4.0)
170.3-856 (4.76/.188) ¹⁾	0.4-0.8/.016 – .031					
170.3-855 (4.76/.188)	1.2-1.6/.048 – .063	181.38-840	3212 010-255	174.1-864 (3.0)	170.38-824-1	3021 010-040 (4.0)
170.3-856 (4.76/.188) ¹⁾	0.4-0.8/.016 – .031					
170.3-854 (6.35/.250)	0.8-1.6/.031 – .063	5313 021-04	3212 100-307	3021 010-040 (4.0)	170.38-825-1	3021 010-040 (4.0)
170.3-857 ¹⁾	.094 ¹⁾					
170.3-855 (4.76/.188)	1.2-1.6/.048 – .063	181.38-840	3212 010-255	174.1-864 (3.0)	170.38-824-1	3021 010-040 (4.0)
170.3-856 (4.76/.188) ¹⁾	0.4-0.8/.016 – .031					
170.3-855 (4.76/.188)	1.2-1.6/.048 – .063	181.38-840	3212 010-255	174.1-864 (3.0)	170.38-824-1	3021 010-040 (4.0)
170.3-856 (4.76/.188) ¹⁾	0.4-0.8/.016 – .031					
170.3-859 (4.76/.188)	0.4-1.6/.016-.063	170.3-836M-1 ²⁾	–	174.1-871 (1/8)	–	–
170.3-855 (6.35/.250) ¹⁾						
170.3-859 (4.76/.188)	0.4-1.6/.016-.063	170.3-836M-1 ²⁾	–	174.1-871 (1/8)	–	–
170.3-859 (4.76/.188)	0.4-1.6/.016-.063	170.3-836M-1 ²⁾	3212 010-206	174.1-871 (1/8)	–	–
170.3-852 (4.76/.188)	0.4-1.6/.016-.063	5313 021-02	5512 030-03	174.1-863 (2.5)	–	–
170.3-852 (4.76/.188)	0.4-1.6/.016-.063	5313 021-02	3212 010-206	174.1-863 (2.5)	–	–
170.3-859 (4.76/.188)	0.4-1.6/.016-.063	170.3-836M-1 ²⁾	–	174.1-871 (1/8)	–	–
170.3-858 (6.35/.250)	0.8-1.6/.031-.063	170.3-848M-1 ²⁾	–	3021 010-040 (4.0)	–	–
170.3-852 (4.76/.188)	0.4-1.6/.016 – .063	5313 021-02	3212 010-206	174.1-863 (2.5)	170.38-823-1	174.1-864 (3.0)
170.3-855 (4.76/.188)	1.2-1.6/.048 – .063	181.38-840	3212 010-255	174.1-864 (3.0)	170.38-824-1	3021 010-040 (4.0)
170.3-856 (4.76/.188) ¹⁾	0.4-0.8/.016 – .031					
5322 331-06	–	5313 022-01	5512 030-03	170.3-864 (1.98)	–	–
5322 331-07 (4.76/.188)	0.4-0.8/.016 – .031	5313 022-03	3212 010-255	174.1-864 (3.0)	–	–
5322 331-08 (4.76/.188) ¹⁾	1.2-1.6/.048 – .063					

²⁾ Shim pin and screw.

CoroTurn® 107 screw clamp design



Nozzle for Coromant Capto® cutting units

Cutting unit size	Nozzle (hole dia.)
C3-C4	5691 029-08
C5-C6	5691 029-09
C8	5691 029-10
C10	5691 034-03(3.5) ²⁾

²⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04

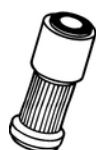
Shank holders			1
Inch	Metric	Coromant Capto®	Insert screw (thread)
	SCACR/L 062C-S	SCACR/L 0808K06-S	5513 020-03 (M2.5)
	SCACR/L 082C-S	SCACR/L 1010K06-S	
	SCACR/L 102C-S	SCACR/L 1212K06-S	
		SCACR/L 1616K06-S	
	SCACR/L 083C-S	SCACR/L 1212K09-S	5513 020-09 (M3.5)
	SCACR/L 103C-S	SCACR/L 1616K09-S	
	SCACR/L 123C-S		
	SCLCR/L 062C-S	SCLCR/L 0808K06-S	5513 020-03 (M2.5)
	SCLCR/L 082C-S	SCLCR/L 1010K06-S	
	SCLCR/L 102C-S	SCLCR/L 1212K06-S	
	SCLCR/L 083C-S	SCLCR/L 1616K06-S	5513 020-09 (M3.5)
	SCLCR/L 103C-S	SCLCR/L 1212K09-S	
	SCLCR/L 123C-S	SCLCR/L 1616K09-S	
	SCLCR/L 062	SCLCR/L 0808D06	5513 020-03 (M2.5)
		SCLCR/L 1010E06	
	SCLCR/L 063	SCLCR/L 1212F09-M	5513 020-10 (M3.5)
	SCLCR/L 103	SCLCR/L 1616H09	5513 020-01 (M3.5)
	SCLCR/L 123B	SCLCR/L 2020K09	
	SCLCR/L 163D		
		C3-SCLCR/L-22040-09	
	SCLCR/L 124B	SCLCR/L 2020K12	5513 020-18 (M4x0.5)
	SCLCR/L 164D	SCLCR/L 2525M12	
	SCLCR/L 204D		
		C4-SCLCR/L-27050-09	
		C5-SCLCR/L-35060-09	
		C6-SCLCR/L-45065-09	
		C3-SCLCR/L-22040-12	5513 020-18 (M4x0.5)
		C4-SCLCR/L-27050-12	
		C5-SCLCR/L-35060-12	
		C6-SCLCR/L-45065-12	
		C10-SCLCR/L-68110-38	5513 028-01
	SDACR/L 062C-S	SDACR/L 0808K07-S	5513 020-03 (M2.5)
	SDACR/L 082C-S	SDACR/L 1010K07-S	
	SDACR/L 102C-S	SDACR/L 1212K07-S	
		SDACR/L 1616K07-S	
	SDACR/L 083C-S	SDACR/L 1212K11-S	5513 020-09 (M3.5)
	SDACR/L 103C-S	SDACR/L 1616K11-S	
	SDACR/L 123C-S		
	SDJCR/L 062C-S	SDJCR/L 0808K07-S	5513 020-03 (M2.5)
	SDJCR/L 082C-S	SDJCR/L 1010K07-S	
	SDJCR/L 102C-S	SDJCR/L 1212K07-S	
		SDJCR/L 1616K07-S	5513 020-09 (M3.5)
	SDJCR/L 083C-S	SDJCR/L 1212K11-S	
	SDJCR/L 103C-S	SDJCR/L 1616K11-S	
	SDJCR/L 123C-S		5513 020-03 (M2.5)
	SDJCR/L 062	SDJCR/L 1010E07	
	SDJCR/L 092	SDJCR/L 1212F07	
	SDJCR/L 102	SDJCR/L 1616H07	
	SDJCR/L 122B	SDJCR/L 2020K07	5513 020-01 (M3.5)
	SDJCR/L 123B	SDJCR/L 1616H11	
	SDJCR/L 163C	SDJCR/L 2020K11	
	SDJCR/L 163D	SDJCR/L 2525M11	
		C3-SDJCR/L-22040-07	
		C4-SDJCR/L-27050-07	
	SDPCN 083C-S	SDNCN 1010K07-S	5513 020-03 (M2.5)
	SDPCN 103C-S	SDNCN 1212K11-S	5513 020-09 (M3.5)
	SDPCN 123C-S	SDNCN 1616K11-S	5513 020-03 (M2.5)
	SDPCN 062	SDNCN 1010E07	
	SDPCN 082	SDNCN 1212F07	5513 020-01 (M3.5)
	SDPCN 103	SDNCN 1616H11	
	SDPCN 123B	SDNCN 2020K11	
	SDPCN 163C	SDNCN 2525M11	
		C3-SDNCN-00040-11	
		C4-SDNCN-00050-11	
		C5-SDNCN-00060-11	

1) Optional part delivered to separate order.

CoroTurn® 107 screw clamp design

2		3	4	5	6
Shim (for insert thickness mm/inch)	Radius mm/inch	Shim screw	Key (Torx Plus)	Key (mm)	Screwdriver (Torx Plus)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 049-01 (15IP)	-	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 049-01 (15IP)	-	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 049-01(15IP)	-	5680 046-02 (15IP)
5322 232-01 (3.97/.156)	0.2-0.8/.008-.031	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
5322 232-02 (4.76/.187)	0.4-1.2/.016-.047	5512 090-03	5680 049-02 (15IP)	5680 049-02 (4.0)	5680 046-02 (15IP)
5322 232-03		5512 089-01	5680 042-03 (T30)	5642 042-03 (6.0)	
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 049-01(15IP)	-	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 049-01(15IP)	-	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 263-01 (3.97/.156) 5322 263-02 (3.97/.156) ¹⁾	0.4-0.8/.016-.031 1.2/.047	5512 090-01	5680 049-01 (15IP)	5680 049-01(3.5)	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 049-01(15IP)	-	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 263-01 (3.97/.156) 5322 263-02 (3.97/.156) ¹⁾	0.4-0.8/.016-.031 1.2/.047	5512 090-01	5680 049-01 (15IP)	5680 049-01(3.5)	5680 046-02 (15IP)

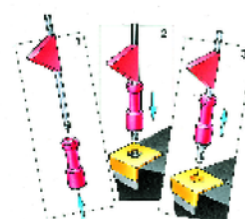
Magnetic sleeve for all sizes of keys and screwdrivers



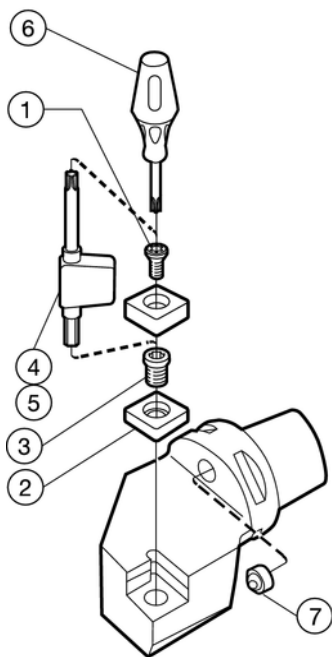
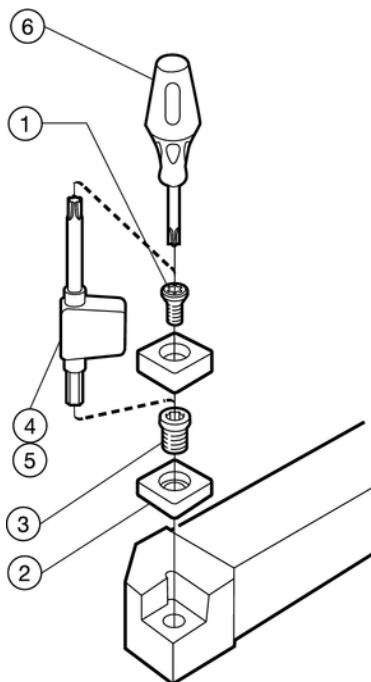
Ordering code:
5680 047-01

Instructions for use of the magnetic sleeve

- Place the magnetic sleeve over the key.
- Locate the key in the Torx-grip of the screw.
- Press the magnet down towards the insert.
- Unscrew, and both the screw and the insert (in most cases), will come out with the key.
- To be used for Torx keys of all sizes.




CoroTurn® 107 screw clamp design



Nozzle for Coromant Capto® cutting units

Cutting unit size	Nozzle (hole dia.)
C3–C4	5691 029-08
C5–C6	5691 029-09
C8	5691 029-10
C10	5691 034-03(3.5) ²⁾

²⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04

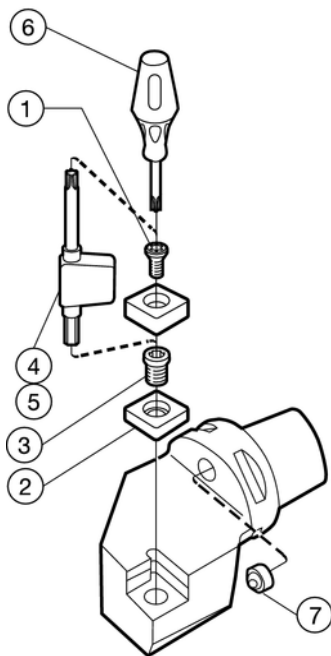
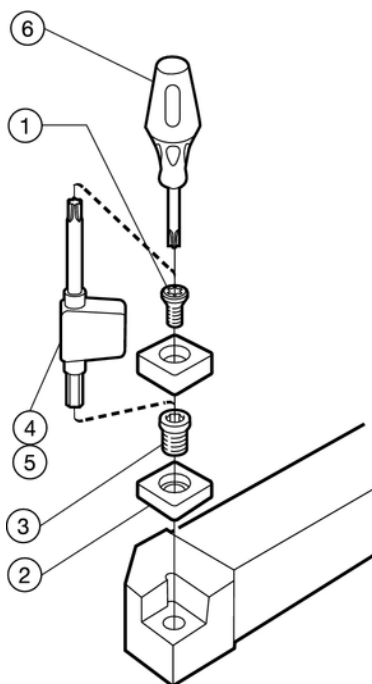
Shank holders				1
Inch	Metric	Coromant Capto®		Insert screw (thread)
				
SRACR/L 162D				5513 020-03 (M2.5)
SRACR/L 202D				
SRACR/L 163D				5513 020-12 (M3.5)
SRACR/L 203D				
SRACR/L 164D				5513 020-13 (M4)
SRACR/L 204D				
	SRDCN	1010E05	C3-SRDCN-00040-05A C4-SRDCN-00050-05A C5-SRDCN-00060-05A	5513 020-05 (M2.2)
SRDCN 082	SRDCN	1212F06	C3-SRDCN-00040-06A C5-SRDCN-00060-06A	5513 020-03 (M2.5)
SRDCN 103				5513 020-12 (M3.5)
	SRDCN	1616 H08	C3-SRDCN-00040-08A C4-SRDCN-00050-08A C5-SRDCN-00060-08A	5513 020-04 (M3.0)
	SRDCN	2020K10-A	C3-SRDCN-00040-10A	5513 020-10 (M3.5)
	SRDCN	2525M10-A	C4-SRDCN-00050-10A	
	SRDCN	3225P10-A	C5-SRDCN-00060-10A C6-SRDCN-00065-10A	
	SRDCN	2020K12-A	C4-SRDCN-00050-12A	5513 020-01 (M3.5)
	SRDCN	2525M12-A	C5-SRDCN-00060-12A	
	SRDCN	3225P12-A	C6-SRDCN-00065-12A	
	SRDCN	2525M16-A	C5-SRDCN-00060-16A	5513 020-26 (M5.0)
	SRDCN	3225P16-A	C6-SRDCN-00065-16A	
	SRDCN	3232P20-A	C5-SRDCN-00060-20A C6-SRDCN-00065-20A	5513 020-14 (M6.0)
	SRDCR/L	3225P05-A		5513 020-05 (M2.2)
	SRDCR/L	2020K06-A		5513 020-03 (M2.5)
	SRDCR/L	3225P06-A		
	SRDCR/L	2020K08-A		5513 020-04 (M3.0)
	SRDCR/L	2525M08-A		
	SRDCR/L	3225P08-A		
	SRDCR/L	3225P08-A		
SRGCR/L 123B				5513 020-12 (M3.5)
SRGCR/L 163D				
SRGCR/L 164C				5513 020-13 (M4)
SRGCR/L 164D				
SRGCR/L 204D				
SRGCR/L 206D				5513 020-14 (M6)
	SRSCR/L	3225P05		5513 020-05 (M2.2)
SRSCR/L 162C	SRSCR/L	3225P06	C3-SRSCR/L-22040-06 C4-SRSCR/L-27050-06 C5-SRSCR/L-35060-06	5513 020-03 (M2.5)
SRSCR/L 162D				
SRSCR/L 123B				5513 020-12 (M3.5)
SRSCR/L 163C				
SRSCR/L 163D				
SRSCR/L 203D				
SRSCR/L 164C				5513 020-13 (M4)
SRSCR/L 164D				
SRSCR/L 204D				
SRSCR/L 244D				
SRSCR/L 244E				
SRSCR/L 854D				
SRSCR/L 206D				5513 020-14 (M6)
SRSCR/L 248D				5513 020-15 (M7)
SRSCR/L 248E				
	SRSCR/L	3225P08	C3-SRSCR/L-22040-08 C4-SRSCR/L-27050-08 C5-SRSCR/L-35060-08	5513 020-04 (M3.0)
	SRSCR/L	2020K10	C3-SRSCR/L-22040-10	5513 020-10 (M3.5)
	SRSCR/L	2525M10	C4-SRSCR/L-27050-10 C5-SRSCR/L-35060-10 C6-SRSCR/L-45065-10	
	SRSCR/L	2525M12	C4-SRSCR/L-27050-12	5513 020-01 (M3.5)
	SRSCR/L	3225P12	C5-SRSCR/L-35060-12 C6-SRSCR/L-45065-12	
	SRSCR/L	3225P16	C5-SRSCR/L-35060-16 C6-SRSCR/L-45065-16	5513 020-26 (M5.0)
	SRSCR/L	3232P20	C5-SRSCR/L-35060-20 C6-SRSCR/L-45065-20	5513 020-14 (M6.0)

1) Optional part delivered to separate order.

CoroTurn® 107 screw clamp design

2		3	4	5	6
Shim (for insert thickness mm/inch)	Radius mm/inch	Shim screw	Key (Torx Plus)	Key (mm)	Screwdriver (Torx Plus)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 120-01 (3.97/.156)	-	-	5680 051-03 (9IP)	-	5680 046-04 (9IP)
5322 120-02 (4.76/.188)	-	-	5680 049-01 (15IP)	-	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 120-01 (3.97/.156)	-	-	5680 051-03 (9IP)	-	5680 046-04 (9IP)
-	-	5680 046-02 (15IP)	5680 051-03 (9IP)	-	5680 046-04 (9IP)
-	-	-	-	-	-
5322 110-01 (3.97/.156)	-	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
5322 110-02 (4.76/.187)	-	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
5322 110-03 (6.35/.250)	-	5512 090-06	5680 043-14 (20IP)	3021 010-050 (5.0)	5680 046-06 (20IP)
5322 110-04 (6.35/.250)	-	5512 090-08	5680 043-15 (25IP)	3021 010-060 (6.0)	5680 046-07 (25IP)
-	-	-	-	-	-
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-03 (9IP)	-	5680 046-04 (9IP)
5322 120-01 (3.97/.156)	-	-	5680 051-03 (9IP)	-	5680 046-04 (9IP)
5322 120-02 (4.76/.188)	-	-	5680 049-01 (15IP)	-	5680 046-02 (15IP)
5322 120-03 (6.35/.250)	-	-	5680 043-15 (25IP)	-	5680 046-07 (25IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 120-01 (3.97/.156)	-	-	5680 051-03 (9IP)	-	5680 046-04 (9IP)
5322 120-02 (4.76/.188)	-	-	5680 049-01 (15IP)	-	5680 046-02 (15IP)
5322 120-03 (6.35/.250)	-	-	5680 043-15 (25IP)	-	5680 046-07 (25IP)
5322 120-04 (7.94/.313)	-	-	5680 043-17 (30IP)	-	416.1-867 (T30)
-	-	-	5680 051-03 (9IP)	-	5680 046-04 (9IP)
5322 110-01 (3.97/.156)	-	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-03 (15IP)
5322 110-02 (4.76/.187)	-	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
5322 110-03 (6.35/.250)	-	5512 090-06	5680 043-14 (20IP)	3021 010-050 (5.0)	5680 046-06 (20IP)
5322 110-04 (6.35/.250)	-	5512 090-08	5680 043-15 (25IP)	3021 010-060 (6.0)	5680 046-07 (25IP)



CoroTurn® 107 screw clamp design



Nozzle for Coromant Capto® cutting units

Cutting unit size	Nozzle (hole dia.)
C3-C4	5691 029-08
C5-C6	5691 029-09
C8	5691 029-10
C10	5691 034-03(3.5) ²⁾

²⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04

Shank holders				1
Inch	Metric		Coromant Capto®	Insert screw (thread)
	SSBCR/L 103	SSBCR/L 1616H09	C3-SSRCR/L-17040-09	5513 020-01 (M3.5)
		SSBCR/L 2020K12	C4-SSRCR/L-22050-12	5513 020-18 (M4x0.5)
		SSBCR/L 2525M12	C5-SSRCR/L-27060-12	5513 028-01
			C10-SSRCR/L-58110-38	5513 020-01 (M3.5)
SSDCR/L 103	SSDCR/L 1616H09			5513 020-01 (M3.5)
SSDCR/L 163C	SSDCR/L 2020K09			
SSDCR/L 163D				
SSDCR/L 164D	SSDCR/L 2020K12			5513 020-18 (M4x0.5)
	SSDCR/L 2525M12			
SSDCN 083	SSDCN 1212F09-M			5513 020-10 (M3.5)
SSDCN 103	SSDCN 1616H09			5513 020-01 (M3.5)
SSDCN 123B				
SSDCN 163C				
SSDCN 163D				
			C10-SSDCN 00110-38	5513 028-01
SSKCR/L 103	SSKCR/L 1616H09			5513 020-01 (M3.5)
SSKCR/L 123B				
	STDCR/L 1010E09			5513 020-05 (M2.2)
	STDCR/L 1212F11			5513 020-03 (M2.5)
	STDCR/L 1212F11-B1 ²⁾			
	STDCR/L 1616H11			
STDCR/L 062	STDCR/L 1212F11			
STDCR/L 062-B1 ²⁾	STDCR/L 1212F11-B1 ²⁾			
STDCR/L 082	STDCR/L 1616H11			
STDCR/L 082-B1 ²⁾	STDCR/L 1616H11-B1 ²⁾			
STDCR/L 103	STDCR/L 1616H16			5513 020-01 (M3.5)
STDCR/L 123B	STDCR/L 2020K16			
STDCR/L 163D	STDCR/L 2525M16			
	STFCR/L 1010E09			5513 020-05 (M2.2)
	STFCR/L 1212F11			5513 020-03 (M2.5)
STFCR/L 062	STFCR/L 1212F11			
STFCR/L 062-B1 ²⁾	STFCR/L 1212F11-B1 ²⁾			
STFCR/L 082	STFCR/L 1616H11			
STFCR/L 082-B1 ²⁾	STFCR/L 1616H11-B1 ²⁾			
	STFCR/L 2020K11-A			
	STFCR/L 2020K11-AB1 ²⁾			
STFCR/L 103	STFCR/L 1616H16			5513 020-01 (M3.5)
STFCR/L 123B	STFCR/L 2020K16			
STFCR/L 163C	STFCR/L 2525M16			
STFCR/L 163C	STFCR/L 2525M16-A			
	STGCR/L 0808D09			5513 020-05 (M2.2)
	STGCR/L 1010E09			
STGCR/L 062	STGCR/L 1212F11	C3-STGCR/L- 22040-11		5513 020-03 (M2.5)
STGCR/L 062-B1 ²⁾	STGCR/L 1212F11-B1 ²⁾	C3-STGCR/L- 22040-11-B1 ²⁾		
STGCR/L 082	STGCR/L 1616H11	C4-STGCR/L- 27050-11		
STGCR/L 082-B1 ²⁾	STGCR/L 1616H11-B1 ²⁾	C4-STGCR/L- 27050-11-B1 ²⁾		
		C5-STGCR/L- 35060-11		
STGCR/L 103	STGCR/L 1616H16	C3-STGCR/L- 22040-16		5513 020-01 (M3.5)
STGCR/L 123B	STGCR/L 2020K16	C4-STGCR/L- 27050-16		
STGCR/L 163C	STGCR/L 2525M16	C5-STGCR/L- 35060-16		
STGCR/L 163D		C6-STGCR/L- 45065-16		
STJCR/L 062C-S	STJCR/L 1010K11-S			5513 020-03 (M2.5)
STJCR/L 082C-S	STJCR/L 1212K11-S			
STJCR/L 102C-S	STJCR/L 1616K11-S			
	STTCR/L 1616H11	C3-STJCR/L- 22040-11		5513 020-03 (M2.5)
	STTCR/L 1616H11-B1 ²⁾	C3-STJCR/L- 22040-11-B1 ²⁾		
		C4-STJCR/L- 27050-11		
		C4-STJCR/L- 27050-11-B1 ²⁾		
STTCR/L 123B	STTCR/L 1616H16	C3-STJCR/L- 22040-16		5513 020-01 (M3.5)
STTCR/L 163D	STTCR/L 2020K16	C4-STJCR/L- 27050-16		
STTCR 163C	STTCR/L 2525M16	C5-STJCR/L- 35060-16		

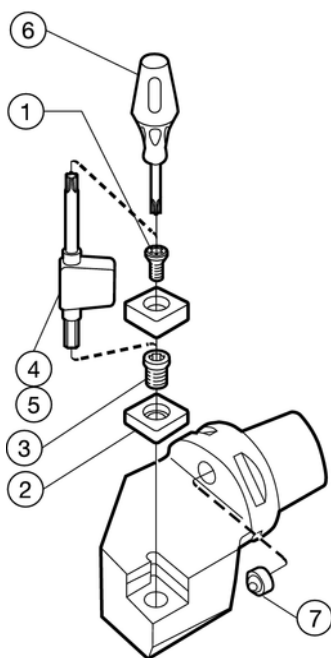
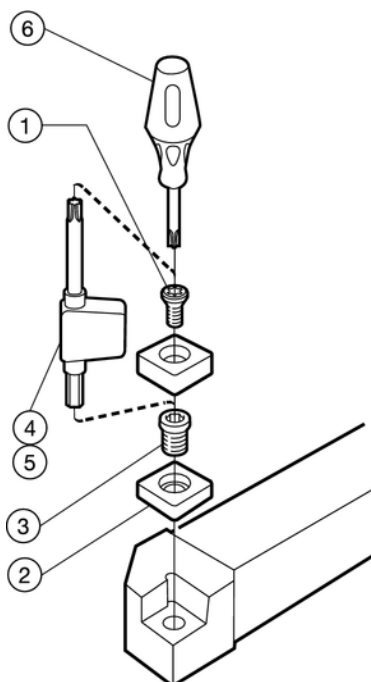
1) Optional part delivered to separate order.

2) B1 = For insert with thickness 2 = 1/8"

CoroTurn® 107 screw clamp design

2		3	4	5	6
Shim (for insert thickness mm/inch)	Radius mm/inch	Shim screw	Key (Torx Plus)	Key (mm)	Screwdriver (Torx Plus)
5322 420-01 (3.97/.156)	0.4-0.8/.016-.031	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
5322 420-02 (4.76/.187)	0.4-1.2/.016-.047	5512 090-03	5680 049-02 (15IP)	5680 049-02 (4.0)	5680 046-02 (15IP)
5322 420-01 (3.97/.156)	0.4-0.8/.016-.031	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
5322 420-02 (4.76/.187)	0.4-1.2/.016-.047	5512 090-03	5680 049-02 (15IP)	5680 049-02 (4.0)	5680 046-02 (15IP)
-	-	-	5680 049-01 (15IP)	-	5680 046-02 (15IP)
5322 420-01 (3.97/.156)	0.4-0.8/.016-.031	5512 090-01	5680 049-01 (15IP)	5680 049-01(3.5)	5680 046-02 (15IP)
5322 420-01 (3.97/.156)	0.4-0.8/.016-.031	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 320-01 (3.97/.156)	0.4-1.2/.016-.047	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 320-01 (3.97/.156)	0.4-1.2/.016-.047	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 320-01 (3.97/.156)	0.4-1.2/.016-.047	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
5322 320-01 (3.97/.156)	0.4-1.2/.016-.047	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)


CoroTurn® 107 screw clamp design



Nozzle for Coromant Capto® cutting units

Cutting unit size	7 Nozzle (hole dia.)
C3-C4	5691 029-08
C5-C6	5691 029-09
C8	5691 029-10
C10	5691 034-03(3.5) ²⁾

²⁾ When changing nozzle use key 5680 019-01 and bits 5680 021-04

Shank holders				1
Inch	Metric		Coromant Capto®	Insert screw (Thread)
				
SVABR/L 062C-S	SVABR/L	0810K11-S		5513 020-03 (M2.5)
SVABR/L 082C-S	SVABR/L	1010K11-S		
SVABR/L 102C-S	SVABR/L	1212K11-S		
	SVABR/L	1616K11-S		
SVABR/L 062C-S-B1 ³⁾	SVABR/L	0810K11-S-B1 ³⁾		5513 020-03 (M2.5)
SVABR/L 082C-S-B1 ³⁾	SVABR/L	1010K11-S-B1 ³⁾		
SVABR/L 102C-S-B1 ³⁾	SVABR/L	1212K11-S-B1 ³⁾		
	SVABR/L	1616K11-S-B1 ³⁾		
SVABR/L 083C-S	SVABR/L	1212K16-S		5513 020-09 (M3.5)
SVABR/L 103C-S	SVABR/L	1616K16-S		
SVABR/L 123C-S				
			C3-SVHBR/L-22040-11 C4-SVHBR/L-27050-11 C5-SVHBR/L-35060-11 C3-SVHBR/L-22040-11-B1 ³⁾ C4-SVHBR/L-27050-11-B1 ³⁾	5513 020-03 (M2.5)
SVHBR/L 123B	SVHBR/L	2020K16	C4-SVHBR/L-27050-16	5513 020-01 (M3.5)
SVHBR/L 163C	SVHBR/L	2525M16	C5-SVHBR/L-35060-16	
SVHBR/L 163D	SVHBR/L	3225P16	C6-SVHBR/L-45065-16	
	SVHCR/L	2525M22-R2 ²⁾		5513 020-18 (M4x0.5)
SVJBR/L 062C-S	SVJBR/L	0810K11-S		5513 020-03 (M2.5)
SVJBR/L 082C-S	SVJBR/L	1010K11-S		
SVJBR/L 102C-S	SVJBR/L	1212K11-S		
	SVJBR/L	1616K11-S		
SVJBR/L 062C-S-B1 ³⁾	SVJBR/L	0810K11-S-B1 ³⁾		5513 020-03 (M2.5)
SVJBR/L 082C-S-B1 ³⁾	SVJBR/L	1010K11-S-B1 ³⁾		
SVJBR/L 102C-S-B1 ³⁾	SVJBR/L	1212K11-S-B1 ³⁾		
	SVJBR/L	1616K11-S-B1 ³⁾		
SVJBR/L 083C-S	SVJBR/L	1212K16-S		5513 020-09 (M3.5)
SVJBR/L 103C-S	SVJBR/L	1616K16-S		
SVJBR/L 123C-S				
SVJBR/L 082	SVJBR/L	1212F11	C3-SVJBR/L-22040-11	5513 020-03 (M2.5)
SVJBR/L 082-B1 ³⁾	SVJBR/L	1616H11	C4-SVJBR/L-27050-11	
SVJBR/L 102	SVJBR/L	2020K11	C5-SVJBR/L-35060-11	
SVJBR/L 102-B1 ³⁾	SVJBR/L	2525M11	C3-SVJBR/L-22040-11-B1 ³⁾	
SVJBR/L 122B	SVJBR/L	1212F11-B1 ³⁾	C4-SVJBR/L-27050-11-B1 ³⁾	5513 020-01 (M3.5)
SVJBR/L 122B-B1 ³⁾	SVJBR/L	1616H11-B1 ³⁾		
SVJBR/L 162C	SVJBR/L	2020K11-B1 ³⁾		
SVJBR/L 162C-B1 ³⁾	SVJBR/L	2525M11-B1 ³⁾		
SVJBR/L 162D				5513 020-03 (M2.5)
SVJBR/L 162D-B1 ³⁾				
SVJBR/L 123B	SVJBR/L	2020K16	C4-SVJBR/L-27050-16	
SVJBR/L 163C	SVJBR/L	2525M16	C5-SVJBR/L-35060-16	
SVJBR/L 163D	SVJBR/L	3225P16	C6-SVJBR/L-45065-16	
SVJBR/L 203D				
SVVBN 062C-S-B1 ³⁾	SVVBN	0808K11-S		5513 020-03 (M2.5)
SVVBN 082C-S-B1 ³⁾	SVVBN	1010K11-S		
SVVBN 102C-S-B1 ³⁾	SVVBN	1212K11-S		
	SVVBN	1616K11-S		
				5513 020-03 (M2.5)
SVVBN 082	SVVBN	1212F11	C3-SVVBN-00040-11	
SVVBN 082-B1 ³⁾	SVVBN	1616H11	C4-SVVBN-00050-11	
SVVBN 102	SVVBN	2020K11	C3-SVVBN-00040-11-B1 ³⁾	
SVVBN 102-B1 ³⁾	SVVBN	2525M11	C4-SVVBN-00050-11-B1 ³⁾	5513 020-01 (M3.5)
SVVBN 122B	SVVBN	1212F11-B1 ³⁾		
SVVBN 162C	SVVBN	1616H11-B1 ³⁾		
SVVBN 162D	SVVBN	2020K11-B1 ³⁾		
	SVVBN	2525M11-B1 ³⁾		5513 020-01 (M3.5)
SVVBN 123B	SVVBN	2020K16	C4-SVVBN-00050-16	
SVVBN 163C	SVVBN	2525M16	C5-SVVBN-00060-16	
SVVBN 203D	SVVBN	3225P16	C6-SVVBN-00065-16	
SVVBN 163D				

1) Optional part delivered to separate order.

2) For insert VCGX 22 05 30-AL.

3) B1 = For insert with thickness 2 = 1/8"




CoroTurn® 107 screw clamp design

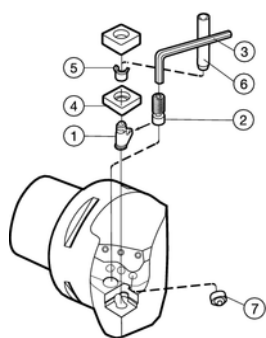
2		3	4	5	6 ¹⁾
Shim (for insert thickness mm/inch)	Radius mm/inch	Shim screw	Key (Torx Plus)	Key (mm)	Screwdriver (Torx Plus)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
–	–	–	5680 049-01 (15IP)	–	5680 046-02 (15IP)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
5322 270-01 (4.76/.187) 5322 270-02 (4.76/.187) ¹⁾	0.4-0.8/.016-.031 1.2/.047	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
5322 270-03 (4.76/.187) 5322 270-04 (4.76/.187) ¹⁾	2.0/.079 3.0/.118	5512 090-03	5680 049-02 (15IP)	–	5680 046-02 (15IP)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
–	–	–	5680 049-01 (15IP)	–	5680 046-02 (15IP)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
					5680 046-03 (7IP)
5322 270-01 (4.76/.187) 5322 270-02 (4.76/.187) ¹⁾	0.4-0.8/.016-.031 1.2/.047	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
5322 270-01 (4.76/.187) 5322 270-02 (4.76/.187) ¹⁾	0.4-0.8/.016-.031 1.2/.047	5512 090-01	5680 049-01 (15IP)	5680 049-01 (3.5)	5680 046-02 (15IP)

¹⁾ Optional part delivered to separate order.

CoroTurn® HP

Lever design

	1	2
Coromant Capto®	Lever	Screw
 C4-PCLNR/L-27050-12HP C5-PCLNR/L-35060-12HP C6-PCLNR/L-45065-12HP C6-PCLNR/L-45165-12HP C8-PCLNR/L-55080-12HP C4-PCMNN-00035-12HP C5-PCMNN-00115-12HP C6-PCMNN-00115-12HP C8-PCMNN-00150-12HP C5-PCLNR/L-35080-16HP C6-PCLNR/L-35065-16HP C8-PCLNR/L-55080-16HP C8-PCLNR/L-35085-16HP C6-PCLNR/L-45065-19HP C8-PCLNR/L-55080-19HP C6-PCRNR/L-35065-19HP C10-PCLNR/L-68110-19HP C10-PCMNN-00110-19HP	174.3-841M	174.3-821
C5-PCLNR/L-35080-16HP C6-PCLNR/L-35065-16HP C8-PCLNR/L-55080-16HP C8-PCLNR/L-35085-16HP	438.3-840	438.4-831
C6-PCLNR/L-45065-19HP C8-PCLNR/L-55080-19HP C6-PCRNR/L-35065-19HP	174.3-842M	174.3-822M
C10-PCLNR/L-68110-19HP C10-PCMNN-00110-19HP	174.3-842M	174.3-822M
 C4-PDJNR/L-27050-11HP C5-PDJNR/L-35060-11HP C4-PDJNR/L-27055-15HP C5-PDJNR/L-35060-15HP C6-PDJNR/L-45165-15HP C5-PDMNR/L-00130-15HP C6-PDJNR/L-45065-15HP C10-PDJNR/L-68110-15HP C5-PDJNR/L-35060-1504HP C8-PDJNR/L-45065-1504HP C8-PDJNR/L-55080-1504HP C6-PDUNR/L-45065-15HP C8-PDUNR/L-55080-15HP	5432 001-01	174.3-820M
C4-PDJNR/L-27055-15HP C5-PDJNR/L-35060-15HP C6-PDJNR/L-45165-15HP C5-PDMNR/L-00130-15HP C6-PDJNR/L-45065-15HP C10-PDJNR/L-68110-15HP	174.3-847M	174.3-830
C5-PDJNR/L-35060-1504HP C8-PDJNR/L-45065-1504HP C8-PDJNR/L-55080-1504HP	174.3-847M 174.3-847M 174.3-847M	174.3-830 174.3-830 174.3-830
C6-PDUNR/L-45065-15HP C8-PDUNR/L-55080-15HP	174.3-847	174.3-830
 C4-PSSNR/L-27042-12HP C5-PSSNR/L-35052-12HP C6-PSSNR/L-45156-12HP C6-PSSNR/L-45056-12HP C8-PSSNR/L-55080-12HP C6-PSDNN-00065-15HP C6-PSKNR/L-45065-15HP C6-PSRNR/L-35065-15HP C5-PSSNR/L-35050-15HP C6-PSSNR/L-45054-15HP C8-PSSNR/L-55080-15HP C6-PSDNN-00065-19HP C6-PSKNR/L-35065-19HP C8-PSKNR/L-55080-19HP C6-PSRNR/L-35065-19HP C8-PSRNR/L-45080-19HP C6-PSSNR/L-45052-19HP C8-PSSNR/L-55080-19HP C10-PSSNR/L-68092-19HP	174.3-841M	174.3-821
C6-PSDNN-00065-15HP C6-PSKNR/L-45065-15HP C6-PSRNR/L-35065-15HP C5-PSSNR/L-35050-15HP C6-PSSNR/L-45054-15HP C8-PSSNR/L-55080-15HP	438.3-840	438.3-831
C6-PSDNN-00065-19HP C6-PSKNR/L-35065-19HP C8-PSKNR/L-55080-19HP C6-PSRNR/L-35065-19HP C8-PSRNR/L-45080-19HP C6-PSSNR/L-45052-19HP C8-PSSNR/L-55080-19HP C10-PSSNR/L-68092-19HP	174.3-842M	174.3-822M
	174.3-842M	174.3-822M



CoroTurn® HP

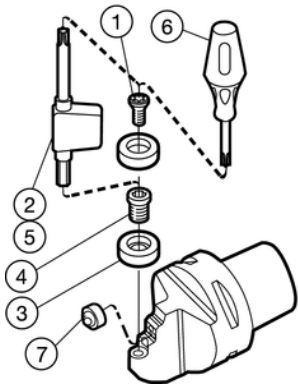
3	4		5	6	7
Key (mm)	Shim (for insert thickness mm/inch)	Radius mm/inch	Shim pin	Shim pin punch	Nozzle (hole diameter, mm) ²⁾
174.1-864 (3.0)	171.31-850M (4.76/.187)	0.4-1.6/.016-.063	174.3-861	5681 002-01	5691 026-03 (1.0)
174.1-864 (3.0)	171.31-852 (6.35/.250)	0.4-2.4/.016-.094	174.3-864	5681 002-02	5691 026-03 (1.0)
3021 010-040 (4.0)	171.35-851M (6.35/.250)	0.4-0.8/.016-.031	174.3-862	5681 002-02	5691 026-03 (1.0)
3021 010-040 (4.0)	171.35-851M (6.35/.250)	0.4-0.8/.016-.031	174.3-862	5681 002-02	5691 034-03 (3.5) 5691 034-03 (3.5)
174.1-863 (2.5)	5322 255-01		174.3-860	5681 002-01	5691 026-03 (1.0)
174.1-864 (3.0)	171.35-851M (6.35/.250) 171.35-850M (6.35/.250) ¹⁾ 171.35-856 (4.76/.187) ¹⁾ 171.35-855 (4.76/.187) ¹⁾	0.4-0.8/.016-.031 1.2-1.6/.047-.063 0.4-0.8/.016-.031 1.2-1.6/.047-.063	174.3-861	5681 002-01	5691 026-03 (1.0)
174.1-864 (3.0)			174.3-861	5681 002-01	5691 034-03 (3.5)
174.1-864 (3.0)	171.35-856 (4.76/.187)		174.3-861	5681 002-01	5691 026-03 (1.0)
174.1-864 (3.0)	171.35-851M (6.35/.250)		174.3-861	5681 002-01	5691 026-03 (1.0)
174.1-864 (3.0)	171.35-851M 171.35-850M	0.4-0.8/.016-.03 1.2C/.047	174.3-861	5681 002-01	5691 026-03(1.0)
174.1-864 (3.0)	174.3-851M (4.76/.187) 171.35-856 (4.76/.187) ¹⁾	0.4-1.2/.016-.047 1.6-2.4/.063-.094	174.3-861	5681 002-01	5691 026-03 (1.0)
174.1-864 (3.0)	174.3-857 (6.35/.250)	0.4-2.4/.016-.094	174.3-864	5681 002-02	5691 026-03 (1.0)
3021 010-040 (4.0)	174.3-852M (6.35/.250)	0.8-2.4/.031-.094	174.3-862	5681 002-02	5691 026-03 (1.0)
					5691 034-03 (3.5)

¹⁾ Accessories, must be ordered separately.



²⁾ Optional nozzles
To be ordered separately

Ordering code	Hole diameter, mm
5691 026-01	0.6
5691 026-02	0.8
5691 026-04	1.2
5691 026-05	1.4

CoroTurn® HP



Screw clamp design

	1	2
Coromant Capto®	Insert screw (Thread)	Key (Torx Plus)
		
C5-SRSCR/L-35060-10HP C6-SRSCR/L-45065-10HP C5-SRSCR/L-350060-12HP C6-SRSCL-45065-12HP C6-SRDCN-00065-12HP	5513 020-10 (M3.5) 5513 020-01 (M3.5)	5680 049-01 (15IP) 5680 049-01 (15IP)
		
C4-SVJBR/L-27050-16HP C5-SVJBR/L-35060-16HP C6-SVJBR/L-45065-16HP C8-SVJBR/L-55080-16HP C6-SVMBR/L-00130-16HP C6-SVUBR/L-45065-16HP C8-SVUBR/L-55080-16HP	5513 020-01 (M3.5)	5680 049-01 (15IP)

CoroTurn® HP

3	4	5	6	7
Shim	Shim screw	Key (Torx Plus)	Torque wrench	Nozzle (hole diameter, mm) ¹⁾
5322 110-01	5512 090-01	5680 049-01 (15IP)	5680 100-06	5691 026-03 (1.0)
5322 110-02	5512 090-01	5680 049-01 (15IP)	5680 100-06	5691 026-03 (1.0)
5322 270-01	5512 090-01	5680 049-01 (15IP)	5680 100-06	5691 026-13 (1.0)

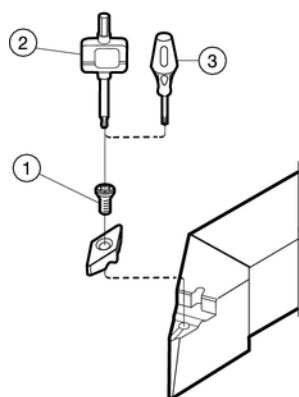
¹⁾ Accessories, must be ordered separately.

²⁾ Optional nozzles

To be ordered separately

Ordering code	Hole diameter, mm
5691 026-01	0.6
5691 026-02	0.8
5691 026-04	1.2
5691 026-05	1.4

CoroTurn® TR screw clamp design



Shank holders

1

Inch

Metric

Coromant Capto®

Insert screw

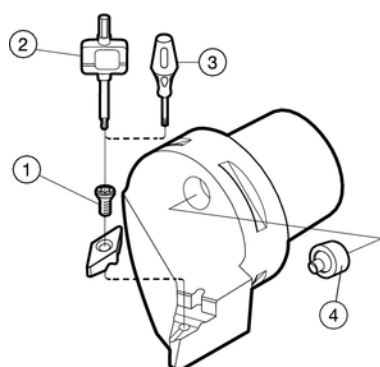


TR-D13JCR/L 12B
TR-D13JCR/L 16D
TR-D13JCR/L 10C-S
TR-D13NCN 12B
TR-D13NCN 16D
TR-D13NCN 10C-S

TR-D13NCN 2020K
TR-D13NCN 2525M
TR-D13NCN 3225M
TR-D13JCR/L 2020K
TR-D13JCR/L 2525M
TR-D13JCR/L 3225P
TR-D13NCN 1616K-S
TR-D13JCR/L 1616K-S

TR-C4-D13NCN-00050
TR-C5-D13NCN-00060
TR-C6-D13NCN-00065
TR-C4-D13JCR/L-27050
TR-C5-D13JCR/L-35060
TR-C6-D13JCR/L-45065
TR-C5-D13MCL-00115
TR-C6-D13MCL-00130

5513 020-01



TR-V13JBR/L 12B
TR-V13JBR/L 16D
TR-V13JBR/L 10C-S
TR-V13VBN 12B
TR-V13VBN 16D
TR-V13VBN 10C-S

TR-V13VBN 2020K
TR-V13VBN 2525M
TR-V12VBN 3225P
TR-V13JBR/L 2020K
TR-V13JBR/L 2525M
TR-V13JBR/L 3225P
TR-V13VBN 1616K-S
TR-V13JBR/L 1616K-S

TR-C4-V13VBN-00050
TR-C5-V13VBN-00060
TR-C6-V13VBN-00065
TR-C4-V13JBR/L-27050
TR-C5-V13JBR/L-35060
TR-C6-V13JBR/L-45065
TR-C5-V13VMBL-00115
TR-C6-V13VMBL-00130

5513 020-64

CoroTurn® TR screw clamp design

2	3 ¹⁾	4
Key (Torx Plus)	Torque wrench	Nozzle ²⁾
5680 049-01 (15 IP)	5680 100-06	5691 029-08 5691 029-09 5691 029-09 5691 029-08 5691 029-09 5691 029-09 5691 029-10 5691 029-10
5680 049-04 (10 IP)	5680 100-05	5691 029-08 5691 029-09 5691 029-09 5691 029-08 5691 029-09 5691 029-09 5691 029-10 5691 029-10

¹⁾ Accessories, must be ordered separately.

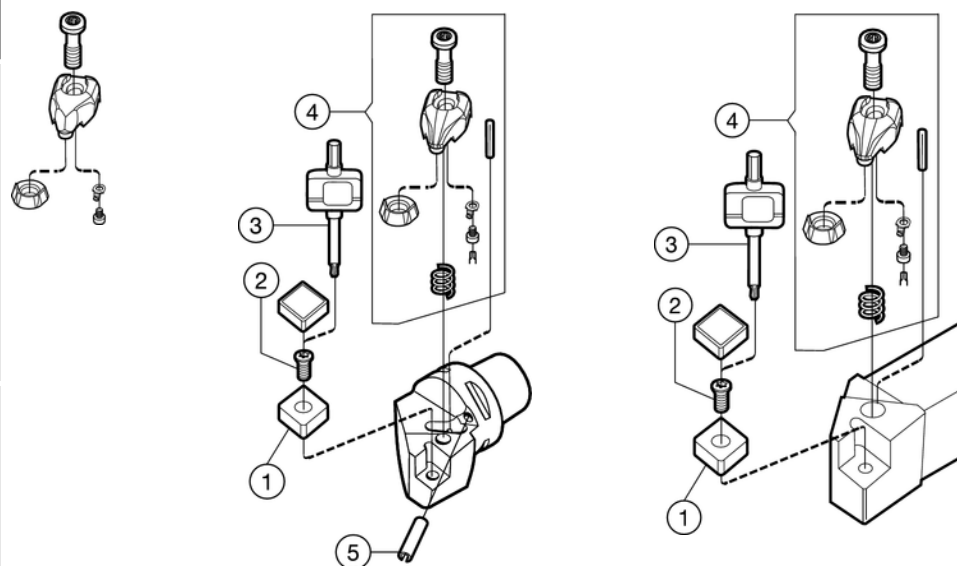
²⁾ Optional full metal nozzles for cutting fluid pressure up to 80 bars

To be ordered separately

Standard nozzle	Nozzle for up to 80 bar pressure
5691 029-08	5691 034-01
5692 029-09	5692 034-02
5693 029-10	5693 034-03

CoroTurn® RC rigid clamp design for ceramic inserts

Clamp set for flat insert without hole





Nozzle for Coromant Capto® cutting units

	5
Cutting unit size	Nozzle
C4–C6	5691 045-01

Shank holder			1	2	3	4)2)
Inch	Metric	Coromant Capto®	Shim (for insert thickness mm/inch)	Shim screw	Key (Torx Plus)	Complete clamp set
 CCRNR/L 124BM1-4 CCRNR/L 164DM1-4 CCRNR/L 204DM1-4 CCRNR/L 854D-4	CCBNR/L 2525M12-4 CCBNR/L 3225P12-4	C4-CCRNR/L-22050-12-4	5322 234-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 034-021
		C5-CCRNR/L-27060-12-4	5322 234-01 (4.76/.187) ²⁾			5412 032-021 ³⁾
		C6-CCRNR/L-35065-12-4				5412 028-021 ⁴⁾
	CCBNR/L 3225P16-4	C5-CCRNR/L-27060-16-4 C6-CCRNR/L-35065-16-4	5322 234-04 (7.94/.313) 5322 234-03 (6.35/.250) ²⁾	5513 020-07	5680 043-14 (20IP)	5412 034-031 5412 032-031 ³⁾ 5412 028-031 ⁴⁾
 CCLNR/L 124B-4 CCLNR/L 164C-4 CCLNR/L 164D-4 CCLNR/L 204D-4 CCLNR/L 244D-4 CCLNR/L 854D-4	CCLNR/L 2525M12-4 CCLNR/L 3225P12-4	C4-CCLNR/L-27050-12-4	5322 234-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 034-021
		C5-CCLNR/L-35060-12-4	5322 234-01 (4.76/.187) ²⁾			5412 032-021 ³⁾
		C6-CCLNR/L-45065-12-4				5412 028-021 ⁴⁾
	CCLNR/L 3225P16-4 CCLNR/L 3232P16-4	C5-CCLNR/L-35060-16-4 C6-CCLNR/L-45065-16-4	5322 234-04 (7.94/.313) 5322 234-03 (6.35/.250) ²⁾	5513 020-07	5680 043-14 (20IP)	5412 034-031 5412 032-031 ³⁾ 5412 028-031 ⁴⁾
 CDJNR/L 164C-4 CDJNR/L 164D-4 CDJNR/L 204D-4 CDJNR/L 244D-4 CDJNR/L 854D-4	CDJNR/L 2525M15-4 CDJNR/L 3225P15-4 CDJNR/L 3232P15-4	C5-CDJNR/L-35060-15-4	5322 266-01 (4.76/.187) ²⁾			5412 032-021 ³⁾
		C6-CDJNR/L-45065-15-4	5322 266-02 (6.35/.250) ²⁾			5412 028-021 ⁴⁾
			5322 266-03 (7.94/.313) 5322 266-01 (4.76/.187) ²⁾ 5322 266-02 (6.35/.250) ²⁾	5513 020-02	5680 049-01 (15IP)	5412 034-021 5412 032-021 ³⁾ 5412 028-021 ⁴⁾
	CDNNR/L 854D-4	CDNNR/L 3225P15-4				
CDNNN 5040T15-4			5322 266-03 (7.94/.313) 5322 266-01 (4.76/.187) ²⁾ 5322 266-02 (6.35/.250) ²⁾	5513 020-02	5680 049-01 (15IP)	5412 034-021 5412 032-021 ³⁾ 5412 028-021 ⁴⁾

CoroTurn® RC rigid clamp design for ceramic inserts

Shank holders			1	2	3	4 ¹⁾²⁾
Inch	Metric	Coromant Capto®	Shim (for insert thickness mm/inch)	Shim screw	Key (Torx Plus)	Complete clamp set
	CSBNR/L 2525M12-4		5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 034-021
			5322 425-01 (4.76/.187) ²⁾			5412 032-021 ³⁾ 5412 028-021 ⁴⁾
CSDNN 164D-4	CSDNN 2525M12-4	C4-CSDNN-00050-12-4	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 034-021
CSDNN 854D-4	CSDNN 3225P12-4	C5-CSDNN-00060-12-4	5322 425-01 (4.76/.187) ²⁾			5412 032-021 ³⁾
		C6-CSDNN-00065-12-4				5412 028-021 ⁴⁾
		C5-CSDNN-00060-15-4	5322 425-05 (7.94/.313)	5513 020-07	5680 043-14 (20IP)	5412 034-031
		C6-CSDNN-00065-15-4	5322 425-03 (6.35/.250) ²⁾			5412 032-031 ³⁾ 5412 028-031 ⁴⁾
CSKNR/L 164D-4	CSKNR/L 2525M12-4	C4-CSKNR/L-27050-12-4	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 034-021
		C5-CSKNR/L-35060-12-4	5322 425-01 (4.76/.187) ²⁾			5412 032-021 ³⁾
		C6-CSKNR/L-45065-12-4				5412 028-021 ⁴⁾
CSRNR/L 124BM1-4	CSRNR/L 2525M12-4	C4-CSRNR/L-22050-12-4	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 034-021
CSRNR/L 164DM1-4	CSRNR/L 3225P12-4	C5-CSRNR/L-27060-12-4	5322 425-01 (4.76/.187) ²⁾			5412 032-021 ³⁾
CSRNR/L 204DM1-4		C6-CSRNR/L-35065-12-4				5412 028-021 ⁴⁾
CSRNR/L 244DM1-4						
CSRNR/L 854D-4						
CSRNR/L 165D-4	CSRNR/L 3225P15-4	C5-CSRNR/L-27060-15-4	5322 425-05 (7.94/.313)	5513 020-07	5680 043-14 (20IP)	5412 034-031
CSRNR/L 855D-4		C6-CSRNR/L-35065-15-4	5322 425-03 (6.35/.250) ²⁾			5412 032-031 ³⁾ 5412 028-031 ⁴⁾
CSSNR/L 164D-4	CSSNR/L 2525M12-4	C4-CSSNR/L-27042-12-4	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 034-021
CSSNR/L 854D-4			5322 425-01 (4.76/.187) ²⁾			5412 032-021 ³⁾
	CSRNR/L 3225P12-4	C5-CSSNR/L-35052-12-4				5412 028-021 ⁴⁾
		C6-CSSNR/L-45056-12-4				
		C5-CSSNR/L-35050-15-4	5322 425-05 (7.94/.313)	5513 020-07	5680 043-14 (20IP)	5412 034-031
		C6-CSSNR/L-45054-15-4	5322 425-03 (6.35/.250) ²⁾			5412 032-031 ³⁾ 5412 028-031 ⁴⁾
	CTGNR/L 204D-4					
CTGNR/L 204D-4	CTGNR/L 3232P22-4	C4-CTGNR/L-27050-22-4	5322 315-04 (4.76/.187)	5513 020-02	5680 049-01 (15IP)	5412 034-021
		C5-CTGNR/L-35060-22-4				5412 032-021 ³⁾
		C6-CTGNR/L-45065-22-4				5412 028-021 ⁴⁾

1) For clamp set parts, see page A445.

2) Optional part delivered to separate order.

3) Clamp sets for ceramic inserts with hole

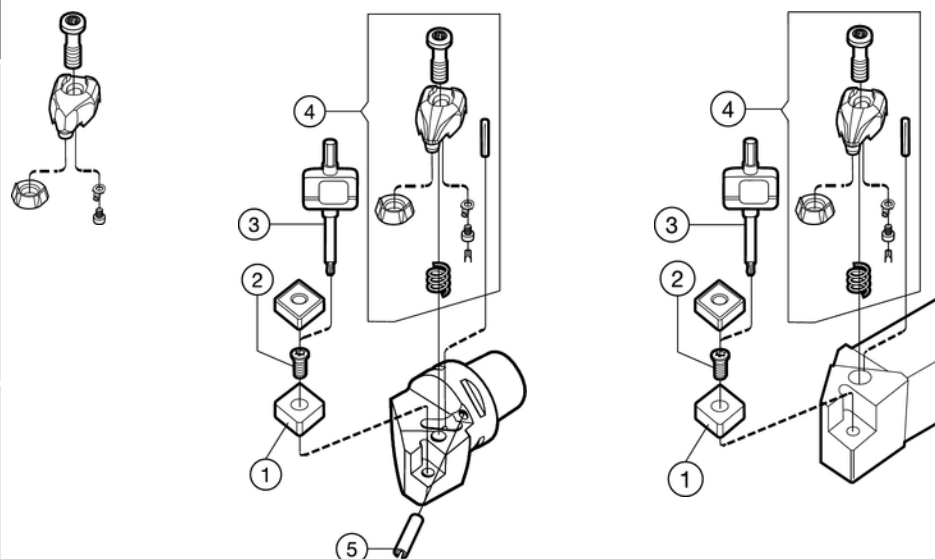
4) Clamp set for carbide inserts

Nozzle for Coromant Capto® cutting units

	5
Cutting unit size	Nozzle
C4–C6	5691 045-01
C5	5691 029-01




CoroTurn® RC rigid clamp design for ceramic inserts

Clamp design for insert with hole





Nozzle for Coromant Capto® cutting units

Cutting unit size	5 Nozzle
C4-C6	5691 045-01

Shank holders			1	2	3	4)2)	
Inch	Metric	Coromant Capto®	Shim (for insert thickness mm/inch)	Shim screw	Key (Torx Plus)	Complete clamp set	
							
	DCRNR/L 124BM1-2	DCBNR/L 2525M12-2	C4-DCRNR/L-22050-12-2	5322 234-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
	DCRNR/L 164DM1-2	DCBNR/L 3225P12-2	C5-DCRNR/L-27060-12-2	5322 234-01 (4.76/.187)2)			5412 034-0213)
	DCRNR/L 204DM1-2		C6-DCRNR/L-35065-12-2				5412 028-0214)
	DCRNR/L 244DM1-2						
	DCRNR/L 854D-2						
	DCRNR/L855D-2	DCBNR/L 3225P16-2	C5-DCRNR/L-27060-16-2	5322 234-04 (7.94/.313)	5513 020-07	5680 043-14 (20IP)	5412 032-031
		C6-DCRNR/L-35065-16-2	5322 234-03 (6.35/.250)2)			5412 034-0313)	
						5412 028-0314)	
	DCLNR/L 124B-2	DCLNR/L 2525M12-2	C4-DCLNR/L-27050-12-2	5322 234-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
	DCLNR/L 164C-2	DCLNR/L 3225P12-2	C5-DCLNR/L-35060-12-2	5322 234-01 (4.76/.187)2)			5412 034-0213)
	DCLNR/L 164D-2		C6-DCLNR/L-45065-12-2				5412 028-0214)
	DCLNR/L 204D-2						
	DCLNR/L 244D-2						
	DCLNR/L 854D-2						
	DCLNR/L 165D-2	DCLNR/L 2525M16-2	C5-DCLNR/L-35060-16-2	5322 234-04 (7.94/.313)	5513 020-07	5680 043-14 (20IP)	5412 032-031
DCLNR/L 205D-2	DCLNR/L 3225P16-2	C6-DCLNR/L-45065-16-2	5322 234-03 (6.35/.250)2)			5412 034-0313)	
DCLNR/L 245D-2	DCLNR/L 3232P16-2					5412 028-0314)	
DCLNR/L 855D-2							
							
		DDNNN 5040T15-2		5322 266-03 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
				5322 266-01 (4.76/.187)2)			5412 034-0213)
				5322 266-02 (6.35/.250)2)			5412 028-0214)
	DDJNR/L 164C-2	DDJNR/L 2525M15-2	C5-DDJNR/L-35060-15-2	5322 266-03 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
	DDJNR/L 164D-2	DDJNR/L 3225P15-2	C6-DDJNR/L-45065-15-2	5322 266-01 (4.76/.187)2)			5412 034-0213)
	DDJNR/L 204D-2	DDJNR/L 3232P15-2		5322 266-02 (6.35/.250)2)			5412 028-0214)
DDJNR/L 244D-2							
DDJNR/L 854D-2							
DDNNR/L 854D-2	DDNNR/L 3225P15-2		5322 266-03 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021	
			5322 266-01 (4.76/.187)2)			5412 034-0213)	
			5322 266-02 (6.35/.250)2)			5412 028-0214)	

CoroTurn® RC rigid clamp design for ceramic inserts

Clamp design for insert with hole

Shank holders			1	2	3	4 ¹⁾²⁾
Inch	Metric	Coromant Capto®	Shim (for insert thickness mm/inch)	Shim screw	Key (Torx Plus)	Complete clamp set
		DSBNR/L 2525M12-2	5322 425-02 (7.94/.313) 5322 425-01 (4.76/.187) ²⁾	5513 020-02	5680 049-01 (15IP)	5412 032-021 5412 034-021 ³⁾ 5412 028-021 ⁴⁾
DSDNN 164D-2	DSDNN 2525M12-2	C4-DSDNN-00050-12-2	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
DSDNN 854D-2	DSDNN 3225P12-2	C5-DSDNN-00060-12-2 C6-DSDNN-00065-12-2	5322 425-01 (4.76/.187) ²⁾			5412 034-021 ³⁾ 5412 028-021 ⁴⁾
DSKNR/L 164D-2	DSKNR/L 2525M12-2	C4-DSKNR/L-27050-12-2	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
	DSKNR/L 3225P12-2	C5-DSKNR/L-35060-12-2 C6-DSKNR/L-45065-12-2	5322 425-01 (4.76/.187) ²⁾			5412 034-021 ³⁾ 5412 028-021 ⁴⁾
DSRNR/L 124BM1-2	DSRNR/L 2525M12-2	C4-DSRNR/L-22050-12-2	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
DSRNR/L 164DM1-2	DSKNR/L 3225P12-2	C5-DSRNR/L-27060-12-2	5322 425-01 (4.76/.187) ²⁾			5412 034-021 ³⁾
DSRNR/L 204DM1-2		C6-DSRNR/L-35065-12-2				5412 028-021 ⁴⁾
DSRNR/L 244DM1-2						
DSRNR/L 854D-2						
DSSNR/L 164D-2	DSSNR/L 2525M12-2	C4-DSSNR/L-27042-12-2	5322 425-02 (7.94/.313)	5513 020-02	5680 049-01 (15IP)	5412 032-021
DSSNR/L 854D-2		C5-DSSNR/L-35052-12-2 C6-DSSNR/L-45056-12-2	5322 425-01 (4.76/.187) ²⁾			5412 034-021 ³⁾ 5412 028-021 ⁴⁾
						
DTGNR/L 204D-2	DTGRN/L 3232P22-2	C4-DTGNR/L-27050-22-2	5322 315-04 (4.76/.187)	5513 020-02	5680 049-01 (15IP)	5412 032-021
	DTGRN/L 3232P22-2	C5-DTGNR/L-35060-22-2				5412 034-021 ³⁾
	DTGRN/L 3232P22-2	C6-DTGNR/L-45065-22-2				5412 028-021 ⁴⁾

1) For clamp set parts, see page A445.

2) Optional part delivered to separate order.

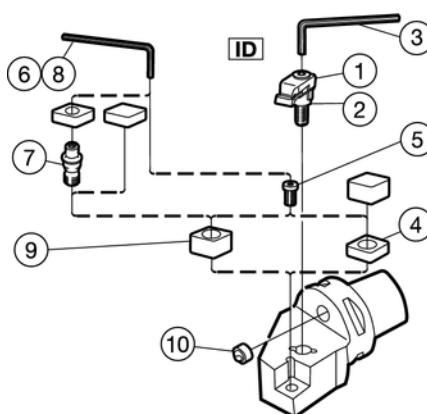
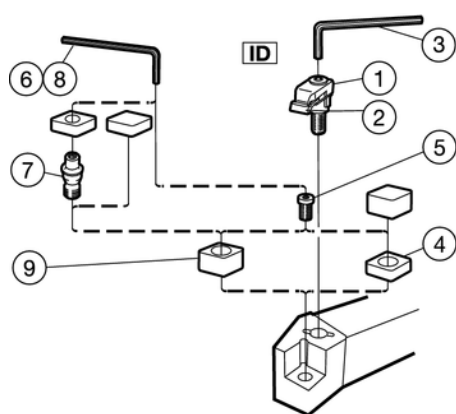
3) Clamp sets for ceramic inserts without hole

4) Clamp set for carbide inserts

Nozzle for Coromant Capto® cutting units



Cutting unit size	5
	Nozzle
C4-C6	5691 045-01

T-Max® top clamp design for ceramic inserts



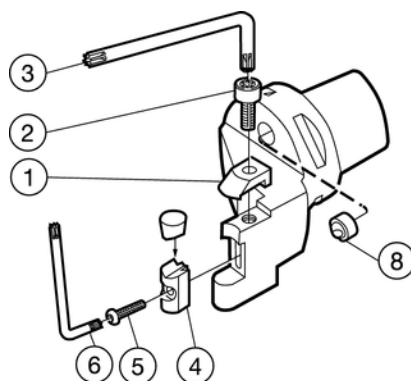
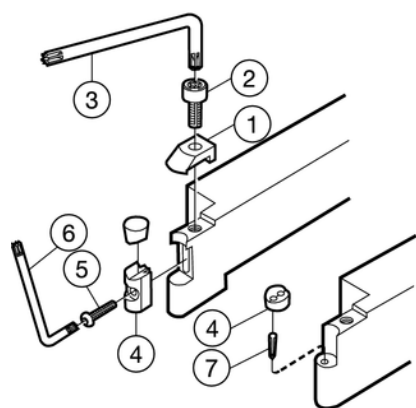
Nozzle for Coromant Capto® cutting units



Cutting unit size	Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-02
C8	5691 029-03

Shank holders	Coromant Capto®	1 Clamp (ID)	2 Pressure plate (ID)	3 Key (mm)	4 Shim (for insert thickness mm/inch)	5 Shim screw
						
CRDNN 2525M09-ID		5412 127-01	–	3021 010-040 (4.0)	5321 215-01 (3.18/.125)	3212 100-206
CRDNN 2525M12-ID		5412 125-01	5192 020-01	3021 010-040 (4.0)	5322 141-01 (7.97/.314)	5513 013-02
CRDNN 3225P12-ID						
CRSNR/L 2525M09-ID	C3-CRSNR/L-22040-09ID	5412 127-01	–	3021 010-040 (4.0)	5321 215-01 (3.18/.125)	3212 100-206
CRSNR/L 2525M12-ID	C4-CRSNR/L-27050-12ID	5412 125-01	5192 020-01	3021 010-040 (4.0)	5322 141-01 (7.97/.314)	5513 013-02
CRSNR/L 3225P12-ID	C5-CRSNR/L-35060-12ID					
	C6-CRSNR/L-45065-12ID					
CRSNR/L 3232P15-ID		5412 125-01	5192 020-01	3021 010-040 (4.0)	5321 215-02 (7.97/.314)	3212 100-206
CRSNR/L 3232P19-ID		5412 125-01	5192 020-01	3021 010-040 (4.0)	5321 215-03 (7.97/.314)	3212 100-257
CRSNR/L 5040T25-ID		5412 125-02	5192 020-01	3021 010-040 (4.0)	5322 141-05	5513 013-03
		6	7 ¹⁾	8 ¹⁾	9 ¹⁾	
Shank holders	Coromant Capto®	Key (mm/Torx Plus)	Centre pin (IP)	Key (mm)	Shim (for insert thickness mm/inch)	
						
CRDNN 2525M09-ID		174.1-870 (2.0)	–	–	–	
CRDNN 2525M12-ID		5680 043-14 (20IP)	5313 032-02	174.1-863 (2.5)	5322 141-02 (4.76/.187)	
CRDNN 3225P12-ID						
CRSNR/L 2525M09-ID	C3-CRSNR/L-22040-09ID	174.1-870 (2.0)	–	–	–	
CRSNR/L 2525M12-ID	C4-CRSNR/L-27050-12ID	5680 043-14 (20IP)	5313 032-02	174.1-863 (2.5)	5322 141-02 (4.76/.187)	
CRSNR/L 3225P12-ID	C5-CRSNR/L-35060-12ID					
	C6-CRSNR/L-45065-12ID					
CRSNR/L 3232P15-ID		174.1-870 (2.0)	–	–	–	
CRSNR/L 3232P19-ID		174.3-863 (2.5)	–	–	–	
CRSNR/L 5040T25-ID		174.1-864 (3.0)	–	–	–	

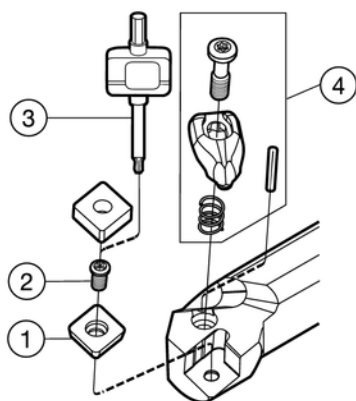
¹⁾ Optional part delivered to separate order.







T-Max® top clamp design for ceramic RCGX/RPGX inserts



Shank holders	Coromant Capto®	1 Clamp	2 Clamp screw	3 Key (Torx Plus/mm)	4 Seat	5 Seat screw
						
CRDCN 3225P06-A		5412 105-01	3212 036-506	5680 043-17 (30IP)	5321 066-01	3212 010-157
CRDCN 3225P09-A	C5-CRDCN-00060-09AV	5412 100-01	3212 035-452	5680 043-16 (27IP)	5321 065-01	3212 106-352
CRDCN 3225P12-A	C5-CRDCN-00060-12AV	5412 100-02	3212 036-504	5680 043-17 (30IP)	5321 065-02	3212 105-453
CRDCN 5040T12-ID		5412 100-02	3212 036-504	5680 043-17 (30IP)	5321 210-02	–
CRDCN 5040T15-ID		5412 126-01	–	3021 010-040 (4.0)	5321 210-03	–
CRDCN 5040T19-ID		5412 126-02	–	3021 010-040 (4.0)	5321 210-04	–
CRDCN 5040T25-ID		5412 126-02	–	3021 010-040 (4.0)	5321 210-05	–
CRDCR/L 3225P09-A		5412 100-01	3212 035-452	5680 043-16 (27IP)	5321 065-01	3212 106-352
CRDCR/L 3225P12-A		5412 100-02	3212 036-504	5680 043-17 (30IP)	5321 065-02	3212 105-453
	C5-CRSCR/L-35060-09V	5412 100-01	3212 035-452	5680 043-16 (27IP)	5321 065-01	3212 106-352
	C5-CRSCR/L-35060-12V	5412 100-02	3212 036-504	5680 043-17 (30IP)	5321 065-02	3212 105-453
R 176.9-3236-06		5412 110-02	3212 036-506	5680 043-17 (30IP)	5321 066-01	3212 010-157
L 176.9-3236-06		5412 110-01	3212 036-506	5680 043-17 (30IP)	5321 066-01	3212 010-157
		6	7	8		
Shank holders	Coromant Capto®	Key (mm/Torx Plus)	Seat pin	Nozzle		
						
CRDCN 3225P06-A		174.1-870 (2.0)	–	–		
CRDCN 3225P09-A	C5-CRDCN-00060-09AV	5680 043-12 (10IP)	–	5691 029-02		
CRDCN 3225P12-A	C5-CRDCN-00060-12AV	5680 043-15 (25IP)	–	5691 029-02		
CRDCN 5040T12-ID		–	3113 030-355	–		
CRDCN 5040T15-ID		–	3113 030-355	–		
CRDCN 5040T19-ID		–	3113 030-406	–		
CRDCN 5040T25-ID		–	3113 030-406	–		
CRDCR/L 3225P09-A		5680 043-12 (10IP)	–	–		
CRDCR/L 3225P12-A		5680 043-15 (25IP)	–	–		
	C5-CRSCR/L-35060-09V	5680 043-12 (10IP)	–	5691 029-02		
	C5-CRSCR/L-35060-12V	5680 043-15 (25IP)	–	5691 029-02		
R 176.9-3236-06		174.1-870 (2.0)	–	–		
L 176.9-3236-06		174.1-870 (2.0)	–	–		

CoroTurn® RC rigid clamp design



Shank holders			1	2	3	4 ¹⁾²⁾
Inch	Metric	Coromant Capto	Shim (for insert thickness mm/inch)	Shim screw	Key (Torx Plus)	Complete clamp set
 A12S-DCLNR/L 3 A16T-DCLNR/L 3 A20T-DCLNR/L 3 A16T-DCLNR/L 4 A20T-DCLNR/L 4 A24T-DCLNR/L 4	A25T-DCLNR/L 09	C4-DCLNR/L-13080-09 C5-DCLNR/L-13080-09	5322 236-04 (3.18/.125)	5513 020-04	5680 051-03 (9IP)	5412 028-011
	A25T-DCLNR/L 12 A32U-DCLNR/L 12	C4-DCLNR/L-17090-12 C5-DCLNR/L-17090-12 C6-DCLNR/L-17090-12	5322 236-03 (4.76/.187)	5513 020-02	5680 049-01 (15IP)	5412 028-021 5412 032-021 ³⁾ 5412 034-021 ⁴⁾
	A40V-DCLNR/L 12		5322 234-01 (4.76/.187) 5322 234-02 (7.94/.312) ²⁾	5513 020-02	5680 049-01 (15IP)	5412 028-021 5412 032-021 ³⁾ 5412 034-021 ⁴⁾
	A24T-DCLNR/L 5 A32U-DCLNR/L 5 A40V-DCLNR/L 5	C6-DCLNR/L-27140-16	5322 234-03 (6.35/.250) 5322 234-04 (7.94/.312) ²⁾	5513 020-07	5680 043-14 (20IP)	5412 028-031 5412 032-031 ³⁾ 5412 034-031 ⁴⁾
 A12S-DDUNR/L 3 A16T-DDUNR/L 3 A20U-DDUNR/L 3 A16T-DDUNR/L 4 A20T-DDUNR/L 4 A24T-DDUNR/L 4 A32U-DDUNR/L 4 A40V-DDUNR/L 4	A25T-DDUNR/L 11 A32U-DDUNR/L 11	C4-DDUNR/L-17090-11 C5-DDUNR/L-17090-11	5322 267-01 (4.76/.187)	5513 020-04	5680 051-03 (9IP)	5412 028-011 ¹⁾
	A40V-DDUNR/L 15 A50U-DDUNR/L 15	C4-DDUNR/L-27080-15 C5-DDUNR/L-27140-15 C6-DDUNR/L-27140-15	5322 266-02 (6.35/.250) 5322 266-01 (4.76/.187) ^{2) 5)} 5322 266-03 (7.94/.312) ²⁾	5513 020-02	5680 049-01 (15IP)	5412 028-021 5412 032-021 ³⁾ 5412 034-021 ⁴⁾
	A25T-DSKNR/L 09 A25T-DSKNR/L 12 A32U-DSKNR/L 12		5322 426-01 (3.18/.125) 5322 426-02 (4.76/.187)	5513 020-04 5513 020-02	5680 051-03 (9IP) 5680 049-01 (15IP)	5412 028-011 5412 028-021 5412 032-021 ³⁾ 5412 034-021 ⁴⁾
	A40V-DSKNR/L 12		5322 425-01 (4.76/.187) 5322 425-02 (7.94/.312) ²⁾	5513 020-02	5680 049-01 (15IP)	5412 028-021 5412 032-021 ³⁾ 5412 034-021 ⁴⁾
 A16T-DSKNR/L 4 A20T-DSKNR/L 4 A24T-DSKNR/L 4						
 A12S-DTFNR/L 3 A16T-DTFNR/L 3 A20T-DTFNR/L 3 A24T-DTFNR/L 3 A24T-DTFNR/L 4 A32U-DTFNR/L 4	A25T-DTFNR/L 16 A32U-DTFNR/L 16 A40T-DTFNR/L 16	C4-DTFNR/L-17090-16 C5-DTFNR/L-17090-16	5322 316-01 (4.76/.187)	5513 020-04	5680 051-03 (9IP)	5412 028-011
	A40V-DTFNR/L 22 A50W-DTFNR/L 22		5322 315-04 (4.76/.187)	5513 020-02	5680 049-01 (15IP)	5412 028-021 5412 032-021 ³⁾ 5412 034-021 ⁴⁾
 A16T-DWLNR/L 3 A20T-DWLNR/L 3 A16T-DWLNR/L 4 A20T-DWLNR/L 4 A24T-DWLNR/L 4 A32U-DWLNR/L 4	A25T-DWLNR/L 06 A32T-DWLNR/L 06 A40T-DWLNR/L 06	C4-DWLNR/L-13075-06	5322 328-01 (4.76/.187)	5513 020-04	5680 051-03(9IP)	5412 028-011
	A25T-DWLNR/L 08 A32T-DWLNR/L 08	C4-DWLNR/L-17090-08 C5-DWLNR/L-17090-08	5322 328-02 (4.76/.187)	5513 020-02	5680 049-01(15IP)	5412 028-021
	A40T-DWLNR/L 08 A50V-DWLNR/L 08		5322 331-12 (4.76/.187)	5513 020-02	5680 049-01(15IP)	5412 028-021
 A24T-DVUNR/L 3	A40T-DVUNR/L 16		5322 269-01 (4.76/.187)	5513 020-09	5680-049-01(15IP)	5412 028-061

1) For clamp set parts, see page A445.

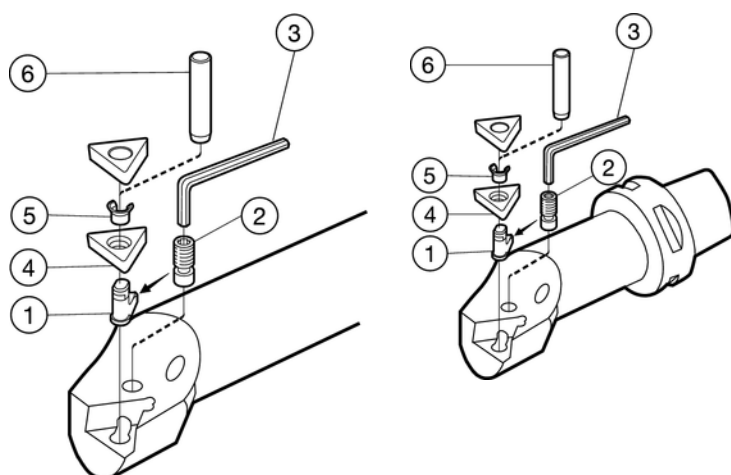
2) Optional part delivered to separate order.



3) Clamp sets for ceramic inserts with hole

4) Clamp sets for ceramic inserts without hole

5) For inserts with nose radius .016-.031

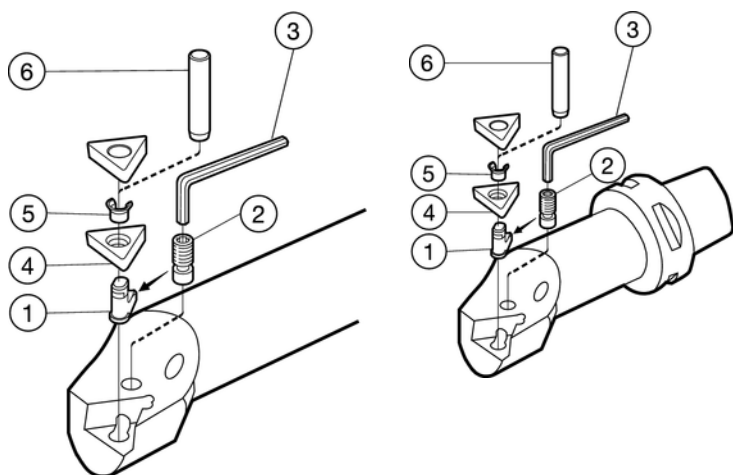
T-Max® P lever design



Shank holders	Coromant Capto®	1 Lever	2 Screw	3 Key (mm)	4 Shim	For insert thickness mm/inch	Radius mm/inch	5 Shim pin	6 Shim pin punch
 A16R-PCLNR/L 09 A20S-PCLNR/L 09 A25T-PCLNR/L 09	C3-PCLNR/L- 13075-09	174.3-845-1	174.3-829	170.3-864 (1.98)	–	–	–	–	–
	C3-PCLNR/L- 17090-09								
	C4-PCLNR/L- 13080-09								
	C4-PCLNR/L- 17090-09								
	C5-PCLNR/L- 13080-09								
	C5-PCLNR/L- 17090-09								
A25T-PCLNR/L 12	C3-PCLNR/L- 17090-12	438.3-841-1	438.3-832M	174.1-863 (2.5)	–	–	–	–	–
	C4-PCLNR/L- 17090-12								
	C5-PCLNR/L- 17090-12								
	C6-PCLNR/L- 17100-12								
A32T-PCLNR/L 12		174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M	4.76/.187	0.4-1.6/.016–.063	174.3-861	174.3-871
A40T-PCLNR/L 12	C3-PCLNR/L- 22064-12	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M	4.76/.187	0.4-1.6/.016–.063	174.3-861	174.3-871
	C3-PCLNR/L- 22096-12								
	C4-PCLNR/L- 22110-12								
	C4-PCLNR/L- 27080-12								
	C4-PCLNR/L- 27120-12								
	C5-PCLNR/L- 22110-12								
	C5-PCLNR/L- 27140-12								
	C5-PCLNR/L- 35100-12								
	C6-PCLNR/L- 22110-12								
A50W-PCLNR/L 16	C5-PCLNR/L- 35150-16	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852	6.35/.250	0.4-2.4/.016–.094	174.3-864	174.3-873
	C6-PCLNR/L- 27140-16								
	C6-PCLNR/L- 35175-16								
A50W-PCLNR/L 19		174.3-849M	174.3-822M	3021 010-040	171.31-851M	6.35/.250	0.4-2.4/.016–.094	174.3-868	174.3-872
 A25T-PDUNR/L 11 A32T-PDUNR/L 11	C3-PDUNR/L-17090-11	5432 015-021	438.3-830	174.1-870 (1.98)	–	–	–	–	–
	C4-PDUNR/L-17090-11								
	C5-PDUNR/L-17090-11								
	C6-PDUNR/L-17100-11								
	C3-PDUNR/L-22064-11	5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01	4.76/.187	0.4-0.8/.016–.031	174.3-860	174.3-870
	C3-PDUNR/L-22096-11				5322 255-02 ¹⁾	4.76/.187	1.2-1.6/.047–.063		
	C4-PDUNR/L-22110-11								
	C5-PDUNR/L-22110-11								

1) Optional part delivered to separate order.

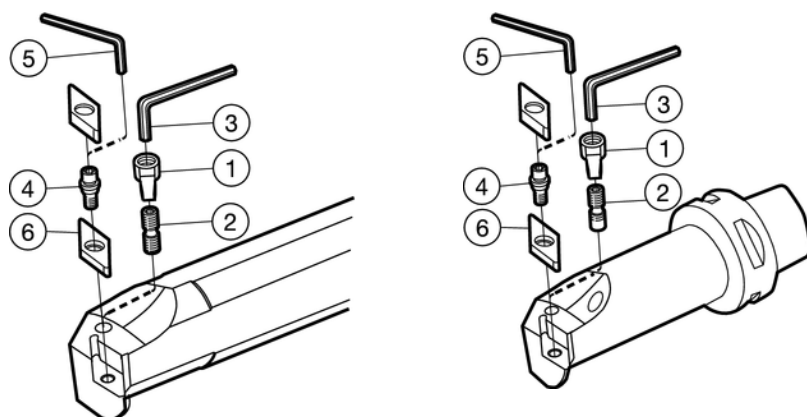
T-Max® P lever design




		1	2	3	4				
Shank holders	Coromant Capto®	Lever	Screw	Key (mm)	Shim	For insert thickness mm/inch	Radius mm/inch	Shim pin	Shim pin punch
A40T-PDUNR/L 15		174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	6.35/.250	0.4-0.8/.016-.031	174.3-861	174.3-871
A50U-PDUNR/L 15					171.35-850M ¹⁾	6.35/.250	1.2-1.6/.047-.063		
					171.35-856 ¹⁾	4.76/.187	0.4-0.8/.016-.031		
					171.35-855 ¹⁾	4.76/.187	1.2-1.6/.047-.063		
	C4-PDUNR/L-27080-15	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	6.35/.250	0.4-0.8/.016-.031	174.3-861	174.3-871
	C4-PDUNR/L-27120-15				171.35-850M ¹⁾	6.35/.250 ¹⁾	1.2-1.6/.047-.063		
	C5-PDUNR/L-27140-15				171.35-856 ¹⁾	4.76/.187 ¹⁾	0.4-0.8/.016-.031		
	C5-PDUNR/L-35100-15				171.35-855 ¹⁾	4.76/.187 ¹⁾	1.2-1.6/.047-.063		
	C6-PDUNR/L-22110-15								
	C6-PDUNR/L-27140-15								
	C6-PDUNR/L-35175-15								
	A25T-PSKNR/L 12	C3-PSKNR/L-17090-12	438.3-841-1	438.3-832M	174.1-863 (2.5)	–	–	–	–
		C4-PSKNR/L-17090-12			174.3-851M	4.76/.187	0.4-1.2/.016-.047	174.3-861	174.3-871
		C5-PSKNR/L-17090-12			174.3-856	4.76/.187 ¹⁾	1.2-1.6/.047-.063		
	A32T-PSKNR/L 12		174.3-848M	174.3-858	174.1-864 (3.0)	174.3-851M	4.76/.187	0.4-1.2/.016-.047	174.3-861
						174.3-856	4.76/.187	1.2-1.6/.047-.063	174.3-871
	A40T-PSKNR/L 12	C3-PSKNR/L-22064-12	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M	4.76/.187	0.4-1.2/.016-.047	174.3-861
		C3-PSKNR/L-22096-12				174.3-856	4.76/.187	1.2-1.6/.047-.063	174.3-871
		C4-PSKNR/L-22110-12							
		C4-PSKNR/L-27080-12							
		C4-PSKNR/L-27120-12							
		C5-PSKNR/L-22110-12							
		C5-PSKNR/L-27140-12							
		C6-PSKNR/L-22110-12							
		C5-PSKNR/L-35100-15	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857	6.35/.250	0.4-1.6/.016-.063	174.3-864
		C5-PSKNR/L-35150-15							174.3-873
		C6-PSKNR/L-27140-15							
		C6-PSKNR/L-35175-15							
	A50U-PSKNR/L 19		174.3-849M	174.3-822M	3021 010-040 (4.0)	171.31-851M	4.76/.187	0.4-1.2/.016-.047	174.3-868
									5681 002-02
	A16R-PTFNR/L 11	C3-PTFNR/L-13075-11	174.3-846-1	174.3-829	170.3-	–	–	–	–
	A20S-PTFNR/L 11	C4-PTFNR/L-13080-11							
	A25T-PTFNR/L 11	C5-PTFNR/L-13080-11							

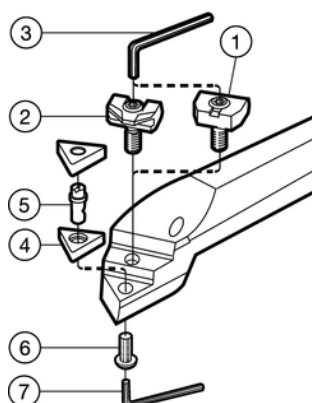
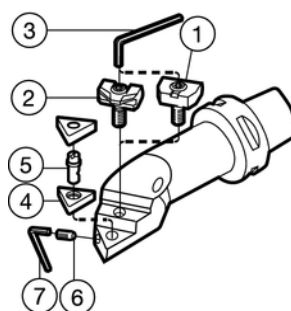
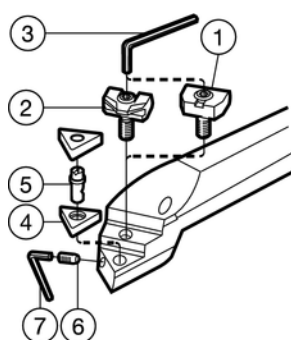
¹⁾ Optional part delivered to separate order.

T-Max P screw and top clamp design



		1	2	3	4	5	6		
Shank holders	Coromant Capto®	Clamp	Clamp screw	Key (mm)	Lock pin	Key (mm)	Shim	For insert thickness mm/inch	Radius mm/inch
 S40V-MVUNR/L 16	C4-MVUNR/L-27120-16	MC-12	MS-510	3021 011-532 (3.96)	MN-34L	174.1-870 (1.98)	MVN-322	4.76/.187	0.4-1.2/.016-.047
	C5-MVUNR/L-27140-16								
	C5-MVUNR/L-35150-16								
	C6-MVUNL-22120-16								
	C6-MVUNR-35175-16								

T-Max P wedge design



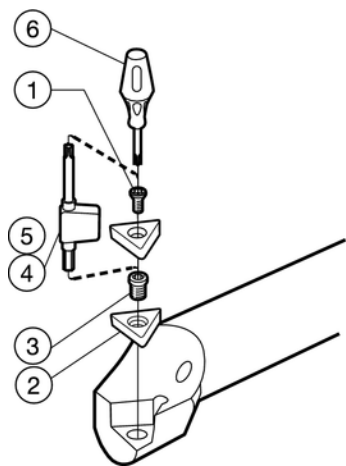
Shank tools			1	2	3
Inch	Metric	Coromant Capto®	Wedge set	Wedge clamp set	Key (mm)
	S25T-PTFNR/L 16-W	C3-PTFNR/L-17090-16-W C4-PTFNR/L-17090-16-W C5-PTFNR/L-17090-16-W	170.38-823-2	–	174.1-864 (3.0)
	S32U-PTFNR/L 16-W S40V-PTFNR/L 16-W	C3-PTFNR/L-22096-16-W C4-PTFNR/L-22110-16-W C5-PTFNR/L-22110-16-W C5-PTFNR/L-27140-16-W C6-PTFNR/L-22110-16-W C6-PTFNR/L-27140-16-W	170.38-823-1 170.38-820-1 ¹⁾		174.1-864 (3.0) 174.1-863 (2.5) ¹⁾
			170.38-823-1 170.38-820-1 ¹⁾		174.1-864 (3.0) 174.1-863 (2.5) ¹⁾
	S40V-PTFNR/L 22-W S50W-PTFNR/L 22-W	C4-PTFNR/L-27120-22-W C5-PTFNR/L-35150-22-W C6-PTFNR/L-35175-22-W	170.38-824-1 170.38-821-1 ¹⁾		3021 010-040 (4.0) 174.1-864 (3.0) ¹⁾
		C5-PTFNR/L-27140-22-W C6-PTFNR/L-27140-22-W	170.38-824-1	–	3021 010-040 (4.0)
	S16T-MWLNRL/L 3 S20U-MWLNRL/L 3 S24V-MWLNRL/L 3	A20S-MWLNRL/L 06	–	5431 125-011	170.3-860 (2.5)
			–	5431 125-011	170.3-860 (2.5)
			–	5431 125-011	170.3-860 (2.5)
		C3-MWLNRL/L-13075-06 C3-MWLNRL/L-17090-06M1 C4-MWLNRL/L-13075-06M C4-MWLNRL/L-17090-06M1			
	S32W-MWLNRL/L 3	A25T-MWLNRL/L 06 A32U-MWLNRL/L 06	–	5431 125-011	170.3-860 (2.5)
				5431 125-011	170.3-860 (2.5)
	S16T-MWLNRL/L 4 S20U-MWLNRL/L 4 S24V-MWLNRL/L 4 S32W-MWLNRL/L 4	A25T-MWLNRL/L 08 A25T-MWLNRL/L 08 A32U-MWLNRL/L 08 A40V-MWLNRL/L 08 A50W-MWLNRL/L 08	–	5431 125-021	174.1-864 (3.0)
		C4-MWLNRL/L-17090-08 C5-MWLNRL/L-17090-08 C4-MWLNRL/L-22110-08 C4-MWLNRL/L-27120-08 C5-MWLNRL/L-22110-08 C5-MWLNRL/L-27140-08	–	5431 125-021	174.1-864 (3.0)

¹⁾ Optional part delivered to separate order.

T-Max P wedge design

4			5	6	7
Shim	For insert thickness mm/ inch	Radius mm/inch	Pin	Screw	Key (mm/Torx Plus)
–	–	–	5313 021-01	5512 031-01	5680 051-03 (9IP)
170.3-852	4.76/.187	0.4-0.8/.016 - .031	5313 021-02	5512 031-01	5680 051-03 (9IP)
170.3-852	4.76/.187	0.4-0.8/.016 - .031	5313 021-02	3212 100-206	174.1-870 (1.98)
170.3-855	4.76/.187	1.2-1.6/.047 - .063	5313 021-03	5512 031-02	5680 049-02 (15IP)
170.3-856 ¹⁾	4.76/.187	0.4-0.8/.016 - .031			
170.3-855	4.76/.187	1.2-1.6/.047 - .063	5313 021-03	5512 031-02	5680 051-03 (9IP)
–	–	–	5313 022-02	–	170.3-864 (1.98)
5322 331-06	4.76/.187	0.4-0.8/.016 - .031	5313 022-01	5512 030-03	170.3-864 (1.98)
5322 331-11			5313 022-02	–	170.3-864 (1.98)
5322 331-11	4.76/.187	0.4-0.8/.016 - .031	5313 022-02	–	170.3-864 (1.98)
5322 331-06	4.76/.187	0.4-0.8/.016 - .031	5313 022-01	5512 030-03	170.3-864 (1.98)
5322 331-09	4.76/.187	0.4-0.8/.016 - .031	5313 022-03	–	–
5322 331-10 ¹⁾	4.76/.187	1.2-1.6/.047 - .063			
5322 331-07	4.76/.187	0.4-0.8/.016 - .031	5313 022-03	–	–
5322 331-08 ¹⁾	4.76/.187	1.2-1.6/.047 - .063			
5322 331-07	4.76/.187	0.4-0.8/.016 - .031	5313 022-03	5512 030-04	174.1-863 (2.5)
5322 331-08 ¹⁾	4.76/.187	1.2-1.6/.047 - .063			

CoroTurn® 107 screw clamp design



Shank holders

Inch

Metric

Coromant Capto®

1

Insert screw (thread)



E05K-SCLCR/L 2-R

A08H-SCLCR/L 06
A10K-SCLCR/L 06
E08K-SCLCR/L 06-R
A08H-SCLCR/L 06-R
A10K-SCLCR/L 06-R
E10M-SCLCR/L 06-R

–

5513 020-46 (M2.5)

E06M-SCLCR/L-2
E08R-SCLCR/L-2
E10R-SCLCR/L-2
A06M-SCLCR/L-2
A08M-SCLCR/L-2
A06M-SCLCR/L 2-R
A08M-SCLCR/L 2-R
A10R-SCLCR/L 2-R
A10R-SCLCR/L 2
E06M-SCLCR/L 2-R
E08R-SCLCR/L 2-R
E10R-SCLCR/L 2-R

E12Q-SCLCR/L 06-R
E16R-SCLCR/L 06-R
A12M-SCLCR/L 06
A16R-SCLCR/L 06
A12M-SCLCR/L 06-R
A16R-SCLCR/L 06-R

–

5513 020-03 (M2.5)

A12S-SCLCR/L3
A10R-SCLCR/L-3
E12S-SCLCR/L-3
A10R-SCLCR/L 3-R
A12S-SCLCR/L 3-R
E12R-SCLCR/L 3-R

A16R-SCLCR/L 09
A20S-SCLCR/L 09
A16R-SCLCR/L 09-R
A20S-SCLCR/L 09-R
E16R-SCLCR/L 09-R
E20S-SCLCR/L 09-R

C3-SCLCR/L-11065-09
C4-SCLCR/L-11070-09
C5-SCLCR/L-11070-09
C3-SCLCR/L-13075-09
C4-SCLCR/L-13080-09
C5-SCLCR/L-13080-09

5513 020-09 (M3.5)

E16T-SCLCR/L-3
A16T-SCLCR/L-3
E10R-SCLCR/L 3-R
E16S-SCLCR/L 3-R

A25T-SCLCR/L 09
E25T-SCLCR/L 09-R

C3-SCLCR/L-17090-09
C4-SCLCR/L-17090-09
C5-SCLCR/L-17090-09

5513 020-10 (M3.5)

C4-SCLCR/L-27080-09
C5-SCLCR/L-35100-09
C3-SCLCR/L-17090-12
C4-SCLCR/L-17090-12

5513 020-01 (M3.5)

A16T-SCLCR/L-4

A25T-SCLCR/L 12

5513 020-17 (M4x0.5)

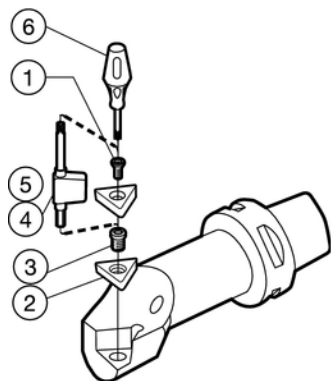
1) Optional parts must be ordered separately.



CoroTurn® 107 screw clamp design

2			3	4/5	6 ¹⁾
Shim	For insert thickness mm/ inch	Radius mm/inch	Shim screw (thread)	Key (Torx Plus/mm)	Screwdriver (Torx Plus)
		–	–	5680 051-02 (7IP)	
–	–			5680 051-02 (7IP)	5680 046-03 (7IP)
–	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
–	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
5322 232-01	3.97/.156	0.4-0.8/.016-.031	5512 090-01 (M5x0.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
–	–	–	–	5680 049-02 (15IP/4.0)	5680 046-02 (15IP)

CoroTurn® 107 screw clamp design

Shank holders



Inch	Metric	Coromant Capto®	Insert screw (thread)
 E06M-SDUCR/L-2 E08R-SDUCR/L-2C E10R-SDUCR/L-2C A06M-SDUCR/L-2 A08M-SDUCR/L-2 A20T-SDUCR/L 3 A08M-SDXCR/L 2 A10R-SDXCR/L 2 A06M-SDQCR/L 2 A08M-SDQCR/L 2 A10R-SDQCR/L 2 A06M-SDUCR/L 2-R A08M-SDUCR/L 2-R A10R-SDUCR/L 2R A12S-SDUCR/L 2-ERX A08M-SDXCR/L 2-R A10R-SDXCR/L 2R A06M-SDQCR/L 2-R A08M-SDQCR/L 2-R A10R-SDQCR/L 2-R A10K-SDXCR/L 2-R A10R-SDUCR/L 2 A12S-SDUCR/L 2-EX A16T-SDUCR/L 2-DX	A10K-SDUCR/L 07-ER A12M-SDUCR/L 07-ER E10M-SDUCR/L 07-ER E12Q-SDUCR/L 07-ER E16R-SDUCR/L 07-ER F10M-SDUCR/L 07-ER F12Q-SDUCR/L 07-ER A10K-SDUCR/L 07 A12M-SDUCR/L 07 A16R-SDUCR/L 07 A16R-SDUCR/L 07-EX A20S-SDUCR/L 07-EX A25T-SDUCR/L 07-DX A10K-SDQCR/L 07 A12M-SDQCR/L 07 A12M-SDXCR/L 07 A16R-SDUCR/L 07-ERX A20S-SDUCR/L 07-ERX A12M-SDXCR/L 07-R A16R-SDXCR/L 07-R A10K-SDQCR/L 07-R A12M-SDQCR/L 07-R A16R-SDQCR/L 07-R A16R-SDQCR/L 07 A16R-SDXCR/L 07	C3-SDUCR/L-11065-07 C4-SDUCR/L-11070-07 C5-SDUCR/L-11070-07 C3-SDUCR/L-13070-07X C3-SDUCR/L-15080-07X C4-SDUCR/L-13070-07X C4-SDUCR/L-15080-07X C4-SDUCR/L-18090-07X C5-SDUCR/L-15080-07X C5-SDUCR/L-18090-07X	5513 020-03 (M2.5)
E12S-SDUCR/L-3 A12S-SDUCR/L-3R A12S-SDXCR/L 3-R A12S-SDQCR/L 3 A12S-SDUCR/L 3 E12R-SDUCR/L 3-R A12S-SDQCR/L 3R	A20S-SDUCR/L 11 A20S-SDQCR/L 11-R A20S-SDQCR/L 11 A20S-SDXCR/L 11 E20S-SDUCR/L 11-R	–	5513 020-09 (M3.5)
E16T-SDUCR/L-3 A16T-SDUCR/L-3 E16S-SDUCR/L 3-R A12S-SDXCR/L 3 A16T-SDXCR/L 3	A25T-SDUCR/L 11 A25T-SDQCR/L 11 A25T-SDXCR/L 11 E25T-SDUCR/L 11-R	C3-SDUCR/L-13075-11 C3-SDUCR/L-17090-11 C4-SDUCR/L-13080-11 C5-SDUCR/L-13080-11 C4-SDUCR/L-17090-11 C5-SDUCR/L-17090-11	5513 020-10 (M3.5)
A20T-SDUCR/L-3 A20T-SDUCR/L-3X	A32T-SDUCR/L 11-X	C3-SDUCR/L-22064-11 C3-SDUCR/L-22096-11 C4-SDUCR/L-22110-11 C4-SDUCR/L-27080-11 C5-SDUCR/L-22110-11 C5-SDUCR/L-35100-11	5513 020-01 (M3.5)
	A16R-SSKCR/L 09 A20S-SSKCR/L 09 A16R-SSKCR/L 09-R A20S-SSKCR/L 09-R	C3-SSKCR/L-11065-09 C3-SSKCR/L-13075-09 C4-SSKCR/L-13080-09 C5-SSKCR/L-13080-09	5513 020-09 (M3.5)
		C3-SSKCR/L-17090-09 C4-SSKCR/L-17090-09	5513 020-10 (M3.5)
	A25T-SSKCR/L 12	C5-SSKCR/L-17090-12 C3-SSKCR/L-22064-12 C4-SSKCR/L-22110-12 C5-SSKCR/L-22110-12	5513 020-17 (M4x0.5)
	A32T-SSKCR/L 12	C4-SSKCR/L-27080-12	5513 020-18 (M4x0.5)
		C5-SSKCR/L-35100-12	


1) Optional parts must be ordered separately.

CoroTurn® 107 screw clamp design

2			3	4/5	6 ¹⁾
Shim	For insert thickness mm/ inch	Radius mm/inch	Shim screw (thread)	Key (Torx Plus/mm)	Screwdriver (Torx Plus)
–	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
–	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
–	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
5322 263-01 5322 263-02 ¹⁾	3.97/.156 3.97/.156	0.4-0.8/.016-.031 1.2/.047	5512 090-01 (M5x0.5/3.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
–	–	–	–	5680 049-01 (15IP/3.5)	416.1-864 (T15)
–	–	–	–	5680 049-01 (15IP/3.5)	416.1-864 (T15)
–	–	–	–	5680 049-02 (15IP/4.0)	416.1-864 (T15)
5322 420-02	4.76/.187	0.4-1.2/.016-.047	5512 090-03 (M6x0.75)	5680 049-02 (15IP/4.0)	416.1-864 (T15)

B



Shank holders			1
Inch	Metric	Coromant Capto®	Insert screw (thread)
			
A04F-STFCR/L 1.2 A05H-STFCR/L 1.2	A06F-STFCR/L 06-R E06H-STFCR/L 06-R A06F-STFCR/L 06	–	5513 020-28 (M2)
E04H-STFCR/L-1.2R E05K-STFCR/L-1.2R A04F-STFCR/L-1.2R A05H-STFCR/L-1.2R	A08H-STFCR/L 06-R E08K-STFCR/L 06-R A08H-STFCR/L 06	–	5513 020-28 (M2)
E06M-STFCR/L-1.8 E08R-STFCR/L-1.8 A06M-STFCR/L-1.8R A08M-STFCR/L-1.8R A06M-STFCR/L 1.8 A08M-STFCR 1.8	A10K-STFCR/L 09-R A12M-STFCR/L 09-R E10M-STFCR/L 09-R E12Q-STFCR/L 09-R F10M-STFCR/L 09-R F12Q-STFCR/L 09-R A10K-STFCR/L 09 A12M-STFCR/L 09	–	5513 020-05 (M2.2)
A06M-STFCR/L-2-B1 ²⁾ A08M-STFCR/L-2-B1 ²⁾ A10R-STFCR/L-2-B1 ²⁾ A12S-STFCR/L-2-B1 ²⁾ A06M-STFCR/L 2-RB1 ²⁾ A08M-STFCR/L 2-RB1 ²⁾ A10R-STFCR/L 2-RB1 ²⁾ A12S-STFCR/L 2-RB1 ²⁾ E06M-STFCR/L-2-B1 ²⁾ E08R-STFCR/L-2-B1 ²⁾ E10R-STFCR/L-2-B1 ²⁾ E12S-STFCR/L-2-B1 ²⁾ E12R-STFCR/L-2-RB1 ²⁾ E16S-STFCR/L-2-RB ²⁾ E15S-STFCR/L 2-R A06M-STFCR/L 2 A08M-STFCR/L 2 A10R-STFCR/L 2 A12S-STFCR/L 2	A12M-STFCR/L 11-B1 ²⁾ A16R-STFCR/L 11-B1 ²⁾ A20S-STFCR/L 11-B1 ²⁾ E16R-STFCR/L 11-R E16R-STFCR/L 11-RB1 ²⁾ A16R-STFCR/L 11-RB1 ²⁾ A12M-STFCR/L 11-RB1 ²⁾ A20S-STFCR/L 11-RB1 ²⁾ A25T-STFCR/L 11 - RB1 ²⁾ A12M-STFCR/L 11 A16R-STFCR/L 11 A20S-STFCR/L 11 E20S-STFCR/L 11-RB1 E25T-STFCR/L 11-RB1	C3-STFCR/L-11065-11-B1 ³⁾ C3-STFCR/L-13075-11-B1 ³⁾ C4-STFCR/L-11070-11-B1 ³⁾ C4-STFCR/L-13080-11-B1 ³⁾ C5-STFCR/L-11070-11-B1 ³⁾ C5-STFCR/L-13080-11-B1 ³⁾	5513 020-03 (M2.5)
E16T-STFCR/L-3 A16T-STFCR/L-3 E16S-STFCR/L 3-R A20T-STFCR/L-3 A24T-STFCR/L-3	A25T-STFCR/L 16-M E25T-STFCR/L 16-R A32T-STFCR/L 16 A40T-STFCR/L 16	C3-STFCR/L-17090-16 C4-STFCR/L-17090-16 C5-STFCR/L-17090-16 C4-STFCR/L-22110-16 C5-STFCR/L-22110-16	5513 020-10 (M3.5) 5513 020-01 (M3.5)
A05F-STUCR/L 05-GR E05H-STUCR/L 05-GR A06F-STUCR/L 05-GR E06H-STUCR/L 05-GR A08H-STUCR/L 06-GR E08K-STUCR/L 06-GR A10K-STUCR/L 06-GR E10M-STUCR/L 06-GR			5513 020-53 5513 020-44 5513 020-28

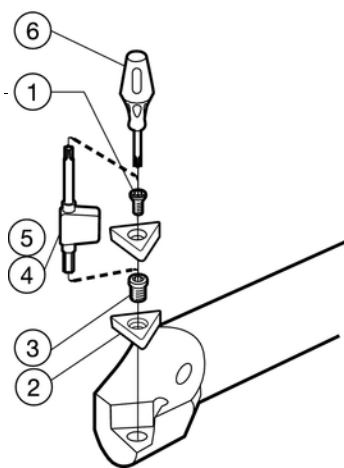
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- Optional parts must be ordered separately.
- B1 = For insert with thickness $2 = 1/8"$


CoroTurn® 107 screw clamp design

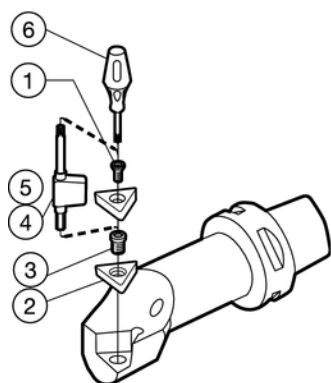
2			3	4/5	6 ¹⁾
Shim	For insert thickness mm/ inch	Radius mm/inch	Shim screw (thread)	Key (Torx Plus/mm)	Screwdriver (Torx Plus)
–	–	–	–	5680 051-01 (6IP)	–
–	–	–	–	5680 051-01 (6IP)	–
–	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
–	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
–	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
5322 320-01	3.97/.156	0.4-1.2/.016-.047	5512 090-01 (M5x0.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
–	–	–	–	5680 041-03 (6IP)	
–	–	–	–	5680 041-03 (6IP)	
–	–	–	–	5680 041-03 (6IP)	

CoroTurn® 107 screw clamp design



Shank holders

Inch	Metric	Coromant Capto®	Insert screw (thread)
 A10R-SVUBR/L 2-EB1 ²⁾ A12S-SVUBR/L 2-EB1 ²⁾ A16T-SVUBR/L 2-DB1 ²⁾ A10R-SVQBR/L 2E A10R-SVUBR/L 2-ERB1 ²⁾ A12S-SVUBR/L 2-ERB1 ²⁾ A10R-SVUBR/L 2-E A12S-SVUBR/L 2-D	A16R-SVUBR/L 11-EB1 ²⁾ A20S-SVUBR/L 11-EB1 ²⁾ A25T-SVUBR/L 11-DB1 ²⁾ A16R SVUBR/L 11-ERB1 ²⁾ A20S SVUBR/L 11-ERB1 ²⁾ A16R-SVQBR/L 11-ERB1 ²⁾ A20S-SVQBR/L 11-ERB1 ²⁾ A16R-SVUBR/L 11-E A20S-SVUBR/L 11-E A25T-SVUBR/L 11-E A25T-SVUBR/L 16-D	–	5513 020-20 (M2.5)
			5513 020-10 (M3.5)
			5513 020-01 (M3.5)
			5513 020-20 (M2.5)
			5513 020-10 (M3.5)
			5513 020-01 (M3.5)
			5513 020-20 (M2.5)
			5513 020-10 (M3.5)
			5513 020-01 (M3.5)
			5513 020-20 (M2.5)
A16T-SVQBR/L 3-D A20T-SVQBR/L 3 A16T-SVPBR/L 3 A24T-SVQBR 3 A20T-SVPBR/L 3 A24T-SVPBR/L 3	A16R-SVQBR/L 11-EB1 ²⁾ A20S-SVQBR/L 11-EB1 ²⁾ A25T-SVQBR/L 11-DB1 ²⁾ A16R-SVQBR/L 11-E A20S-SVQBR/L 11-E A25T-SVQBR/L 11-D A25T-SVQBR/L 16-D A25T-SVPR/L 16 A32T-SVQBR/L 16 A40T-SVQBR/L 16 A32T-SVPR/L 16 A40T-SVPR/L 16	C3-SVQBR/L-13070-11 C3-SVQBR/L-15080-11 C4-SVQBR/L-13070-11 C4-SVQBR/L-15080-11 C5-SVQBR/L-15080-11 C3-SVQBR/L-18090-16 C4-SVQBR/L-18090-16 C5-SVQBR/L-18090-16 C3-SVQBR/L-22064-16 C3-SVQBR/L-22096-16 C4-SVQBR/L-22110-16 C4-SVQBR/L-27080-16 C4-SVQBR/L-27120-16 C5-SVQBR/L-22110-16 C5-SVQBR/L-27140-16 C5-SVQBR/L-35100-16 C5-SVQBR/L-35150-16 C6-SVQBR/L-22120-16 C6-SVQBR/L-27145-16 C6-SVQBR/L-35175-16	5513 020-20 (M2.5)
			5513 020-10 (M3.5)
			5513 020-01 (M3.5)
			5513 020-20 (M2.5)
			5513 020-10 (M3.5)
			5513 020-01 (M3.5)
			5513 020-20 (M2.5)
			5513 020-10 (M3.5)
			5513 020-01 (M3.5)
			5513 020-20 (M2.5)



Magnetic sleeve, see page A457

Note: CoroTurn® boring bars type SVQCR/L and SVUCR/L on page A491.

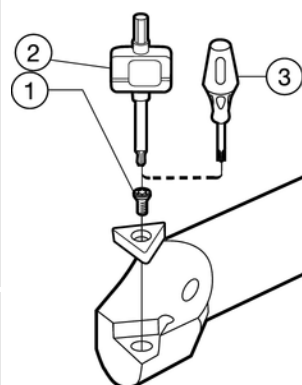
1) Optional parts must be ordered separately.




2) B1 = For insert with thickness 2 = 1/8"

CoroTurn® 107 screw clamp design



2			3	4/5	6 ¹⁾
Shim	For insert thickness mm/ inch	Radius mm/inch	Shim screw (thread)	Key (Torx Plus/mm)	Screwdriver (Torx Plus)
–	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
–	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
5322 270-01	4.76/.187	0.4-0.8/.016-.031	5512 090-01 (M5x0.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
5322 270-02 ¹⁾	4.76/.187	1.2/.047			
–	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
–	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
5322 270-01	4.76/.187	0.4-0.8/.016-.031	5512 090-01 (M5x0.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
5322 270-02 ¹⁾	4.76/.187	1.2/.047			

CoroTurn® 111 screw clamp design



Boring bars		1	2	3 ¹⁾
Inch	Metric	Insert screw (thread)	Key (Torx Plus/mm)	Screwdriver (Torx Plus)
<div></div> <div>A05K-SCLPR/L 2 A06M-SCLPR/L 2 A05K-SCLPR/L 2-R A06M-SCLPR/L 2-R E05K-SCLPR/L 2 E06M-SCLPR/L 2 E06M-SCLPR/L 2-R A08M-SCLPR/L 2 A08M-SCLPR/L 2-R E08R-SCLPR/L 2 E08R-SCLPR/L 2-R</div>	<div>A08K-SCLPR/L 06 A10K-SCLPR/L 06 A08K-SCLPR/L 06-R A10K-SCLPR/L 06-R E08K-SCLPR/L 06-R E10M-SCLPR/L 06-R</div>	5513 020-21 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div>A08M-SCLPR/L 2 A08M-SCLPR/L 2-R E08R-SCLPR/L 2 E08R-SCLPR/L 2-R</div>	<div>A12M-SCLPR/L 06 A12M-SCLPR/L 06-R E12Q-SCLPR/L 06-R</div>	5513 020-46 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div></div> <div>A06M-SDUPR/L 2-E A08M-SDUPR/L 2-E A06M-SDUPR/L 2-ER A08M-SDUPR/L 2-ER E06M-SDUPR/L 2-E E08R-SDUPR/L 2-E E06M-SDUPR/L 2-ER E08R-SDUPR/L 2-ER F06M-SDUPR/L 2-ER F08Q-SDUPR/L 2-ER</div>	<div>A10K-SDUPR/L 07-E A10K-SDUPR/L 07-ER E10M-SDUPR/L 07-ER F10M-SDUPR/L 07-ER</div>	5513 020-48 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div>A10R-SDUPR/L 2 A10R-SDUPR/L 2-E A10R-SDUPR/L 2-ER A10R-SDUPR/L 2-ERX E10R-SDUPR/L 2 E10R-SDUPR/L 2-R E10R-SDUPR/L 2-ERX E10R-SDUPR/L 2-EX</div>	<div>A12M-SDUPR/L 07-E A12M-SDUPR/L 07-ER A16R-SDUPR/L 07 A16R-SDUPR/L 07-R A16R-SDUPR/L 07-ERX A16R-SDUPR/L 07-EX E12Q-SDUPR/L 07-ER E16R-SDUPR/L 07-R E16R-SDUPR/L 07-ERX F12Q-SDUPR/L 07-ER</div>	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div>A12S-SDUPR/L 3 A12S-SDUPR/L 3-R A16T-SDUPR/L 3-ER</div>	<div>A20S-SDUPR/L 11 A20S-SDUPR/L 11-R A25T-SDUPR/L 11</div>	5513 020-09 (M3.5)	5680 049-01 (15IP)	5680 046-02 (15IP)
<div>A10R-SDXPR/L 2-E A10R-SDXPR/L 2-ER</div>	<div>A16R-SDXPR/L 07-E A16R-SDXPR/L 07-ER</div>	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div></div> <div>A04F-STFPR/L 1.2-R A04F-STFPR/L 1.2 E04H-STFPR/L 1.2-R</div>	<div>A06H-STFPR/L 06 A06F-STFPR/L 06-R E06H-STFPR/L 06-R</div>	5513 020-44 (M2.0)	5680 051-01 (6IP)	–
<div>A05H-STFPR/L 1.2 A05H-STFPR/L 1.2-R E05K-STFPR/L 1.2-R</div>	<div>A08K-STFPR/L 06 A08H-STFPR/L 06-R E08K-STFPR/L 06-R</div>	5513 020-28 (M2.0)	5680 051-01 (6IP)	–
<div>A06M-STFPR/L 1.8 A06M-STFPR/L 1.8-R A08M-STFPR/L 1.8 A08M-STFPR/L 1.8-R E06M-STFPR/L 1.8 E06M-STFPR/L 1.8-R E08Q-STFPR/L 1.8-R E08Q-STFPR/L 1.8 F06M-STFPR/L 1.8-R F08Q-STFPR/L 1.8-R</div>	<div>A10K-STFPR/L 09 A10K-STFPR/L 09-R A12M-STFPR/L 09 A12M-STFPR/L 09-R E10M-STFPR/L 09-R E12Q-STFPR/L 09-R F10M-STFPR/L 09-R F12Q-STFPR/L 09-R</div>	5513 020-47 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div>A08M-STFPR/L 2 A08M-STFPR/L 2-R E08R-STFPR/L 2 E08R-STFPR/L 2-R</div>	<div>A12M-STFPR/L 11 A12M-STFPR/L 11-R E12Q-STFPR/L 11-R</div>	5513 020-48 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div>A10R-STFPR/L 2 A10R-STFPR/L 2-R E10R-STFPR/L 2 E10R-STFPR/L 2-R</div>	<div>A16R-STFPR/L 11 A16R-STFPR/L 11-R E16R-STFPR/L 11-R</div>	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<div>A12S-STFPR/L 3 A12S-STFPR/L 3-R A16T-STFPR/L 3</div>	<div>A20S-STFPR/L 16 A20S-STFPR/L 16-R A25S-STFPR/L 16</div>	5513 020-09 (M3.5)	5680 049-01 (15IP)	5680 046-02 (15IP)
		5513 020-10 (M3.5)	5680 049-01 (15IP)	5680 046-02 (15IP)

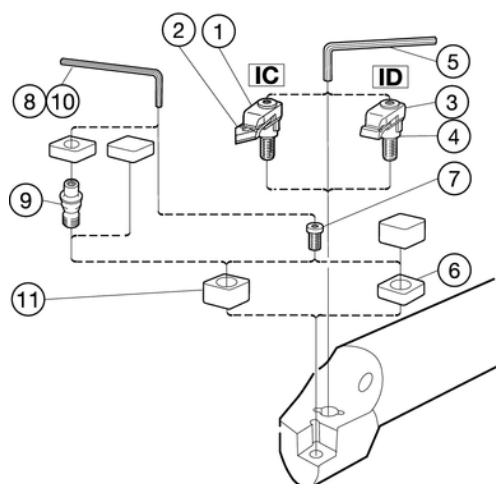
CoroTurn® 111/107 screw clamp design







Boring bars		1	2	3 ¹⁾
Inch	Metric	Insert screw (thread)	Key (Torx Plus/mm)	Screwdriver (Torx Plus)
CoroTurn® 107				
				
A10R-SVUCR/L 2-E A10R-SVUCR/L 2-ER E10R-SVUCR/L 2-E E10R-SVUCR/L 2-ER	A16R-SVUCR/L 11-E A16R-SVUCR/L 11-ER E16R-SVUCR/L 11-ER	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
A10R-SVQCR/L 2-E A10R-SVQCR/L 2-ER E10R-SVQCR/L 2-ER	A16R-SVQCR/L 11-E A16R-SVQCR/L 11-ER E16R-SVQCR/L 11-ER	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
CoroTurn® 111				
				
A03F-SWLPR/L 1.2-R A03H-SWLPR/L 1.2-R A04F-SWLPR/L 1.2 A04F-SWLPR/L 1.2-R E04H-SWLPR/L 1.2-R	A05F-SWLPR/L 02-R E05H-SWLPR/L 02-R	5513 020-53 (M2.0)	5680 051-01 (6IP)	–
A05H-SWLPR/L 1.2 A05H-SWLPR/L 1.2-R E05K-SWLPR/L 1.2-R	A06F-SWLPR/L 02 A06F-SWLPR/L 02-R A08H-SWLPR/L 02 A08H-SWLPR/L 02-R E06H-SWLPR/L 02-R E08K-SWLPR/L 02-R	5513 020-44 (M2.0)	5680 051-01 (6IP)	–
A06M-SWLPR/L 2 A06M-SWLPR/L 2-R E06M-SWLPR/L 2-R	A10K-SWLPR/L 04 A10K-SWLPR/L 04-R E10M-SWLPR/L 04-R	5513 020-21 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
A08M-SWLPR/L 2 A08M-SWLPR/L 2-R E08R-SWLPR/L 2 E08R-SWLPR/L 2-R	A12M-SWLPR/L 04 A12M-SWLPR/L 04-R E12Q-SWLPR/L 04-R	5513 020-46 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)

¹⁾ Optional part delivered to separate order.

Magnetic sleeve, see page A457

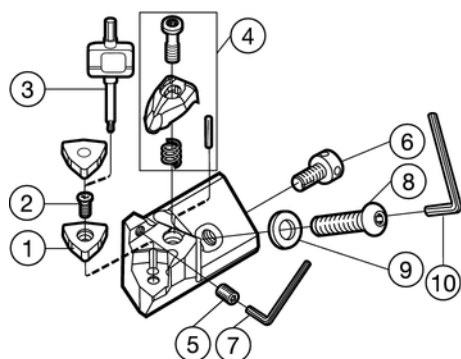
T-Max® top clamp design for ceramic inserts







	1	2			3	4	5
Round shank tool	Clamp (IC)	Chip breaker (IC) Right hand	Neutral	Left hand	Clamp (ID)	Pressure plate (ID)	Key (mm)
 S40T-CCLNR/L 12-IC S50U-CCLNR/L 12-IC	5412 125-02	–	5192 022-04	–	5412 125-02 ¹⁾	5192 020-01 ¹⁾	3021 010-040 (4.0)
 S25T-CRSPR/L 09-ID S40T-CRSPR/L 12-ID	–	–	–	–	5412 126-03 5412 125-01	– 5192 020-01	3021 010-040 (4.0) 3021 010-040 (4.0)
 S40T-CSKNR/L 12-IC	5412 125-02	5192 022-05	–	5192 022-05	5412 125-02 ¹⁾	5192 020-01 ¹⁾	3021 010-040 (4.0)
	6	7	8	9 ¹⁾	11 ¹⁾	10 ¹⁾	
Round shank tool	Shim (For insert thickness)	Shim screw	Key (Torx Plus)	Centre pin (IP)	Shim (For insert thickness)	Key (mm)	
 S40T-CCLNR/L 12-IC S50U-CCLNR/L 12-IC	5322 233-01 (7.94/.312)	5513 013-02 (20IP)	5680 043-14 (20IP)	5313 032-02	5322 233-02 (4.76/.187)	174.1-863 (2.5)	
 S25T-CRSPR/L 09-ID S40T-CRSPR/L 12-ID	– 5322 141-01 (7.94/.312)	– 5513 013-02 (20IP)	– 5680 043-14 (20IP)	– 5313 032-02	– 5322 141-02 (4.76/.187)	– 174.1-863 (2.5)	
 S40T-CSKNR/L 12-IC	5322 421-01 (7.94/.312)	5513 013-02 (20IP)	5680 043-14 (20IP)	5313 032-02	5322 421-02 (4.76/.187)	174.1-863 (2.5)	

¹⁾ Optional part delivered to separate order.

CoroTurn® RC rigid clamp design



	1	2	3	4
Cartridge	Shim screw	Shim (for insert thickness mm/inch)	Key (Torx Plus)	Complete clamp set
 DCLNR/L 25CA-12	5513 020-02	5322 234-01 (4.76/.187) 5322 234-02 (7.94/.313) ⁴⁾	5680 049-01 (15IP)	5412 028-021 ¹⁾ 5412 032-021 ²⁾ 5412 034-021 ³⁾
DCLNR/L 25CA-16	5513 020-07	5322 234-03 (4.76/.187) 5322 234-04 (7.94/.313) ⁴⁾	5680 043-14 (20IP)	5412 028-031 ¹⁾ 5412 032-031 ²⁾ 5412 034-031 ³⁾
 DSKNR/L 25CA-12	5513 020-02	5322 425-01 (4.76/.187) 5322 425-02 (7.94/.313) ⁴⁾	5680 049-01 (15IP)	5412 028-021 ¹⁾ 5412 032-021 ²⁾ 5412 034-021 ³⁾
 DTFNR/L 16CA-16	5513 020-04	5322 316-01 (4.76/.187)	5680 051-03 (9IP)	5412 028-011 ¹⁾
 DWLNR/L 20CA-08	5513 020-02	5322 331-12 (4.76/.187)	5680 049-01 (15IP)	5412 028-021 ¹⁾

1) For clamp set parts, see page A445.

2) Clamp sets for ceramic inserts with hole

3) Clamp sets for ceramic inserts without hole

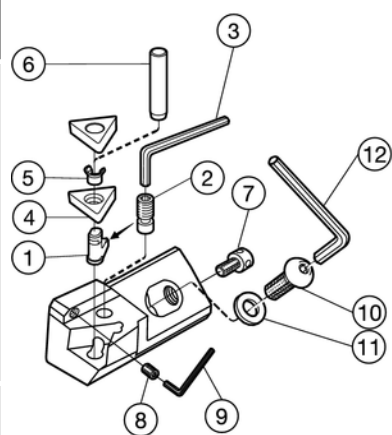
4) Optional part delivered to separate order.




Setting and clamping

	5	6	7	8	9	10 ¹⁾
	Adjusting screw, axial	Adjusting screw, radial	Key (mm)	Mounting screw	Washer	Key (mm)
DCLNR/L 25CA-12	3214 010-305	5519 095-03	174.1-863 (2.5)	434.9-822	3411 010-105	3021 010-060 (6.0)
DCLNR/L 25CA-16	3214 010-305	5519 095-03	174.1-863 (2.5)	434.9-822	3411 010-105	3021 010-060 (6.0)
DSKNR/L 25CA-12	3214 010-305	5519 095-03	174.1-863 (2.5)	434.9-822	3411 010-105	3021 010-060 (6.0)
DTFNR/L 16CA-16	438.3-820	5519 095-02	174.1-870 (1.98)	434.9-830	3411 011-084	3021 010-050 (5.0)
DWLNR/L 20CA-08	3214 010-305	5519 095-01	174.1-863 (2.5)	434.9-830	3411 011-084	3021 010-050 (5.0)

1) Optional part delivered to separate order.

T-Max® P lever design



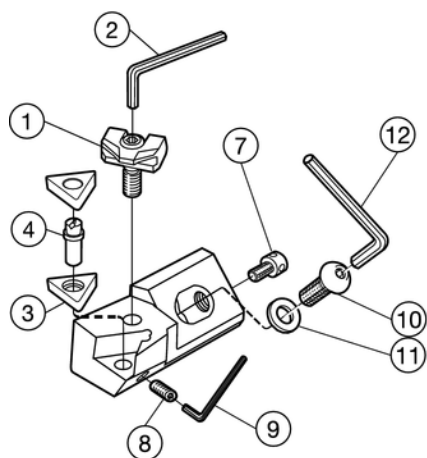
	1	2	3	4	5	6
Cartridge	Lever	Screw	Key (mm)	Shim	For insert Thickness (Radius) mm/inch	Shim pin Shim pin punch
						
PCLNR/L 16CA-12	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M	4.76/.187 (0.4-1.6/.016-.063)	174.3-861 174.3-871
PCLNR/L 25CA-19	174.3-849M	174.3-835	3021 010-040 (4.0)	171.31-851M	6.35/.250 (0.4-2.4/.016-.094)	174.3-868 174.3-872
PCFNR/L 16CA-12	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M	4.76/.187 (0.4-1.6/.016-.063)	174.3-861 174.3-871
PCGNR/L 16CA-12	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M	4.76/.187 (0.4-1.6/.016-.063)	174.3-861 174.3-871
						
PSKNR/L 12CA-12	438.3-841-1	438.3-832M	174.1-863 (2.5)	–	–	–
PSKNR/L 16CA-12	174.3-848M	174.3-858	174.1-864 (3.0)	174.3-851M 174.3-856 ¹⁾	4.76/.187 (0.4-1.2/.016-.047) 4.76/.187 (1.6-2.4/.063-.094)	174.3-861 174.3-871
PSKNR/L 20CA-15	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857	6.35/.250 (0.4-2.4/.016-.094)	174.3-864 174.3-873
PSSNR/L 12CA-12	438.3-841-1	438.3-832M	174.1-863 (2.5)	–	–	–
PSSNR/L 16CA-12	174.3-848M	174.3-858	174.1-864 (3.0)	174.3-851M 174.3-856 ¹⁾	4.76/.187 (0.4-1.2/.016-.047) 4.76/.187 (1.6-2.4/.063-.094)	174.3-861 174.3-871
PSSNR/L 20CA-15	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857	6.35/.250 (1.6-2.4/.063-.094)	174.3-864 174.3-873
PSRNR/L 16CA-12	174.3-848M	174.3-858	174.1-864 (3.0)	174.3-851M 174.3-856 ¹⁾	4.76/.187 (0.4-1.2/.016-.047) 4.76/.187 (1.6-2.4/.063-.094)	174.3-861 174.3-871
PSRNR/L 20CA-15	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857	6.35/.250 (0.4-2.4/.016-.094)	174.3-864 174.3-873
						
PTFNR/L 12CA-16	5432 015-011	438.3-830	174.1-870 (1.98)	–	–	–
PTFNR/L 16CA-16	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M 179.3-858 ¹⁾	4.76/.187 (0.4-0.8/.016-.031) 4.76/.187 (1.2-1.6/.047-.063)	174.3-860 174.3-870
PTFNR/L 20CA-22	174.3-841M	174.3-821	174.1-864 (3.0)	179.3-852M 179.3-853M ¹⁾	4.76/.187 (1.2-1.6/.047-.063) 4.76/.187 (0.4-0.8/.016-.031)	174.3-861 174.3-871
PTWNR/L 12CA-16	5432 015-011	438.3-830	174.1-870 (1.98)	–	–	–
PTSNR/L 12CA-16	5432 015-011	438.3-830	174.1-870 (1.98)	–	–	–
PTSNR/L 16CA-16	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M 179.3-858 ¹⁾	4.76/.187 (0.4-0.8/.016-.031) 4.76/.187 (1.2-1.6/.047-.063)	174.3-860 174.3-870
PTSNR/L 20CA-22	174.3-841M	174.3-821	174.1-864 (3.0)	179.3-852M 179.3-853M ¹⁾	4.76/.187 (1.2-1.6/.047-.063) 4.76/.187 (0.4-0.8/.016-.031)	174.3-861 174.3-871
PTTNR/L 12CA-16	5432 015-011	438.3-830	174.1-870 (1.98)	–	–	–
PTGNR/L 12CA-16	5432 015-011	438.3-830	174.1-870 (1.98)	–	–	–
PTGNR/L 16CA-16	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M 179.3-858 ¹⁾	4.76/.187 (0.4-0.8/.016-.031) 4.76/.187 (1.2-1.6/.047-.063)	174.3-860 174.3-870
PTGNR/L 20CA-22	174.3-841M	174.3-821	174.1-864 (3.0)	179.3-852M 179.3-853M ¹⁾	4.76/.187 (1.2-1.6/.047-.063) 4.76/.187 (0.4-0.8/.016-.031)	174.3-861 174.3-871


Setting and clamping

	7	8	9	10	11	12 ¹⁾
	Adjusting screw, axial	Adjusting screw, radial	Key (mm)	Mounting screw	Washer	Key (mm)
12CA	438.3-824	438.3-820	174.1-870 (1.98)	434.9-824	3411 011-064	3021 010-040 (4.0)
16CA	438.3-828	438.3-821	174.1-863 (2.5)	434.9-830	3411 011-084	3021 010-050 (5.0)
20CA	438.3-839	438.3-821	174.1-863 (2.5)	434.9-830	3411 011-084	3021 010-050 (5.0)
25CA	438.3-825	438.3-822	174.1-864 (3.0)	434.9-822	3411 010-105	3021 010-060 (6.0)

¹⁾ Optional part delivered to separate order.

T-Max P wedge clamp design



	1	2	3	4	
Cartridge	Wedge clamp set	Key (mm)	Shim	For insert Thickness (Radius) mm/ inch	Pin
					
MWLNRL 16CA-06	5431 125-011	170.3-860 (2.5)	5322 331-06	-	5313 022-01
MWLNRL 25CA-08	5431 125-021	174.1-864 (3.0)	5322 331-09 5322 331-10 ¹⁾	4.76/.187 (0.4-0.8/.016--.031) 4.76/.187 (1.2-1.6/.047--.063)	5313 022-03

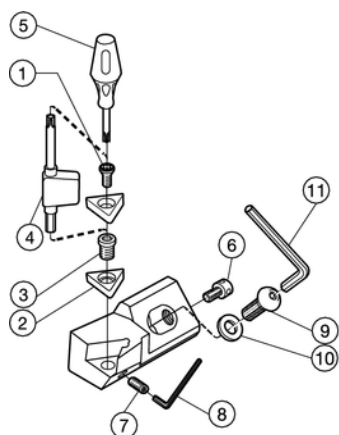
Ordering example: 10 pieces 5431 125-011





Setting and clamping

	7	8	9	10	11	12 ¹⁾
	Adjusting screw, axial	Adjusting screw, radial	Key (mm)	Mounting screw	Washer	Key (mm)
MWLNRL 16CA-06	438.3-828	434.9-836	174.1-870 (1.98)	434.9-830	3411-011-084	3021 010-050 (5.0)
MWLNRL 25CA-08	438.3-825	434.9-838	174.1-864 (3.0)	434.9-822	3411 010-105	3021 010-060 (6.0)

1) Optional part delivered to separate order.

CoroTurn® 107 screw clamp design



	1	2	3	4	5 ¹⁾	
Cartridge	Insert screw (Thread)	Shim (for insert thickness mm/inch)	Radius mm/inch	Shim screw	Key (Torx Plus)	Screwdriver (Torx Plus)
						
SCFCR/L 08CA-06	5513 020-03	–	–	–	5680 051-02 (7IP)	5680 046-03(7IP)
SCFCR/L 10CA-09	5513 020-09	–	–	–	5680 049-01 (15IP)	3021 010-040 (4.0)
SCFCR/L 12CA-09	5513 020-09	–	–	–	5680 049-01 (15IP)	
						
SRSCR/L 06CA-06	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
SRSCR/L 08CA-08	5513 020-04 (M3.0)	–	–	–	5680 051-03 (9IP)	5680 046-04 (9IP)
SRSCR/L 10CA-10	5513 020-09 (M3.5)	5322 110-01 (3.97/.156)	–	5512 090-01	5680 049-01 (15IP)	5680 046-02 (15IP)
						
SSKCR/L 10CA-09-M	5513 020-09 (M3.5)	–	–	–	5680 049-01 (15IP)	5680 046-02 (15IP)
SSKCR/L 12CA-12	5513 020-17 (M4x0.5)	–	–	–	5680 049-02 (15IP)	5680 046-02 (15IP)
SSKCR/L 16CA-12	5513 020-18 (M4x0.5)	5322 420-02 (4.76/.187)	0.4-1.2/.016 – .047	5512 090-03	5680 049-02 (15IP)	5680 046-02 (15IP)
SSSCR/L 10CA-09-M	5513 020-09 (M3.5)	–	–	–	5680 049-01 (15IP)	5680 046-02 (15IP)
SSSCR/L 12CA-12	5513 020-17 (M4x0.5)	–	–	–	5680 049-02 (15IP)	5680 046-02 (15IP)
						
STFCR/L 06CA-06	5513 020-27 (M2)	–	–	–	5680 051-01 (6IP)	–
STFCR/L 08CA-09	5513 020-05 (M2.2)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STFCR/L 10CA-11-B1	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STFCR/L 12CA-16-M	5513 020-10 (M3.5)	–	–	–	5680 049-01 (15IP)	5680 046-02 (15IP)
STFCR/L 16CA-16	5513 020-01 (M3.5)	5322 320-01 (3.97/.156)	0.4-1.2/.016 – .047	5512 090-01	5680 049-01 (15IP)	5680 046-02 (15IP)
STGCR/L 06CA-06	5513 020-27 (M2)	–	–	–	5680 051-01 (6IP)	–
STGCR/L 08CA-09	5513 020-05 (M2.2)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STGCR/L 10CA-11	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STGCR/L 10CA-11-B1	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STGCR/L 12CA-16-M	5513 020-10 (M3.5)	–	–	–	5680 049-01 (15IP)	5680 046-02 (15IP)
STGCR/L 16CA-16	5513 020-01 (M3.5)	5322 320-01 (3.97/.156)	0.4-1.2/.016 – .047	5512 090-01	5680 049-01 (15IP)	5680 046-02 (15IP)
STWCR/L 06CA-06	5513 020-27 (M2)	–	–	–	5680 051-01 (6IP)	–
STWCR/L 08CA-09	5513 020-05 (M2.2)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STWCR/L 10CA-11-B1	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STWCR/L 12CA-16-M	5513 020-10 (M3.5)	–	–	–	5680 049-01 (15IP)	5680 046-02 (15IP)
STSCR/L 06CA-06	5513 020-27 (M2)	–	–	–	5680 051-01 (6IP)	–
STSCR/L 08CA-09	5513 020-05 (M2.2)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STSCR/L 10CA-11-B1	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STSCR/L 12CA-16-M	5513 020-10 (M3.5)	–	–	–	5680 049-01 (15IP)	5680 046-02 (15IP)
STSCR/L 16CA-16	5513 020-01 (M3.5)	5322 320-01 (3.97/.156)	0.4-1.2/.016 – .047	5512 090-01	5680 049-01 (15IP)	5680 046-02 (15IP)
STTCR/L 06CA-06	5513 020-27 (M2)	–	–	–	5680 051-01 (6IP)	–
STTCR/L 08CA-09	5513 020-05 (M2.2)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STTCR/L 10CA-11-B1	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
STTCR/L 12CA-16-M	5513 020-10 (M3.5)	–	–	–	5680 049-01 (15IP)	5680 046-02 (15IP)
STTCR/L 16CA-16	5513 020-01 (M3.5)	5322 320-01 (3.97/.156)	0.4-1.2/.016 – .047	5512 090-01	5680 049-01 (15IP)	5680 046-02 (15IP)

1) Optional part delivered to separate order.

Magnetic sleeve, see page A456

CoroTurn® 107 screw clamp design

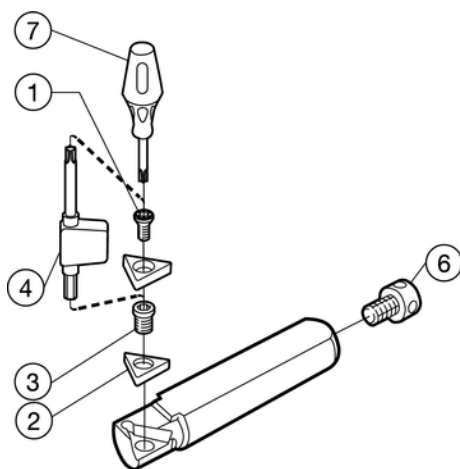
Setting and clamping


CoroTurn 107, ISO cartridges

	6	7	8	9	10	11	11 ¹⁾
CoroTurn® 107	Adjusting screw, axial	Adjusting screw, radial	Key (mm)	Mounting screw	Washer	Key (Torx Plus)	Key (mm)
06 CA	5512 050-01	3214 010-203	3021 012-015 (1.5)	5512 031-04	–	5680 043-10 (T8)	–
08 CA	5512 050-02	3214 010-203	3021 012-015 (1.5)	5512 031-03	–	5680 043-13 (T15)	–
10 CA	438.3-824	434.9-835	174.1-870 (1.98)	434.9-826	170.38-834	–	3021 010-040 (4.0)
12 CA	438.3-824	434.9-836	174.1-870 (1.98)	434.9-824	3411 011-064	–	3021 010-040 (4.0)
16 CA	438.3-828	434.9-836	174.1-870 (1.98)	434.9-830	3411 011-084	–	3021 010-050 (5.0)

1) Optional part delivered to separate order.

CoroTurn® 107 round shank boring tools



	1	2		3		4	6	7 ¹⁾
Round shank tool	Insert screw (Thread)	Shim	For insert Thickness mm/inch	Radius mm/inch	Shim screw	Key (Torx Plus)	Length adjusting screw	Screwdriver (Torx Plus)
								
R/L 140.0-8-06	5513 020-27 (M2)	–	–	–	–	5680 051-01 (6IP)	–	–
R/L 140.0-10-09	5513 020-05 (M2.2)	–	–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
R/L 140.0-12-11	5513 020-03 (M2.5)	–	–	–	–	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
R/L 140.0-16-11	5513 020-03 (M2.5)	–	–	–	–	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
R/L 140.0-20-16	5513 020-01 (M3.5)	5322 320-01	3.97/.156	0.4-1.2/.016 – .047	5512 090-01	5680 049-01 (15IP)	434.9-825	5680 046-02 (15IF)
R/L 141.0-8-06	5513 020-27 (M2)	–	–	–	–	5680 051-01 (6IP)	–	–
R/L 141.0-10-09	5513 020-05 (M2.2)	–	–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
R/L 141.0-12-11	5513 020-03 (M2.5)	–	–	–	–	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
R/L 141.0-16-11	5513 020-03 (M2.5)	–	–	–	–	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
R/L 141.0-20-16	5513 020-01 (M3.5)	5322 320-01	3.97/.156	0.4-1.2/.016 – .047	5512 090-01	5680 049-01 (15IP)	434.9-825	5680 046-02 (15IF)
R/L 142.0-8-06	5513 020-27 (M2)	–	–	–	–	5680 051-01 (6IP)	–	–
R/L 142.0-10-09	5513 020-05 (M2.2)	–	–	–	–	5680 051-02 (7IP)	–	5680 046-03 (7IP)
R/L 142.0-12-11	5513 020-03 (M2.5)	–	–	–	–	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
R/L 142.0-16-11	5513 020-03 (M2.5)	–	–	–	–	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
R/L 142.0-20-16	5513 020-01 (M3.5)	5322 320-01	3.97/.156	0.4-1.2/.016 – .047	5512 090-01	5680 049-01 (15IP)	434.9-825	5680 046-02 (15IF)

1) Optional part delivered to separate order.

Magnetic sleeve, see page A456



Cutting data recommendations for CoroTurn® XS

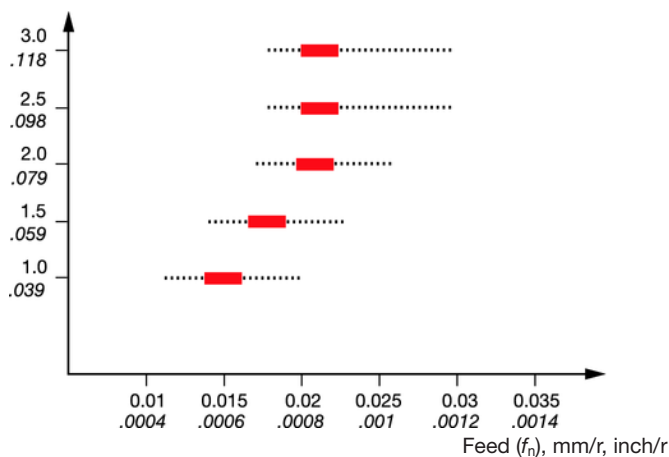
Turning inserts

Insert size	Dimensions, mm, inch				Application area				Rec. cutting feed			
					General turning/Back boring Rec. depth of cut							
dm_m	b_{21} mm	b_{21} inch	r_6 mm	r_6 inch	a_p mm	Min - Max	a_p inch	Min - Max	f_n mm/r	Min - Max	f_n inch/r	Min - Max
04	0.18	.007	—	—	0.05	(0.01 - 0.08)	.0020	(.0004 - .0031)	0.007	(0.050 - 0.015)	.00028	(.00020 - .00059)
04	0.28	.011	—	—	0.06	(0.01 - 0.10)	.0024	(.0004 - .0041)	0.010	(0.050 - 0.014)	.00039	(.00020 - .00059)
04	0.38	.015	—	—	0.08	(0.01 - 0.15)	.0031	(.0004 - .0059)	0.012	(0.008 - 0.017)	.00047	(.00032 - .00067)
04	0.46	.018	—	—	0.09	(0.01 - 0.20)	.0035	(.0004 - .0071)	0.015	(0.010 - 0.020)	.00059	(.00039 - .00079)
04	0.56	.022	—	—	0.12	(0.01 - 0.22)	.0047	(.0004 - .0087)	0.018	(0.010 - 0.025)	.00071	(.00039 - .00098)
04	0.63	.025	—	—	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
04	0.66	.026	0.05	.002	0.15	(0.05 - 0.30)	.0059	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	0.66	.026	0.10	.004	0.15	(0.09 - 0.30)	.0059	(.0039 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	0.74	.029	—	—	0.15	(0.01 - 0.25)	.0059	(.0004 - .0098)	0.020	(0.012 - 0.025)	.00079	(.00047 - .00098)
04	1.04	.041	0.05	.002	0.18	(0.05 - 0.30)	.0071	(.0020 - .0118)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	1.04	.041	0.10	.004	0.18	(0.01 - 0.30)	.0071	(.0004 - .0118)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	1.55	.061	0.05	.002	0.20	(0.05 - 0.40)	.0079	(.0020 - .0158)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	1.55	.061	0.10	.004	0.20	(0.09 - 0.40)	.0079	(.0039 - .0158)	0.020	(0.015 - 0.080)	.00079	(.00059 - .00315)
04	2.06	.081	0.05	.002	0.25	(0.05 - 0.51)	.0098	(.0020 - .0200)	0.020	(0.012 - 0.030)	.00079	(.00047 - .00118)
04	2.06	.081	0.15	.006	0.25	(0.15 - 0.51)	.0098	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	2.54	.100	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
04	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)
04	2.95	.116	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
04	3.45	.136	0.05	.002	0.30	(0.05 - 0.51)	.0118	(.0020 - .0200)	0.020	(0.015 - 0.030)	.00079	(.00059 - .00118)
04	3.45	.136	0.15	.006	0.30	(0.15 - 0.51)	.0118	(.0059 - .0200)	0.025	(0.015 - 0.050)	.00098	(.00059 - .00197)
05	3.76	.148	0.15	.006	0.35	(0.15 - 0.60)	.0138	(.0059 - .0236)	0.040	(0.020 - 0.060)	.00157	(.00079 - .00236)
05	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)
05	4.19	.165	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
05	4.24	.167	0.05	.002	0.25	(0.05 - 0.60)	.0098	(.0020 - .0236)	0.030	(0.020 - 0.040)	.00118	(.00079 - .00157)
05	4.24	.167	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
06	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)
06	3.96	.156	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.045	(0.020 - 0.070)	.00177	(.00079 - .00276)
06	5.26	.207	0.20	.008	0.40	(0.20 - 0.70)	.0157	(.0079 - .0276)	0.045	(0.020 - 0.080)	.00177	(.00079 - .00315)
07	4.29	.169	0.20	.008	0.35	(0.20 - 0.60)	.0138	(.0079 - .0236)	0.040	(0.020 - 0.070)	.00157	(.00079 - .00276)
07	6.25	.246	0.20	.008	0.50	(0.20 - 0.80)	.0197	(.0079 - .0315)	0.050	(0.030 - 0.080)	.00197	(.00118 - .00315)

When using CBN grade CB7015 reduce feed and cutting depth by 50%, compared to carbide grades.

Grooving and face grooving

Insert width (l_a), mm, inch



■ = Recommended starting value.

Cutting speed recommendations

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

Grade 1025

P

60-200
(185-655)

M

60-180
(195-590)

N

90-400
(295-1310)

S

20-50
(65-165)

Grade CB7015

H

60-200
(200-600)

Threading, (Infeed recommendations)

Thread	Pitch		a_p mm	a_p inch	nap
	mm	TPI			
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	7
		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
Whitworth 55° (WH)		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	12
		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

Recommended depth of cut and cutting feed, metric

T-MAX P negative basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
CNMG090304-WF	0.5	0.3	1.5	0.15	0.05	0.25
CNMG090308-WF	1	0.3	2	0.3	0.1	0.5
CNMG120404-WF	0.4	0.25	3	0.15	0.05	0.25
CNMG120408-WF	1	0.25	4	0.3	0.1	0.5
CNMG120412-WF	1.5	0.4	4	0.5	0.2	0.6
DNMX110404-WF	1	0.2	1.5	0.2	0.08	0.3
DNMX110408-WF	1	0.2	3	0.3	0.1	0.4
DNMX150404-WF	0.8	0.2	3	0.2	0.08	0.3
DNMX150408-WF	1.5	0.2	3	0.3	0.1	0.4
DNMX150412-WF	1.5	0.4	3.5	0.4	0.15	0.55
DNMX150604-WF	0.8	0.2	3	0.2	0.08	0.3
DNMX150608-WF	1.5	0.2	3	0.3	0.1	0.4
CNMX150612-WF	1.5	0.4	3.5	0.4	0.15	0.55
TNMX160404-WF	1	0.2	3	0.2	0.08	0.3
TNMX160408-WF	1.5	0.2	3	0.3	0.1	0.4
WNMG060404-WF	0.4	0.25	2	0.15	0.05	0.25
WNMG060408-WF	1	0.25	3	0.3	0.1	0.5
WNMG080404-WF	0.4	0.25	3	0.15	0.05	0.25
WNMG080408-WF	1	0.25	4	0.3	0.1	0.5
WNMG080412-WF	1.5	0.4	4	0.5	0.2	0.6
CNMG090304-PF	0.4	0.25	1.5	0.15	0.07	0.3
CNMG090308-PF	0.4	0.3	1.5	0.15	0.1	0.3
CNMG120404-PF	0.4	0.25	1.5	0.15	0.07	0.3
CNMG120408-PF	0.4	0.3	1.5	0.2	0.1	0.4
CNMG120412-PF	0.8	0.35	1.5	0.25	0.15	0.5
DNMG110404-PF	0.4	0.25	1.5	0.15	0.07	0.3
DNMG110408-PF	0.4	0.3	1.5	0.2	0.1	0.4
DNMG110412-PF	0.8	0.35	1.5	0.25	0.15	0.5
DNMG150404-PF	0.4	0.25	1.5	0.15	0.07	0.3
DNMG150408-PF	0.4	0.3	1.5	0.2	0.1	0.4
DNMG150412-PF	0.8	0.35	1.5	0.25	0.15	0.5
DNMG150604-PF	0.4	0.25	1.5	0.15	0.07	0.3
DNMG150608-PF	0.4	0.3	1.5	0.2	0.1	0.4
DNMG150612-PF	0.8	0.35	1.5	0.25	0.15	0.5
SNMG120408-PF	0.4	0.3	1.5	0.2	0.1	0.4
SNMG120412-PF	0.8	0.35	1.5	0.25	0.15	0.5
TNMG160404-PF	0.4	0.25	1.5	0.15	0.07	0.3
TNMG160408-PF	0.4	0.3	1.5	0.2	0.1	0.4
TNMG160412-PF	0.8	0.35	1.5	0.25	0.15	0.5
TNMG220408-PF	0.4	0.3	1.5	0.2	0.1	0.4
TNMG220412-PF	0.8	0.35	1.5	0.25	0.15	0.5
VNMG160404-PF	0.4	0.25	1.5	0.15	0.07	0.3
VNMG160408-PF	0.4	0.3	1.5	0.2	0.1	0.4
WNMG060404-PF	0.4	0.25	1.5	0.15	0.07	0.3
WNMG060408-PF	0.4	0.3	1.5	0.2	0.1	0.4
WNMG060412-PF	0.8	0.4	1.5	0.25	0.15	0.5
WNMG080404-PF	0.4	0.25	1.5	0.15	0.07	0.3
WNMG080408-PF	0.4	0.3	1.5	0.2	0.1	0.4
WNMG080412-PF	0.8	0.4	1.5	0.25	0.15	0.5
CNMG120404-MF	0.4	0.1	1.5	0.15	0.05	0.3
CNMG120408-MF	0.4	0.1	1.5	0.2	0.1	0.4
CNMG120412-MF	0.8	0.2	2.5	0.25	0.15	0.5
DNMG 11 04 04-MF	0.4	0.1	1.5	0.15	0.05	0.3
DNMG110408-MF	0.4	0.1	1.5	0.2	0.1	0.4
DNMG150404-MF	0.4	0.1	1.5	0.15	0.05	0.3
DNMG150408-MF	0.4	0.1	1.5	0.2	0.1	0.4
DNMG150412-MF	0.8	0.2	2.5	0.25	0.15	0.5
DNMG150604-MF	0.4	0.1	1.5	0.15	0.05	0.3
DNMG150608-MF	0.4	0.1	1.5	0.2	0.1	0.4
DNMG150612-MF	0.8	0.2	2.5	0.25	0.15	0.5
SNMG120404-MF	0.4	0.1	1.5	0.15	0.05	0.3
SNMG120408-MF	0.4	0.1	1.5	0.2	0.1	0.4
TNMG160404-MF	0.4	0.1	1.5	0.15	0.05	0.3
TNMG160408-MF	0.4	0.1	1.5	0.2	0.1	0.4
TNMG160412-MF	0.8	0.2	2.5	0.25	0.15	0.5
VNMG160404-MF	0.4	0.1	1.5	0.15	0.05	0.3
VNMG160408-MF	0.8	0.2	2.5	0.15	0.08	0.3
WNMG060404-MF	0.4	0.1	1.5	0.15	0.05	0.3
WNMG060408-MF	0.4	0.1	1.5	0.2	0.1	0.4
WNMG080404-MF	0.4	0.1	1.5	0.15	0.05	0.3
WNMG080408-MF	0.4	0.1	1.5	0.2	0.1	0.4
CNMG120404-KF	0.5	0.15	2	0.15	0.08	0.25
CNMG120408-KF	0.5	0.15	2	0.2	0.1	0.3

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
CNMG120412-KF	1	0.2	2.5	0.25	0.1	0.35
DNMG110404-KF	0.5	0.15	2	0.15	0.08	0.25
DNMG110408-KF	0.5	0.15	2	0.2	0.1	0.3
DNMG150404-KF	0.5	0.15	2	0.15	0.08	0.25
DNMG150408-KF	0.5	0.15	2	0.2	0.1	0.3
DNMG150604-KF	0.5	0.15	2	0.15	0.08	0.25
DNMG150608-KF	0.5	0.15	2	0.2	0.1	0.3
DNMG150612-KF	1	0.2	2.5	0.25	0.1	0.35
TNMG160404-KF	0.5	0.15	2	0.15	0.08	0.25
TNMG160408-KF	0.5	0.15	2	0.2	0.1	0.3
WNMG060404-KF	0.5	0.15	2	0.15	0.08	0.25
WNMG060408-KF	0.5	0.15	2	0.2	0.1	0.3
WNMG080404-KF	0.5	0.15	2	0.15	0.08	0.25
WNMG080408-KF	0.5	0.15	2	0.2	0.1	0.3
WNMG080412-KF	1	0.2	2.5	0.25	0.1	0.35
CNMG120408-WMX	3	0.5	5	0.45	0.15	0.7
CNMG120412-WMX	3.5	0.8	6	0.5	0.2	0.75
CNMG160608-WMX	3	0.5	5	0.45	0.15	0.7
CNMG160612-WMX	3.5	0.8	6	0.5	0.2	0.75
DNMX150408-WMX	3	0.5	5	0.45	0.15	0.7
DNMX150412-WMX	3.5	0.8	6	0.5	0.2	0.75
DNMX150416-WMX	3.5	0.5	6	0.5	0.2	0.8
DNMX150608-WMX	3	0.5	5	0.45	0.15	0.7
DNMX150612-WMX	3.5	0.8	6	0.5	0.2	0.75
DNMX150616-WMX	3.5	0.5	6	0.5	0.2	0.8
TNMX160408-WMX	3	0.5	5	0.45	0.15	0.7
TNMX160412-WMX	3.5	0.8	6	0.5	0.2	0.75
WNMG060408-WMX	3	0.5	5	0.45	0.15	0.7
WNMG060412-WMX	3.5	0.8	6	0.5	0.2	0.75
WNMG080408-WMX	3	0.5	5	0.45	0.15	0.7
WNMG080412-WMX	3.5	0.8	6	0.5	0.2	0.75
CNMG120408-WM	3	0.5	5	0.3	0.15	0.6
CNMG120412-WM	3.5	0.8	6	0.5	0.2	0.9
CNMG160608-WM	3.5	0.7	6.5	0.4	0.2	0.7
CNMG160612-WM	3.5	0.7	6.5	0.4	0.2	0.7
DNMX110408-WM	1.5	0.5	3.5	0.35	0.15	0.5
DNMX110412-WM	2	0.5	4	0.45	0.15	0.6
DNMX150408-WM	2	0.5	4.5	0.35	0.15	0.5
DNMX150412-WM	2.5	0.5	5	0.45	0.15	0.6
DNMX150416-WM	3.5	0.5	6	0.6	0.2	0.8
DNMX150608-WM	2	0.5	4.5	0.35	0.15	0.5
DNMX150612-WM	2.5	0.5	5	0.45	0.15	0.6
DNMX150616-WM	3.5	0.5	6	0.6	0.2	0.8
TNMX160408-WM	2	0.5	4.5	0.35	0.15	0.5
TNMX160412-WM	2.5	0.5	5	0.4	0.15	0.6
WNMG060408-WM	1.5	0.5	3.5	0.3	0.15	0.6
WNMG060412-WM	1.5	0.8	3.5	0.5	0.2	0.9
WNMG080408-WM	3	0.5	5	0.3	0.15	0.6
WNMG080412-WM	3.5	0.8	6	0.5	0.2	0.9
CNMG090304-PM	2	0.4	4	0.2	0.1	0.3
CNMG090308-PM	2	0.5	4	0.3	0.15	0.5
CNMG120404-PM	3	0.4	5.5	0.2	0.1	0.3
CNMG120408-PM	3	0.5	5.5	0.3	0.15	0.5
CNMG120412-PM	3	0.8	5.5	0.35	0.18	0.6
CNMG120416-PM	3	1	5.5	0.4	0.23	0.65
CNMG160608-PM	4	0.5	7.2	0.3	0.15	0.5
CNMG160612-PM	4	0.8	7.2	0.35	0.18	0.6
CNMG160616-PM	4	1	7.2	0.4	0.23	0.65
CNMG190608-PM	4	0.5	8.6	0.3	0.15	0.5
CNMG190612-PM	4	0.8	8.6	0.35	0.18	0.6
CNMG190616-PM	4	1	8.6	0.4	0.23	0.65
DNMG110404-PM	2	0.4	5	0.2	0.1	0.3
DNMG110408-PM	2	0.5	5	0.3	0.15	0.5
DNMG110412-PM	2	0.8	5	0.35	0.18	0.5
DNMG150404-PM	3	0.4	6	0.2	0.1	0.3
DNMG150408-PM	3	0.5	6	0.3	0.15	0.5
DNMG150412-PM	3	0.8	6	0.35	0.18	0.6
DNMG150604-PM	3	0.4	6	0.2	0.1	0.3
DNMG150608-PM	3	0.5	6	0.3	0.15	0.5
DNMG150612-PM	3	0.8	6	0.35	0.18	0.6
DNMG150616-PM	3	1	6	0.4	0.23	0.65
SNMG090304-PM	2	0.4	4.5	0.2	0.1	0.3
SNMG090308-PM	2	0.5	4.5	0.3	0.15	0.5

Recommended depth of cut and cutting feed, metric

T-MAX P negative basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
SNMG120404-PM	3	0.4	6	0.2	0.1	0.3
SNMG120408-PM	3	0.5	6	0.3	0.15	0.5
SNMG120412-PM	3	0.8	6	0.35	0.18	0.6
SNMG120416-PM	3	1	6	0.4	0.23	0.65
SNMG150612-PM	4	0.8	7.5	0.35	0.18	0.6
SNMG150616-PM	4	1	7.5	0.4	0.23	0.65
TNMG160404-PM	3	0.4	5	0.2	0.1	0.3
TNMG160408-PM	3	0.5	5	0.3	0.15	0.5
TNMG160412-PM	3	0.8	5	0.35	0.18	0.6
TNMG220404-PM	4	0.4	6.6	0.2	0.1	0.3
TNMG220408-PM	4	0.5	6.6	0.3	0.15	0.5
TNMG220412-PM	4	0.8	6.6	0.35	0.18	0.6
TNMG220416-PM	4	1	6.6	0.4	0.23	0.65
VNMG160408-PM	2	0.5	4	0.3	0.15	0.5
VNMG160412-PM	2	0.8	4	0.35	0.18	0.6
WNMG060408-PM	2	0.5	3	0.3	0.15	0.5
WNMG060412-PM	2	0.8	3	0.35	0.18	0.6
WNMG080408-PM	2.5	0.5	4	0.3	0.15	0.5
WNMG080412-PM	2.5	0.8	4	0.35	0.18	0.6
WNMG080416-PM	3	1	4	0.4	0.23	0.65
CNMG120408-MM	3	0.5	5.7	0.25	0.1	0.45
CNMG120412-MM	3	0.5	5.7	0.3	0.1	0.6
CNMG120416-MM	3	0.5	5.7	0.37	0.1	0.65
CNMG160608-MM	4	0.5	7.2	0.25	0.1	0.45
CNMG160612-MM	4	0.5	7.2	0.3	0.1	0.6
CNMG160616-MM	4	0.5	7.2	0.37	0.1	0.65
CNMG190608-MM	4	0.5	8.5	0.25	0.1	0.45
CNMG190612-MM	4	0.5	8.5	0.3	0.1	0.6
CNMG190616-MM	4	0.5	8.5	0.37	0.1	0.65
DNMG110408-MM	2	0.5	4.4	0.25	0.1	0.45
DNMG110412-MM	2	0.5	4.4	0.3	0.1	0.6
DNMG150408-MM	3	0.5	6.4	0.25	0.1	0.45
DNMG150412-MM	3	0.5	6.4	0.3	0.1	0.6
DNMG150608-MM	3	0.5	6.4	0.25	0.1	0.45
DNMG150612-MM	3	0.5	6.4	0.3	0.1	0.6
SNMG120408-MM	3	0.5	6.35	0.25	0.1	0.45
SNMG120412-MM	3	0.5	6.35	0.3	0.1	0.6
SNMG120416-MM	3	0.5	6.35	0.37	0.1	0.65
SNMG150612-MM	4	0.5	8	0.3	0.1	0.6
SNMG150616-MM	4	0.5	8	0.37	0.1	0.65
SNMG190612-MM	4	0.5	9.5	0.3	0.1	0.6
SNMG190616-MM	4	0.5	9.5	0.37	0.1	0.65
TNMG160408-MM	3	0.5	4.8	0.25	0.1	0.45
TNMG160412-MM	3	0.5	4.8	0.3	0.1	0.6
TNMG220408-MM	4	0.5	6.6	0.25	0.1	0.45
TNMG220412-MM	4	0.5	6.6	0.3	0.1	0.6
TNMG220416-MM	4	0.5	6.6	0.37	0.1	0.65
VNMG160408-MM	2	0.5	4	0.25	0.1	0.45
VNMG060408-MM	2	0.5	3	0.25	0.1	0.45
WNMG060412-MM	2	0.5	3	0.3	0.1	0.6
WNMG080408-MM	2.5	0.5	4	0.25	0.1	0.45
WNMG080412-MM	2.5	0.5	4	0.3	0.1	0.6
CNMG120408-KM	3	0.2	6	0.35	0.15	0.5
CNMG120412-KM	3	0.3	6	0.4	0.15	0.6
CNMG120416-KM	3	0.3	6	0.45	0.2	0.7
CNMG160608-KM	4	0.2	8	0.35	0.15	0.5
CNMG160612-KM	4	0.3	8	0.4	0.15	0.6
CNMG160616-KM	4	0.3	8	0.45	0.2	0.7
CNMG190612-KM	4.5	0.3	9	0.4	0.15	0.6
CNMG190616-KM	4.5	0.3	9	0.45	0.2	0.7
DNMG110408-KM	2	0.2	3.5	0.35	0.15	0.5
DNMG110412-KM	2	0.3	3.5	0.4	0.15	0.6
DNMG150408-KM	2.5	0.2	5	0.35	0.15	0.5
DNMG150412-KM	2.5	0.3	5	0.4	0.15	0.6
DNMG150608-KM	2.5	0.2	5	0.35	0.15	0.5
DNMG150612-KM	2.5	0.3	5	0.4	0.15	0.6
SNMG090308-KM	2.5	0.2	4.5	0.35	0.15	0.5
SNMG120408-KM	3	0.2	6	0.35	0.15	0.5
SNMG120412-KM	3	0.3	6	0.4	0.15	0.6
SNMG120416-KM	3	0.3	6	0.45	0.2	0.7
SNMG150612-KM	4	0.3	8	0.4	0.15	0.6
SNMG150616-KM	4	0.3	8	0.45	0.2	0.7
SNMG190612-KM	4.5	0.3	9	0.4	0.15	0.6
SNMG190616-KM	4.5	0.3	9	0.45	0.2	0.7
TNMG160408-KM	3	0.2	5.5	0.35	0.15	0.5
TNMG160412-KM	3	0.3	5.5	0.4	0.15	0.6
TNMG220408-KM	4	0.2	8	0.35	0.15	0.5
TNMG220412-KM	4	0.3	8	0.4	0.15	0.6
TNMG220416-KM	4	0.3	8	0.45	0.2	0.7
VNMG160408-KM	2	0.2	3.5	0.3	0.15	0.4
VNMG160412-KM	2	0.3	3.5	0.35	0.15	0.5
WNMG060408-KM	2	0.2	4	0.35	0.15	0.5
WNMG060412-KM	2	0.3	4	0.4	0.15	0.6
WNMG080408-KM	2.5	0.2	5	0.35	0.15	0.5
WNMG080412-KM	2.5	0.3	5	0.4	0.15	0.6
CNMG120408-HM	4	1	8	0.5	0.25	0.8
CNMG160616-HM	4	1.5	8	0.6	0.3	0.9
CNMG190612-HM	4	1	10	0.5	0.25	0.8
CNMG190616-HM	4	1.5	10	0.6	0.3	0.9
CNMG190624-HM	5	2	10	0.6	0.3	1.2
SNMG150612-HM	4	1	8	0.5	0.25	0.8
SNMG150616-HM	4	1.5	8	0.6	0.3	0.9
SNMG190612-HM	4	1	10	0.5	0.25	0.8
SNMG190616-HM	4	1.5	10	0.6	0.3	0.9
SNMG190624-HM	5	2	10	0.6	0.3	1.2
SNMG250924-HM	6	2	15	0.8	0.4	1.2
TNMG270612-HM	6	2	12	0.6	0.35	0.75
TNMG270616-HM	6	2	12	0.6	0.35	0.75
TNMG330924-HM	7	3	15	0.6	0.45	0.9
CNMM120408-WR	2.5	0.8	5	0.6	0.3	0.8
CNMM120412-WR	2.5	1	5	0.8	0.4	1.1
CNMM120416-WR	2.5	1.2	5	0.8	0.44	1.2
CNMM160612-WR	3	1.2	6	0.8	0.42	1.2
CNMM160616-WR	3	1.4	6	0.9	0.46	1.3
CNMM190616-WR	3.3	1.6	6.7	1	0.48	1.3
TNMX220412-WR	2.5	1	5	0.8	0.4	1.1
TNMX220416-WR	2.5	1.2	5	0.9	0.44	1.2
CNMM120408-PR	5	0.7	7.5	0.4	0.2	0.55
CNMM120412-PR	5	1	7.5	0.5	0.25	0.7
CNMM120416-PR	5	1.5	7.5	0.55	0.32	0.9
CNMM160608-PR	6	0.7	9.5	0.4	0.2	0.55
CNMM160612-PR	6	1	9.5	0.5	0.25	0.7
CNMM160616-PR	6	1.5	9.5	0.55	0.32	0.9
CNMM190612-PR	6	1	12	0.5	0.25	0.7
CNMM190616-PR	6	1.5	12	0.55	0.32	0.9
CNMM190624-PR	6	2	12	0.55	0.35	1.2
DNMM150608-PR	5	0.7	6	0.4	0.2	0.55
DNMM150612-PR	5	1	6	0.5	0.25	0.7
DNMM150616-PR	5	1.5	6	0.55	0.32	0.9
SNMM120408-PR	5	0.7	7.5	0.4	0.2	0.55
SNMM120412-PR	5	1	7.5	0.5	0.25	0.7
SNMM150612-PR	6	1	9	0.5	0.25	0.7
SNMM150616-PR	6	1.5	9	0.55	0.32	0.9
SNMM190612-PR	6	1	12	0.5	0.25	0.7
SNMM190616-PR	6	1.5	12	0.55	0.32	0.9
SNMM190624-PR	6	2	12	0.55	0.35	1.2
TNMM160408-PR	4	0.7	6	0.4	0.2	0.55
TNMM160412-PR	4	1	6	0.5	0.25	0.7
TNMM220408-PR	5	0.7	8	0.4	0.2	0.55
TNMM220412-PR	5	1	8	0.5	0.25	0.7
TNMM220416-PR	5	1.5	8	0.55	0.32	0.9
CNMG120408-PR	4	0.7	7	0.35	0.2	0.5
CNMG120412-PR	4	1	7	0.4	0.25	0.7
CNMG120416-PR	4	1.5	7	0.5	0.32	0.75
CNMG160608-PR	5	0.7	8	0.35	0.2	0.5
CNMG160612-PR	5	1	8	0.4	0.25	0.7
CNMG160616-PR	5	1.5	8	0.5	0.3	0.8
CNMG160624-PR	5	2	8	0.5	0.32	0.9
CNMG190608-PR	5	0.7	10	0.35	0.2	0.5
CNMG190612-PR	5	1	10	0.4	0.25	0.7
CNMG190616-PR	5	1.5	10	0.5	0.3	0.8
CNMG190624-PR	5	2	10	0.5	0.32	0.9
CNMG250924-PR	6	2	15	0.6	0.4	1
DNMG150408-PR	4	0.7	6	0.35	0.2	0.5
DNMG150412-PR	4	1	6	0.4	0.25	0.7
DNMG150416-PR	4	1.5	6	0.5	0.3	0.75

Recommended depth of cut and cutting feed, metric

T-MAX P negative basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
DNMG150608-PR	4	0.7	6	0.35	0.2	0.5
DNMG150612-PR	4	1	6	0.4	0.25	0.7
DNMG150616-PR	4	1.5	6	0.5	0.32	0.75
SNMG120408-PR	4	0.7	7	0.35	0.2	0.5
SNMG120412-PR	4	1	7	0.4	0.25	0.7
SNMG120416-PR	4	1.5	7	0.5	0.32	0.75
SNMG150608-PR	5	1.5	8	0.35	0.2	0.5
SNMG150612-PR	5	1	8	0.4	0.25	0.7
SNMG150616-PR	5	1.5	8	0.5	0.3	0.8
SNMG150624-PR	5	2	8	0.5	0.32	0.9
SNMG190608-PR	5	0.7	10	0.35	0.2	0.5
SNMG190612-PR	5	1	10	0.4	0.25	0.7
SNMG190616-PR	5	1.5	10	0.5	0.3	0.8
SNMG190624-PR	5	2	10	0.5	0.32	0.9
SNMG250716-PR	6	2	15	0.8	0.4	1
SNMG250724-PR	6	2	15	1	0.4	1.2
SNMG250924-PR	6	2	15	1	0.4	1.2
TNMG160408-PR	3	0.7	6	0.35	0.2	0.55
TNMG160412-PR	3	1	6	0.4	0.25	0.65
TNMG220408-PR	4	0.7	7	0.35	0.2	0.55
TNMG220412-PR	4	1	7	0.4	0.25	0.65
TNMG220416-PR	4	1.5	7	0.5	0.32	0.75
TNMG270608-PR	6	1.5	12	0.5	0.35	0.55
TNMG270612-PR	6	2	12	0.6	0.35	0.75
TNMG270616-PR	6	2	12	0.6	0.35	0.7
TNMG330716-PR	3	1.5	8	0.6	0.4	0.75
TNMG330924-PR	7	3	15	0.6	0.45	0.9
WNMG060408-PR	3	0.7	3.5	0.3	0.2	0.45
WNMG060412-PR	3	0.8	3.5	0.35	0.25	0.55
WNMG080408-PR	4	0.7	5	0.35	0.2	0.55
WNMG080412-PR	4	1	5	0.4	0.25	0.7
WNMG080416-PR	4	1.5	5	0.5	0.32	0.75
CNMG120408-MR	3	2	7.6	0.3	0.15	0.55
CNMG120412-MR	3	2	7.6	0.35	0.15	0.6
CNMG120416-MR	3	2	7.6	0.4	0.15	0.7
CNMG160612-MR	4	2	10	0.35	0.15	0.6
CNMG160616-MR	4	2	10	0.4	0.15	0.7
CNMG190612-MR	4	2	11.4	0.35	0.15	0.6
CNMG190616-MR	4	2	11.4	0.4	0.15	0.7
CNMG190624-MR	4	2	11.4	0.5	0.15	1
DNMG150408-MR	3	2	6	0.3	0.15	0.55
DNMG150412-MR	3	2	6	0.35	0.15	0.6
DNMG150416-MR	3	2	6	0.4	0.15	0.7
DNMG150608-MR	3	2	6	0.3	0.15	0.55
DNMG150612-MR	3	2	6	0.35	0.15	0.6
DNMG150616-MR	3	2	6	0.4	0.15	0.7
SNMG120408-MR	3	2	7.6	0.3	0.15	0.55
SNMG120412-MR	3	2	7.6	0.35	0.15	0.6
SNMG150612-MR	4	2	9.6	0.35	0.15	0.6
SNMG150616-MR	4	2	9.6	0.4	0.15	0.7
SNMG190612-MR	4	2	11.4	0.35	0.15	0.6
SNMG190616-MR	4	2	11.4	0.4	0.15	0.7
SNMG190624-MR	4	2	11.4	0.5	0.15	1
TNMG160408-MR	3	2	5.6	0.3	0.15	0.55
TNMG160412-MR	3	2	5.6	0.35	0.15	0.6
TNMG220408-MR	4	2	7.7	0.3	0.15	0.55
TNMG220412-MR	4	2	7.7	0.35	0.15	0.6
TNMG220416-MR	4	2	7.7	0.4	0.15	0.7
WNMG060408-MR	2	1.5	3	0.3	0.15	0.55
WNMG060412-MR	2	1.5	3	0.35	0.15	0.6
WNMG080408-MR	2.5	2	4	0.3	0.15	0.55
WNMG080412-MR	2.5	2	4	0.35	0.15	0.6
CNMM120408-MR	3	0.7	7.5	0.35	0.2	0.55
CNMM120412-MR	3	1	7.5	0.4	0.25	0.7
CNMM120416-MR	3	1.5	7.5	0.5	0.32	0.9
CNMM160612-MR	6	1.2	9.5	0.45	0.32	0.65
CNMM160616-MR	6	1.5	9.5	0.5	0.35	0.8
CNMM190612-MR	7	1.5	12	0.5	0.32	0.7
CNMM190616-MR	7	1.8	12	0.55	0.35	0.9
CNMM190624-MR	7	2.5	12	0.6	0.4	1.2
CNMM250924-MR	9	2.5	15	0.65	0.45	1.4
CNMM250932-MR	9	3.5	15	0.65	0.45	1.4
DNMM150608-MR	3	0.7	6	0.35	0.2	0.55

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
DNMM150612-MR	3	1	6	0.4	0.25	0.7
SNMM120408-MR	3	0.7	7.5	0.35	0.2	0.55
SNMM120412-MR	3	1	7.5	0.4	0.25	0.7
SNMM120416-MR	3	1.5	7.5	0.5	0.32	0.9
SNMM150612-MR	4	1	9	0.4	0.25	0.7
SNMM150616-MR	4	1.5	9	0.5	0.32	0.9
SNMM190612-MR	7	1.5	12	0.5	0.32	0.7
SNMM190616-MR	7	1.8	12	0.55	0.35	0.9
SNMM190624-MR	7	2.5	12	0.6	0.4	1.2
SNMM190632-MR	4	3.5	12	0.5	0.4	1.2
SNMM250724-MR	9	2.8	18	0.7	0.45	1.4
SNMM250732-MR	6	2	15	0.5	0.32	1.4
SNMM250924-MR	9	2.8	18	0.7	0.45	1.4
TNMM160408-MR	3	0.7	7.5	0.35	0.2	0.55
TNMM220408-MR	3	0.7	8	0.35	0.2	0.55
TNMM220412-MR	3	1	8	0.4	0.25	0.7
TNMM220416-MR	3	1.5	8	0.5	0.32	0.9
TNMM270616-MR	4	1.5	9	0.5	0.32	0.9
TNMM270624-MR	4	2	9	0.5	0.35	1
CNMA120404-KR	2.5	0.2	5	0.2	0.1	0.3
CNMA120408-KR	4	0.2	8	0.35	0.15	0.6
CNMA120412-KR	4	0.3	8	0.45	0.2	0.8
CNMA120416-KR	4	0.3	8	0.55	0.2	1
CNMA160612-KR	5	0.3	10	0.45	0.2	0.8
CNMA160616-KR	5	0.3	10	0.55	0.2	1
CNMA190608-KR	6	0.2	12	0.35	0.15	0.6
CNMA190612-KR	6	0.3	12	0.45	0.2	0.8
CNMA190616-KR	6	0.3	12	0.55	0.2	1
CNMA190624-KR	6	0.4	12	0.6	0.2	1.4
DNMA150408-KR	3	0.2	6	0.35	0.15	0.6
DNMA150412-KR	3	0.3	6	0.45	0.2	0.8
DNMA150608-KR	3	0.2	6	0.35	0.15	0.6
DNMA150612-KR	3	0.3	6	0.45	0.2	0.8
DNMA150616-KR	3	0.3	6	0.55	0.2	1
SNMA120408-KR	4	0.2	8	0.35	0.15	0.6
SNMA120412-KR	4	0.3	8	0.45	0.2	0.8
SNMA120416-KR	4	0.3	8	0.55	0.2	1
SNMA150612-KR	5	0.3	10	0.45	0.2	0.8
SNMA150616-KR	5	0.3	10	0.55	0.2	1
SNMA190608-KR	6	0.2	12	0.35	0.15	0.6
SNMA190612-KR	6	0.3	12	0.45	0.2	0.8
SNMA190616-KR	6	0.3	12	0.55	0.2	1
SNMA250724-KR	6	0.4	12	0.6	0.2	1.4
TNMA160404-KR	2.5	0.2	5	0.2	0.1	0.3
TNMA160408-KR	3.5	0.2	7	0.35	0.15	0.6
TNMA160412-KR	3.5	0.3	7	0.45	0.2	0.8
TNMA160416-KR	3.5	0.3	7	0.55	0.2	1
TNMA220404-KR	2.5	0.2	10	0.2	0.1	0.3
TNMA220408-KR	5	0.2	10	0.35	0.15	0.6
TNMA220412-KR	5	0.3	10	0.45	0.2	0.8
TNMA220416-KR	5	0.3	10	0.55	0.2	1
TNMA220432-KR	5	0.5	10	0.6	0.5	1.2
TNMA270616-KR	5	0.3	12	0.5	0.2	1
WNMA060408-KR	2.5	0.2	4	0.35	0.15	0.6
WNMA060412-KR	2.5	0.3	4	0.45	0.2	0.8
WNMA080408-KR	3	0.2	5	0.35	0.15	0.6
WNMA080412-KR	3	0.3	5	0.45	0.2	0.8
WNMA080416-KR	3	0.3	5	0.55	0.2	1
CNMG120408-KR	3.5	0.38	7	0.38	0.19	0.53
CNMG120412-KR	3.5	0.5	7	0.5	0.25	0.7
CNMG120416-KR	3.5	0.75	7	0.61	0.28	0.85
CNMG160612-KR	4.7	0.8	9.3	0.55	0.28	0.77
CNMG160616-KR	4.7	1	9.3	0.61	0.3	0.85
CNMG190612-KR	7	1	14	0.55	0.28	0.77
CNMG190616-KR	7	1.5	14	0.61	0.3	0.85
CNMG120408-KRR	4	0.2	8	0.35	0.15	0.6
CNMG120412-KRR	4	0.3	8	0.45	0.2	0.8
CNMG120416-KRR	4	0.3	8	0.55	0.2	1
CNMG160612-KRR	5	0.3	10	0.45	0.2	0.8
CNMG160616-KRR	5	0.3	10	0.55	0.2	1
DNMG150408-KR	3.5	0.38	7	0.34	0.17	0.47
DNMG150412-KR	3.5	0.5	7	0.45	0.23	0.63
DNMG150608-KR	3.5	0.38	7	0.34	0.17	0.47

T-MAX P negative basic-shape inserts

B

C

G

H

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J

Recommended depth of cut and cutting feed, metric

CoroTurn® 107 positive basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
CCMT060202-WF	0.3	0.1	1.5	0.1	0.03	0.15
CCMT060204-WF	0.8	0.3	2	0.12	0.05	0.3
CCMT060208-WF	0.8	0.3	2	0.15	0.09	0.35
CCMT09T302-WF	0.3	0.1	1.5	0.1	0.03	0.15
CCMT09T304-WF	1	0.3	3	0.2	0.07	0.3
CCMT09T308-WF	1	0.3	3	0.25	0.12	0.5
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
TCMX090202-WF	0.3	0.1	1.5	0.1	0.03	0.15
TCMX090204-WF	0.7	0.3	2	0.12	0.05	0.3
TCMX090208-WF	0.7	0.3	2	0.25	0.1	0.35
TCMX110302-WF	0.3	0.1	1.5	0.1	0.03	0.15
TCMX110304-WF	1	0.3	2.5	0.2	0.07	0.3
TCMX110308-WF	1	0.3	2.5	0.25	0.12	0.4
TCMX16T304-WF	1.2	0.3	3.5	0.2	0.07	0.35
TCMX16T308-WF	1.2	0.3	3.5	0.25	0.12	0.5
CCMT060202-PF	0.3	0.06	1.7	0.06	0.03	0.11
CCMT060204-PF	0.3	0.1	1.7	0.08	0.05	0.17
CCMT09T302-PF	0.35	0.08	2	0.08	0.04	0.15
CCMT09T304-PF	0.35	0.11	2	0.11	0.06	0.23
CCMT09T308-PF	0.35	0.15	2	0.15	0.08	0.3
CCMT120404-PF	0.42	0.14	2.4	0.14	0.07	0.27
DCMT070202-PF	0.26	0.06	1.5	0.06	0.03	0.11
DCMT070204-PF	0.26	0.08	1.5	0.08	0.05	0.17
DCMT11T302-PF	0.35	0.08	2	0.08	0.04	0.15
DCMT11T304-PF	0.35	0.11	2	0.11	0.06	0.23
DCMT11T308-PF	0.35	0.15	2	0.15	0.08	0.3
SCMT09T304-PF	0.35	0.11	2	0.11	0.06	0.23
SCMT09T308-PF	0.35	0.15	2	0.15	0.08	0.3
TCMT06T102-PF	0.26	0.06	1.5	0.06	0.03	0.11
TCMT06T104-PF	0.26	0.08	1.5	0.08	0.05	0.17
TCMT06T108-PF	0.26	0.11	1.5	0.11	0.06	0.23
TCMT090202-PF	0.3	0.06	1.7	0.06	0.03	0.13
TCMT090204-PF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT110302-PF	0.3	0.06	1.7	0.06	0.03	0.13
TCMT110304-PF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT110308-PF	0.3	0.13	1.7	0.13	0.07	0.26
TCMT16T304-PF	0.35	0.11	2	0.11	0.06	0.23
VBMT110302-PF	0.3	0.06	1.7	0.06	0.03	0.13
VBMT110304-PF	0.3	0.1	1.7	0.1	0.05	0.19
VBMT110308-PF	0.3	0.13	1.7	0.13	0.07	0.26
VBMT110312-PF	0.3	0.13	1.7	0.15	0.08	0.31
VBMT160402-PF	0.32	0.07	1.8	0.07	0.04	0.14
VBMT160404-PF	0.32	0.1	1.8	0.1	0.05	0.2
VBMT160408-PF	0.32	0.14	1.8	0.14	0.07	0.27
VBMT160412-PF	0.32	0.14	1.8	0.16	0.09	0.32
CCMT060202-MF	0.3	0.06	1.7	0.06	0.03	0.11
CCMT060204-MF	0.3	0.1	1.7	0.08	0.05	0.17
CCMT09T302-MF	0.35	0.08	2	0.08	0.04	0.15
CCMT09T304-MF	0.35	0.11	2	0.11	0.06	0.23
CCMT09T308-MF	0.35	0.15	2	0.15	0.08	0.3
CCMT120404-MF	0.42	0.14	2.4	0.14	0.07	0.27
DCMT070202-MF	0.26	0.06	1.5	0.06	0.03	0.11
DCMT070204-MF	0.26	0.08	1.5	0.08	0.05	0.17
DCMT11T302-MF	0.35	0.08	2	0.08	0.04	0.15
DCMT11T304-MF	0.35	0.11	2	0.11	0.06	0.23
DCMT11T308-MF	0.35	0.15	2	0.15	0.08	0.3
SCMT09T304-MF	0.35	0.11	2	0.11	0.06	0.23
SCMT09T308-MF	0.35	0.15	2	0.15	0.08	0.3
TCMT06T102-MF	0.26	0.06	1.5	0.06	0.03	0.11
TCMT06T104-MF	0.26	0.08	1.5	0.08	0.05	0.17
TCMT06T108-MF	0.26	0.11	1.5	0.11	0.06	0.23
TCMT090202-MF	0.3	0.06	1.7	0.06	0.03	0.13
TCMT090204-MF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13
TCMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26
TCMT16T304-MF	0.35	0.11	2	0.11	0.06	0.23
VBMT110302-MF	0.3	0.06	1.7	0.06	0.03	0.13

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
VBMT110304-MF	0.3	0.1	1.7	0.1	0.05	0.19
VBMT110308-MF	0.3	0.13	1.7	0.13	0.07	0.26
VBMT160402-MF	0.32	0.07	1.8	0.07	0.04	0.14
VBMT160404-MF	0.32	0.1	1.8	0.1	0.05	0.2
VBMT160408-MF	0.32	0.14	1.8	0.14	0.07	0.27
VBMT160412-MF	0.32	0.14	1.8	0.16	0.09	0.32
CCMT060202-KF	0.3	0.06	1.7	0.06	0.03	0.11
CCMT060204-KF	0.3	0.1	1.7	0.08	0.05	0.17
CCMT09T302-KF	0.35	0.08	2	0.08	0.04	0.15
CCMT09T304-KF	0.35	0.11	2	0.11	0.06	0.23
CCMT120404-KF	0.42	0.14	2.4	0.14	0.07	0.27
DCMT070202-KF	0.26	0.06	1.5	0.06	0.03	0.11
DCMT070204-KF	0.26	0.08	1.5	0.08	0.05	0.17
DCMT11T302-KF	0.35	0.08	2	0.08	0.04	0.15
DCMT11T304-KF	0.35	0.11	2	0.11	0.06	0.23
SCMT09T304-KF	0.35	0.11	2	0.11	0.06	0.23
SCMT09T308-KF	0.35	0.15	2	0.15	0.08	0.3
TCMT06T102-KF	0.26	0.06	1.5	0.06	0.03	0.11
TCMT06T104-KF	0.26	0.08	1.5	0.08	0.05	0.17
TCMT06T108-KF	0.26	0.11	1.5	0.11	0.06	0.23
TCMT090202-KF	0.3	0.06	1.7	0.06	0.03	0.13
TCMT090204-KF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT110302-KF	0.3	0.06	1.7	0.06	0.03	0.13
TCMT110304-KF	0.3	0.1	1.7	0.1	0.05	0.19
TCMT16T304-KF	0.35	0.11	2	0.11	0.06	0.23
VBMT110302-KF	0.3	0.06	1.7	0.06	0.03	0.13
VBMT110304-KF	0.3	0.1	1.7	0.1	0.05	0.19
VBMT110308-KF	0.3	0.13	1.7	0.13	0.07	0.26
VBMT160402-KF	0.32	0.07	1.8	0.07	0.04	0.14
VBMT160404-KF	0.32	0.1	1.8	0.1	0.05	0.2
VBMT160408-KF	0.32	0.14	1.8	0.14	0.07	0.27
TCMX050100L-F	0.15	0.05	0.8	0.06	0.02	0.1
TCMX050100R-F	0.15	0.05	0.8	0.06	0.02	0.1
TCMX050101L-F	0.15	0.05	0.8	0.06	0.02	0.1
TCMX050101R-F	0.15	0.05	0.8	0.06	0.02	0.1
TCMX06T100L-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMX06T100R-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMX06T101L-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMX06T101R-F	0.2	0.05	1.5	0.08	0.02	0.12
TCMX06T102L-F	0.2	0.05	0.5	0.08	0.02	0.12
TCMX090200L-F	0.3	0.05	3	0.1	0.02	0.15
TCMX090200R-F	0.3	0.05	3	0.1	0.02	0.15
TCMX090201L-F	0.3	0.05	3	0.1	0.02	0.15
TCMX090201R-F	0.3	0.05	3	0.1	0.02	0.15
TCMX090202L-F	0.2	0.05	0.5	0.1	0.02	0.15
TCMX110300L-F	0.4	0.05	4	0.1	0.02	0.15
TCMX110300R-F	0.4	0.05	4	0.1	0.02	0.15
TCMX110301L-F	0.4	0.05	4	0.1	0.02	0.15
TCMX110301R-F	0.4	0.05	4	0.1	0.02	0.15
TCMX110302L-F	0.2	0.05	0.5	0.1	0.02	0.2
VCX110300L-F	1	0.03	4	0.05	0.01	0.2
VCX110300R-F	1	0.03	4	0.05	0.01	0.2
VCX110301L-F	1	0.05	4	0.1	0.01	0.3
VCX110301R-F	1	0.05	4	0.1	0.01	0.3
TCGX06T104L-WK	0.5	0.15	1	0.15	0.03	0.25
TCGX06T104R-WK	0.5	0.15	1	0.15	0.03	0.25
TCGX090204L-WK	0.5	0.15	1.2	0.2	0.04	0.28
TCGX090204R-WK	0.5	0.15	1.2	0.2	0.04	0.28
TCGX110204L-WK	0.5	0.15	1.5	0.2	0.05	0.3
TCGX110204R-WK	0.5	0.15	1.5	0.2	0.05	0.3
TCGX110304L-WK	0.5	0.15	1.5	0.2	0.05	0.3
TCGX110304R-WK	0.5	0.15	1.5	0.2	0.05	0.3
CCMT060208-WM	1.2	0.5	2.5	0.2	0.1	0.4
CCMT09T304-WM	1.5	0.5	4	0.25	0.12	0.4
CCMT09T308-WM	1.5	0.7	4	0.3	0.15	0.5
CCMT120404-WM	2	0.5	4	0.25	0.15	0.4
CCMT120408-WM	2	0.7	4	0.3	0.15	0.5
DCMX11T304-WM	1.5	0.5	4	0.25	0.12	0.4
DCMX11T308-WM	1.5	0.5	4	0.3	0.15	0.5
TCMX110304-WM	1.2	0.5	3	0.25	0.12	0.35
TCMX110308-WM	1.2	0.5	3	0.3	0.15	0.5
TCMX16T308-WM	1.5	0.5	4	0.3	0.15	0.5
CCMT060204-PM	0.64	0.2	2.4	0.11	0.06	0.17

Recommended depth of cut and cutting feed, metric

CoroTurn® 107 positive basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = mm			f_n = mm/r		
	Min	Max.		Min	Max.	
CCMT060208-PM	0.64	0.4	2.4	0.15	0.08	0.23
CCMT09T304-PM	0.64	0.25	3	0.15	0.08	0.23
CCMT09T308-PM	0.8	0.5	3	0.2	0.1	0.3
CCMT120404-PM	0.96	0.3	3.6	0.18	0.09	0.27
CCMT120408-PM	0.96	0.6	3.6	0.24	0.12	0.36
CCMT120412-PM	0.96	0.72	3.6	0.29	0.14	0.43
DCMT070204-PM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070208-PM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT11T304-PM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T308-PM	0.8	0.5	3	0.2	0.1	0.3
DCMT11T312-PM	0.8	0.6	3	0.24	0.12	0.36
SCMT09T304-PM	0.8	0.25	3	0.15	0.08	0.23
SCMT09T308-PM	0.8	0.5	3	0.2	0.1	0.3
SCMT120404-PM	0.96	0.3	3.6	0.18	0.09	0.27
SCMT120408-PM	0.96	0.6	3.6	0.24	0.12	0.36
SCMT120412-PM	0.96	0.72	3.6	0.29	0.14	0.43
TCMT090204-PM	0.6	0.19	2.25	0.11	0.06	0.17
TCMT090208-PM	0.6	0.38	2.25	0.15	0.08	0.23
TCMT110304-PM	0.67	0.21	2.5	0.13	0.06	0.19
TCMT110308-PM	0.67	0.42	2.5	0.17	0.09	0.26
TCMT110312-PM	0.67	0.5	2.5	0.2	0.1	0.31
TCMT16T304-PM	0.8	0.25	3	0.15	0.08	0.23
TCMT16T308-PM	0.8	0.5	3	0.2	0.1	0.3
TCMT16T312-PM	0.8	0.6	3	0.24	0.12	0.36
TCMT220408-PM	0.96	0.6	3.6	0.24	0.12	0.36
VBMT160404-PM	0.72	0.23	2.7	0.14	0.07	0.2
VBMT160408-PM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160412-PM	0.72	0.54	2.7	0.22	0.11	0.32
CCMT060204-MM	0.64	0.2	2.4	0.11	0.06	0.17
CCMT060208-MM	0.64	0.4	2.4	0.15	0.08	0.23
CCMT09T304-MM	0.64	0.25	3	0.15	0.08	0.23
CCMT09T308-MM	0.8	0.5	3	0.2	0.1	0.3
CCMT120404-MM	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
CCMT120412-MM	0.96	0.72	3.6	0.29	0.14	0.43
DCMT070204-MM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070208-MM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT11T304-MM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T308-MM	0.8	0.5	3	0.2	0.1	0.3
DCMT11T312-MM	0.8	0.6	3	0.24	0.12	0.36
SCMT09T304-MM	0.8	0.25	3	0.15	0.08	0.23
SCMT09T308-MM	0.8	0.5	3	0.2	0.1	0.3
SCMT120404-MM	0.96	0.3	3.6	0.18	0.09	0.27
SCMT120408-MM	0.96	0.6	3.6	0.24	0.12	0.36
SCMT120412-MM	0.96	0.72	3.6	0.29	0.14	0.43
TCMT090204-MM	0.6	0.19	2.25	0.11	0.06	0.17
TCMT090208-MM	0.6	0.38	2.25	0.15	0.08	0.23
TCMT110304-MM	0.67	0.21	2.5	0.13	0.06	0.19
TCMT110308-MM	0.67	0.42	2.5	0.17	0.09	0.26
TCMT16T304-MM	0.8	0.25	3	0.15	0.08	0.23
TCMT16T308-MM	0.8	0.5	3	0.2	0.1	0.3
TCMT16T312-MM	0.8	0.6	3	0.24	0.12	0.36
TCMT220408-MM	0.96	0.6	3.6	0.24	0.12	0.36
VBMT160404-MM	0.72	0.23	2.7	0.14	0.07	0.2
VBMT160408-MM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160412-MM	0.72	0.54	2.7	0.22	0.11	0.32
CCMT060204-KM	0.64	0.2	2.4	0.11	0.06	0.17
CCMT060208-KM	0.64	0.4	2.4	0.15	0.08	0.23
CCMT09T304-KM	0.64	0.25	3	0.15	0.08	0.23
CCMT09T308-KM	0.8	0.5	3	0.2	0.1	0.3
CCMT120404-KM	0.96	0.3	3.6	0.18	0.09	0.27
CCMT120408-KM	0.96	0.6	3.6	0.24	0.12	0.36
DCMT070204-KM	0.6	0.19	2.25	0.11	0.06	0.17
DCMT070208-KM	0.6	0.38	2.25	0.15	0.08	0.23
DCMT11T304-KM	0.8	0.25	3	0.15	0.08	0.23
DCMT11T308-KM	0.8	0.5	3	0.2	0.1	0.3
SCMT09T304-KM	0.8	0.25	3	0.15	0.08	0.23
SCMT09T308-KM	0.8	0.5	3	0.2	0.1	0.3
SCMT120408-KM	0.96	0.6	3.6	0.24	0.12	0.36
TCMT090204-KM	0.6	0.19	2.25	0.11	0.06	0.17
TCMT090208-KM	0.6	0.38	2.25	0.15	0.08	0.23
TCMT110304-KM	0.67	0.21	2.5	0.13	0.06	0.19
TCMT110308-KM	0.67	0.42	2.5	0.17	0.09	0.26
TCMT16T304-KM	0.8	0.25	3	0.15	0.08	0.23
TCMT16T308-KM	0.8	0.5	3	0.2	0.1	0.3
TCMT16T312-KM	0.8	0.6	3	0.24	0.12	0.36
TCMT220408-KM	0.96	0.6	3.6	0.24	0.12	0.36
VBMT160404-KM	0.72	0.23	2.7	0.14	0.07	0.2
VBMT160408-KM	0.72	0.45	2.7	0.18	0.09	0.27
VBMT160412-KM	0.72	0.54	2.7	0.22	0.11	0.32
CCET060201-UM	0.3	0.1	4	0.03	0.01	0.06
CCET060201-UM	0.3	0.1	4	0.03	0.01	0.08
CCET060202-UM	0.5	0.2	4	0.03	0.01	0.06
CCET060202-UM	0.5	0.2	4	0.03	0.01	0.08
CCET060204-UM	1	0.5	4	0.03	0.01	0.08
CCET060204-UM	1	0.5	4	0.03	0.01	0.06
DCET070200-UM	0.3	0.1	4	0.03	0.01	0.06
DCET070201-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
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
RCMT0502M0	1	0.5	2	0.112	0.032	0.158
RCMT0602M0	1.5	0.5	2.4	0.15	0.038	0.173
RCMT0803M0	2	0.8	3.2	0.2	0.051	0.253
RCMT10T3M0	2.5	1	4	0.25	0.063	0.316
RCMT1204M0	3	1.2	4.8	0.3	0.076	0.379
RCMT1606M0	3.5	1.6	6.4	0.374	0.101	0.506
RCMT2006M0	4	2	8	0.447	0.126	0.632
RCMT2507M0	5	2.5	10	0.559	0.158	0.791
RCMT3209M0	6	3.2	12.8	0.693	0.202	1.012
CCGX060202-AL	1	0.3	3	0.12	0.05	0.15
CCGX060204-AL	1.5	0.5	3	0.2	0.1	0.3
CCGX09T304-AL	1.5	0.5	5	0.2	0.1	0.3
CCGX09T308-AL	1.5	0.5	5	0.3	0.15	0.6
CCGX120404-AL	1.5	0.5	7	0.2	0.1	0.3
CCGX120408-AL	1.5	0.5	7	0.3	0.15	0.6
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
RCGX0602M0-AL	1	0.6	2.4	0.245	0.126	0.379
RCGX0803M0-AL	1.5	0.8	3.2	0.346	0.158	0.538
RCGX10T3M0-AL	2	1	4	0.358	0.158	0.632
RCGX1204M0-AL	2.5	1.2	4.8	0.455	0.19	0.79
SCGX09T308-AL	1.5	0.5	5	0.3	0.15	0.6
TCGX06T104-AL	1	0.5	2	0.2	0.1	0.3
TCGX090202-AL	1	0.3	4	0.12	0.05	0.15
TCGX090204-AL	1.5	0.5	4	0.2	0.1	0.3
TCGX110202-AL	1	0.3	5	0.12	0.05	0.15
TCGX110204-AL	1.5	0.5	5	0.2	0.1	0.3
TCGX110208-AL	1.5	0.5	5	0.3	0.15	0.6
TCGX110302-AL	1	0.3	5	0.12	0.05	0.15
TCGX110304-AL	1.5	0.5	5	0.2	0.1	0.3
TCGX110308-AL	1.5	0.5	5	0.3	0.15	0.6
TCGX16T304-AL	1.5	0.5	7	0.2	0.1	0.3
TCGX16T308-AL	1.5	0.5	7	0.3	0.15	0.6
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
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
CCMT060208-PR	1.6	0.8	3.2	0.19	0.09	0.26
CCMT09T308-PR	2	1	4	0.25	0.12	0.35
CCMT09T312-PR	2	1.2	4	0.3	0.14	0.42
CCMT120408-PR	2.4	1.2	4.8	0.3	0.14	0.42
CCMT120412-PR	2.4	1.44	4.8	0.36	0.17	0.5
DCMT11T308-PR	2	1	4	0.25	0.12	0.35
DCMT11T312-PR	2	1.2	4	0.3	0.14	0.42

CoroTurn® 107 positive basic-shape inserts

[illegible]

CoroTurn® 111 positive basic-shape inserts

B

Recommended depth of cut and cutting feed, inch

T-Max® P negative basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = inch			f_n = inch/r		
	Min	Max.		Min	Max.	
CNMG321-WF	.02	.012	.059	.006	.002	.01
CNMG322-WF	.039	.012	.079	.012	.004	.02
CNMG431-WF	.016	.01	.118	.006	.002	.01
CNMG432-WF	.039	.01	.157	.012	.004	.02
CNMG433-WF	.059	.016	.157	.02	.008	.024
DNMG331-WF	.039	.008	.059	.008	.003	.012
DNMG332-WF	.039	.008	.118	.012	.004	.016
DNMG431-WF	.031	.008	.118	.008	.003	.012
DNMG432-WF	.059	.008	.118	.012	.004	.016
DNMG433-WF	.059	.016	.138	.016	.006	.022
DNMG441-WF	.031	.008	.118	.008	.003	.012
DNMG442-WF	.059	.008	.118	.012	.004	.016
DNMG443-WF	.059	.016	.138	.016	.006	.022
TNMG331-WF	.039	.008	.118	.008	.003	.012
TNMG332-WF	.059	.008	.118	.012	.004	.016
WNMG331-WF	.016	.01	.079	.006	.002	.01
WNMG332-WF	.039	.01	.118	.012	.004	.02
WNMG431-WF	.016	.01	.118	.006	.002	.01
WNMG432-WF	.039	.01	.157	.012	.004	.02
WNMG433-WF	.059	.016	.157	.02	.008	.024
CNMG321-PF	.016	.01	.059	.006	.003	.012
CNMG322-PF	.016	.012	.059	.006	.004	.012
CNMG431-PF	.016	.01	.059	.006	.003	.012
CNMG432-PF	.016	.012	.059	.008	.004	.016
CNMG433-PF	.031	.014	.059	.01	.006	.02
DNMG331-PF	.016	.01	.059	.006	.003	.012
DNMG332-PF	.016	.012	.059	.008	.004	.016
DNMG333-PF	.031	.014	.059	.01	.006	.02
DNMG431-PF	.016	.01	.059	.006	.003	.012
DNMG432-PF	.016	.012	.059	.008	.004	.016
DNMG433-PF	.031	.014	.059	.01	.006	.02
DNMG441-PF	.016	.01	.059	.006	.003	.012
DNMG442-PF	.016	.012	.059	.008	.004	.016
DNMG443-PF	.031	.014	.059	.01	.006	.02
SNMG432-PF	.016	.012	.059	.008	.004	.016
SNMG433-PF	.031	.014	.059	.01	.006	.02
TNMG331-PF	.016	.01	.059	.006	.003	.012
TNMG332-PF	.016	.012	.059	.008	.004	.016
TNMG333-PF	.031	.014	.059	.01	.006	.02
TNMG432-PF	.016	.012	.059	.008	.004	.016
TNMG433-PF	.031	.014	.059	.01	.006	.02
VNMG331-PF	.016	.01	.059	.006	.003	.012
VNMG332-PF	.016	.012	.059	.008	.004	.016
WNMG331-PF	.016	.01	.059	.006	.003	.012
WNMG332-PF	.016	.012	.059	.008	.004	.016
WNMG333-PF	.031	.016	.059	.01	.006	.02
WNMG431-PF	.016	.01	.059	.006	.003	.012
WNMG432-PF	.016	.012	.059	.008	.004	.016
WNMG433-PF	.031	.016	.059	.01	.006	.02
CNMG431-MF	.016	.004	.059	.006	.002	.012
CNMG432-MF	.016	.004	.059	.008	.004	.016
CNMG433-MF	.031	.008	.098	.01	.006	.02
DNMG331-MF	.016	.004	.059	.006	.002	.012
DNMG332-MF	.016	.004	.059	.008	.004	.016
DNMG431-MF	.016	.004	.059	.006	.002	.012
DNMG432-MF	.016	.004	.059	.008	.004	.016
DNMG433-MF	.031	.008	.098	.01	.006	.02
DNMG441-MF	.016	.004	.059	.006	.002	.012
DNMG442-MF	.016	.004	.059	.008	.004	.016
DNMG443-MF	.031	.008	.098	.01	.006	.02
SNMG431-MF	.016	.004	.059	.008	.004	.016
SNMG432-MF	.016	.004	.059	.008	.004	.016
SNMG433-MF	.031	.008	.098	.01	.006	.02
TNMG331-MF	.016	.004	.059	.006	.002	.012
TNMG332-MF	.016	.004	.059	.008	.004	.016
TNMG333-MF	.031	.008	.098	.01	.006	.02
VNMG331-MF	.016	.004	.059	.006	.002	.012
VNMG332-MF	.031	.008	.098	.006	.003	.012
WNMG331-MF	.016	.004	.059	.006	.002	.012
WNMG332-MF	.016	.004	.059	.008	.004	.016
WNMG431-MF	.016	.004	.059	.006	.002	.012
WNMG432-MF	.016	.004	.059	.008	.004	.016
CNMG431-KF	.02	.006	.079	.006	.003	.01
CNMG432-KF	.02	.006	.079	.008	.004	.012

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = inch			f_n = inch/r		
	Min	Max.		Min	Max.	
CNMG433-KF	.039	.008	.098	.01	.004	.014
DNMG331-KF	.02	.006	.079	.006	.003	.01
DNMG332-KF	.02	.006	.079	.008	.004	.012
DNMG431-KF	.02	.006	.079	.006	.003	.01
DNMG432-KF	.02	.006	.079	.008	.004	.012
DNMG441-KF	.02	.006	.079	.006	.003	.01
DNMG442-KF	.02	.006	.079	.008	.004	.012
DNMG443-KF	.039	.008	.098	.01	.004	.014
TNMG331-KF	.02	.006	.079	.006	.003	.01
TNMG332-KF	.02	.006	.079	.008	.004	.012
WNMG331-KF	.02	.006	.079	.006	.003	.01
WNMG332-KF	.02	.006	.079	.008	.004	.012
WNMG431-KF	.02	.006	.079	.006	.003	.01
WNMG432-KF	.02	.006	.079	.008	.004	.012
WNMG433-KF	.039	.008	.098	.01	.004	.014
CNMG432-WMX	.118	.02	.197	.018	.006	.028
CNMG433-WMX	.138	.031	.236	.02	.008	.03
CNMG542-WMX	.118	.02	.197	.018	.006	.028
CNMG543-WMX	.138	.031	.236	.02	.008	.03
DNMG432-WMX	.118	.02	.197	.018	.006	.028
DNMG433-WMX	.138	.031	.236	.02	.008	.03
DNMG442-WMX	.118	.02	.197	.018	.006	.028
DNMG443-WMX	.138	.031	.236	.02	.008	.03
DNMG444-WMX	.138	.02	.236	.02	.008	.031
TNMG332-WMX	.118	.02	.197	.018	.006	.028
TNMG333-WMX	.138	.031	.236	.02	.008	.03
WNMG332-WMX	.118	.02	.197	.018	.006	.028
WNMG333-WMX	.138	.031	.236	.02	.008	.03
WNMG432-WMX	.118	.02	.197	.018	.006	.028
WNMG433-WMX	.138	.031	.236	.02	.008	.03
CNMG432-WM	.118	.02	.197	.012	.006	.024
CNMG433-WM	.138	.031	.236	.02	.008	.035
CNMG542-WM	.138	.028	.256	.016	.008	.028
CNMG543-WM	.138	.028	.256	.016	.008	.028
DNMG332-WM	.059	.02	.138	.014	.006	.02
DNMG333-WM	.079	.02	.157	.018	.006	.024
DNMG432-WM	.079	.02	.177	.014	.006	.02
DNMG433-WM	.098	.02	.197	.018	.006	.024
DNMG434-WM	.138	.02	.236	.024	.008	.031
DNMG442-WM	.079	.02	.177	.014	.006	.02
DNMG443-WM	.098	.02	.197	.018	.006	.024
DNMG444-WM	.138	.02	.236	.024	.008	.031
TNMG332-WM	.079	.02	.177	.014	.006	.02
TNMG333-WM	.098	.02	.197	.016	.006	.024
WNMG332-WM	.059	.02	.138	.012	.006	.024
WNMG333-WM	.059	.031	.138	.02	.008	.035
WNMG432-WM	.118	.02	.197	.012	.006	.024
WNMG433-WM	.138	.031	.236	.02	.008	.035
CNMG321-PM	.079	.016	.157	.008	.004	.012
CNMG322-PM	.079	.02	.157	.012	.006	.02
CNMG431-PM	.118	.016	.217	.008	.004	.012
CNMG432-PM	.118	.02	.217	.012	.006	.02
CNMG433-PM	.118	.031	.217	.014	.007	.024
CNMG434-PM	.118	.039	.217	.016	.009	.026
CNMG542-PM	.157	.02	.283	.012	.006	.02
CNMG543-PM	.157	.031	.283	.014	.007	.024
CNMG544-PM	.157	.039	.283	.016	.009	.026
CNMG642-PM	.157	.02	.339	.012	.006	.02
CNMG643-PM	.157	.031	.339	.014	.007	.024
CNMG644-PM	.157	.039	.339	.016	.009	.026
DNMG331-PM	.079	.016	.197	.008	.004	.012
DNMG332-PM	.079	.02	.197	.012	.006	.02
DNMG333-PM	.079	.031	.197	.014	.007	.02
DNMG431-PM	.118	.016	.236	.008	.004	.012
DNMG432-PM	.118	.02	.236	.012	.006	.02
DNMG433-PM	.118	.031	.236	.014	.007	.024
DNMG441-PM	.118	.016	.236	.008	.004	.012
DNMG442-PM	.118	.02	.236	.012	.006	.02
DNMG443-PM	.118	.031	.236	.014	.007	.024
DNMG444-PM	.118	.039	.236	.016	.009	.026
SNMG321-PM	.079	.016	.177	.008	.004	.012
SNMG322-PM	.079	.02	.177	.012	.006	.02

T-Max® P negative basic-shape inserts

B

Recommended depth of cut and cutting feed, inch

T-Max® P negative basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = inch			f_n = inch/r		
	Min	Max.		Min	Max.	
DNMG442-PR	.157	.028	.236	.014	.008	.02
DNMG443-PR	.157	.039	.236	.016	.01	.028
DNMG444-PR	.157	.059	.236	.02	.013	.03
SNMG432-PR	.157	.028	.276	.014	.008	.02
SNMG433-PR	.157	.039	.276	.016	.01	.028
SNMG434-PR	.157	.059	.276	.02	.013	.03
SNMG542-PR	.197	.059	.315	.014	.008	.02
SNMG543-PR	.197	.039	.315	.016	.01	.028
SNMG544-PR	.197	.059	.315	.02	.012	.031
SNMG546-PR	.197	.079	.315	.02	.013	.035
SNMG642-PR	.197	.028	.394	.014	.008	.02
SNMG643-PR	.197	.039	.394	.016	.01	.028
SNMG644-PR	.197	.059	.394	.02	.012	.031
SNMG646-PR	.197	.079	.394	.02	.013	.035
SNMG854-PR	.236	.079	.591	.031	.016	.039
SNMG856-PR	.236	.079	.591	.039	.016	.047
SNMG866-PR	.236	.079	.591	.039	.016	.047
TNMG332-PR	.118	.028	.236	.014	.008	.022
TNMG333-PR	.118	.039	.236	.016	.01	.026
TNMG432-PR	.157	.028	.276	.014	.008	.022
TNMG433-PR	.157	.039	.276	.016	.01	.026
TNMG434-PR	.157	.059	.276	.02	.013	.03
TNMG542-PR	.236	.059	.472	.02	.014	.022
TNMG543-PR	.236	.079	.472	.024	.014	.03
TNMG544-PR	.236	.079	.472	.024	.014	.028
TNMG654-PR	.118	.059	.315	.024	.016	.03
TNMG666-PR	.276	.118	.591	.024	.018	.035
WNMG332-PR	.118	.028	.138	.012	.008	.018
WNMG333-PR	.118	.031	.138	.014	.01	.022
WNMG432-PR	.157	.028	.197	.014	.008	.022
WNMG433-PR	.157	.039	.197	.016	.01	.028
WNMG434-PR	.157	.059	.197	.02	.013	.03
CNMG432-MR	.118	.079	.299	.012	.006	.022
CNMG433-MR	.118	.079	.299	.014	.006	.024
CNMG434-MR	.118	.079	.299	.016	.006	.028
CNMG543-MR	.157	.079	.394	.014	.006	.024
CNMG544-MR	.157	.079	.394	.016	.006	.028
CNMG643-MR	.157	.079	.449	.014	.006	.024
CNMG644-MR	.157	.079	.449	.016	.006	.028
CNMG646-MR	.157	.079	.449	.02	.006	.039
DNMG432-MR	.118	.079	.236	.012	.006	.022
DNMG433-MR	.118	.079	.236	.014	.006	.024
DNMG434-MR	.118	.079	.236	.016	.006	.028
DNMG442-MR	.118	.079	.236	.012	.006	.022
DNMG443-MR	.118	.079	.236	.014	.006	.024
DNMG444-MR	.118	.079	.236	.016	.006	.028
SNMG432-MR	.118	.079	.299	.012	.006	.022
SNMG433-MR	.118	.079	.299	.014	.006	.024
SNMG543-MR	.157	.079	.378	.014	.006	.024
SNMG544-MR	.157	.079	.378	.016	.006	.028
SNMG643-MR	.157	.079	.449	.014	.006	.024
SNMG644-MR	.157	.079	.449	.016	.006	.028
SNMG646-MR	.157	.079	.449	.02	.006	.039
TNMG332-MR	.118	.079	.22	.012	.006	.022
TNMG333-MR	.118	.079	.22	.014	.006	.024
TNMG432-MR	.157	.079	.303	.012	.006	.022
TNMG433-MR	.157	.079	.303	.014	.006	.024
TNMG434-MR	.157	.079	.303	.016	.006	.028
WNMG332-MR	.079	.059	.118	.012	.006	.022
WNMG333-MR	.079	.059	.118	.014	.006	.024
WNMG432-MR	.098	.079	.157	.012	.006	.022
WNMG433-MR	.098	.079	.157	.014	.006	.024
CNMM432-MR	.118	.028	.295	.014	.008	.022
CNMM433-MR	.118	.039	.295	.016	.01	.028
CNMM434-MR	.118	.059	.295	.02	.013	.035
CNMM543-MR	.236	.047	.374	.018	.013	.026
CNMM544-MR	.236	.059	.374	.02	.014	.031
CNMM643-MR	.276	.059	.472	.02	.013	.028
CNMM644-MR	.276	.071	.472	.022	.014	.035
CNMM646-MR	.276	.098	.472	.024	.016	.047
CNMM866-MR	.354	.098	.591	.026	.018	.055
CNMM868-MR	.354	.138	.591	.026	.018	.055
DNMM442-MR	.118	.028	.236	.014	.008	.022

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = inch			f_n = inch/r		
	Min	Max.		Min	Max.	
DNMM443-MR	.118	.039	.236	.016	.01	.028
SNMM432-MR	.118	.028	.295	.014	.008	.022
SNMM433-MR	.118	.039	.295	.016	.01	.028
SNMM434-MR	.118	.059	.295	.02	.013	.035
SNMM543-MR	.157	.039	.354	.016	.01	.028
SNMM544-MR	.157	.059	.354	.02	.013	.035
SNMM643-MR	.276	.059	.472	.02	.013	.028
SNMM644-MR	.276	.071	.472	.022	.014	.035
SNMM646-MR	.276	.098	.472	.024	.016	.047
SNMM648-MR	.157	.138	.472	.02	.016	.047
SNMM856-MR	.354	.11	.709	.028	.018	.055
SNMM858-MR	.236	.079	.591	.02	.013	.055
SNMM866-MR	.354	.11	.709	.028	.018	.055
TNMM332-MR	.118	.028	.295	.014	.008	.022
TNMM432-MR	.118	.028	.315	.014	.008	.022
TNMM433-MR	.118	.039	.315	.016	.01	.028
TNMM434-MR	.118	.059	.315	.02	.013	.035
TNMM544-MR	.157	.059	.354	.02	.013	.035
TNMM546-MR	.157	.079	.354	.02	.014	.039
CNMA431-KR	.098	.008	.197	.008	.004	.012
CNMA432-KR	.157	.008	.315	.014	.006	.024
CNMA433-KR	.157	.012	.315	.018	.008	.031
CNMA434-KR	.157	.012	.315	.022	.008	.039
CNMA543-KR	.197	.012	.394	.018	.008	.031
CNMA544-KR	.197	.012	.394	.022	.008	.039
CNMA642-KR	.236	.008	.472	.014	.006	.024
CNMA643-KR	.236	.012	.472	.018	.008	.031
CNMA644-KR	.236	.012	.472	.022	.008	.039
CNMA646-KR	.236	.016	.472	.024	.008	.055
DNMA432-KR	.118	.008	.236	.014	.006	.024
DNMA433-KR	.118	.012	.236	.018	.008	.031
DNMA442-KR	.118	.008	.236	.014	.006	.024
DNMA443-KR	.118	.012	.236	.018	.008	.031
DNMA444-KR	.118	.012	.236	.022	.008	.039
SNMA432-KR	.157	.008	.315	.014	.006	.024
SNMA433-KR	.157	.012	.315	.018	.008	.031
SNMA434-KR	.157	.012	.315	.022	.008	.039
SNMA543-KR	.197	.012	.394	.018	.008	.031
SNMA544-KR	.197	.012	.394	.022	.008	.039
SNMA642-KR	.236	.008	.472	.014	.006	.024
SNMA643-KR	.236	.012	.472	.018	.008	.031
SNMA644-KR	.236	.012	.472	.022	.008	.039
SNMA856-KR	.236	.016	.472	.024	.008	.055
TNMA331-KR	.098	.008	.197	.008	.004	.012
TNMA332-KR	.138	.008	.276	.014	.006	.024
TNMA333-KR	.138	.012	.276	.018	.008	.031
TNMA334-KR	.138	.012	.276	.022	.008	.039
TNMA431-KR	.098	.008	.394	.008	.004	.012
TNMA432-KR	.197	.008	.394	.014	.006	.024
TNMA433-KR	.197	.012	.394	.018	.008	.031
TNMA434-KR	.197	.012	.394	.022	.008	.039
TNMA438-KR	.197	.02	.394	.024	.02	.047
TNMA544-KR	.197	.012	.472	.02	.008	.039
WNMA332-KR	.098	.008	.157	.014	.006	.024
WNMA333-KR	.098	.012	.157	.018	.008	.031
WNMA432-KR	.118	.008	.197	.014	.006	.024
WNMA433-KR	.118	.012	.197	.018	.008	.031
WNMA434-KR	.118	.012	.197	.022	.008	.039
CNMG432-KR	.138	.015	.276	.015	.007	.021
CNMG433-KR	.138	.02	.276	.02	.01	.028
CNMG434-KR	.138	.03	.276	.024	.011	.033
CNMG543-KR	.185	.031	.366	.022	.011	.03
CNMG544-KR	.185	.039	.366	.024	.012	.033
CNMG643-KR	.276	.039	.551	.022	.011	.03
CNMG644-KR	.276	.059	.551	.024	.012	.033
CNMG432-KRR	.157	.008	.315	.014	.006	.024
CNMG433-KRR	.157	.012	.315	.018	.008	.031
CNMG434-KRR	.157	.012	.315	.022	.008	.039
CNMG543-KRR	.197	.012	.394	.018	.008	.031
CNMG544-KRR	.197	.012	.394	.022	.008	.039
DNMG432-KR	.138	.015	.276	.013	.007	.019
DNMG433-KR	.138	.02	.276	.018	.009	.025
DNMG442-KR	.138	.015	.276	.013	.007	.019

T-Max® P negative basic-shape inserts

B

C

G

H

1

J

Recommended depth of cut and cutting feed, inch

CoroTurn® 107 positive basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = inch			f_n = inch/r		
	Min	Max.		Min	Max.	
CCMT2(1.5)0-WF	.012	.004	.059	.004	.001	.006
CCMT2(1.5)1-WF	.031	.012	.079	.005	.002	.012
CCMT2(1.5)2-WF	.031	.012	.079	.006	.004	.014
CCMT3(2.5)0-WF	.012	.004	.059	.004	.001	.006
CCMT3(2.5)1-WF	.039	.012	.118	.008	.003	.012
CCMT3(2.5)2-WF	.039	.012	.118	.01	.005	.02
DCMX2(1.5)0-WF	.012	.004	.059	.004	.001	.006
DCMX2(1.5)1-WF	.028	.012	.079	.005	.002	.01
DCMX2(1.5)2-WF	.028	.012	.079	.006	.004	.014
DCMX3(2.5)0-WF	.012	.004	.059	.004	.001	.006
DCMX3(2.5)1-WF	.039	.012	.118	.008	.003	.012
DCMX3(2.5)2-WF	.039	.012	.118	.01	.005	.016
TCMX1.8(1.5)0-WF	.012	.004	.059	.004	.001	.006
TCMX1.8(1.5)1-WF	.028	.012	.079	.005	.002	.012
TCMX1.8(1.5)2-WF	.028	.012	.079	.01	.004	.014
TCMX220-WF	.012	.004	.059	.004	.001	.006
TCMX221-WF	.039	.012	.098	.008	.003	.012
TCMX222-WF	.039	.012	.098	.01	.005	.016
TCMX3(2.5)1-WF	.047	.012	.138	.008	.003	.014
TCMX3(2.5)2-WF	.047	.012	.138	.01	.005	.02
CCMT2(1.5)0-PF	.012	.002	.067	.002	.001	.004
CCMT2(1.5)1-PF	.012	.004	.067	.003	.002	.007
CCMT3(2.5)0-PF	.014	.003	.079	.003	.002	.006
CCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009
CCMT3(2.5)2-PF	.014	.006	.079	.006	.003	.012
CCMT431-PF	.017	.006	.094	.006	.003	.011
DCMT2(1.5)0-PF	.01	.002	.059	.002	.001	.004
DCMT2(1.5)1-PF	.01	.003	.059	.003	.002	.007
DCMT3(2.5)0-PF	.014	.003	.079	.003	.002	.006
DCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009
DCMT3(2.5)2-PF	.014	.006	.079	.006	.003	.012
SCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009
SCMT3(2.5)2-PF	.014	.006	.079	.006	.003	.012
TCMT1.2(1.2)0-PF	.01	.002	.059	.002	.001	.004
TCMT1.2(1.2)1-PF	.01	.003	.059	.003	.002	.007
TCMT1.2(1.2)2-PF	.01	.004	.059	.004	.002	.009
TCMT1.8(1.5)0-PF	.012	.002	.067	.002	.001	.005
TCMT1.8(1.5)1-PF	.012	.004	.067	.004	.002	.007
TCMT220-PF	.012	.002	.067	.002	.001	.005
TCMT221-PF	.012	.004	.067	.004	.002	.007
TCMT222-PF	.012	.005	.067	.005	.003	.01
TCMT3(2.5)1-PF	.014	.004	.079	.004	.002	.009
VBMT220-PF	.012	.002	.067	.002	.001	.005
VBMT221-PF	.012	.004	.067	.004	.002	.007
VBMT222-PF	.012	.005	.067	.005	.003	.01
VBMT223-PF	.012	.005	.067	.006	.003	.012
VBMT330-PF	.013	.003	.071	.003	.002	.006
VBMT331-PF	.013	.004	.071	.004	.002	.008
VBMT332-PF	.013	.006	.071	.006	.003	.011
VBMT333-PF	.013	.006	.071	.006	.004	.013
CCMT2(1.5)0-MF	.012	.002	.067	.002	.001	.004
CCMT2(1.5)1-MF	.012	.004	.067	.003	.002	.007
CCMT3(2.5)0-MF	.014	.003	.079	.003	.002	.006
CCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009
CCMT3(2.5)2-MF	.014	.006	.079	.006	.003	.012
CCMT431-MF	.017	.006	.094	.006	.003	.011
DCMT2(1.5)0-MF	.01	.002	.059	.002	.001	.004
DCMT2(1.5)1-MF	.01	.003	.059	.003	.002	.007
DCMT3(2.5)0-MF	.014	.003	.079	.003	.002	.006
DCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009
DCMT3(2.5)2-MF	.014	.006	.079	.006	.003	.012
SCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009
SCMT3(2.5)2-MF	.014	.006	.079	.006	.003	.012
TCMT1.2(1.2)0-MF	.01	.002	.059	.002	.001	.004
TCMT1.2(1.2)1-MF	.01	.003	.059	.003	.002	.007
TCMT1.2(1.2)2-MF	.01	.004	.059	.004	.002	.009
TCMT1.8(1.5)0-MF	.012	.002	.067	.002	.001	.005
TCMT1.8(1.5)1-MF	.012	.004	.067	.004	.002	.007
TCMT220-MF	.012	.002	.067	.002	.001	.005
TCMT221-MF	.012	.004	.067	.004	.002	.007
TCMT222-MF	.012	.005	.067	.005	.003	.01
TCMT3(2.5)1-MF	.014	.004	.079	.004	.002	.009
VBMT220-MF	.012	.002	.067	.002	.001	.005

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = inch			f_n = inch/r		
	Min	Max.		Min	Max.	
VBMT221-MF	.012	.004	.067	.004	.002	.007
VBMT222-MF	.012	.005	.067	.005	.003	.01
VBMT330-MF	.013	.003	.071	.003	.002	.006
VBMT331-MF	.013	.004	.071	.004	.002	.008
VBMT332-MF	.013	.006	.071	.006	.003	.011
VBMT333-MF	.013	.006	.071	.006	.004	.013
CCMT2(1.5)0-KF	.012	.002	.067	.002	.001	.01
CCMT2(1.5)1-KF	.012	.004	.067	.003	.002	.006
CCMT3(2.5)0-KF	.014	.003	.079	.003	.002	.006
CCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
CCMT431-KF	.017	.006	.094	.006	.003	.011
DCMT2(1.5)0-KF	.01	.002	.059	.002	.001	.004
DCMT2(1.5)1-KF	.01	.003	.059	.003	.002	.007
DCMT3(2.5)0-KF	.014	.003	.079	.003	.002	.006
DCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
SCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
SCMT3(2.5)2-KF	.014	.006	.079	.006	.003	.012
TCMT1.2(1.2)0-KF	.01	.002	.059	.002	.001	.004
TCMT1.2(1.2)1-KF	.01	.003	.059	.003	.002	.007
TCMT1.2(1.2)2-KF	.01	.004	.059	.004	.002	.009
TCMT1.8(1.5)0-KF	.012	.002	.067	.002	.001	.005
TCMT1.8(1.5)1-KF	.012	.004	.067	.004	.002	.007
TCMT220-KF	.012	.002	.067	.002	.001	.005
TCMT221-KF	.012	.004	.067	.004	.002	.007
TCMT3(2.5)1-KF	.014	.004	.079	.004	.002	.009
VBMT220-KF	.012	.002	.067	.002	.001	.005
VBMT221-KF	.012	.004	.067	.004	.002	.007
VBMT222-KF	.012	.005	.067	.005	.003	.01
VBMT330-KF	.013	.003	.071	.003	.002	.006
VBMT331-KF	.013	.004	.071	.004	.002	.008
VBMT332-KF	.013	.006	.071	.006	.003	.011
TCEX1(1)00L-F	.006	.002	.031	.002	.001	.004
TCEX1(1)00R-F	.006	.002	.031	.002	.001	.004
TCEX1(1)03L-F	.006	.002	.031	.002	.001	.004
TCEX1(1)03R-F	.006	.002	.031	.002	.001	.004
TCEX1.2(1.2)00L-F	.008	.002	.059	.003	.001	.005
TCEX1.2(1.2)00R-F	.008	.002	.059	.003	.001	.005
TCEX1.2(1.2)03L-F	.008	.002	.059	.003	.001	.005
TCEX1.2(1.2)03R-F	.008	.002	.059	.003	.001	.005
TCEX1.2(1.2)0L-F	.008	.002	.02	.003	.001	.005
TCEX1.8(1.5)00L-F	.012	.002	.118	.004	.001	.006
TCEX1.8(1.5)00R-F	.012	.002	.118	.004	.001	.006
TCEX1.8(1.5)03L-F	.012	.002	.118	.004	.001	.006
TCEX1.8(1.5)03R-F	.012	.002	.118	.004	.001	.006
TCEX1.8(1.5)0L-F	.008	.002	.02	.004	.001	.006
TCEX22(00)L-F	.016	.002	.157	.004	.001	.006
TCEX22(00)R-F	.016	.002	.157	.004	.001	.006
TCEX22(03)L-F	.016	.002	.157	.004	.001	.006
TCEX22(03)R-F	.016	.002	.157	.004	.001	.006
TCEX220L-F	.008	.002	.02	.004	.001	.008
VCEX22(00)L-F	.039	.001	.157	.002	0	.008
VCEX22(00)R-F	.039	.001	.157	.002	0	.008
VCEX22(03)L-F	.039	.002	.157	.004	0	.012
VCEX22(03)R-F	.039	.002	.157	.004	0	.012
TCGX1.2(1.2)1L-WK	.02	.006	.039	.006	.001	.01
TCGX1.2(1.2)1R-WK	.02	.006	.039	.006	.001	.01
TCGX1.8(1.5)1L-WK	.02	.006	.047	.008	.002	.011
TCGX1.8(1.5)1R-WK	.02	.006	.047	.008	.002	.011
TCGX2(1.5)1L-WK	.02	.006	.059	.008	.002	.012
TCGX2(1.5)1R-WK	.02	.006	.059	.008	.002	.012
TCGX221L-WK	.02	.006	.059	.008	.002	.012
TCGX221R-WK	.02	.006	.059	.008	.002	.012
CCMT2(1.5)2-WM	.047	.02	.098	.008	.004	.016
CCMT3(2.5)1-WM	.059	.02	.157	.01	.005	.016
CCMT3(2.5)2-WM	.059	.028	.157	.012	.006	.02
CCMT431-WM	.079	.02	.157	.01	.006	.016
CCMT432-WM	.079	.028	.157	.012	.006	.02
DCMX3(2.5)1-WM	.059	.02	.157	.01	.005	.016
DCMX3(2.5)2-WM	.059	.02	.157	.012	.006	.02
TCMX221-WM	.047	.02	.118	.01	.005	.014
TCMX222-WM	.047	.02	.118	.012	.006	.02
TCMX3(2.5)2-WM	.059	.02	.157	.012	.006	.02
CCMT2(1.5)1-PM	.025	.008	.094	.004	.002	.007

Recommended depth of cut and cutting feed, inch

CoroTurn® 107 positive basic-shape inserts

Insert	Rec. depth of cut			Rec. cutting feed		
	a_p = inch			f_n = inch/r		
	Min	Max.		Min	Max.	
CCMT2(1.5)2-PM	.025	.016	.094	.006	.003	.009
CCMT3(2.5)1-PM	.025	.01	.118	.006	.003	.009
CCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
CCMT431-PM	.038	.012	.142	.007	.004	.011
CCMT432-PM	.038	.024	.142	.009	.005	.014
CCMT433-PM	.038	.028	.142	.011	.006	.017
DCMT2(1.5)1-PM	.024	.007	.089	.004	.002	.007
DCMT2(1.5)2-PM	.024	.015	.089	.006	.003	.009
DCMT3(2.5)1-PM	.031	.01	.118	.006	.003	.009
DCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
DCMT3(2.5)3-PM	.031	.024	.118	.009	.005	.014
SCMT3(2.5)1-PM	.031	.01	.118	.006	.003	.009
SCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
SCMT431-PM	.038	.012	.142	.007	.004	.011
SCMT432-PM	.038	.024	.142	.009	.005	.014
SCMT433-PM	.038	.028	.142	.011	.006	.017
TCMT1.8(1.5)1-PM	.024	.007	.089	.004	.002	.007
TCMT1.8(1.5)2-PM	.024	.015	.089	.006	.003	.009
TCMT221-PM	.026	.008	.098	.005	.002	.007
TCMT222-PM	.026	.017	.098	.007	.004	.01
TCMT223-PM	.026	.02	.098	.008	.004	.012
TCMT3(2.5)1-PM	.031	.01	.118	.006	.003	.009
TCMT3(2.5)2-PM	.031	.02	.118	.008	.004	.012
TCMT3(2.5)3-PM	.031	.024	.118	.009	.005	.014
TCMT432-PM	.038	.024	.142	.009	.005	.014
VBMT331-PM	.028	.009	.106	.006	.003	.008
VBMT332-PM	.028	.018	.106	.007	.004	.011
VBMT333-PM	.028	.021	.106	.009	.004	.013
CCMT2(1.5)1-MM	.025	.008	.094	.004	.002	.007
CCMT2(1.5)2-MM	.025	.016	.094	.006	.003	.009
CCMT3(2.5)1-MM	.025	.01	.118	.006	.003	.009
CCMT3(2.5)2-MM	.031	.02	.118	.008	.004	.012
CCMT431-MM	.038	.012	.142	.007	.004	.011
CCMT432-MM	.038	.024	.142	.009	.005	.014
CCMT433-MM	.038	.028	.142	.011	.006	.017
DCMT2(1.5)1-MM	.024	.007	.089	.004	.002	.007
DCMT2(1.5)2-MM	.024	.015	.089	.006	.003	.009
DCMT3(2.5)1-MM	.031	.01	.118	.006	.003	.009
DCMT3(2.5)2-MM	.031	.02	.118	.008	.004	.012
DCMT3(2.5)3-MM	.031	.024	.118	.009	.005	.014
SCMT3(2.5)1-MM	.031	.01	.118	.006	.003	.009
SCMT3(2.5)2-MM	.031	.02	.118	.008	.004	.012
SCMT431-MM	.038	.012	.142	.007	.004	.011
SCMT432-MM	.038	.024	.142	.009	.005	.014
SCMT433-MM	.038	.028	.142	.011	.006	.017
TCMT1.8(1.5)1-MM	.024	.007	.089	.004	.002	.007
TCMT1.8(1.5)2-MM	.024	.015	.089	.006	.003	.009
TCMT221-MM	.026	.008	.098	.005	.002	.007
TCMT222-MM	.026	.017	.098	.007	.004	.01
TCMT3(2.5)1-MM	.031	.01	.118	.006	.003	.009
TCMT3(2.5)2-MM	.031	.02	.118	.008	.004	.012
TCMT3(2.5)3-MM	.031	.024	.118	.009	.005	.014
TCMT432-MM	.038	.024	.142	.009	.005	.014
VBMT331-MM	.028	.009	.106	.006	.003	.008
VBMT332-MM	.028	.018	.106	.007	.004	.011
VBMT333-MM	.028	.021	.106	.009	.004	.013
CCMT2(1.5)1-KM	.025	.008	.094	.004	.002	.007
CCMT2(1.5)2-KM	.025	.016	.094	.006	.003	.009
CCMT3(2.5)1-KM	.025	.01	.118	.006	.003	.009
CCMT3(2.5)2-KM	.031	.02	.118	.008	.004	.012
CCMT431-KM	.038	.012	.142	.007	.004	.011
CCMT432-KM	.038	.024	.142	.009	.005	.014
DCMT2(1.5)1-KM	.024	.007	.089	.004	.002	.007
DCMT2(1.5)2-KM	.024	.015	.089	.006	.003	.009
DCMT3(2.5)1-KM	.031	.01	.118	.006	.003	.009
DCMT3(2.5)2-KM	.031	.02	.118	.008	.004	.012
SCMT3(2.5)1-KM	.031	.01	.118	.006	.003	.009
SCMT3(2.5)2-KM	.031	.02	.118	.008	.004	.012
SCMT432-KM	.038	.024	.142	.009	.005	.014
TCMT1.8(1.5)1-KM	.024	.007	.089	.004	.002	.007
TCMT1.8(1.5)2-KM	.024	.015	.089	.006	.003	.009
TCMT221-KM	.026	.008	.098	.005	.002	.007
TCMT222-KM	.026	.017	.098	.007	.004	.01
TCMT3(2.5)1-KM	.031	.01	.118	.006	.003	.009
TCMT3(2.5)2-KM	.031	.02	.118	.008	.004	.012
TCMT3(2.5)3-KM	.031	.024	.118	.009	.005	.014
TCMT432-KM	.038	.024	.142	.009	.005	.014
VBMT331-KM	.028	.009	.106	.006	.003	.008
VBMT332-KM	.028	.018	.106	.007	.004	.011
VBMT333-KM	.028	.021	.106	.009	.004	.013
CCET2(1.5)03-UM	.012	.004	.157	.001	0	.002
CCET2(1.5)03-UM	.012	.004	.157	.001	0	.003
CCET2(1.5)0-UM	.02	.008	.157	.001	0	.002
CCET2(1.5)0-UM	.02	.008	.157	.001	0	.003
CCET2(1.5)1-UM	.039	.02	.157	.001	0	.002
CCET2(1.5)1-UM	.039	.02	.157	.001	0	.003
DCET2(1.5)00-UM	.012	.004	.157	.001	0	.002
DCET2(1.5)03-UM	.012	.004	.157	.001	0	.002
DCET2(1.5)03-UM	.02	.004	.157	.001	0	.002
DCET3(2.5)0-UM	.012	.008	.157	.001	0	.002
DCET3(2.5)1-UM	.049	.02	.157	.002	.001	.004
VCET22(03)-UM	.012	.004	.157	.001	0	.002
VCET220-UM	.02	.008	.157	.001	.001	.003
CCGX2(1.5)0-AL	.039	.012	.118	.005	.002	.006
CCGX2(1.5)1-AL	.059	.02	.118	.008	.004	.012
CCGX3(2.5)1-AL	.059	.02	.197	.008	.004	.012
CCGX3(2.5)2-AL	.059	.02	.197	.012	.006	.024
CCGX431-AL	.059	.02	.276	.008	.004	.012
CCGX432-AL	.059	.02	.276	.012	.006	.024
DCGX2(1.5)0-AL	.039	.012	.157	.005	.002	.006
DCGX2(1.5)1-AL	.059	.02	.157	.008	.004	.012
DCGX3(2.5)0-AL	.039	.012	.217	.005	.002	.006
DCGX3(2.5)1-AL	.059	.02	.217	.008	.004	.012
DCGX3(2.5)2-AL	.059	.02	.217	.012	.006	.024
SCGX3(2.5)2-AL	.059	.02	.197	.012	.006	.024
TCGX1.2(1.2)1-AL	.039	.02	.079	.008	.004	.012
TCGX1.8(1.5)0-AL	.039	.012	.157	.005	.002	.006
TCGX1.8(1.5)1-AL	.059	.02	.157	.008	.004	.012
TCGX2(1.5)0-AL	.039	.012	.197	.005	.002	.006
TCGX2(1.5)1-AL	.059	.02	.197	.008	.004	.012
TCGX2(1.5)2-AL	.059	.02	.197	.012	.006	.024
TCGX220-AL	.039	.012	.197	.005	.002	.006
TCGX221-AL	.059	.02	.197	.008	.004	.012
TCGX222-AL	.059	.02	.197	.012	.006	.024
TCGX3(2.5)1-AL	.059	.02	.276	.008	.004	.012
TCGX3(2.5)2-AL	.059	.02	.276	.012	.006	.024
VCGX2(1.5)0-AL	.039	.012	.118	.005	.002	.006
VCGX2(1.5)1-AL	.059	.02	.118	.008	.004	.012
VCGX220-AL	.039	.012	.118	.005	.002	.006
VCGX221-AL	.059	.02	.118	.008	.004	.012
VCGX331-AL	.059	.02	.197	.008	.004	.012
VCGX332-AL	.059	.02	.197	.012	.006	.024
VCGX333-AL	.059	.02	.197	.016	.006	.031
CCMT2(1.5)2-PR	.063	.031	.126	.007	.004	.01
CCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
CCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
CCMT432-PR	.094	.047	.189	.012	.006	.017
CCMT433-PR	.094	.057	.189	.014	.007	.02
DCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
DCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
SCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
SCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
SCMT432-PR	.094	.047	.189	.012	.006	.017
SCMT433-PR	.094	.057	.189	.014	.007	.02
TCMT222-PR	.059	.03	.118	.008	.004	.012
TCMT223-PR	.059	.035	.118	.01	.005	.014
TCMT3(2.5)2-PR	.079	.039	.157	.01	.005	.014
TCMT3(2.5)3-PR	.079	.047	.157	.012	.006	.017
TCMT432-PR	.094	.047	.189	.012	.006	.017
TCMT433-PR	.094	.057	.189	.014	.007	.02
VBMT332-PR	.071	.035	.142	.009	.004	.013
VBMT333-PR	.071	.043	.142	.011	.005	.015
CCMT2(1.5)2-MR	.063	.031	.126	.007	.004	.01
CCMT3(2.5)2-MR	.079	.039	.157	.01	.005	.014
CCMT3(2.5)3-MR	.079	.047	.157	.012	.006	.017

CoroTurn® 107 positive basic-shape inserts

[illegible]

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			
					CT5005	CT5015	GC1525	GC15
					$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$
					0.05-0.1-0.2	0.05-0.1-0.2	0.05-0.1-0.2	0.1-0.2-0.3
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	730-590-485	650-540-440	560-465-380	300-250-215
P1.2.Z.AN	01.2	C = 0.25–0.55%	1600	150	650-530-420	570-480-385	495-415-335	275-225-195
P1.3.Z.AN	01.3	C = 0.55–0.80%	1700	170	-	510-425-340	430-365-295	260-215-185
P2.1.Z.AN	02.1	Low-alloy steel (alloying elements ≤5%) Non-hardened	1700	180	530-450-360	480-400-320	375-320-255	220-175-150
P2.1.Z.AN	02.12	Ball bearing steel	1800	210	-	-	-	190-155-135
P2.5.Z.HT	02.2	Hardened and tempered	1850	275	395-325-250	285-235-190	200-165-135	140-115-100
P2.5.Z.HT	02.2	Hardened and tempered	2050	350	320-260-200	230-190-150	160-135-110	110-95-80
P3.0.Z.AN	03.11	High-alloy steel (alloying elements >5%) Annealed	1950	200	-	395-330-250	260-215-175	-
P3.0.Z.HT	03.21	Hardened tool steel	3000	325	-	195-165-130	145-115-90	-
P1.5.C.UT	06.1	Steel castings Unalloyed	1550	180	-	260-215-175	225-185-145	-
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	-	270-225-170	175-145-105	-
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2050	225	-	200-165-125	140-115-85	-
ISO M	CMC No.	Stainless steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE			
					GC1525	GC1105	GC1115	GC15
					$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$
					0.1-0.2	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
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	290-240	380-305-245	335-255-200	250-190-150
P5.0.Z.PH	05.12	PH-hardened	2850	330	170-150	350-280-225	185-150-120	145-115-95
P5.0.Z.HT	05.13	Hardened	2350	330	170-150	245-195-160	200-160-140	145-120-105
M1.0.Z.AQ	05.21	Austenitic Bars/forged Austenitic	1800	180	220-195	410-330-265	265-215-165	205-165-130
M1.0.Z.PH	05.22	PH-hardened	2850	330	195-170	220-175-145	185-150-120	145-115-90
M2.0.Z.AQ	05.23	Super austenitic	2250	200	145-130	245-200-160	220-190-155	170-145-120
M3.1.Z.AQ	05.51	Austenitic-ferritic (Duplex) Bars/forged Non-weldable ≥ 0.05%C	2000	230	-	315-255-205	250-205-155	195-160-120
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	-	280-225-185	230-170-130	175-130-100
P5.0.C.UT	15.11	Ferritic/martensitic Cast Non-hardened	1700	200	-	320-265-205	320-265-205	240-200-155
P5.0.C.UT	15.12	PH-hardened	2450	330	-	160-130-95	160-130-95	135-110-80
P5.0.C.HT	15.13	Hardened	2150	330	-	175-145-110	175-145-110	140-115-85
M1.0.C.UT	15.21	Austenitic Cast Austenitic	1700	180	-	280-225-170	280-225-170	215-175-135
M1.0.C.UT	15.22	PH-hardened	2450	330	-	160-130-95	160-130-95	135-110-80
M2.0.C.AQ	15.23	Super austenitic	2150	200	-	210-180-150	210-180-150	160-135-115
M3.1.C.AQ	15.51	Austenitic-ferritic (Duplex) Cast Non-weldable ≥ 0.05%C	1800	230	-	230-170-120	230-170-120	185-135-95
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	-	205-155-110	205-155-110	170-130-90
ISO K	CMC No.		Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE			
					CB50	CB7525	CB7925	CC620
					$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$	$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$
					0.1-0.25-0.4	0.1-0.25-0.4	0.1-0.25-0.4	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	-	-	-	800-700-600
K1.1.C.NS	07.2	Pearlitic (long chipping)	900	230	-	-	-	700-590-500
K2.1.C.UT	08.1	Grey cast iron Low tensile strength	890	180	1700-1450-	1700-1450-1200	1450-1200-1050	800-700-600
K2.2.C.UT	08.2	High tensile strength	970	220	1450-1250-	1450-1250-1050	1250-1050-890	760-650-540
K3.1.C.UT	09.1	Nodular SG iron Ferritic	900	160	-	-	-	-
K3.3.C.UT	09.2	Pearlitic	1350	250	-	-	-	-
K3.4.C.UT	09.3	Martensitic	2100	380	-	-	-	-

Cutting speed recommendations, metric values

TOUGHNESS >>>>										
GC1515	GC1125	GC3005	GC4205	GC4215	GC4225	GC2015	GC4235	GC30	GC2025	
0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.3-0.5	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.1-0.4-0.8	0.15-0.25-0.4	0.1-0.4-0.8	
310-290-255 280-255-245 285-260-230	310-290-255 280-255-225 260-235-210	520-415-340 470-370-305 445-355-290	620-450-330 560-405-295 530-385-275	570-405-300 510-365-265 460-330-240	510-345-245 455-305-215 425-290-205	440-300-210 400-270-190 370-250-175	425-275-200 380-245-180 365-235-170	305-260-215 275-235-195 260-220-185	295-200-145 265-180-130 250-170-120	
295-200-125 - 195-100-40 160-80-34	- - - -	500-375-300 - 275-215-175 225-170-140	610-410-285 530-350-250 330-230-175 265-185-140	560-370-260 460-305-215 300-210-155 240-170-125	460-305-215 395-265-190 255-180-140 205-145-110	395-265-190 350-230-160 260-180-140 210-145-115	300-185-135 250-155-110 185-120-85 150-95-70	215-180-150 190-160-130 135-115-95 110-95-80	220-145-100 195-125-85 145-95-65 115-75-50	
	- -	370-275-225 180-130-105	445-295-215 220-140-105	405-270-200 200-130-95	300-205-150 135-95-75	260-180-130 115-85-65	240-155-105 110-70-50		185-125-85 85-55-38	
	- - -	275-220-185 270-200-170 205-155-130	335-235-185 290-205-155 225-150-115	300-215-170 260-185-140 205-135-105	240-180-130 210-140-100 185-125-90	210-155-110 180-120-85 160-110-75	185-140-100 165-100-70 145-95-65		140-105-80 125-80-55 110-75-50	
TOUGHNESS >>>>										
GC1515	GC1125	GC2015	GC30	GC2025	GC2035	GC235				
0.1-0.2-0.3	0.1-0.2-0.3	0.2-0.4-0.6	0.15-0.25-0.4	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6				
305-235-185 170-135-110 180-150-130	280-215-170 155-125-100 165-135-120	260-220-200 125-100-80 145-120-85	220-200-175 85-75-60 95-90-70	230-175-135 110-70-50 120-80-55	180-160-130 85-65-45 95-70-50	130-110-90 70-55-45 75-60-50				
245-195-150 170-135-110 205-175-145	220-180-135 155-125-100 185-160-130	290-240-190 130-100-80 160-135-100	190-175-145 100-85-70 130-120-95	240-175-130 100-70-55 130-100-75	170-145-115 85-65-45 100-90-70	115-100-85 70-55-45 85-70-60				
230-185-145 210-155-120	210-170-130 190-140-110	220-185-145 190-150-120	175-160-130 125-115-105	190-150-110 150-120-90	160-135-105 130-110-85	105-95-80 95-80-70				
290-240-185 150-120-90 160-130-100	265-220-170 135-110-80 145-120-90	250-210-170 100-70-55 110-90-60	200-170-150 80-65-50 90-75-60	220-160-120 85-55-40 120-80-55	170-145-115 70-50-40 75-60-50	115-100-85 60-45-35 65-50-40				
255-205-160 150-120-90 195-165-135	230-185-145 135-110-80 175-150-125	220-180-140 105-80-60 145-115-95	155-135-115 80-65-50 120-100-85	200-155-115 85-55-40 130-90-65	150-120-95 70-50-40 100-80-60	100-90-75 65-45-33 80-65-55				
210-155-110 185-145-100	190-140-100 170-130-90	185-150-135 160-140-105	165-145-115 115-100-95	150-120-90 125-105-80	130-110-85 105-95-75	95-80-70 90-75-65				
TOUGHNESS >>>>										
CC650	CC6190	CC1690	CT5015	GC3205	GC3210	GC3215	GC3005	GC4215	GC30	H13A
0.1-0.25-0.4	0.2-0.4-0.6	0.2-0.4-0.6	0.1-0.2-0.3	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.2-0.4-0.6	0.1-0.3-0.5
800-700-600 700-600-500	810-660-550 700-550-440	740-600-500 640-500-400	200-165-135 140-115-95	460-380-325 375-310-265	385-315-265 315-255-215	260-215-185 210-175-150	250-210-185 235-190-150	325-265-225 265-220-185	165-165-150 120-110-90	140-125-110 125-110-90
800-700-600 760-650-540	890-720-600 790-620-500	740-600-500 690-540-435	320-260-220 280-235-205	530-435-375 425-350-300	445-360-305 355-290-245	300-250-210 240-200-170	275-245-225 260-225-200	370-305-260 285-245-220	230-200-160 175-150-120	180-145-110 140-115-95
610-550-450 510-450-350 350-305-260	- - -	580-450-345 480-350-250 325-260-220	255-200-160 230-195-170 115-95-85	390-330-275 350-300-250 265-225-190	360-305-250 325-275-225 245-210-170	240-195-165 215-175-150 165-135-115	265-215-180 240-195-160 185-140-110	280-230-195 260-210-175 205-160-125	170-145-120 120-105-90 65-50-37	135-125-95 125-115-90 100-85-65

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Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO N	CMC No.	Non-ferrous metals	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CD10	CD1810	H10
					$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$		
					0.05-0.4	0.15-0.8	0.15-0.8
MC No.	CMC No.	Material	N/mm ²	HB	Cutting speed (v_c), m/min		
N1.2.Z.UT	30.11	Aluminium alloys Wrought or wrought and coldworked, non-aging	400	60	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.2.Z.AG	30.12	Wrought or wrought and aged	650	100	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.3.C.UT	30.21	Aluminium alloys Cast, non-aging	600	75	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.3.C.AG	30.22	Cast or cast and aged	700	90	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾	2 000 (2500-250) ¹⁾
N1.4.C.NS	30.41	Aluminium alloys Cast, 13-15% Si	700	130	1 550 (1950-195) ¹⁾	770 (960-95) ¹⁾	450 (560-55) ¹⁾
	30.42	Cast, 16-22% Si	700	130	770 (960-95) ¹⁾	510 (640-65) ¹⁾	300 (375-38) ¹⁾
N3.3.U.UT	33.1	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb	550	110	500 (630-65) ¹⁾	500 (630-65) ¹⁾	500 (630-65) ¹⁾
N3.2.C.UT	33.2	Brass, leaded bronzes, $\leq 1\%$ Pb	550	90	500 (630-65) ¹⁾	500 (630-65) ¹⁾	500 (630-65) ¹⁾
N3.1.U.UT	33.3	Bronze and non-leadad copper incl. electrolytic copper	1350	100	300 (375-38) ¹⁾	300 (375-38) ¹⁾	300 (375-38) ¹⁾
ISO S	CMC No.	Heat resistant material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CC650	CC6060	CC6065
					$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$		
					0.1 - 0.2	0.1-0.2-0.3	0.1-0.2-0.3
MC No.	CMC No.	Material	N/mm ²	HB	Cutting speed (v_c), m/min		
S1.0.U.AN	20.11	Heat resistant super alloys Iron base Annealed or solution treated	2400	200	-	-	-
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	-	-	-
S2.0.Z.AN	20.21	Nickel base Annealed or solution treated	2650	250	400-320	400-325-270	330-255-200
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	340-265	300-235-190	240-175-130
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	220-160	240-205-175	215-180-150
S3.0.Z.AN	20.31	Cobalt base Annealed or solution treated	2700	200	345-260	-	-
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	300-225	-	-
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	285-225	-	-
S4.1.Z.UT	23.1	Titanium alloys²⁾ Commercial pure (99.5% Ti)	1300	Rm ³⁾ 400	H10 0.1-0.2-0.3	GC1105 0.1-0.2-0.3	H10A 0.1-0.3-0.5
S4.2.Z.AN	23.21	α , near α and $\alpha + \beta$ alloys, annealed	1400	950	205-170-145	205-170-145	195-160-135
S4.3.Z.AG	23.22	$\alpha + \beta$ alloys in aged conditions, β alloys, annealed or aged	1400	1050	85-70-55	85-70-55	80-65-55
					80-60-50	80-60-50	80-60-50
ISO H	CMC No.	Hardened material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CB7015	CB7025	CB20
					$h_{ex}, \text{mm} \approx \text{feed } f_n, \text{mm/r}$		
					0.05-0.15-0.25	0.05-0.15-0.25	0.05-0.15-0.25
MC No.	CMC No.	Material	N/mm ²	HB	Cutting speed (v_c), m/min		
H1.1.Z.HA	04.1	Hard steel Hardened and tempered	2500	45HRC	-	-	-
H1.1.Z.HA	04.1		3050	50HRC	350-265-225	250-210-185	260-230-205
H1.2.Z.HA	04.1		3650	55HRC	295-225-185	210-175-155	215-195-170
H1.3.Z.HA	04.1	Extra hard steel Hardened and tempered	4300	60HRC	250-190-160	180-150-135	185-165-145
H1.4.Z.HA	04.1		5000	65HRC	215-165-135	155-130-115	160-140-125
H2.0.C.UT	10.1	Chilled cast iron Cast or cast and aged	2250	400	-	-	-

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

TOUGHNESS >>>>									
H13A	GC1115	GC15	GC1025	GC1125					
0.15-0.8	0.15-0.8	0.15-0.8	0.15-0.8	0.15-0.8					
1 900 (2400-240) ¹⁾	810 (1000-100) ¹⁾	810 (1000-100)1)	770 (960-95) ¹⁾	770 (960-95) ¹⁾					
1 900 (2400-240) ¹⁾	315 (395-39) ¹⁾	315 (395-39)1)	300 (375-38) ¹⁾	300 (375-38) ¹⁾					
1 900 (2400-240) ¹⁾	810 (1000-100) ¹⁾	810 (1000-100)1)	770 (960-95) ¹⁾	770 (960-95) ¹⁾					
1 900 (2400-240) ¹⁾	540 (680-70) ¹⁾	540 (680-70)1)	510 (640-65) ¹⁾	510 (640-65) ¹⁾					
400 (500-50) ¹⁾	315 (395-39) ¹⁾	315 (395-39)1)	300 (375-38) ¹⁾	300 (375-38) ¹⁾					
250 (315-31) ¹⁾	220 (275-28) ¹⁾	220 (275-28)1)	210 (265-26) ¹⁾	210 (265-26) ¹⁾					
450 (560-55) ¹⁾	210 (265-26) ¹⁾	210 (265-26)1)	200 (250-25) ¹⁾	200 (250-25) ¹⁾					
450 (560-55) ¹⁾	125 (155-16) ¹⁾	125 (155-16)1)	120 (150-15) ¹⁾	120 (150-15) ¹⁾					
270 (340-34) ¹⁾	90 (115-11) ¹⁾	90 (115-11)1)	85 (105-11) ¹⁾	85 (105-11) ¹⁾					
TOUGHNESS >>>>									
CC670	S05F	GC1105	GC1115	GC15	GC1005	H10A	H13A	GC1125	H10F
0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.2-0.5	0.1-0.3-0.5
-	160-135-110	150-100-70	120-80-55	120-80-55	150-100-70	85-70-55	80-65-50	75-60-45	70-55-40
-	125-105-85	120-80-60	95-65-50	95-65-50	120-80-60	65-55-40	60-50-40	55-45-35	50-40-30
385-315-270	100-85-70	90-55-30	70-45-24	70-45-24	90-55-30	55-40-32	50-40-30	45-35-25	40-30-20
325-270-230	90-75-60	80-50-27	65-40-22	65-40-22	80-50-27	40-32-21	40-30-20	35-25-15	30-20-10
295-245-210	80-65-55	70-45-24	60-37-19	60-37-19	70-45-24	26-21-16	25-20-15	23-17-12	20-15-10
345-255-205	100-85-70	90-60-30	70-45-24	70-45-24	90-60-30	55-40-32	50-40-30	45-35-25	40-30-20
300-225-175	90-75-60	80-50-27	65-40-21	65-40-21	80-50-27	40-32-21	40-30-20	35-25-15	30-20-10
285-225-170	80-65-55	70-45-24	60-37-19	60-37-19	70-45-24	26-21-16	25-20-15	23-17-12	20-15-10
H13A	H10F	GC1115	GC15						
0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5	0.1-0.3-0.5						
180-150-125	160-135-115	185-155-130	185-155-130						
75-60-50	65-55-45	80-65-50	80-65-50						
70-55-45	65-50-40	75-55-45	75-55-45						
TOUGHNESS >>>>									
CB7525	CB7925	CC6050	CC670	GC4205	GC4215	H13A			
0.1-0.25-0.4	0.1-0.25-0.4	0.05-0.15-0.25	0.1-0.25-0.4	0.1-0.3-0.6	0.1-0.3-0.6	0.1-0.3-0.6			
-	-	290-235-175	205-170-135	70-45-29	65-40-26	45-25-16			
205-165-135	-	240-195-145	165-140-110	-	-	-			
175-140-110	-	200-165-120	140-115-95	-	-	-			
145-120-95	-	170-140-105	120-100-80	-	-	-			
125-100-80	-	145-120-90	105-85-70	-	-	-			
180-150-120	180-150-120	-	120-90-60	50-29-17	45-26-15	35-20-11			

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				
					CT5005	CT5015	GC1525	GC15	GC1515
					h_{ex} , inch \approx feed, f_n inch/rev. at 0° to -5° lead				
					.002-.004-.008	.002-.004-.008	.002-.004-.008	.004-.008-.012	.004-.008-.012
MC No.	CMC No.	Material	lbs/in ²	HB	Cutting speed v_c , ft/min				
P1.1.Z.AN	01.1	Unalloyed steel C = 0.1–0.25%	216,500	125	2400-1950-1600	2150-1800-1450	1850-1500-1250	990-820-710	1000-950-830
P1.2.Z.AN	01.2	C = 0.25–0.55%	233,000	150	2150-1750-1350	1900-1550-1250	1600-1350-1100	890-740-640	1000-910-810
P1.3.Z.AN	01.3	C = 0.55–0.80%	247,000	170	-	1650-1400-1100	1400-1200-960	850-700-610	940-850-750
P2.1.Z.AN	02.1	Low-alloy steel (alloying elements $\leq 5\%$) Non-hardened	249,500	180	1750-1450-1150	1550-1300-1050	1250-1050-830	710-570-490	960-650-405
P2.1.Z.AN	02.12	Ball bearing steel	259,500	210	-	-	-	630-510-440	-
P2.5.Z.HT	02.2	Hardened and tempered	268,000	275	1300-1050-810	920-770-610	650-540-435	455-375-325	640-320-130
P2.5.Z.HT	02.2	Hardened and tempered	298,000	350	1050-850-650	740-620-495	520-435-350	365-305-265	520-255-105
P3.0.Z.AN	03.11	High-alloy steel (alloying elements $> 5\%$) Annealed	282,000	200	-	1300-1050-820	840-710-570	-	-
P3.0.Z.HT	03.21	Hardened tool steel	435,500	325	-	640-530-420	465-370-290	-	-
P1.5.C.UT	06.1	Steel castings Unalloyed	225,000	180	-	850-700-570	740-600-470	-	-
P2.6.C.UT	06.2	Low-alloy (alloying elements $\leq 5\%$)	230,500	200	-	880-730-550	580-470-345	-	-
P3.0.C.UT	06.3	High-alloy (alloying elements $> 5\%$)	300,500	225	-	660-550-410	460-365-280	-	-
ISO M	CMC No.	Stainless steel	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE				
					GC1525	GC1105	GC1115	GC15	GC1515
					h_{ex} , inch \approx feed, f_n inch/rev. at 0° to -5° lead				
					.004-.008	.004-.008-.012	.004-.008-.012	.004-.008-.012	.004-.008-.012
MC No.	CMC 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	950-790	1250-990-800	1100-840-650	820-620-485	1000-770-600
P5.0.Z.PH	05.12	PH-hardened	411,500	330	560-490	1150-910-740	610-490-390	470-380-300	560-445-355
P5.0.Z.HT	05.13	Hardened	340,000	330	560-490	790-630-510	650-530-460	475-385-340	590-485-425
M1.0.Z.AQ	05.21	Austenitic Bars/forged Austenitic	259,000	180	720-640	1350-1050-870	870-700-530	680-540-415	800-640-490
M1.0.Z.PH	05.22	PH-hardened	414,000	330	630-560	720-580-470	610-490-390	470-375-385	560-445-355
M2.0.Z.AQ	05.23	Super austenitic	328,000	200	485-430	810-640-520	730-630-510	550-475-385	670-570-465
M3.1.Z.AQ	05.51	Austenitic-ferritic (Duplex) Bars/forged Non-weldable $\geq 0.05\%C$	286,500	230	-	1050-820-670	830-660-510	640-510-390	760-610-465
M3.2.Z.AQ	05.52	Weldable $< 0.05\%C$	356,500	260	-	920-740-600	740-550-430	570-415-325	680-500-390
P5.0.C.UT	15.11	Ferritic/martensitic Cast Non-hardened	246,500	200	-	-	1050-860-660	790-650-500	960-790-610
P5.0.C.UT	15.12	PH-hardened	354,500	330	-	-	530-430-310	440-355-255	490-395-285
P5.0.C.HT	15.13	Hardened	311,000	330	-	-	570-470-350	460-380-280	520-430-320
M1.0.C.UT	15.21	Austenitic Cast Austenitic	248,000	180	-	-	910-730-560	710-570-435	830-670-510
M1.0.C.UT	15.22	PH-hardened	356,000	330	-	-	530-430-310	440-355-255	485-395-285
M2.0.C.AQ	15.23	Super austenitic	310,500	200	-	-	690-590-490	520-440-365	630-540-445
M3.1.C.AQ	15.51	Austenitic-ferritic (Duplex) Cast Non-weldable $\geq 0.05\%C$	258,000	230	-	-	750-550-390	600-440-315	680-500-355
M3.2.C.AQ	15.52	Weldable $< 0.05\%C$	326,000	260	-	-	670-510-350	550-420-290	610-465-320
ISO K	CMC No.	Cast iron	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE				
					CB50	CB7525	CB7925	CC620	CC650
					h_{ex} , inch \approx feed, f_n inch/rev. at 0° to -5° lead				
					.004-.010-.016	.004-.010-.016	.004-.010-.016	.004-.010-.016	.004-.010-.016
MC No.	CMC No.	Material	lbs/in ²	HB	Cutting speed v_c , ft/min				
K1.1.C.NS	07.1	Malleable cast iron Ferritic (short chipping)	115,000	130	-	-	-	2600-2300-1950	2600-2300-1950
K1.1.C.NS	07.2	Pearlitic (long chipping)	131,000	230	-	-	-	2300-1950-1650	2300-1950-1600
K2.1.C.UT	08.1	Grey cast iron Low tensile strength	130,000	180	5600-4650-3950	5600-4650-3950	4750-3950-3400	2650-2300-1950	2650-2300-1950
K2.2.C.UT	08.2	High tensile strength	140,500	220	4800-4000-3450	4800-4000-3450	4100-3400-2900	2500-2100-1750	2500-2100-1750
K3.1.C.UT	09.1	Nodular SG iron Ferritic	130,000	160	-	-	-	-	2000-1800-1450
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 >>>>									
GC1125	GC3005	GC4205	GC4215	GC4225	GC2015	GC4235	GC30	GC2025	
.004-.008-.012	.004-.012-.020	.004-.016-.031	.004-.016-.031	.004-.016-.031	.004-.016-.031	.004-.016-.031	.006-.010-.016	.004-.016-.031	
1000-950-830 920-830-730 850-770-690	1700-1350-1100 1550-1200-1000 1450-1150-950	2050-1450-1100 1850-1300-970 1750-1250-920	1850-1350-990 1650-1200-880 1500-1100-790	1650-1150-810 1500-990-710 1400-940-680	1450-980-700 1300-880-630 1200-810-580	1400-890-660 1250-800-590 1200-760-560	990-840-710 890-760-640 850-720-610	970-650-480 870-590-430 820-550-395	
-	1650-1250-980	2000-1350-940	1800-1200-860	1500-1000-710	1300-860-630	980-600-445	700-580-485	720-470-330	
-	-	1750-1150-820	1500-990-710	1300-870-620	1150-750-530	820-500-365	620-520-430	640-405-280	
-	910-700-580	1050-750-570	980-680-510	830-590-455	850-590-460	600-385-280	450-380-315	475-310-215	
-	730-560-465	870-610-460	790-550-415	670-475-365	690-475-375	485-310-225	360-310-255	380-250-175	
-	1200-900-740	1450-970-720	1350-880-650	980-670-500	850-590-430	780-500-345	-	610-405-280	
-	590-425-350	710-460-345	650-415-315	445-310-240	375-275-215	360-225-165	-	280-180-125	
-	910-710-610	1100-770-610	990-700-550	790-580-430	690-510-365	600-450-335	-	460-345-265	
-	880-660-560	950-670-510	860-610-470	690-460-330	590-390-280	540-320-235	-	410-260-180	
-	670-500-420	730-490-380	660-450-345	600-410-295	520-360-250	470-305-220	-	360-245-165	
TOUGHNESS >>>>									
GC1125	GC2015	GC30	GC2025	GC2035	GC235				
.004-.008-.012	.008-.016-.024	.006-.010-.016	.008-.016-.024	.008-.016-.024	.008-.016-.024				
910-700-550 510-405-325 540-440-385	850-720-650 410-325-260 475-390-275	720-650-570 285-245-195 315-295-220	750-570-440 360-225-160 390-260-175	590-520-420 280-210-145 310-225-160	425-360-295 230-180-145 245-195-165				
730-580-445 510-405-325 610-520-420	950-780-620 425-325-260 520-440-325	620-570-465 320-275-220 420-385-315	790-570-425 330-235-175 425-325-245	560-470-375 280-210-145 330-295-225	375-325-275 230-180-145 280-230-195				
690-550-420 620-455-355	720-600-470 620-490-390	570-520-425 405-375-350	620-485-355 490-390-290	520-440-340 425-360-275	345-310-260 310-260-230				
870-720-550 445-360-260 475-390-290	820-680-550 325-225-180 360-290-195	660-560-490 255-205-165 300-245-190	720-520-390 275-180-130 390-260-175	560-470-375 230-165-130 240-190-160	375-325-275 195-145-115 215-165-130				
760-610-465 445-360-260 570-490-405	720-590-455 345-260-195 475-375-310	500-445-365 255-205-165 385-330-270	660-500-370 275-180-130 425-290-210	490-390-310 230-165-130 330-260-195	330-295-245 205-145-110 260-210-180				
620-455-325 560-420-290	600-490-440 530-455-340	540-465-280 385-335-205	490-390-290 410-340-260	425-360-275 345-310-245	310-260-230 295-245-210				
TOUGHNESS >>>>									
CC6190	CC1690	CT5015	GC3205	GC3210	GC3215	GC3005	GC4215	GC30	H13A
.008-.016-.024	.008-.016-.024	.004-.010-.012	.008-.016-.024	.008-.016-.024	.008-.016-.024	.008-.016-.024	.008-.016-.024	.006-.010-.016	.004-.010-.016
2650-2150-1800 2300-1800-1450	2400-1950-1650 2100-1600-1300	650-530-445 455-370-310	1500-1250-1050 1250-1000-860	1250-1050- 1050-830-700	850-700-600 690-570-490	820-690-600 770-620-485	1050-870-740 870-720-600	540-540-485 390-355-295	460-410-360 410-360-295
2900-2350-1950 2600-2000-1650	2400-1950-1650 2250-1750-1400	1050-850-710 910-770-670	1750-1400-1200 1400-1150-980	1450-1150- 1150-950-800	980-820-680 790-650-550	900-810-740 850-730-650	1200-1000- 930-800-720	750-650-530 580-495-390	590-470-355 460-375-310
-	1900-1450-1100	840-650-530	1300-1100-890	1200-990-810	780-640-540	860-690-590	920-750-630	560-470-385	445-470-310
-	1600-1150-820	740-630-560	1150-980-810	1050-900-730	700-570-490	780-630-520	840-680-560	390-350-295	410-375-290
-	1050-860-710	370-315-275	870-730-620	800-680-550	540-440-375	600-455-355	660-510-410	205-160-120	330-275-210

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO N	CMC No.	Non-ferrous metals	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CD10	CD1810	H10
					h_{ex} , inch \approx feed, f_n inch/rev. at 0° to -5° lead		
					.002-.016	.006-.031	.006-.031
MC No.	CMC No.	Material	lbs/in ²	HB	Cutting speed v_c , ft/min		
N1.2.Z.UT	30.11	Aluminium alloys Wrought or wrought and coldworked, non-aging	58,000	60	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.2.Z.AG	30.12	Wrought or wrought and aged	94,500	100	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.3.C.UT	30.21	Aluminium alloys Cast, non-aging	87,000	75	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.3.C.AG	30.22	Cast or cast and aged	101,500	90	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾	6550 (8200-820) ¹⁾
N1.4.C.NS	30.41	Aluminium alloys Cast, 13–15% Si	101,500	130	5000 (6250-630) ¹⁾	2500 (3150-315) ¹⁾	1500 (1900-190) ¹⁾
	30.42	Cast, 16–22% Si	101,500	130	2500 (3150-315) ¹⁾	1650 (2050-205) ¹⁾	980 (1250-125) ¹⁾
N3.3.U.UT	33.1	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb	79,500	110	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾
N3.2.C.UT	33.2	Brass, leaded bronzes, $\leq 1\%$ Pb	80,000	90	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾	1650 (2050-205) ¹⁾
N3.1.U.UT	33.3	Bronze and non-leadad copper incl. electrolytic copper	196,000	100	980 (1250-125) ¹⁾	980 (1250-125) ¹⁾	980 (1250-125) ¹⁾
ISO S	CMC No.	Heat resistant material	Specific cutting force k_{c1}	Hardness Brinell	<<<< WEAR RESISTANCE		
					CC650	CC6060	CC6065
					h_{ex} , inch \approx feed, f_n inch/rev. at 0° to -5° lead		
					.004-.008	.004-.008-.012	.004-.008-.012
MC No.	CMC No.	Material	lbs/in ²	HB	Cutting speed v_c , ft/min		
S1.0.U.AN	20.11	Heat resistant super alloys Iron base Annealed or solution treated	348,000	200	-	-	-
	20.12	Aged or solution treated and aged	359,000	280	-	-	-
S2.0.Z.AN	20.21	Nickel base Annealed or solution treated	383,000	250	1300-1050	1300-1050-880	1100-830-650
	20.22	Aged or solution treated and aged	420,500	350	1100-860	980-770-620	790-570-420
	20.24	Cast or cast and aged	436,500	320	720-520	790-660-570	700-580-485
S3.0.Z.AN	20.31	Cobalt base Annealed or solution treated	391,500	200	1150-840	-	-
	20.32	Solution treated and aged	432,000	300	980-720	-	-
	20.33	Cast or cast and aged	450,500	320	930-730	-	-
S4.1.Z.UT	23.1	Titanium alloys²⁾ Commercial pure (99.5% Ti)	188,500	Rm³⁾ 400	H10 .004-.008-.012	GC1105 .004-.008-.012	H10A .004-.012-.020
		α , near α and $\alpha + \beta$ alloys, annealed	203,000	950	670-550-470	670-550-470	640-530-445
		$\alpha + \beta$ alloys in aged conditions, β alloys, annealed or aged	203,000	1050	280-230-180	280-230-180	265-215-175
					260-195-165	260-195-165	255-190-160
ISO H	CMC No.	Hardened material	Specific cutting force k_{c1}	Hardness	<<<< WEAR RESISTANCE		
					CB7015	CB7025	CB20
					h_{ex} , inch \approx feed, f_n inch/rev. at 0° to -5° lead		
					.002-.006-.010	.002-.006-.010	.002-.006-.010
MC No.	CMC No.	Material	lbs/in ²		Cutting speed v_c , ft/min		
H1.1.Z.HA	04.1	Hard steel Hardened and tempered	366,000	45HRC	-	-	-
			445,500	50HRC	1150-870-730	820-690-610	850-760-670
			532,000	55HRC	960-730-610	690-580-510	710-630-560
H1.3.Z.HA	04.1	Extra hard steel Hardened and tempered	625,500	60HRC	820-620-520	590-490-435	610-540-480
			726,500	65HRC	710-530-450	510-425-375	520-465-410
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

TOUGHNESS >>>>									
GC1115	GC15	GC1025	GC1125	H13A					
.006-.031	.006-.031	.006-.031	.006-.031	.006-.031					
2650 (3300-330) ¹⁾	2650 (3300-330)1)	2500 (3150-315) ¹⁾	2500 (3150-315) ¹⁾	6250 (7800-780) ¹⁾					
1050 (1300-130) ¹⁾	1050 (1300-130)1)	980 (1250-125) ¹⁾	980 (1250-125) ¹⁾	6250 (7800-780) ¹⁾					
2650 (3300-330) ¹⁾ 1750 (2200-220) ¹⁾	2650 (3300-330)1) 1750 (2200-220)1)	2500 (3150-315) ¹⁾ 1650 (2050-205) ¹⁾	2500 (3150-315) ¹⁾ 1650 (2050-205) ¹⁾	6250 (7800-780) ¹⁾ 6250 (7800-780) ¹⁾					
1050 (1300-130) ¹⁾ 720 (900-90) ¹⁾	1050 (1300-130)1) 720 (900-90)1)	980 (1250-125) ¹⁾ 690 (860-85) ¹⁾	980 (1250-125) ¹⁾ 690 (860-85) ¹⁾	1300 (1650-165) ¹⁾ 820 (1050-105) ¹⁾					
690 (860-85) ¹⁾ 410 (510-50) ¹⁾ 290 (365-36) ¹⁾	690 (860-85)1) 410 (510-50)1) 290 (365-36)1)	650 (810-80) ¹⁾ 390 (490-50) ¹⁾ 275 (345-34) ¹⁾	650 (810-80) ¹⁾ 390 (490-50) ¹⁾ 275 (345-34) ¹⁾	1500 (1900-190) ¹⁾ 1500 (1900-190) ¹⁾ 890 (1100-110) ¹⁾					
TOUGHNESS >>>>									
CC670	S05F	GC1105	GC1115	GC15	GC1005	H10A	H13A	GC1125	H10F
.004-.008-.012	.004-.008-.012	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020
-	520-435-355	490-325-225	395-260-180	395-260-180	490-325-225	280-230-180	260-210-160	245-195-145	230-180-130
-	410-345-280	390-260-195	315-210-155	315-210-155	390-260-195	215-180-130	195-165-130	180-145-115	165-130-95
1250-1050-880	325-275-225	295-185-95	235-150-75	235-150-75	295-185-95	180-130-105	165-130-95	150-115-80	130-95-65
1050-870-740	295-245-200	265-165-85	215-135-70	215-135-70	265-165-85	130-105-70	130-95-65	115-80-50	100-65-32
970-800-680	260-220-180	235-150-75	190-120-60	190-120-60	235-150-75	85-70-50	80-65-50	75-55-39	65-50-32
1150-830-660	325-275-225	295-185-95	240-150-75	240-150-75	295-185-95	180-130-105	165-130-95	150-115-80	130-95-65
980-720-570	290-245-200	265-165-85	210-135-70	210-135-70	265-165-85	130-105-70	130-95-65	115-80-50	100-65-32
930-730-550	260-220-180	235-150-75	190-120-60	190-120-60	235-150-75	85-70-50	80-65-50	75-55-39	65-50-32
H13A	H10F	GC1115	GC15						
.004-.012-.020	.004-.012-.020	.004-.012-.020	.004-.012-.020						
590-485-410	530-440-370	610-500-425	610-500-425						
245-200-165	220-180-145	255-205-170	255-205-170						
235-175-150	210-155-135	245-180-155	245-180-155						
TOUGHNESS >>>>									
CB7525	CB7925	CC6050	CC670	GC4205	GC4215	H13A			
.004-.010-.016	.004-.010-.016	.002-.006-.010	.004-.010-.016	.004-.012-.024	.004-.012-.024	.004-.012-.024			
-	-	950-770-570	670-550-440	225-155-95	205-135-85	145-80-50			
680-540-435	-	780-630-470	550-450-365	-		-			
570-455-365	-	660-530-395	460-375-305	-		-			
480-385-310		560-450-335	390-320-260	-		-			
415-330-270	-	480-390-290	335-275-225	-		-			
590-480-390	590-480-390	-	390-290-190	170-95-55	155-85-50	115-65-35			

Grades for general turning

	ISO	ANSI		
P Steel	01	C8	CT 5015	GC 4205
	10		GC 1525	GC 4215
	20	C7		GC 4225
	30	C6		GC 4235
	40			GC 1515
				GC 3005
	50	C5		GC 15
M Stainless steel	10		GC 2015	GC 1115
	20		GC 1125	GC 2025
	30			GC 2035
	40			GC 235
K Cast iron	01	C4	CB 7525	GC 3205
	10	C3	CC 6190	GC 3210
	20	C2	GC 1690	GC 3215
	30	C1		
	40			
N Non-ferrous metals	01	C4		
	10	C3	H10	CD 1810
	20	C2		CD 10
	30	C1		
S Heat resistant and super alloys	01		Ni-based	
	10		CC 670	CC 6060
	20		CC 6065	S05F
	30		GC 1105	GC 1005
	40		GC 1115	H10A
H Hardened materials	01	C4		
	10	C3	CB 7015	CB 7025
	20	C2	CB 20	CB 7525
	30	C1		

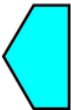
The position and form of the grade symbols indicate the suitable field of application.

Centre of the field of application.

Recommended field of application.

▲ Wear resistance

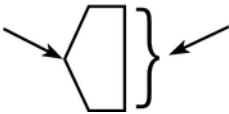
▼ Toughness



= Basic grades



= Complementary grades



Grades for general turning



Steel, cast steel, long chipping malleable iron

Basic grades

CT5015 (HT) – P10 (P01-P20)

An uncoated cermet with excellent resistance to built-up-edge and plastic deformation. New formula with improved toughness. For finishing of low alloy and alloy steels when high surface quality and/or low cutting force are required. $f_n \times a_p < 0.35 \text{ mm}^2$

GC1515 (HC) - P25 (P10-P30)

A thin CVD-coated micro-grain carbide. Recommended for finishing of low carbon-to low alloy steels, and other "sticky" steel alloys using medium to low cutting speed. Excellent when surface finish or sharp cutting action is needed. Great resistance to thermal shock makes it also suitable for light intermittent cuts.

GC1525 (HC) – P15 (P05-P25)

A PVD coated cermet. Very high wear resistance and good edge toughness. 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. $f_n \times a_p < 0.35 \text{ mm}^2$.

GC4205 (HC) – P05 (P01-P15)

A CVD coated grade with excellent resistance against craterwear and plastic deformation. Recommended for stable conditions when higher metal removal rate is needed in medium to rough steel applications. Is able to withstand high temperatures without sacrificing edge line security in wet and dry machining.

GC4215 (HC) - P15 (P01-P30)

CVD-coated carbide grade for finishing to roughing in applications with continuous cut to light intermittence of steel and steel castings. A gradient substrate optimized in hardness and toughness with a wear resistant coating. Is able to withstand high temperatures without sacrificing edge line security in wet and dry applications.

GC4225 (HC) - P25 (P10 - P40)

CVD-coated carbide grade for finishing to roughing of steel and steel castings. A gradient substrate with optimized hardness and toughness for steel turning in combination with a thick wear resistant coating. This grade can handle continuous cuts as well as interrupted cuts at high metal removal rates. A grade for a broad application area.

GC4235 (HC) - P35 (P20-P45)

CVD-coated carbide grade for roughing of steel and steel castings under unfavorable conditions. A gradient substrate with optimized hardness and toughness for steel turning in combination with a thick wear resistant coating. The edge line security enables the grade to handle interrupted cuts at high metal removal rates.

Complementary grades

GC3005 (HC) - P10 (P01-P25)

CVD-coated carbide consisting of a wear resistant coating with very good adhesion to a hard substrate, capable of withstanding high temperatures. For finishing and semi-finishing at high cutting speed in high alloy steels.

GC2015 (HC) – P25 (P20-P30)

CVD-coated carbide grade. Combined with geometries providing sharp cutting action, this grade is recommended for finishing to light roughing of carbon steels and other 'sticky' alloys

GC2025 (HC) – P35 (P25-P40)

CVD-coated carbide grade. Alternative choice for toughness demanding steel applications.

GC1125 (HC) – P25 (P10-P30)

Recommended to be used as complementary to GC1515, when finishing of low carbon steels, using low feedrate or low cutting speed.

GC15 (HC) - P20 (P15-P25)

Complementary grade to GC30 for edge-line toughness demanding operations in steel materials: small components, interrupted cuts; facing to center or shoulders at medium to low cutting data.

GC30 (HC) - P30 (P25-P40)

CVD-coated tough cemented carbide grade for medium rough to finish machining. First-choice in steel materials at medium to low cutting data.

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



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

Basic grades

GC1125 (HC) – M25 (M10-M30)

A PVD-coated micro-grain carbide. Recommended for finishing of all kinds of stainless steels, using medium to low cutting speeds. Excellent when sharp cutting action combined with superior edge toughness or surface finish is needed. Great resistance to thermal shock makes it also suitable for light intermittent cuts.

GC2015 (HC) – M15 (M05-M25)

CVD-coated carbide grade for finishing and light roughing of stainless steels. A substrate, which can handle high temperatures, combined with a wear resistant coating makes this grade a first choice for continuous cuts at moderate to high cutting speeds.

GC2025 (HC) – M25 (M15-M35)

CVD-coated carbide optimized for semi-finishing to roughing of austenitic stainless and duplex stainless steels at moderate cutting speeds. Good resistance to thermal shock and mechanical shock provides excellent edge security also for interrupted cuts.

GC2035 (HC) – M35 (M25-M40)

PVD-coated carbide. Recommended for semi-finishing to roughing of austenitic stainless and duplex stainless steels at low to moderate cutting speeds. Great resistance to thermal shock makes it ideal for applications with fast intermittent cuts.

GC235 (HC) – M40 (M25-M40)

CVD-coated carbide grade for roughing of stainless steels and stainless steel castings with difficult skin. The tough substrate provides extremely good edge security which allows the grade to handle heavy interrupted cuts at low to moderate speeds.

GC1115 (HC) – M15 (M05-M25)

A PVD coated fine-grained carbide. The substrate has high hot hardness and good resistance against plastic deformation combined with good edge line security. The thin PVD-oxide coating with excellent resistance to smearing material and good adhesion on sharp edges. This guarantees toughness, even flank wear and high performance.

Complementary grades

GC1105 (HC) - M15 (M05 - M20)

The substrate consists of a hard fine-grained WC with 6% Co for high hot hardness and good resistance against plastic deformation. The new thin PVD TiAlN-coating with excellent adhesion, also on sharp edges, guarantees toughness, even flank wear and high performance. Suitable for finishing of stainless steel at high speeds.

GC1515 (HC) – M20 (M10-M25)

Recommended for finishing of all kinds of stainless steels and used as complementary to GC1125, when wear resistance is of more importance than edge toughness.

GC1525 (HC) – M10 (M05-M15)

A PVD coated cermet. Very high wear resistance and good edge toughness. Low smearing tendency. Excellent for finishing of stainless steel under favourable conditions. To be used at high speeds and relatively low feeds.

$$f_n \times a_p < 0.35 \text{ mm}^2$$

GC15 (HC) - M15 (M05-M25)

PVD-coated tough, micro-grain cemented carbide grade for medium rough to finish machining. First-choice in stainless steels, duplex and precipitation-hardened (PH) materials at medium to low cutting data.

GC30 (HC) - M20 (M15-M25)

Complementary grade to GC15 in stainless steel materials for large components, long times-in-cut, medium to low cutting data.

Grades for general turning



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

Basic grades

CB7525 (BN) - K05 (K01-K10)

An extremely hard cubic boron nitride grade. High edge toughness and good wear resistance makes it optimal for high speed finishing of grey cast iron under continuous as well as interrupted conditions.

CC6190 (CN) - K10 (K01 - K20)

Pure silicon nitride based ceramic providing good wear resistance at high temperatures. Recommended for high speed roughing to finishing of cast irons under good conditions. Is able to handle some interruptions.

GC1690 (CC) - K10 (K05-K15)

A CVD coated silicon nitride ceramic grade. The properties of GC1690 makes it highly recommendable for light roughing, medium and finishing applications in cast iron.

GC3205 (HC) - K05 (K01-K15)

CVD-coated carbide consisting of a thick, smooth, wear resistant coating and a very hard substrate. Recommended for high speed turning of Grey Cast Iron (GCI).

GC3210 (HC) - K05 (K01-K20)

CVD-coated carbide consisting of a thick, smooth, wear resistant coating and a very hard substrate. Recommended for high speed turning of Nodular Cast Iron (NCI).

GC3215 (HC) - K05 (K01-K25) CVD-coated carbide consisting of a thick, smooth, wear resistant coating and a very hard substrate, capable of withstanding demanding interrupted cutting conditions. Recommended as general choice for roughing of all cast irons at low to medium cutting speeds.

Complementary grades

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.

GC3005 (HC) - K10 (K01-K20)

CVD-coated carbide consisting of a wear resistant coating with very good adhesion to a hard substrate, capable of withstanding high temperatures. For finishing to roughing of nodular iron, high strength malleable iron and "gummy" (alloyed) grey iron.

CB7925 (BN) - K05 (K01-K10)

A solid CBN grade with a high edge toughness and good wear resistance. CB7925 is suited for both machining in grey cast iron and chilled iron under continuous as well as interrupted conditions.

CC620 (CA) - K01 (K01-K05)

'Pure' Al₂O₃-based ceramic. Recommended for high speed finishing of grey cast irons under stable and dry conditions.

CT5015 (HT) - K05 (K01-K10)

An uncoated cermet grade with excellent resistance to built-up-edge and plastic deformation. For finishing of nodular cast irons when high surface quality, close tolerances and/or low cutting forces are required.

$$f_n \times a_p < 0.35 \text{ mm}^2$$

H13A (HW) - K20 (K10-K30)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness. For moderate to low speeds and high feeds in cast iron.

GC4215 (HC) - K15 (K10-K25)

CVD-coated carbide grade for finishing to roughing in applications at low to medium cutting speeds of grey and nodular cast irons. A gradient substrate optimized in hardness and toughness with a wear resistant coating. Withstand edge line security in wet and dry applications.

GC30 (HC) - K40 (K25-K40) Recommended for medium to finish machining of cast iron at medium to low cutting data

GC15 (HC) - K10 (K05-K15) Complementary grade in boring and fine-finishing operations.



Non ferrous metals

Basic grades

H10 (HW) - N15 (N01-N25)

Uncoated carbide grade. Combines excellent abrasive wear resistance and edge sharpness. For rough to finish turning of Aluminum alloys.

CD1810 (HC) - N10 (N01-N15)

A diamond-coated grade for finishing to roughing of aluminium, magnesium, copper, brass, plastics etc. The diamond-coating gives excellent wear-resistance and less built-up-edge, which results in high surface quality.

CD10 (DP) - N05 (N01-N10)

A polycrystalline diamond grade for finishing and semi-finishing of non-ferrous and non-metallic materials. Gives long tool life, clean cut and good finish.

Complementary grades

H13A (HW) - N15 (N05-N25)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness for medium to rough turning of aluminum alloys.

GC1005 (HC) - N10 (N05-N15)

PVD-coated carbide. The combination of a hard, fine grade substrate and a coating with a high wear resistance, makes the grade most suitable for roughing of aluminium.

GC1125 (HC) - N25 (N15-N30)

Recommended to use in toughness demanding operations, or when a sharp edge is needed.

GC1115 (HC) - N15 (N10-N20)

A PVD coated fine-grained carbide for applications when sharp edges are needed. The combination of a hard substrate with good edge line security and a coating with high wear resistance makes this grade suitable for toughness demanding operations in non ferrous materials.

GC15 (HC) - N15 (N10-N20) For toughness demanding operations in non-ferrous materials.

Grades for general turning

S

Heat resistant and super alloys

Basic grades

GC 1105 (GC) - S15 (S05 - S20)

The substrate consists of a hard fine-grained WC with 6% Co for high hot hardness and good resistance against plastic deformation. The new thin PVD TiAlN-coating with excellent adhesion, also on sharp edges, guarantees toughness, even flank wear and outstanding performance in heat resistant super alloys.

CC670 (CA) – S15 (S05-S25)

A silicon carbide whisker reinforced aluminium oxide based ceramic with excellent bulk toughness. Primarily recommended for heat resistant alloys under unfavourable conditions.

S05F (HC) - (S05-S15)

CVD-coated carbide. For high speed finishing in HRSA, or long cuts at lower speeds. For applications where notch is not a significant problem, ie round inserts, large entry angle and softer materials, this grade can also be used in roughing applications.

GC1005 (HC)– S15 (S10-S25)

PVD-coated carbide. The combination of a hard fine grain substrate with good plastic deformation resistance and a coating with high wear resistance at high temperatures, makes this grade most suitable for Ni, Fe or Co-based heat resistant super alloys.

CC6060 (CA) - S10 (S05-S20)

Sialon based ceramic, designed to optimise performance in pre-machined HRSA materials under stable conditions. Offers high security and predictable wear, due to high notch resistance

CC6065 (CA) - S15 (S05-S20)

Sialon based ceramic, first choice for all HRSA-machining. Offers good toughness and security. Well suited for first stage machining in semi-intermittent applications, as well as machining forged skin and other toughness demanding operations.

GC1115 (HC) - S20 (S15-S25)

A PVD coated fine-grained carbide. The substrate has high hot hardness and good resistance against plastic deformation combined with good edge line security. The thin PVD-oxide coating with excellent resistance to smearing material and good adhesion on sharp edges. This guarantees toughness, good crater wear resistance, even flank wear and high performance. GC1115 is suitable for medium to rough turning of heat resistant super alloys.

Complementary grades

GC1125 (HC) – S25 (S20-S30)

Recommended for heat resistant super alloys at low speeds, or light intermittent cuts. Good resistance against notch and good thermal shock makes the grade suitable to use in semi tough operations, at short contact times.

CC650 (CM) – S05 (S01-S10)

Mixed Al₂O₃-based ceramic. Could be used in semi-finishing operations of high-temp alloys in applications with low demand on edge security.

H10A (HW) – S10 (S01-S20)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness for medium to rough turning of heat resistant steels and titanium alloys.

H10F (HW) – S15 (S10-S30)

Uncoated fine-grain carbide grade. Recommended for heat resistant super alloys or Titanium alloys at very low speeds. Great resistance to thermal shock and notch wear makes it suitable for long cuts or intermittent cuts.

H13A (HW) – S15 (S10-S30)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness for medium to rough turning of heat resistant steels and titanium alloys.

GC15 (HC) - S20 (S15-S25)

Recommended for medium roughing to finishing of aged Ni- and Ti-based alloys.

GC30 (HC) - S35 (S35-S45)

For complementary use in Ni- and Ti-based alloys in their soft stage / non-aged.

H

Hardened materials

Basic grades

CB7015 (BN) - H10 (H05 - H15)

High performance, low content Cubic Boron Nitride grade. First choice for continuous and light interrupted cuts at high speed in case hardened steels.

CB20(BN) – H15 (H10-H20)

High performance Cubic Boron Nitride grade. First choice for continuous and light interrupted cuts in hardened steel.

CC6050 (CC) - H05 (H01 - H10)

Mixed Al₂O₃-based ceramic. Good thermal properties and wear resistance. Primarily recommended for light continuous finishing.

CB7025 (BN) - H15 (H10-H20)

High performance, medium content Cubic Boron Nitride grade. First choice for cuts with substantial elements of heavy interruptions with otherwise continuous cuts at medium speeds in case hardened steels.

CB7525 (BN) - H25 (H20-H30)

An extremely hard cubic boron nitride grade. High edge toughness makes it a good complementary grade in interrupted cuts in hardened steel.

Complementary grades

CC670 (CA) – H10 (H05-H15)

A silicon carbide whisker reinforced aluminium oxide based ceramic with excellent bulk toughness. Recommended for hard part turning under unfavourable conditions.

GC4205 (HC) – H15 (H05-H20)

CVD-coated carbide grade for medium to roughing applications with continuous cut at low speeds in hardened materials.

GC4215 (HC) - H15 (H05-H25)

CVD-coated carbide grade for finishing to roughing in applications with continuous cut to light intermittence hardened materials. A gradient substrate optimized in hardness and toughness with a wear resistant coating. Withstand edge line security in wet and dry applications.

H13A (HW) – H20 (H15-H25)

Uncoated carbide grade. Combines good abrasive wear resistance and toughness for turning of hardened materials at low speeds.

