

Rotating tools

MILLING
DRILLING
BORING
ROTATING TOOL ADAPTORS





Let us introduce our new catalogues

The catalogue consists of three volumes: Turning tools, Rotating tools and Solid round tools. In total, over 30,000 standard products are presented.

Turning tools – General Turning, Parting and Grooving, Thread Turning, Multifunctional tools, Tool holding and Turning tool adaptors

Rotating tools – Milling, Drilling, Boring and Rotating tool adaptors

Solid Round Tools – Milling, Drilling, Tapping and Reaming









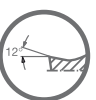





Use the product overviews in the beginning of each chapter to find your area of interest, and a reference will take you to the actual product page. References at the bottom of each product page will guide you to related products and information, such as holders, inserts and cutting data.

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

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



Explanation of reference symbols:

| | | | | |
|---|---|---|--|---|
|  Inserts |  Milling cutters |  Drill bodies |  Boring tools |  Adaptors |
|  Accessories |  Cutting data |  Grade description |  Geometry description |  Parameter explanation |
|  Tailor Made |  Code key |  Coolant information |  Information | |

| | |
|---|---------------|
|  | First choice |
|  | Good choice |
|  | Not available |

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

I Milling

J Drilling

K Boring

L Rotating tool adaptors

M Accessories

N General information

Milling

Face milling tools 13

| | |
|---------------|---------|
| CoroMill® 345 | 14-18 |
| CoroMill® 245 | 19-112 |
| CoroMill® 425 | 113-115 |
| CoroMill® 745 | 116-119 |
| CoroMill® 360 | 120-122 |
| CoroMill® 365 | 123-126 |

High-feed milling tools 127

| | |
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| CoroMill® 419 | 128-131 |
| CoroMill® 210 | 132-136 |
| CoroMill® 415 | 137-141 |
| CoroMill® 745 | 142-145 |

Shoulder milling tools 146

| | |
|-------------------|---------|
| CoroMill® 490 | 147-156 |
| CoroMill® 390 | 157-178 |
| CoroMill® 690 | 179-182 |
| CoroMill® Century | 183-189 |

Profile milling tools 190

| | |
|---------------|-----------|
| CoroMill® 300 | 191-199 |
| CoroMill® 200 | 1100-1104 |
| CoroMill® 216 | 1105-1111 |

Disc milling tools 1112

| | |
|---------------|-----------|
| CoroMill® 331 | 1113-1134 |
|---------------|-----------|

Groove milling tools 1135

| | |
|---------------|-----------|
| CoroMill® QD | 1136-1141 |
| CoroMill® 328 | 1142-1144 |
| CoroMill® 327 | 1145-1147 |

Thread milling tools 1135

| | |
|---------------|-----------|
| CoroMill® 328 | 1148 |
| CoroMill® 327 | 1149-1150 |

Chamfer milling tools 1135

| | |
|---------------|-----------|
| CoroMill® 327 | 1150 |
| CoroMill® 495 | 1151-1153 |

For complete assortment, see www.sandvik.coromant.com

How to choose your milling tool

Cutter pitch

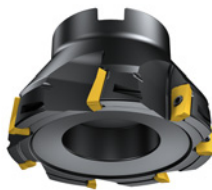
L



Coarse pitch

Reduced number of inserts, low cutting forces. Small machines. Best productivity when stability and power is limited. Long overhang.

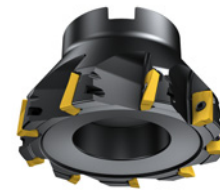
M



Close pitch

General purpose milling and mixed production. Always first choice.

H

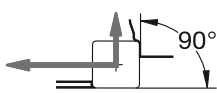


Extra close pitch

Maximum number of inserts for best productivity under stable conditions. Short chipping or heat resistant materials.

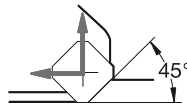
Entering angle

90° entering angle



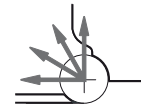
- Thin-walled components
- Weak fixtured components
- Where 90° form is required

45° entering angle



- General purpose first choice
- Reduces vibration on long overhang
- Chip thinning effect allows increased productivity

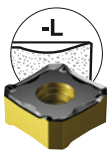
Round insert cutters



- Strongest cutting edge with multiple indexes
- General purpose cutter
- Increased chip thinning effect for heat resistant alloys

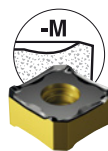
Insert geometries

Light



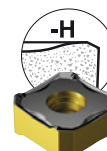
Extra positive, light machining, low cutting forces and for low feed rates.

Medium



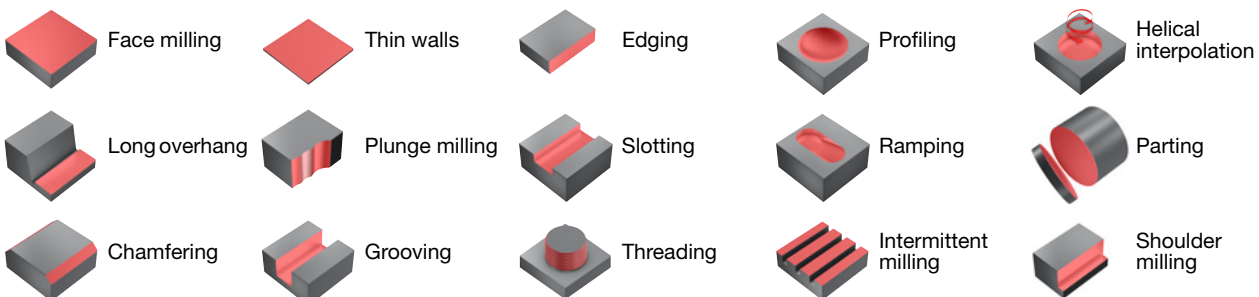
For general use in most materials.

Heavy




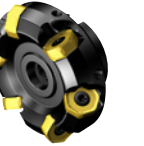

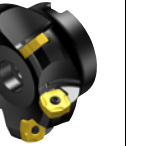













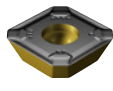


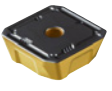
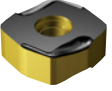















Reinforced cutting edge, heavy machining, highest edge security and for high feed rates.

Explanation of application symbols



Face milling tools

| | CoroMill® 345 | CoroMill® 245 | CoroMill® 425 | CoroMill® 745 | CoroMill® 360 | CoroMill® 365 |
|------------------|---|---|---|--|---|---|
| |  |  |  |  |  |  |
| Page | 15 | 110 | 114 | 117 | 121 | 123 |
| Material |  |  |  |  |  |  |
| Main operation |  |  |  |  |  |  |
| KAPR | 45° | 45° | 25° | 42° | 60° | 65° |
| DC mm | 40 - 250 | 32 - 250 | 100 - 500 | 63 - 250 | 160 - 400 | 50 - 250 |
| DCX mm | 54.1 - 264.1 | 44.5 - 268.8 | 107.0 - 507.0 | 78.2 - 264.4 | 175.0 - 420.8 | 50.0 - 166.7 |
| APMX mm | 6 | 6 - 10 | 0.90 | 5.20 | 13 - 18 | 6.0 |
| Insert |  |  |  |  |  |  |
| Insert sizes | 13 | 12 & 18 | 17 | 21 | 19 & 28 | 15 |
| Couplings | Coromant Capto® Cylindrical shank Arbor | Arbor Cylindrical shank | Arbor Cap coupling | Coromant Capto® Arbor | Arbor | Coromant Capto® Arbor |
| Internal coolant |  |  |  |  |  |  |
| Options | Shim protection tipseat | Shim protection tipseat | Adjustable cassettes for wiper inserts | | Exchangeable cassette design | Internal coolant on selected models |
| Other operations |  |  |  |   |  |  |

CoroMill® 345

Face mill for high productivity

Application

- Face milling
- Roughing to finishing

ISO application area:



Benefits and features

- Low cost per component thanks to eight cutting edges
- High output – with internal coolant high productivity is possible also in demanding materials
- Secure machining thanks to shim-protected tip seats and tough cutter body
- Optimized machine utilization and productivity with four different pitches
- Wide application area – use the same concept for different application

www.sandvik.coromant.com/coromill345

Couplings

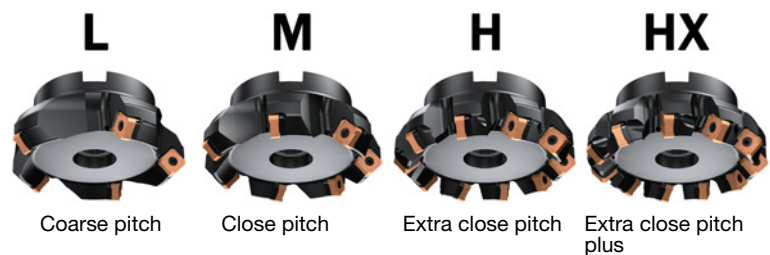
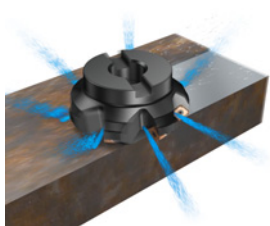
- Coromant Capto®
- Arbor
- Cylindrical shank

Inserts

- Eight cutting edges
- Wiper inserts for excellent surface finish at high feed per tooth

Internal coolant

Coolant supply to each insert pocket gives good chip evacuation and performance in demanding materials.



15

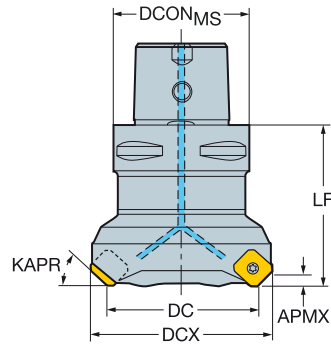


18

CoroMill® 345 face milling cutter

Coromant Capto® - Internal coolant supply

KAPR 45°



| | | | | | | | Dimensions, mm | | | | | | | |
|-------|-------------------|---------------------|------|---------------|---|--------------------|----------------|-------|------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | | DCON _{MS} | DCX | LF | NM | KG | RPM | CICT | MIID | |
| 40.0 | 13 | C4 | 6.00 | 3 | 4 | 345-040C4-13M | 40.0 | 54.1 | 60.0 | 3.0 | 0.89 | 19600 | 4 | 345R-1305 |
| 50.0 | 13 | C5 | 6.00 | 3 | 4 | 345-050C5-13M | 50.0 | 64.1 | 60.0 | 3.0 | 1.39 | 17500 | 4 | 345R-1305 |
| | 13 | C6 | 6.00 | 3 | 4 | 345-050C6-13M | 63.0 | 64.1 | 60.0 | 3.0 | 1.80 | 17500 | 4 | 345R-1305 |
| | 13 | C5 | 6.00 | 3 | 5 | 345-050C5-13H | 50.0 | 64.1 | 60.0 | 3.0 | 1.48 | 17500 | 5 | 345R-1305 |
| | 13 | C6 | 6.00 | 3 | 5 | 345-050C6-13H | 63.0 | 64.1 | 60.0 | 3.0 | 1.79 | 17500 | 5 | 345R-1305 |
| 63.0 | 13 | C5 | 6.00 | 3 | 5 | 345-063C5-13M | 50.0 | 77.1 | 60.0 | 3.0 | 1.53 | 15500 | 5 | 345R-1305 |
| | 13 | C6 | 6.00 | 3 | 5 | 345-063C6-13M | 63.0 | 77.1 | 60.0 | 3.0 | 1.91 | 15500 | 5 | 345R-1305 |
| | 13 | C5 | 6.00 | 3 | 6 | 345-063C5-13H | 50.0 | 77.1 | 60.0 | 3.0 | 1.62 | 15500 | 6 | 345R-1305 |
| | 13 | C6 | 6.00 | 3 | 6 | 345-063C6-13H | 63.0 | 77.1 | 60.0 | 3.0 | 1.97 | 15500 | 6 | 345R-1305 |
| 80.0 | 13 | C6 | 6.00 | 3 | 6 | 345-080C6-13M | 63.0 | 94.1 | 70.0 | 3.0 | 2.46 | 13700 | 6 | 345R-1305 |
| | 13 | C8 | 6.00 | 3 | 6 | 345-080C8-13M | 80.0 | 94.1 | 70.0 | 3.0 | 3.32 | 13700 | 6 | 345R-1305 |
| | 13 | C6 | 6.00 | 3 | 8 | 345-080C6-13H | 63.0 | 94.1 | 70.0 | 3.0 | 2.54 | 13700 | 8 | 345R-1305 |
| 100.0 | 13 | C8 | 6.00 | 3 | 7 | 345-100C8-13M | 80.0 | 114.1 | 80.0 | 3.0 | 4.01 | 12200 | 7 | 345R-1305 |

Spare parts

| Insert screw | Shim | Shim screw |
|--------------|-------------|-------------|
| 416.1-834 | 5322 474-01 | 5512 090-11 |

For complete list of spare parts, see www.sandvik.coromant.com



I8



L2



N23



N9



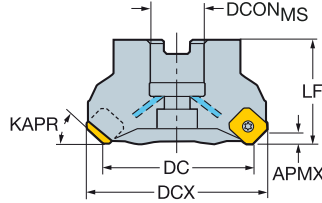
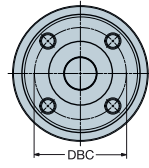
N15

CoroMill® 345 face milling cutter

Arbor - Internal coolant supply

STDNO
KAPR

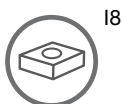
ISO6462
45°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|-------------------|--------------------|------|---------------|--------------------|-----------------|------|-----|-------|-------|------|------|-------|------|-----------|-----------|--|
| DC | CZC _{MS} | APMX _{FW} | CNSC | Ordering code | DCON _{MS} | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID | | | |
| 40.0 | 13 | 22 | 6.00 | 1 | 3 | 345-040Q22-13L | 22.0 | A | 54.1 | 45.0 | 3.0 | 0.68 | 19600 | 3 | 345R-1305 | | |
| | 13 | 22 | 6.00 | 1 | 4 | 345-040Q22-13M | 22.0 | A | 54.1 | 45.0 | 3.0 | 0.67 | 19600 | 4 | 345R-1305 | | |
| 50.0 | 13 | 22 | 6.00 | 1 | 3 | 345-050Q22-13L | 22.0 | A | 64.1 | 45.0 | 3.0 | 0.82 | 17500 | 3 | 345R-1305 | | |
| | 13 | 22 | 6.00 | 1 | 4 | 345-050Q22-13M | 22.0 | A | 64.1 | 45.0 | 3.0 | 0.78 | 17500 | 4 | 345R-1305 | | |
| | 13 | 22 | 6.00 | 1 | 5 | 345-050Q22-13H | 22.0 | A | 64.1 | 45.0 | 3.0 | 0.82 | 17500 | 5 | 345R-1305 | | |
| 63.0 | 13 | 22 | 6.00 | 1 | 4 | 345-063Q22-13L | 22.0 | A | 77.1 | 45.0 | 3.0 | 0.98 | 15500 | 4 | 345R-1305 | | |
| | 13 | 22 | 6.00 | 1 | 5 | 345-063Q22-13M | 22.0 | A | 77.1 | 45.0 | 3.0 | 0.94 | 15500 | 5 | 345R-1305 | | |
| | 13 | 22 | 6.00 | 1 | 6 | 345-063Q22-13H | 22.0 | A | 77.1 | 45.0 | 3.0 | 0.60 | 15500 | 6 | 345R-1305 | | |
| | 13 | 22 | 6.00 | 1 | 7 | 345-063Q22-13HX | 22.0 | A | 77.1 | 45.0 | 3.0 | 1.03 | 15500 | 7 | 345R-1305 | | |
| 80.0 | 13 | 27 | 6.00 | 1 | 4 | 345-080Q27-13L | 27.0 | A | 94.1 | 50.0 | 3.0 | 1.65 | 13700 | 4 | 345R-1305 | | |
| | 13 | 27 | 6.00 | 1 | 6 | 345-080Q27-13M | 27.0 | A | 94.1 | 50.0 | 3.0 | 1.72 | 13700 | 6 | 345R-1305 | | |
| | 13 | 27 | 6.00 | 1 | 8 | 345-080Q27-13H | 27.0 | A | 94.1 | 50.0 | 3.0 | 1.72 | 13700 | 8 | 345R-1305 | | |
| | 13 | 27 | 6.00 | 1 | 9 | 345-080Q27-13HX | 27.0 | A | 94.1 | 50.0 | 3.0 | 1.76 | 13700 | 9 | 345R-1305 | | |
| 100.0 | 13 | 32 | 6.00 | 1 | 5 | 345-100Q32-13L | 32.0 | A | 114.1 | 50.0 | 3.0 | 2.30 | 12200 | 5 | 345R-1305 | | |
| | 13 | 32 | 6.00 | 1 | 7 | 345-100Q32-13M | 32.0 | A | 114.1 | 50.0 | 3.0 | 2.29 | 12200 | 7 | 345R-1305 | | |
| | 13 | 32 | 6.00 | 1 | 10 | 345-100Q32-13H | 32.0 | A | 114.1 | 50.0 | 3.0 | 2.31 | 12200 | 10 | 345R-1305 | | |
| | 13 | 32 | 6.00 | 1 | 11 | 345-100Q32-13HX | 32.0 | A | 114.1 | 50.0 | 3.0 | 2.38 | 12200 | 11 | 345R-1305 | | |
| 125.0 | 13 | 40 | 6.00 | 1 | 6 | 345-125Q40-13L | 40.0 | B | 139.1 | 63.0 | 3.0 | 3.64 | 10900 | 6 | 345R-1305 | | |
| | 13 | 40 | 6.00 | 1 | 8 | 345-125Q40-13M | 40.0 | B | 139.1 | 63.0 | 3.0 | 3.48 | 10900 | 8 | 345R-1305 | | |
| | 13 | 40 | 6.00 | 1 | 12 | 345-125Q40-13H | 40.0 | B | 139.1 | 63.0 | 3.0 | 3.63 | 10900 | 12 | 345R-1305 | | |
| | 13 | 40 | 6.00 | 1 | 14 | 345-125Q40-13HX | 40.0 | B | 139.1 | 63.0 | 3.0 | 3.64 | 10900 | 14 | 345R-1305 | | |
| 160.0 | 13 | 40S | 6.00 | 0 | 7 | 345-160Q40-13L | 40.0 | C | 66.7 | 174.1 | 63.0 | 3.0 | 4.59 | 9600 | 7 | 345R-1305 | |
| | 13 | 40S | 6.00 | 0 | 10 | 345-160Q40-13M | 40.0 | C | 66.7 | 174.1 | 63.0 | 3.0 | 4.50 | 9600 | 10 | 345R-1305 | |
| | 13 | 40S | 6.00 | 0 | 12 | 345-160Q40-13H | 40.0 | C | 66.7 | 174.1 | 63.0 | 3.0 | 4.72 | 9600 | 12 | 345R-1305 | |
| | 13 | 40S | 6.00 | 0 | 16 | 345-160Q40-13HX | 40.0 | C | 66.7 | 174.1 | 63.0 | 3.0 | 4.58 | 9600 | 16 | 345R-1305 | |
| 200.0 | 13 | 60 | 6.00 | 0 | 12 | 345-200Q60-13M | 60.0 | C | 101.6 | 214.1 | 63.0 | 3.0 | 10.60 | 8600 | 12 | 345R-1305 | |
| | 13 | 60 | 6.00 | 0 | 16 | 345-200Q60-13H | 60.0 | C | 101.6 | 214.1 | 63.0 | 3.0 | 6.64 | 8600 | 16 | 345R-1305 | |
| 250.0 | 13 | 60 | 6.00 | 0 | 14 | 345-250Q60-13M | 60.0 | C | 101.6 | 264.1 | 63.0 | 3.0 | 10.36 | 7700 | 14 | 345R-1305 | |
| | 13 | 60 | 6.00 | 0 | 18 | 345-250Q60-13H | 60.0 | C | 101.6 | 264.1 | 63.0 | 3.0 | 10.79 | 7700 | 18 | 345R-1305 | |

| Spare parts | | | | |
|---------------|--------------|--------------|-------------|-------------|
| DC | Shower screw | Insert screw | Shim | Shim screw |
| 40.00-63.00 | 5512-073-01 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 80.00 | 5512-073-02 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 100.00 | 5512-073-05 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 125.00-160.00 | 5512-098-03 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 250.00 | | 416.1-834 | 5322 474-01 | 5512 090-11 |

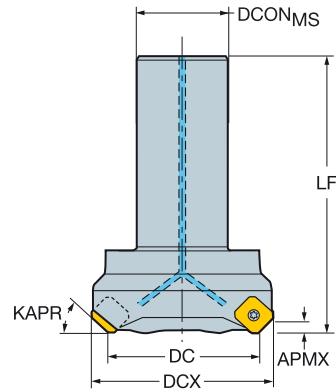
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 345 face milling cutter

Cylindrical shank - Internal coolant supply

KAPR 45°



| | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|------|---------------|--------------------|----------------|----------------|------|-------|------|------|-------|---|-----------|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | DCON _{MS} | DCX | LF | NM | KG | RPMX | CICT | MIID | | |
| 40.0 | 13 | 32 | 6.00 | 1 | 4 | 345-040A32-13M | 32.0 | 54.1 | 120.0 | 3.0 | 1.26 | 19600 | 4 | 345R-1305 |
| 50.0 | 13 | 32 | 6.00 | 1 | 3 | 345-050A32-13L | 32.0 | 64.1 | 120.0 | 3.0 | 1.41 | 17500 | 3 | 345R-1305 |
| | 13 | 32 | 6.00 | 1 | 4 | 345-050A32-13M | 32.0 | 54.1 | 120.0 | 3.0 | 1.41 | 17500 | 4 | 345R-1305 |

Spare parts

| Insert screw | Shim | Shim screw |
|--------------|-------------|-------------|
| 416.1-834 | 5322 474-01 | 5512 090-11 |

For complete list of spare parts, see www.sandvik.coromant.com



I8



L2



N23



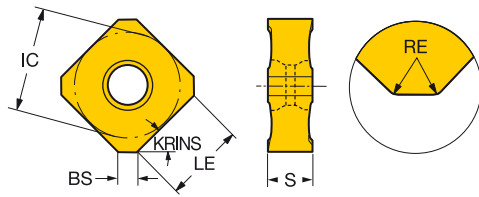
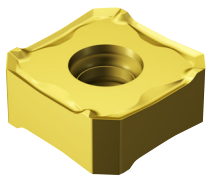
N9



N15

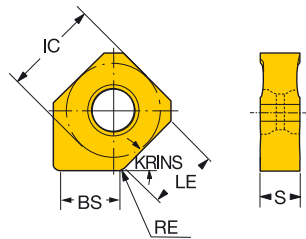
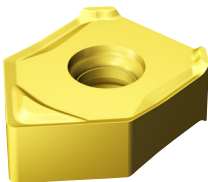
CoroMill® 345 insert for milling

KRINS 45°



| | | RE | Ordering code | P | | | | M | | K | | | | N | | S | | H | | Dimensions, mm | | | | | | | | | | | | |
|--------|------|---------------|---------------|------|------|------|------|-----|------|------|-----|------|------|------|------|------|------|------|-----|----------------|------|------|------|------|------|------|------|------|------|------|------|------|
| | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 2040 | 530 | 1020 | 3040 | 3220 | 3330 | H13A | K20W | 1130 | 530 | H13A | S30T | S40T | H13A | 1010 | 1130 | 530 | IC | LE | S | BS | | |
| Light | KL | 0.80 | 345R-1305E-KL | | | | | | | ★ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | | 13.0 | 8.8 | 5.60 | 2.0 | | | |
| | | 0.80 | 345R-1305M-KL | | ☆ | | | | | | ★ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | | 13.0 | 8.8 | 5.60 | 2.0 | | |
| | 0.80 | 345R-13T5E-ML | | ☆ | | | | | ★ | ☆ | | | | | | | | | ★ | ☆ | | | | | | | 13.0 | 8.8 | 5.95 | 2.0 | | |
| | ML | 0.80 | 345R-1305E-PL | | ☆ | | ★ | ☆ | | | | | | | | | | | | | | | ★ | ☆ | | | 13.0 | 8.8 | 5.60 | 2.0 | | |
| | | 0.80 | 345R-1305M-PL | | ☆ | ☆ | ★ | ☆ | | | | | | | | | | | | | | | | ★ | ☆ | | | 13.0 | 8.8 | 5.60 | 2.0 | |
| Medium | KM | 0.80 | 345R-1305E-KM | | | | | ☆ | | | ☆ | ☆ | | ★ | | | | ☆ | | | | | | ★ | ☆ | | 13.0 | 8.8 | 5.60 | 2.0 | | |
| | | 0.80 | 345R-1305M-KM | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | ★ | ☆ | 13.0 | 8.8 | 5.60 | 2.0 | |
| | 0.80 | 345R-13T5E-MM | | ☆ | | | | | ★ | ☆ | | | | | | | | | ★ | ☆ | | | | | ☆ | ☆ | 13.0 | 8.8 | 5.95 | 2.0 | | |
| | 0.80 | 345R-13T5M-MM | | ☆ | | | | | ★ | ☆ | | | | | | | | | ★ | ☆ | | | | | ☆ | ☆ | 13.0 | 8.8 | 5.95 | 2.0 | | |
| | 0.80 | 345L-1305M-PM | | ☆ | | ★ | ☆ | | | | | | | | | | | | | | | | | | ★ | ☆ | ☆ | ☆ | 13.0 | 8.8 | 5.60 | 2.0 |
| Heavy | PH | 0.80 | 345R-1305M-PM | | ☆ | ☆ | ★ | ☆ | | | | | | | | | | | | | | | | | ★ | ☆ | ☆ | ☆ | 13.0 | 8.8 | 5.60 | 2.0 |
| | | 0.80 | 345R-1305M-KH | | ☆ | ☆ | ★ | ☆ | | | | | ☆ | ☆ | ★ | | ☆ | | | | | | | | | ★ | ☆ | ☆ | ☆ | 13.0 | 8.8 | 5.60 |
| | | 0.80 | 345R-1305M-PH | | ☆ | ☆ | ★ | ☆ | | | | | ★ | | | ☆ | | | | | | | | | ★ | ☆ | | | 13.0 | 8.8 | 5.60 | 2.0 |

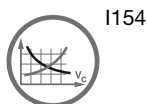
KRINS 45°



Wiper TECHNOLOGY

| | | RE | Ordering code | P | | | M | | K | | | | N | | S | | H | | Dimensions, mm | | | | | | | | | | | | | | |
|-------|-----|------|----------------|------|------|-----|------|------|-----|------|------|------|------|------|------|-----|------|------|----------------|------|------|------|-----|----|----|---|----|------|------|------|------|-------|-------|
| | | | | 1130 | 4330 | 530 | 1040 | 2040 | 530 | 1020 | 3220 | 3330 | H13A | K20W | 1130 | 530 | H13A | H13A | S30T | S40T | 1010 | 1130 | 530 | IC | LE | S | BS | BSR | | | | | |
| Light | KW8 | 1.00 | 345N-1305E-KW8 | | | | | | | | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | | | 13.0 | 8.8 | 5.60 | 8.0 | 500.0 | |
| | | 1.00 | 345N-13T5E-MW8 | | ☆ | | | ☆ | ☆ | | | | | ☆ | | | | | ☆ | ☆ | | | | | | | | | 13.0 | 8.8 | 5.95 | 8.0 | 500.0 |
| | PW8 | 1.00 | 345N-1305E-PW5 | | ☆ | ☆ | | | | | | | ☆ | | | | | | | | | ☆ | ☆ | | | | | | 13.0 | 8.8 | 5.60 | 5.0 | 500.0 |
| | | 1.00 | 345N-1305E-PW8 | | ☆ | ☆ | ☆ | | | | | | ☆ | ☆ | | | | | | | | ☆ | ☆ | ☆ | | | | | 13.0 | 8.8 | 5.60 | 8.0 | 500.0 |

T5 Wiper insert should be used with T5 standard insert



CoroMill® 245

Light-cutting face mill for heavy roughing to mirror finishing

Application

- Face milling
- Roughing to finishing

ISO application area



Benefits and features

- Easy to use and high productivity
- Light cutting with low power consumption
- Close tolerance combined with the wiper insert for superior surface finish
- 45° face milling cutter
- Demanding roughing to mirror finishing
- Smooth and light-cutting action for low cutting forces
- Available in exchangeable cassette system, a concept for rough to semi-finishing of steel



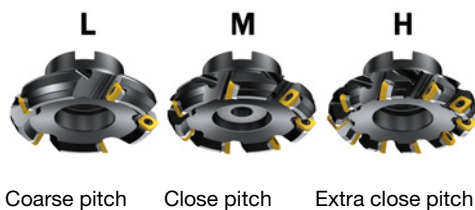
www.sandvik.coromant.com/coromill245

Couplings

- Arbor
- Cylindrical Shank

Inserts

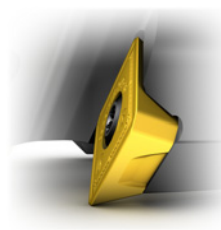
- Four cutting edges
- Wide range of grades and geometries including ceramic and CBN grades
- Wiper inserts for high feed finishing



Coarse pitch

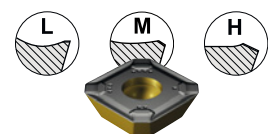
Close pitch

Extra close pitch

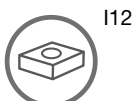


Light cutting action

Single-sided positive inserts positioned to give a smooth cutting action and very low cutting forces.



I10



I12



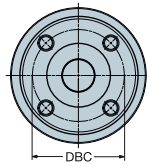
N6

CoroMill® 245 face milling cutter

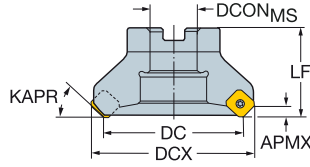
Arbor



STDNO
KAPR



ISO6462
45°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|-------------------|---------------------|---------------|--------------------|-----------------|----------------|-------|-------|-------|------|-------|-------|------|-------------|-------------|--|--|
| DC | CZC _{MS} | APMX _{FFW} | Ordering code | DCON _{MS} | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID | | | | |
| 50.0 | 12 | 22 | 6.00 | 3 | R245-050Q22-12L | 22.0 | A | 62.5 | 40.0 | 3.0 | 0.65 | 16250 | 3 | R245-12T3.. | | | |
| | 12 | 22 | 6.00 | 4 | R245-050Q22-12M | 22.0 | A | 62.5 | 40.0 | 3.0 | 0.67 | 16250 | 4 | R245-12T3.. | | | |
| | 12 | 22 | 6.00 | 5 | R245-050Q22-12H | 22.0 | A | 62.5 | 40.0 | 3.0 | 0.62 | 16250 | 5 | R245-12T3.. | | | |
| 63.0 | 12 | 22 | 6.00 | 4 | R245-063Q22-12L | 22.0 | A | 75.5 | 40.0 | 3.0 | 0.89 | 14400 | 4 | R245-12T3.. | | | |
| | 12 | 22 | 6.00 | 5 | R245-063Q22-12M | 22.0 | A | 75.5 | 40.0 | 3.0 | 0.84 | 14400 | 5 | R245-12T3.. | | | |
| | 12 | 22 | 6.00 | 6 | R245-063Q22-12H | 22.0 | A | 75.5 | 40.0 | 3.0 | 0.87 | 14400 | 6 | R245-12T3.. | | | |
| 80.0 | 12 | 27 | 6.00 | 4 | R245-080Q27-12L | 27.0 | B | 92.5 | 50.0 | 3.0 | 1.50 | 12700 | 4 | R245-12T3.. | | | |
| | 12 | 27 | 6.00 | 6 | R245-080Q27-12M | 27.0 | B | 92.5 | 50.0 | 3.0 | 1.45 | 12700 | 6 | R245-12T3.. | | | |
| | 12 | 27 | 6.00 | 8 | R245-080Q27-12H | 27.0 | B | 92.5 | 50.0 | 3.0 | 1.40 | 12700 | 8 | R245-12T3.. | | | |
| | 18 | 32 | 10.00 | 4 | R245-080Q32-18M | 32.0 | B | 98.8 | 50.0 | 5.0 | 1.72 | 6100 | 4 | R245-18T6.. | | | |
| 100.0 | 18 | 32 | 10.00 | 5 | R245-080Q32-18H | 32.0 | B | 98.8 | 50.0 | 5.0 | 1.60 | 6100 | 5 | R245-18T6.. | | | |
| | 12 | 32 | 6.00 | 5 | R245-100Q32-12L | 32.0 | B | 112.5 | 50.0 | 3.0 | 1.77 | 11300 | 5 | R245-12T3.. | | | |
| | 12 | 32 | 6.00 | 7 | R245-100Q32-12M | 32.0 | B | 112.5 | 50.0 | 3.0 | 1.81 | 11300 | 7 | R245-12T3.. | | | |
| | 12 | 32 | 6.00 | 10 | R245-100Q32-12H | 32.0 | B | 112.5 | 50.0 | 3.0 | 1.74 | 11300 | 10 | R245-12T3.. | | | |
| 125.0 | 18 | 32 | 10.00 | 4 | R245-100Q32-18M | 32.0 | B | 118.8 | 50.0 | 5.0 | 2.08 | 5400 | 4 | R245-18T6.. | | | |
| | 18 | 32 | 10.00 | 6 | R245-100Q32-18H | 32.0 | B | 118.8 | 50.0 | 5.0 | 1.92 | 5400 | 6 | R245-18T6.. | | | |
| | 12 | 40 | 6.00 | 6 | R245-125Q40-12L | 40.0 | B | 137.5 | 63.0 | 3.0 | 3.20 | 10100 | 6 | R245-12T3.. | | | |
| | 12 | 40 | 6.00 | 8 | R245-125Q40-12M | 40.0 | B | 137.5 | 63.0 | 3.0 | 3.12 | 10100 | 8 | R245-12T3.. | | | |
| | 12 | 40 | 6.00 | 12 | R245-125Q40-12H | 40.0 | B | 137.5 | 63.0 | 3.0 | 3.10 | 10100 | 12 | R245-12T3.. | | | |
| 160.0 | 18 | 40 | 10.00 | 5 | R245-125Q40-18M | 40.0 | B | 138.8 | 63.0 | 5.0 | 3.74 | 4900 | 5 | R245-18T6.. | | | |
| | 18 | 40 | 10.00 | 7 | R245-125Q40-18H | 40.0 | B | 138.8 | 63.0 | 5.0 | 3.64 | 4900 | 7 | R245-18T6.. | | | |
| | 12 | 40S | 6.00 | 7 | R245-160Q40-12L | 40.0 | C | 66.7 | 172.5 | 63.0 | 3.0 | 4.63 | 8900 | 7 | R245-12T3.. | | |
| | 12 | 40S | 6.00 | 10 | R245-160Q40-12M | 40.0 | C | 66.7 | 172.5 | 63.0 | 3.0 | 4.50 | 8900 | 10 | R245-12T3.. | | |
| | 12 | 40S | 6.00 | 16 | R245-160Q40-12H | 40.0 | C | 66.7 | 172.5 | 63.0 | 3.0 | 4.49 | 8900 | 16 | R245-12T3.. | | |
| 200.0 | 18 | 40S | 10.00 | 6 | R245-160Q40-18M | 40.0 | C | 66.7 | 178.8 | 63.0 | 5.0 | 5.11 | 4300 | 6 | R245-18T6.. | | |
| | 18 | 40S | 10.00 | 9 | R245-160Q40-18H | 40.0 | C | 66.7 | 178.8 | 63.0 | 5.0 | 4.99 | 4300 | 9 | R245-18T6.. | | |
| | 12 | 60 | 6.00 | 8 | R245-200Q60-12L | 60.0 | C | 101.6 | 212.5 | 63.0 | 3.0 | 6.43 | 7950 | 8 | R245-12T3.. | | |
| | 12 | 60 | 6.00 | 12 | R245-200Q60-12M | 60.0 | C | 101.6 | 212.5 | 63.0 | 3.0 | 10.64 | 7950 | 12 | R245-12T3.. | | |
| 250.0 | 18 | 60 | 10.00 | 8 | R245-200Q60-18M | 60.0 | C | 101.6 | 218.8 | 63.0 | 5.0 | 6.24 | 3800 | 8 | R245-18T6.. | | |
| | 18 | 60 | 10.00 | 12 | R245-200Q60-18H | 60.0 | C | 101.6 | 218.8 | 63.0 | 5.0 | 6.43 | 3800 | 12 | R245-18T6.. | | |
| | 12 | 60 | 6.00 | 10 | R245-250Q60-12L | 60.0 | C | 101.6 | 262.5 | 63.0 | 3.0 | 9.12 | 7100 | 10 | R245-12T3.. | | |
| | 12 | 60 | 6.00 | 14 | R245-250Q60-12M | 60.0 | C | 101.6 | 262.5 | 63.0 | 3.0 | 8.93 | 7100 | 14 | R245-12T3.. | | |
| | 12 | 60 | 6.00 | 24 | R245-250Q60-12H | 60.0 | C | 101.6 | 262.5 | 63.0 | 3.0 | 8.74 | 7100 | 24 | R245-12T3.. | | |
| | 18 | 60 | 10.00 | 10 | R245-250Q60-18M | 60.0 | C | 101.6 | 268.8 | 63.0 | 5.0 | 17.22 | 3400 | 10 | R245-18T6.. | | |
| 18 | 60 | 10.00 | 14 | R245-250Q60-18H | 60.0 | C | 101.6 | 268.8 | 63.0 | 5.0 | 16.00 | 3400 | 14 | R245-18T6.. | | | |

| Spare parts | | | | |
|---------------|--------------|-------------|-------------|-------------|
| DC | Insert screw | Shim | Shim screw | |
| 50.00-250.00 | 12 | 5513 020-01 | 5322 472-01 | 5512 090-09 |
| 80.00-100.00 | 18 | 5513 020-55 | | |
| 125.00-250.00 | 18 | 5513 020-26 | 5322 472-03 | 5512 090-10 |

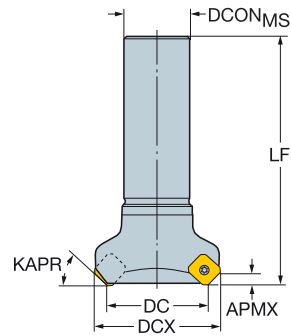
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 245 face milling cutter

Cylindrical shank

KAPR 45°



| | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|------|---------------|--------------------|----------------|------|------|-------|-----|------|-------|------|-------------|
| DC | CZC _{MS} | APMX _{FFW} | | Ordering code | DCON _{MS} | DCX | LB | LF | NM | KG | RPMX | CICT | MIID | |
| 32.0 | 12 | 32 | 6.00 | 3 | R245-032A32-12M | 32.0 | 44.5 | 39.0 | 117.0 | 3.0 | 0.97 | 18250 | 3 | R245-12T3.. |
| 40.0 | 12 | 32 | 6.00 | 3 | R245-040A32-12L | 32.0 | 52.5 | 39.0 | 120.0 | 3.0 | 1.06 | 18250 | 3 | R245-12T3.. |
| 50.0 | 12 | 32 | 6.00 | 3 | R245-050A32-12L | 32.0 | 62.5 | 39.0 | 120.0 | 3.0 | 1.28 | 16250 | 3 | R245-12T3.. |
| | 12 | 32 | 6.00 | 4 | R245-050A32-12M | 32.0 | 62.5 | 39.0 | 120.0 | 3.0 | 1.33 | 16250 | 4 | R245-12T3.. |
| 63.0 | 12 | 32 | 6.00 | 4 | R245-063A32-12L | 32.0 | 75.5 | 39.0 | 120.0 | 3.0 | 1.48 | 14400 | 4 | R245-12T3.. |
| | 12 | 32 | 6.00 | 5 | R245-063A32-12M | 32.0 | 75.5 | 39.0 | 120.0 | 3.0 | 1.49 | 14400 | 5 | R245-12T3.. |
| 80.0 | 12 | 32 | 6.00 | 4 | R245-080A32-12L | 32.0 | 92.5 | 39.0 | 120.0 | 3.0 | 1.80 | 12700 | 4 | R245-12T3.. |
| | 12 | 32 | 6.00 | 6 | R245-080A32-12M | 32.0 | 92.5 | 39.0 | 120.0 | 3.0 | 1.74 | 12700 | 6 | R245-12T3.. |

| Spare parts | | | | |
|-------------|----|--------------|-------------|-------------|
| DC | | Insert screw | Shim | Shim screw |
| 32.00 | 12 | 5513 020-01 | | |
| 40.00-80.00 | 12 | 5513 020-01 | 5322 472-01 | 5512 090-09 |

For complete list of spare parts, see www.sandvik.coromant.com

I12



L2



N23



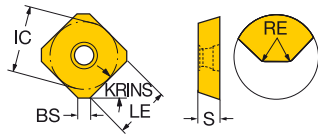
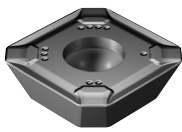
N6



N9

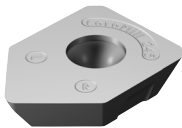
CoroMill® 245 insert for milling

KRINS 45°

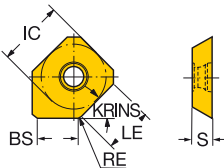


| | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|---------|----|-----------------|-----------------|------|------|------|-----|------|------|------|------|------|------|------|------|------|-----|-----|------|------|------|------|------|------|------|------|-----|---|---|------|------|------|------|------|------|------|-----|
| | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 2040 | 3040 | 3220 | 3330 | H13A | K15W | K20W | 1130 | 530 | H10 | H13A | 1130 | H13A | 530T | S40T | 1010 | 1010 | 1130 | 530 | | | | | | | | | | |
| Light | AL | 12 1.50 | R245-12 T3 E-AL | | | | | | | | | | | | | | | * | | | | | | | | | | | | IC | LE | S | BS | 13.4 | 10.0 | 3.97 | 2.3 |
| | KL | 12 1.50 | R245-12 T3 E-KL | | | | | | | | | | | | | | | | | * | | * | | | | | | | | | 13.4 | 10.0 | 3.97 | 2.1 | | | |
| | | 1.50 | R245-12 T3 M-KL | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 13.4 | 10.0 | 3.97 | 2.0 | | | |
| | ML | 12 1.50 | R245-12 T3 E-ML | * | | | | | * | | | | | | | | | | | | * | | | | | | * | | | | 13.4 | 10.0 | 3.97 | 2.1 | | | |
| | PL | 12 1.50 | R245-12 T3 E-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 13.4 | 10.0 | 3.97 | 2.1 | | |
| 1.50 | | R245-12 T3 M-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 13.4 | 10.0 | 3.97 | 2.1 | | | |
| Medium | KM | 12 1.50 | R245-12 T3 M-KM | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 13.4 | 10.0 | 3.97 | 2.0 | | | | |
| | | 18 1.00 | R245-18 T6 M-KM | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 18.0 | 13.9 | 6.10 | 1.5 | | | | |
| | MM | 12 1.50 | R245-12 T3 K-MM | | | | | | * | | | | | | | | | | | | * | * | | | | | | | | | 13.4 | 10.0 | 3.97 | 2.1 | | | |
| | | 18 1.00 | R245-18 T6 M-MM | | | | | | * | | | | | | | | | | | | * | * | | | | | | | | | 18.0 | 13.9 | 6.10 | 1.5 | | | |
| | PM | 12 1.50 | R245-12 T3 M-PM | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 13.4 | 10.0 | 3.97 | 2.1 | | | |
| 18 1.00 | | R245-18 T6 M-PM | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 18.0 | 13.9 | 6.10 | 1.5 | | | | |
| Heavy | KH | 12 1.50 | R245-12 T3 M-KH | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 13.4 | 10.0 | 3.97 | 2.0 | | | | |
| | | 12 1.60 | R245-12 T3 M-PH | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 13.4 | 9.8 | 3.97 | 1.5 | | | | |

KRINS 45°



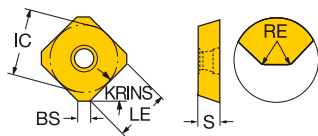
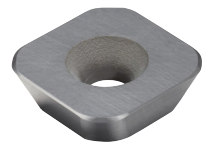
Wiper TECHNOLOGY



| | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|-------|---------|----------------|----------------|-----|------|------|------|------|------|-----|------|-----|------|------|------|------|-----|------|---|---|---|---|---|---|---|---|---|---|---|------|------|------|------|-------|------|-----|------|-----|-------|
| | | | 1130 | 530 | 1020 | 3220 | CB50 | H13A | K15W | H10 | 1130 | 530 | H13A | 1130 | 1010 | 1130 | 530 | CB50 | | | | | | | | | | | | | | | | | | | | | |
| Light | W | 12 2.50 | R245-12 T3 E-W | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | IC | LE | S | BS | BSR | 13.4 | 3.5 | 3.97 | 6.4 | 400.0 |
| | 18 1.00 | R245-18 T6 E-W | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 18.0 | 13.9 | 6.10 | 10.8 | 500.0 | | | | | |

Advanced cutting materials

KRINS 45°



| | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | |
|-------|---------|---------------|----------------|------|------|------|------|------|------|------|-----|------|-----|------|-----|
| | | | K | N | H | H | | | | | | | | | |
| Light | 12 1.50 | R245-12 T3 E | 6190 | CB50 | CD10 | 6190 | CB50 | IC | LE | S | BS | 13.4 | 3.5 | 3.97 | 1.4 |
| | 2.50 | R245-12 T3 E1 | * | * | * | * | * | 13.4 | 10.0 | 3.97 | 0.4 | | | | |



110



1154



1175



N23



N10



N2

CoroMill® 425

Easily adjustable finish face milling

Application

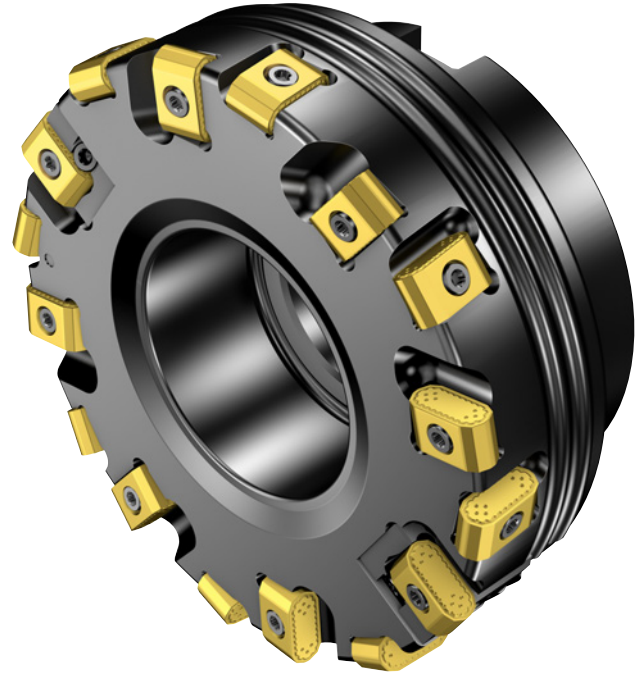
- Finish face milling in cast iron
- Main components: Engine blocks and cylinder heads
- Other components: Axle housings, brake carriers, crank cases

ISO application area:



Benefits and features

- Easy to use
- Eight cutting edges
- Accurate and reliable adjustment system



www.sandvik.coromant.com/coromill425

Couplings

- Arbor
- Cap mounting

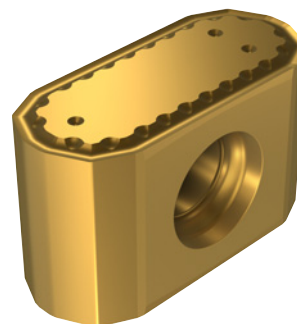
Inserts

- Eight cutting edges

Adjustable wiper inserts

CoroMill® 425 is designed to allow for easily adjustable wiper inserts. You can adjust the wiper insert up and down without loosening the cartridge clamping screw.

Thanks to the design, the adjustment system is very stable and accurate.



I14

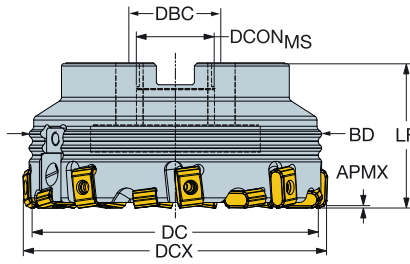


I15

CoroMill® 425 face milling cutter

Arbor

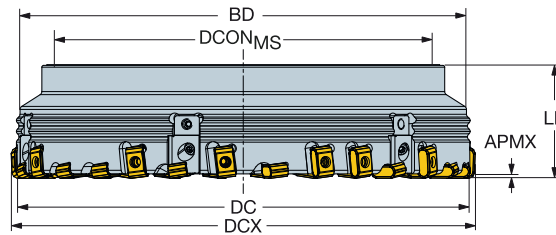
STDNO ISO6462
KAPR 25°



| | | | | | | | Dimensions, mm | | | | | | | | | | |
|-------|-------------------|------|------|---------------|--------------------|----------------|----------------|-----|-------|-------|-------|------|------|-------|------|-----------|-----------|
| DC | CZC _{MS} | APMX | ZADJ | Ordering code | DCON _{MS} | ISO | DBC | DCX | BD | LF | NM | KG | RPMX | CICT | MIID | | |
| 100.0 | 17 | 32 | 0.9 | 2 | 12 | 425-100Q32-17H | 32.0 | A | 107.0 | 101.9 | 63.0 | 3.0 | 2.23 | 4770 | 12 | 425N-1707 | |
| 125.0 | 17 | 40 | 0.9 | 2 | 16 | 425-125Q40-17H | 40.0 | B | 132.0 | 126.6 | 63.0 | 3.0 | 3.45 | 3820 | 16 | 425N-1707 | |
| 160.0 | 17 | 40S | 0.9 | 3 | 18 | 425-160Q40-17H | 40.0 | C | 66.7 | 167.0 | 161.3 | 63.0 | 3.0 | 5.10 | 2980 | 18 | 425N-1707 |
| 200.0 | 17 | 60 | 0.9 | 3 | 24 | 425-200Q60-17H | 60.0 | C | 101.6 | 207.0 | 201.1 | 63.0 | 3.0 | 7.69 | 2390 | 24 | 425N-1707 |
| 250.0 | 17 | 60 | 0.9 | 6 | 30 | 425-250Q60-17H | 60.0 | C | 101.6 | 257.0 | 251.1 | 63.0 | 3.0 | 12.99 | 1910 | 30 | 425N-1707 |

Cap coupling

KAPR 25°



| | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|------|------|---------------|--------------------|--------------|----------------|-------|-------|------|-------|-------|------|-----------|-----------|--|
| DC | CZC _{MS} | APMX | ZADJ | Ordering code | DCON _{MS} | DCX | BD | LF | NM | KG | RPMX | CICT | MIID | | | |
| 250.0 | 17 | 250 | 0.9 | 6 | 30 | 425-250P-17H | 203.7 | 257.0 | 251.1 | 63.0 | 3.0 | 9.62 | 1910 | 30 | 425N-1707 | |
| 17 | 250 | 0.9 | 6 | 30 | L425-250P-17H | 203.7 | 257.0 | 251.1 | 63.0 | 3.0 | 9.62 | 1910 | 30 | 425N-1707 | | |
| 315.0 | 17 | 315 | 0.9 | 6 | 36 | 425-315P-17H | 268.7 | 322.0 | 316.1 | 63.0 | 3.0 | 13.60 | 1520 | 36 | 425N-1707 | |
| 17 | 315 | 0.9 | 6 | 36 | L425-315P-17H | 268.7 | 322.0 | 316.1 | 63.0 | 3.0 | 13.60 | 1520 | 36 | 425N-1707 | | |
| 355.0 | 17 | 355 | 0.9 | 6 | 48 | 425-355P-17H | 308.7 | 362.0 | 356.1 | 63.0 | 3.0 | 16.45 | 1340 | 48 | 425N-1707 | |
| 17 | 355 | 0.9 | 6 | 48 | L425-355P-17H | 308.7 | 362.0 | 356.1 | 63.0 | 3.0 | 16.45 | 1340 | 48 | 425N-1707 | | |
| 400.0 | 17 | 400 | 0.9 | 9 | 54 | 425-400P-17H | 353.7 | 407.0 | 401.1 | 63.0 | 3.0 | 20.09 | 1190 | 54 | 425N-1707 | |
| 17 | 400 | 0.9 | 9 | 54 | L425-400P-17H | 353.7 | 407.0 | 401.1 | 63.0 | 3.0 | 20.09 | 1190 | 54 | 425N-1707 | | |
| 500.0 | 17 | 500 | 0.9 | 9 | 54 | 425-500P-17M | 453.7 | 507.0 | 501.1 | 63.0 | 3.0 | 30.92 | 950 | 54 | 425N-1707 | |
| 17 | 500 | 0.9 | 9 | 54 | L425-500P-17M | 453.7 | 507.0 | 501.1 | 63.0 | 3.0 | 42.00 | 950 | 54 | 425N-1707 | | |

Spare parts

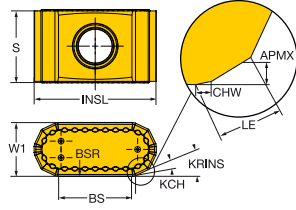
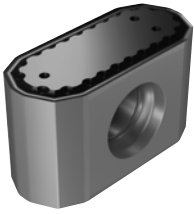
| Clamping screw | Wedge | Screw | Screw | Insert screw | Cassette |
|----------------|-------------|-------------|-------------|--------------|--------------|
| 3212 012-260 | 5332 010-09 | 5516 035-09 | 5513 014-75 | 5513 020-13 | R425-CA-17-2 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 425 insert for milling

KRINS 25°



| | | | | | | K | | Dimensions, mm | | | | | | |
|-------|-----|---------|-----|------------------|------|------|------|----------------|------|----|-----|-----|-------|------|
| Light | KLW | KCH CHW | | Ordering code | 1010 | 1020 | 3220 | 3330 | K20W | W1 | LE | S | BS | BSR |
| | | 17 | 14° | | 0.4 | ★ | ☆ | ☆ | ☆ | ☆ | 7.5 | 2.1 | 10.00 | 10.4 |
| | | | | 425N-1707E-KLW12 | | | | | | | | | | |
| | | | | | | | | | | | | | | |
| | | | | | | | | | | | | | | |



I14



I154



I175



N23



N10



CoroMill® 745

Multi-edge face milling and high feed milling concepts

Application

- Face milling
- Roughing to semi-finishing
- High feed milling

ISO application area:



Benefits and features

- Multi-edge concept suitable for large batch productions, flexible transfer lines and when maximum tool utilization is important
- CoroMill 745 with 42° entering angle is used in ISO P, K, M and S applications where APMX is 5.2 mm
- CoroMill 745 high feed cutter with 25° entering angle is used as a productivity booster in ISO P and ISO K applications where APMX is 2.8 mm
- Great problem-solving abilities when machining vibration-sensitive components and in weak set-ups with the unique differential MD pitch



CoroMill® 745 face milling cutter See page I17

CoroMill® 745 high feed face milling cutter See page I43

www.sandvik.coromant.com/coromill745

Couplings

- Coromant Capto®
- Arbor

Inserts

- 14 cutting edges
- The secure tip seat and the large, robust insert with strong, light-cutting geometries are designed for reliable and predictable machining.

Ground-breaking technology

Available with 42° entering angle for larger cutting depths and as a high feed version with 25° entering angle for an even higher metal removal rate. Same inserts are used in both cutters.



Differential MD pitch

The unique differential MD pitch is first choice in roughing operations where light cutting action is required, e.g. in vibration-sensitive and weak set-ups. It is a perfect problem-solver when vibration is a limitation in the production. The length and weight of the cutter body has been reduced in order to boost the performance in low-productive applications. The cutter has a logarithmic differential pitch design, and the insert position is radially compensated to produce an even chip load on every insert.



I17



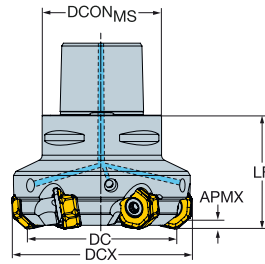
I19

CoroMill® 745 face milling cutter

Coromant Capto® - Internal coolant supply

KAPR

42°



| | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|---------------------|------|---------------|----|--------------------|------|-------|------|------|------|------|------|-----------|--|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | | DCON _{MS} | DCX | LF | NM | KG | RPMX | CICT | MIID | | |
| 63.0 | 21 | C5 | 5.20 | 3 | 5 | 745-063C5-21M | 50.0 | 78.2 | 60.0 | 12.0 | 1.30 | 5894 | 5 | 745R-2109 | |
| | 21 | C6 | 5.20 | 3 | 5 | 745-063C6-21M | 63.0 | 78.2 | 60.0 | 12.0 | 1.84 | 5894 | 5 | 745R-2109 | |
| | 21 | C5 | 5.20 | 3 | 7 | 745-063C5-21H | 50.0 | 78.2 | 60.0 | 12.0 | 1.34 | 5894 | 7 | 745R-2109 | |
| | 21 | C6 | 5.20 | 3 | 7 | 745-063C6-21H | 63.0 | 78.2 | 60.0 | 12.0 | 1.66 | 5894 | 7 | 745R-2109 | |
| 80.0 | 21 | C6 | 5.20 | 3 | 6 | 745-080C6-21M | 63.0 | 95.2 | 60.0 | 12.0 | 2.21 | 5324 | 6 | 745R-2109 | |
| | 21 | C8 | 5.20 | 3 | 6 | 745-080C8-21M | 80.0 | 95.2 | 65.0 | 12.0 | 3.12 | 5324 | 6 | 745R-2109 | |
| | 21 | C6 | 5.20 | 3 | 9 | 745-080C6-21H | 63.0 | 95.2 | 60.0 | 12.0 | 2.09 | 5324 | 9 | 745R-2109 | |
| | 21 | C8 | 5.20 | 3 | 9 | 745-080C8-21H | 80.0 | 95.2 | 65.0 | 12.0 | 3.23 | 5324 | 9 | 745R-2109 | |
| 100.0 | 21 | C8 | 5.20 | 3 | 7 | 745-100C8-21M | 80.0 | 115.2 | 65.0 | 12.0 | 3.66 | 4765 | 7 | 745R-2109 | |
| | 21 | C8 | 5.20 | 3 | 11 | 745-100C8-21H | 80.0 | 115.2 | 65.0 | 12.0 | 3.62 | 4765 | 11 | 745R-2109 | |

Spare parts

Insert screw
5513 020-80

For complete list of spare parts, see www.sandvik.coromant.com



I19



L2



N23



N9



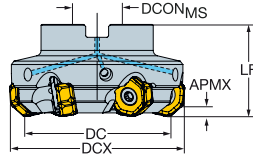
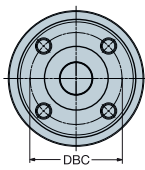
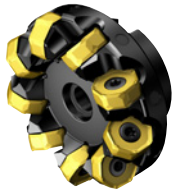
N15

CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

STDNO
KAPR

ISO6462
42°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|-------------------|---------------------|------|---------------|----|--------------------|------|-----|-------|-------|------|------|------|------|-----------|-----------|--|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | | DCON _{MS} | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID | | |
| 63.0 | 21 | 22 | 5.20 | 3 | 5 | 745-063Q22-21M | 22.0 | A | 78.2 | 50.0 | 12.0 | 0.80 | 5894 | 5 | 745R-2109 | | |
| | 21 | 22 | 5.20 | 3 | 5 | 745-063Q22-21MD | 22.0 | A | 78.2 | 46.0 | 12.0 | 0.83 | 5894 | 5 | 745R-2109 | | |
| | 21 | 22 | 5.20 | 3 | 7 | 745-063Q22-21H | 22.0 | A | 78.2 | 50.0 | 12.0 | 0.98 | 5894 | 7 | 745R-2109 | | |
| 80.0 | 21 | 27 | 5.20 | 3 | 6 | 745-080Q27-21M | 27.0 | A | 95.2 | 50.0 | 12.0 | 1.48 | 5324 | 6 | 745R-2109 | | |
| | 21 | 27 | 5.20 | 3 | 6 | 745-080Q27-21MD | 27.0 | A | 95.2 | 48.0 | 12.0 | 1.38 | 5324 | 6 | 745R-2109 | | |
| | 21 | 27 | 5.20 | 3 | 9 | 745-080Q27-21H | 27.0 | A | 95.2 | 50.0 | 12.0 | 1.37 | 5324 | 9 | 745R-2109 | | |
| 100.0 | 21 | 32 | 5.20 | 3 | 7 | 745-100Q32-21M | 32.0 | A | 115.2 | 50.0 | 12.0 | 2.19 | 4765 | 7 | 745R-2109 | | |
| | 21 | 32 | 5.20 | 3 | 7 | 745-100Q32-21MD | 32.0 | A | 115.2 | 50.0 | 12.0 | 2.12 | 4765 | 7 | 745R-2109 | | |
| | 21 | 32 | 5.20 | 3 | 11 | 745-100Q32-21H | 32.0 | A | 115.2 | 50.0 | 12.0 | 2.01 | 4765 | 11 | 745R-2109 | | |
| 125.0 | 21 | 40 | 5.20 | 3 | 8 | 745-125Q40-21M | 40.0 | B | 140.2 | 63.0 | 12.0 | 3.75 | 4216 | 8 | 745R-2109 | | |
| | 21 | 40 | 5.20 | 3 | 8 | 745-125Q40-21MD | 40.0 | B | 140.2 | 54.0 | 12.0 | 2.95 | 4216 | 8 | 745R-2109 | | |
| | 21 | 40 | 5.20 | 3 | 14 | 745-125Q40-21H | 40.0 | B | 140.2 | 63.0 | 12.0 | 3.53 | 4216 | 14 | 745R-2109 | | |
| 160.0 | 21 | 40 | 5.20 | 3 | 10 | 745-160Q40-21M | 40.0 | B | 175.2 | 63.0 | 12.0 | 5.26 | 3675 | 10 | 745R-2109 | | |
| | 21 | 40 | 5.20 | 3 | 10 | 745-160Q40-21MD | 40.0 | B | 175.2 | 60.0 | 12.0 | 4.70 | 3675 | 10 | 745R-2109 | | |
| | 21 | 40 | 5.20 | 3 | 16 | 745-160Q40-21H | 40.0 | B | 175.2 | 63.0 | 12.0 | 4.75 | 3675 | 16 | 745R-2109 | | |
| 200.0 | 21 | 60 | 5.20 | 0 | 14 | 745-200Q60-21M | 60.0 | C | 101.6 | 215.2 | 63.0 | 12.0 | 6.31 | 3292 | 14 | 745R-2109 | |
| | 21 | 60 | 5.20 | 0 | 21 | 745-200Q60-21H | 60.0 | C | 101.6 | 215.2 | 63.0 | 12.0 | 6.61 | 3292 | 21 | 745R-2109 | |
| 250.0 | 21 | 60 | 5.20 | 0 | 16 | 745-250Q60-21M | 60.0 | C | 101.6 | 264.4 | 63.0 | 12.0 | 9.40 | 2998 | 16 | 745R-2109 | |
| | 21 | 60 | 5.20 | 0 | 26 | 745-250Q60-21H | 60.0 | C | 101.6 | 264.4 | 63.0 | 12.0 | 9.00 | 2998 | 26 | 745R-2109 | |

| Spare parts | | |
|---------------|--------------|--------------|
| DC | Shower screw | Insert screw |
| 63.00 | 5512 073-01 | 5513 020-80 |
| 80.00 | 5512 073-02 | 5513 020-80 |
| 100.00 | 5512 073-05 | 5513 020-80 |
| 125.00-160.00 | 5512 098-03 | 5513 020-80 |
| 250.00 | - | 5513 020-80 |

For complete list of spare parts, see www.sandvik.coromant.com



I45



L2



M1



N23



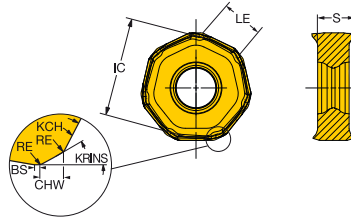
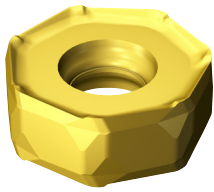
N9



N15

CoroMill® 745 insert for milling

KRINS 42°



| | | RE | KCH | CHW | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | |
|--------|-----|------|------|-----|----------------|----------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|-------|
| | | | | | | P | | | M | K | | | S | | IC | LE | S | BS | BSR | | | | |
| | | | | | | 1130 | 4220 | 4230 | 4240 | 1040 | 2040 | 1020 | 3040 | K200 | K20W | S30T | S40T | | | | | | |
| Medium | M30 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-M30 | ★ | ☆ | ★ | ☆ | | | ★ | ☆ | ☆ | ☆ | | | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | M31 | 21 | 1.00 | | | 745R-2109E-M31 | ★ | ☆ | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | 21.0 | 7.1 | 9.00 | 1.9 | 150.0 |
| | | | | | | | | | | | | | | | | | | | | | | | |
| | M50 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-M50 | ☆ | ☆ | ★ | ☆ | | | | ★ | ☆ | ☆ | | | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | 1.00 | 17° | 1.3 | 745L-2109E-M50 | | | ★ | | | | | | ☆ | ☆ | | | 21.0 | 8.5 | 9.00 | 0.3 | 25.0 | |
| Heavy | H50 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-H50 | ☆ | ★ | ☆ | | | | ★ | ☆ | ☆ | | | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 | |
| | | | | | | | | | | | | | | | | | | | | | | | |

745R-2109E-M31 not recommended for CoroMill 745 high feed cutter with 25° entering angle.



I17



I154



I175



N23



N10

CoroMill® 360

Heavy duty face mill

ISO application area:



Application

- Heavy duty face milling

Benefits and features

- Exchangeable insert cassettes with serrated interfaces provide for safe, accurate location and easy handling
- Separate cassettes for each insert size for use in the same cutter body reduces down time and inventory
- Right- or left-hand tool design available
- Unique cassette solution



M

H



The unique cassette solution with wedge-clamped inserts gives high security and easy handling when indexing inserts. The same body is used for both cassette sizes. There is a separate wedge and cassette for respective insert size. When replacing ensure you have the correct size of each.



I21



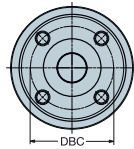
I22

CoroMill® 360 face milling cutter

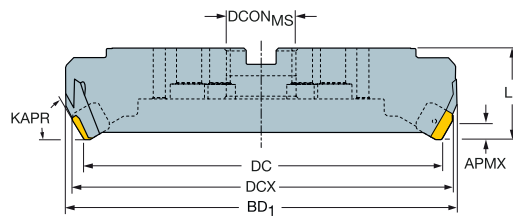
Arbor



STDNO
KAPR



ISO6462
60°



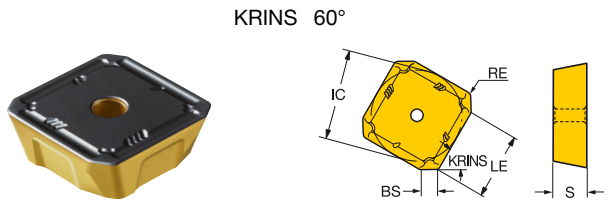
| | | Dimensions, mm | | | | | | | | | | | | | | | | |
|-------|-------------------|----------------|------|---------------|----|--------------------|------|-----|-------|-------|-------|------|------|-------|-------|------|-----------|-----------|
| DC | CZC _{MS} | APMX | ZADJ | Ordering code | | DCON _{MS} | ISO | DBC | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MID | |
| 160.0 | 19 | 40 | 13.0 | 6 | 6 | 360-160Q40-Z8D19 | 40.0 | B | 175.0 | 186.6 | 13.0 | 80.0 | 16.0 | 16.11 | 795 | 6 | 360R-1906 | |
| | 19 | 40 | 13.0 | 8 | 8 | 360-160Q40-Z8E19 | 40.0 | B | 175.0 | 186.6 | 13.0 | 80.0 | 16.0 | 10.66 | 795 | 8 | 360R-1906 | |
| | 28 | 40 | 18.0 | 8 | 8 | 360-160Q40-Z8E28 | 40.0 | B | 180.8 | 186.2 | 18.0 | 80.0 | 16.0 | 15.47 | 795 | 8 | 360R-2807 | |
| 200.0 | 19 | 60 | 13.0 | 8 | 8 | 360-200Q60-Z8D19 | 60.0 | C | 101.6 | 215.0 | 226.6 | 13.0 | 80.0 | 16.0 | 19.96 | 640 | 8 | 360R-1906 |
| | 19 | 60 | 13.0 | 10 | 10 | 360-200Q60-Z10E19 | 60.0 | C | 101.6 | 215.0 | 226.6 | 13.0 | 80.0 | 16.0 | 19.78 | 640 | 10 | 360R-1906 |
| | 28 | 60 | 18.0 | 10 | 10 | 360-200Q60-Z10E28 | 60.0 | C | 101.6 | 220.8 | 226.2 | 18.0 | 80.0 | 16.0 | 15.20 | 640 | 10 | 360R-2807 |
| 250.0 | 19 | 60 | 13.0 | 10 | 10 | 360-250Q60-Z10D19 | 60.0 | C | 101.6 | 265.0 | 276.6 | 13.0 | 80.0 | 16.0 | 26.77 | 510 | 10 | 360R-1906 |
| | 19 | 60 | 13.0 | 12 | 12 | 360-250Q60-Z12E19 | 60.0 | C | 101.6 | 265.0 | 276.6 | 13.0 | 80.0 | 16.0 | 27.00 | 510 | 12 | 360R-1906 |
| | 28 | 60 | 18.0 | 10 | 10 | 360-250Q60-Z10D28 | 60.0 | C | 101.6 | 270.8 | 276.2 | 18.0 | 80.0 | 16.0 | 26.50 | 510 | 10 | 360R-2807 |
| | 28 | 60 | 18.0 | 12 | 12 | 360-250Q60-Z12E28 | 60.0 | C | 101.6 | 270.8 | 276.2 | 18.0 | 80.0 | 16.0 | 26.13 | 510 | 12 | 360R-2807 |
| 315.0 | 19 | 60 | 13.0 | 12 | 12 | 360-315Q60-Z12D19 | 60.0 | C | 330.0 | 341.6 | 330.0 | 13.0 | 80.0 | 16.0 | 42.32 | 405 | 12 | 360R-1906 |
| | 28 | 60 | 18.0 | 12 | 12 | 360-315Q60-Z12D28 | 60.0 | C | 335.8 | 341.2 | 341.2 | 18.0 | 80.0 | 16.0 | 39.90 | 405 | 12 | 360R-2807 |
| | 28 | 60 | 18.0 | 15 | 15 | 360-315Q60-Z15E28 | 60.0 | C | 335.8 | 341.2 | 341.2 | 18.0 | 80.0 | 16.0 | 34.00 | 405 | 15 | 360R-2807 |
| 400.0 | 19 | 60 | 13.0 | 15 | 15 | 360-400Q60-Z15D19 | 60.0 | C | 415.0 | 426.6 | 426.6 | 13.0 | 80.0 | 16.0 | 60.00 | 320 | 15 | 360R-1906 |
| | 28 | 60 | 18.0 | 15 | 15 | 360-400Q60-Z15D28 | 60.0 | C | 420.8 | 426.2 | 426.2 | 18.0 | 80.0 | 16.0 | 58.00 | 320 | 15 | 360R-2807 |

| Spare parts | | | | | | |
|---------------|-------------------|------------|--------------|--------------------|----------------|----------------------|
| DC | CZC _{MS} | Cassette | Insert wedge | Insert wedge screw | Cassette wedge | Cassette wedge screw |
| 160.00-315.00 | 19 | 360R-CA-19 | 360R-IW-19 | 267.21-830 | 5431 105-08 | 5516 010-06 |
| 200.00-400.00 | 28 | 360R-CA-28 | 360R-IW-28 | 267.21-830 | 5431 105-08 | 5516 010-06 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 360 insert for milling



| | SSC | RE | Ordering code | P | | | | | | M | | K | | Dimensions, mm | | | | |
|-------|------|----------------|----------------|----------------|------|------|------|------|------|------|----|----|------|----------------|------|------|-------|-------|
| | | | | 4220 | 4330 | 4340 | 2030 | 2040 | 3040 | 3330 | IC | LE | S | BS | BSR | | | |
| Heavy | KH | 19 | 1.60 | 360R-19 06M-KH | | | | | | ☆ | ★ | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | 28 | 1.70 | 360L-2807M-KH | | | | | | ★ | | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | 1.70 | 360R-28 07M-KH | | | | | | | ☆ | ★ | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | MH | 19 | 1.60 | 360L-1906M-MH | | | | | | ★ | | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | 1.60 | 360R-19 06M-MH | | | | ☆ | ★ | | | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 | |
| | | 28 | 1.70 | 360L-2807M-MH | | | | | | ★ | | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | PH | 1.70 | 360R-28 07M-MH | | | | | | | ★ | | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | 19 | 1.60 | 360L-1906M-PH | | ★ | | | | | | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | 1.60 | 360R-19 06M-PH | ☆ | ★ | ☆ | | | | | | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | 28 | 1.70 | 360L-2807M-PH | | ★ | | | | | | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 | |
| | 1.70 | 360R-28 07M-PH | ★ | ☆ | | | | | | | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 | |



I21



I154



I175



N23



N10

CoroMill® 365

Secure face milling in cast iron and steel

ISO application area



Application

- Face milling
- Roughing to semi-finishing

Benefits and features

- Unique design with eight true cutting edges for high productivity machining to achieve low cost per component
- Multi-edge self-located insert provides robust and reliable machining
- Coromant Capto® coupling or Arbor mounted
- Through coolant design
- Geometry and grade laser marked on the insert for easy identification
- Wiper inserts for improved surface finish



CoroMill® 365 is the essential tool for rough to semi-finish face milling of cast iron and steel components. Use the tool for large series production and applications where high metal removal rate is critical.

Inserts

- The tool design gives large support surface and optimal distribution of cutting forces.



I24



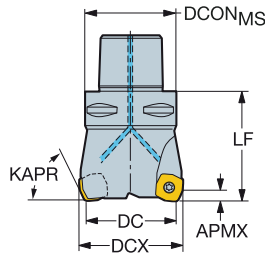
I26

CoroMill® 365 face milling cutter

Coromant Capto®

Screw clamp design

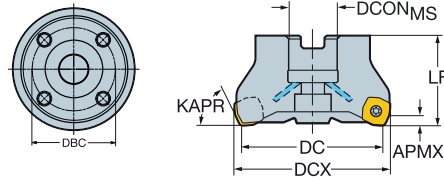
KAPR 65°



| | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|------|------|---------------|--------------------|-----------------|------|------|------|------|------|-------|---|--------------|
| DC | CZC _{MS} | APMX | CNSC | Ordering code | DCON _{MS} | DCX | LF | NM | KG | RPMX | CICT | MIID | | |
| 60.0 | 15 | C6 | 6.0 | 3 | 5 | R365-063C6-S15M | 63.0 | 69.7 | 60.0 | 3.0 | 1.88 | 13600 | 5 | R365-1505ZNE |

Arbor
Screw clamp design

STDNO
KAPR ISO6462
65°



| | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|------|------|---------------|--------------------|------------------|------|-------|-------|-------|------|-------|-------|--------------|--------------|
| DC | CZC _{MS} | APMX | CNSC | Ordering code | DCON _{MS} | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID | |
| 50.0 | 15 | 22 | 6.0 | 1 | 5 | R365-050Q22-S15H | 22.0 | A | 56.7 | 50.0 | 3.0 | 0.68 | 15700 | 5 | R365-1505ZNE |
| 63.0 | 15 | 22 | 6.0 | 1 | 5 | R365-063Q22-S15M | 22.0 | A | 69.7 | 50.0 | 3.0 | 1.00 | 13600 | 5 | R365-1505ZNE |
| 15 | 22 | 6.0 | 1 | 6 | R365-063Q22-S15H | 22.0 | A | 69.7 | 50.0 | 3.0 | 0.98 | 13600 | 6 | R365-1505ZNE | |
| 80.0 | 15 | 27 | 6.0 | 1 | 6 | R365-080Q27-S15M | 27.0 | A | 86.7 | 50.0 | 3.0 | 1.70 | 11500 | 6 | R365-1505ZNE |
| 15 | 27 | 6.0 | 1 | 8 | R365-080Q27-S15H | 27.0 | A | 86.7 | 50.0 | 3.0 | 1.68 | 11500 | 8 | R365-1505ZNE | |
| 100.0 | 15 | 32 | 6.0 | 1 | 7 | R365-100Q32-S15M | 32.0 | A | 106.7 | 50.0 | 3.0 | 2.20 | 9900 | 7 | R365-1505ZNE |
| 15 | 32 | 6.0 | 1 | 10 | R365-100Q32-S15H | 32.0 | A | 106.7 | 50.0 | 3.0 | 2.20 | 9900 | 10 | R365-1505ZNE | |
| 125.0 | 15 | 40 | 6.0 | 1 | 8 | R365-125Q40-S15M | 40.0 | B | 131.7 | 63.0 | 3.0 | 3.94 | 8500 | 8 | R365-1505ZNE |
| 15 | 40 | 6.0 | 1 | 12 | R365-125Q40-S15H | 40.0 | B | 131.7 | 63.0 | 3.0 | 3.87 | 8500 | 12 | R365-1505ZNE | |
| 160.0 | 15 | 40S | 6.0 | 0 | 10 | R365-160Q40-S15M | 40.0 | C | 66.7 | 166.7 | 63.0 | 5.80 | 7500 | 10 | R365-1505ZNE |
| 15 | 40S | 6.0 | 0 | 14 | R365-160Q40-S15H | 40.0 | C | 66.7 | 166.7 | 63.0 | 5.76 | 7500 | 14 | R365-1505ZNE | |

| |
|-------------|
| Spare parts |
| Screw |
| 5513 020-29 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 365 face milling cutter

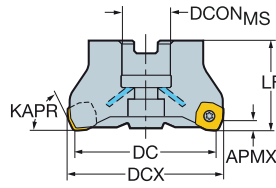
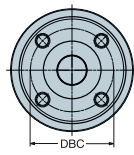
Arbor

Wedge clamp design



STDNO
KAPR

ISO6462
65°



| | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|------|------------------|--------------------|----------------|-------|-------|------|-----|-------|-------|------|--------------|--|
| DC | CZC _{MS} | APMX | Ordering code | DCON _{MS} | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID | |
| 80.0 | 15 | 27 | R365-080Q27-W15H | 27.0 | A | 86.7 | 86.7 | 50.0 | 6.0 | 1.79 | 11200 | 10 | R365-1505ZNE | |
| | 15 | 27 | L365-080Q27-W15H | 27.0 | A | 86.7 | 86.7 | 50.0 | 6.0 | 1.79 | 11200 | 10 | L365-1505ZNE | |
| 100.0 | 15 | 32 | R365-100Q32-W15H | 32.0 | A | 106.7 | 106.7 | 50.0 | 6.0 | 2.26 | 9900 | 14 | R365-1505ZNE | |
| 125.0 | 15 | 40 | R365-125Q40-W15H | 40.0 | B | 131.7 | 131.7 | 63.0 | 6.0 | 4.00 | 8800 | 18 | R365-1505ZNE | |
| | 15 | 40 | L365-125Q40-W15H | 40.0 | B | 131.7 | 131.7 | 63.0 | 6.0 | 4.00 | 8800 | 18 | L365-1505ZNE | |
| 160.0 | 15 | 40S | R365-160Q40-W15H | 40.0 | C | 66.7 | 166.7 | 63.0 | 6.0 | 5.86 | 7700 | 22 | R365-1505ZNE | |
| 200.0 | 15 | 60 | R365-200Q60-W15H | 60.0 | C | 101.6 | 206.7 | 63.0 | 6.0 | 14.54 | 6800 | 28 | R365-1505ZNE | |
| 250.0 | 15 | 60 | R365-250Q60-W15H | 60.0 | C | 101.6 | 256.7 | 63.0 | 6.0 | 20.16 | 6100 | 36 | R365-1505ZNE | |

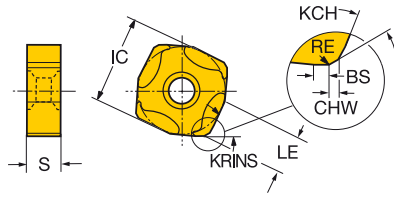
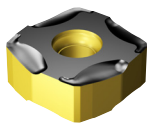
| Spare parts | |
|-------------|-------------|
| Wedge screw | Wedge |
| 339-831 | 5431 058-01 |

For complete list of spare parts, see www.sandvik.coromant.com



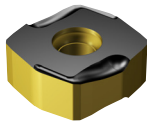
CoroMill® 365 insert for milling

KRINS 65°

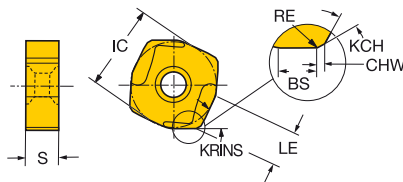


| | RE | KCH | CHW | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | |
|--------|----|------|------|---------------|-----------------|-----------------|------|------|------|------|------|------|------|------|------|------|------|------|-----|------|-----|-------|
| | | | | | P | M | K | N | S | H | IC | LE | S | BS | BSR | | | | | | | |
| Light | KL | 15 | 30° | 0.7 | L365-1505ZNE-KL | 1130 | 4220 | 4330 | 1130 | 1020 | 3330 | K200 | K20W | 1130 | 1130 | 1010 | 1130 | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| | | 0.30 | 35° | 0.7 | R365-1505ZNE-KL | | | | | ★ | ☆ | ☆ | ☆ | | | | | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| | PL | 15 | 0.30 | 35° | 0.7 | R365-1505ZNE-PL | ☆ | | | ☆ | | | | | ☆ | ☆ | ☆ | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| Medium | KM | 15 | 0.30 | 35° | 0.7 | L365-1505ZNE-KM | | | | | ☆ | ★ | ☆ | ☆ | | | | 15.0 | 6.4 | 5.66 | 1.5 | |
| | | 0.30 | 35° | 0.7 | R365-1505ZNE-KM | | | | | ☆ | ★ | ☆ | ☆ | | | | | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| | PM | 15 | 0.30 | 35° | 0.7 | R365-1505ZNE-PM | ☆ | ☆ | ★ | ☆ | | | | | ☆ | ☆ | ☆ | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |

KRINS 65°



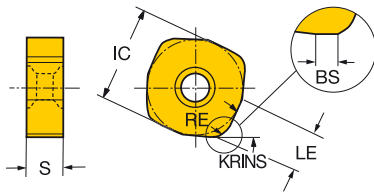
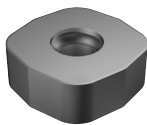
Wiper TECHNOLOGY



| | RE | KCH | CHW | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | |
|-------|-----|------|------|---------------|------------------|------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|-------|
| | | | | | P | M | K | H | IC | LE | S | BS | BSR | | | | | | | | |
| Light | KW4 | 15 | 0.55 | 35° | 0.8 | N365-1505ZNE-KW4 | 1030 | 1130 | 1030 | 1130 | 1020 | K20W | 3220 | 3330 | 1030 | 1130 | 15.0 | 6.4 | 5.66 | 4.0 | 200.0 |
| | | 0.20 | 35° | 0.8 | N365-1505ZNE-KW8 | | | | | ☆ | ☆ | ☆ | ☆ | | | | | 15.0 | 6.4 | 5.66 | 8.0 |
| | PW4 | 15 | 0.55 | 35° | 0.8 | N365-1505ZNE-PW4 | ☆ | | ☆ | | | | | | ☆ | | 15.0 | 6.4 | 5.66 | 4.0 | 200.0 |
| | PW8 | 15 | 0.20 | 35° | 0.8 | N365-1505ZNE-PW8 | | ☆ | ☆ | | | | | | ☆ | | 15.0 | 6.4 | 5.66 | 8.0 | 431.0 |

Advanced cutting materials

KRINS 65°



| | RE | Ordering code | Dimensions, mm | | | | | | | |
|--------|------|---------------|----------------|------|------|-----|------|-----|-------|--|
| | | | K | H | IC | LE | S | BS | BSR | |
| Light | 3.60 | N365-1505ZNE | 6190 | 6190 | 15.0 | 6.4 | 5.66 | 1.2 | 150.0 | |
| | | | ☆ | ☆ | | | | | | |
| Medium | 3.60 | N365-150536E | 6190 | 6190 | 15.0 | 6.4 | 5.66 | | | |
| | | | ☆ | ☆ | | | | | | |



I24



I154



I175





















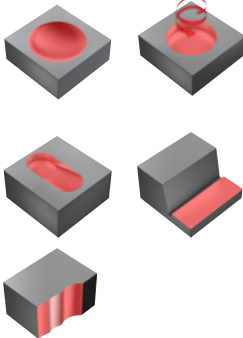
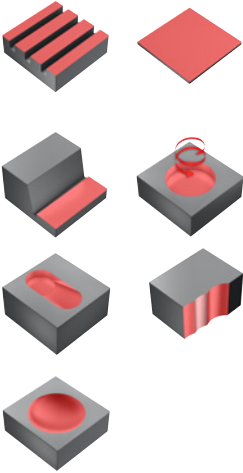
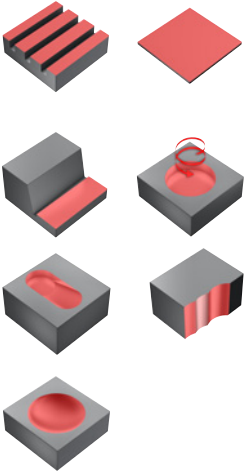



N23



N10

High-feed milling tools

| | CoroMill® 419 | CoroMill® 210 | CoroMill® 415 | CoroMill® 745 |
|------------------|---|---|---|---|
| Image |  |  |  |  |
| Page | I29 | I33 | I38 | I43 |
| Material |  |  |  |  |
| Main operation |  |  |  |  |
| KAPR | 19° | 10° | 15° | 25° |
| DC mm | 17.4 - 85.3 | 10.9 - 136 | 4.6 - 23.6 | 63 - 160 |
| DCX mm | 32.0 - 100.0 | 25 - 160 | 13 - 32 | 86.4 - 183.4 |
| APMX mm | 2 | 1.2 - 2 | 0.85 - 1.2 | 2.80 |
| Insert |  |  |  |  |
| Insert sizes | 14 | 09 & 14 | 05 & 07 | 21 |
| Couplings | Coromant Capto® Cylindrical shank Arbor | Coromant Capto® Cylindrical shank Arbor Threaded coupling Weldon | Cylindrical shank Coromant EH Threaded coupling | Coromant Capto® Arbor |
| Internal coolant |  |  |  |  |
| Options | | | iLock | |
| Other operations |  |  |  |  |

CoroMill® 419

High-feed milling cutter

Application

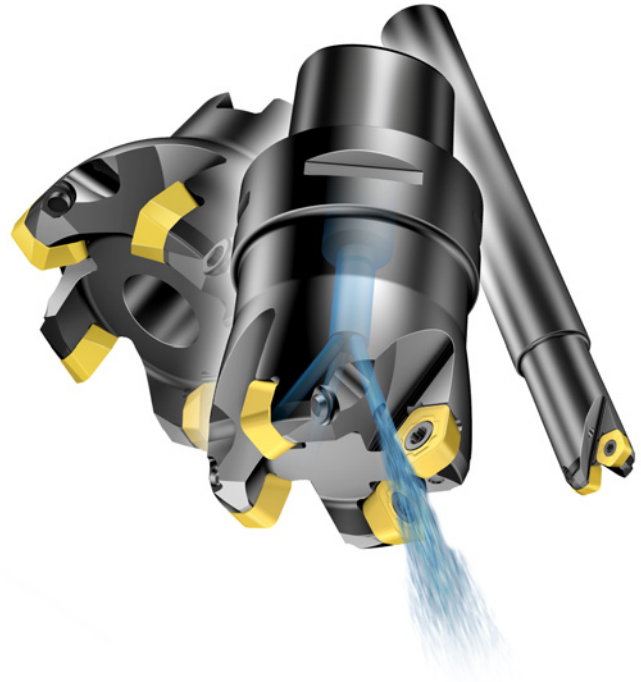
- High feed face milling
- Profiling
- Ramping
- Helical interpolation
- Machining of components requiring long overhangs
- Suitable for low-powered machines and weak fixtures
- Roughing to semi-finishing

ISO application area:



Benefits and features

- High productivity in applications requiring light cutting action
- Long tool life, especially in difficult-to-machine materials
- Strong and robust inserts for reliable machining
- Low power consumption
- Through coolant on all cutters enables efficient wet machining as well as compressed air cooling
- Reduced axial forces with a 19 degree entering angle and a positive axial inclination angle



www.sandvik.coromant.com/coromill419

Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank

Inserts

- Five cutting edges
- Inserts with parallel land for high feed face filling and radius inserts for pocketing
- Wide range of grades and geometries

L



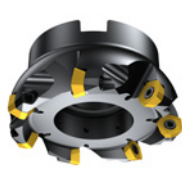
Coarse pitch

M



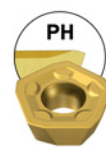
Close pitch

H



Extra close pitch

Face milling



Face and Profile Milling



I29



I31



N6

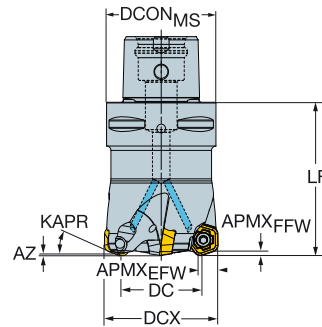
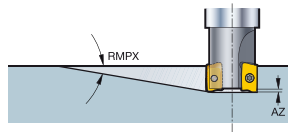
CoroMill® 419 face milling cutter

Coromant Capto® - Internal coolant supply

High-feed milling cutter

KAPR

19°

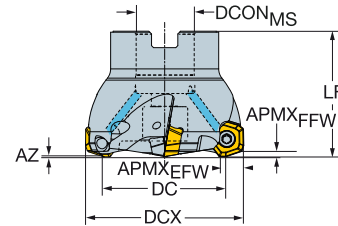
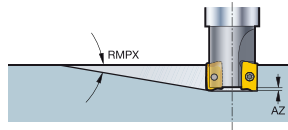


| | | | | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|---------------------|------|----|------|---------------|---|--------------------|----------------|------|------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | LF | NM | KG | RPMX | CICT | MIID | |
| 21.4 | 14 | C3 | 8.0 | 2.00 | 9° | 2.0 | 3 | 2 | 419-036C3-14L | 32.0 | 36.0 | 50.0 | 5.0 | 0.36 | 22400 | 2 | 419R-1405 |
| 27.4 | 14 | C4 | 8.0 | 2.00 | 8° | 2.0 | 3 | 3 | 419-042C4-14M | 40.0 | 42.0 | 70.0 | 5.0 | 0.62 | 19900 | 3 | 419R-1405 |
| 37.4 | 14 | C5 | 8.0 | 2.00 | 8° | 2.0 | 3 | 4 | 419-052C5-14M | 50.0 | 52.0 | 70.0 | 5.0 | 1.08 | 17100 | 4 | 419R-1405 |
| 51.3 | 14 | C6 | 8.0 | 2.00 | 6° | 2.0 | 3 | 5 | 419-066C6-14M | 63.0 | 66.0 | 70.0 | 5.0 | 1.73 | 14600 | 5 | 419R-1405 |
| 69.3 | 14 | C8 | 8.0 | 2.00 | 5° | 2.0 | 3 | 6 | 419-084C8-14H | 80.0 | 84.0 | 70.0 | 5.0 | 3.02 | 12600 | 6 | 419R-1405 |

Arbor - Internal coolant supply

STDNO
KAPR

ISO 6462
19°



| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|----|------|---------------|---|--------------------|----------------|-----|-------|------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | ISO | DCX | LF | NM | KG | RPMX | CICT | MIID | |
| 29.4 | 14 | 16 | 8.0 | 2.00 | 8° | 2.0 | 1 | 3 | 419-044Q16-14M | 16.0 | A | 44.0 | 45.0 | 5.0 | 0.37 | 19300 | 3 | 419R-1405 |
| 35.4 | 14 | 22 | 8.0 | 2.00 | 8° | 2.0 | 1 | 4 | 419-050Q22-14M | 22.0 | A | 50.0 | 45.0 | 5.0 | 0.43 | 17600 | 4 | 419R-1405 |
| 37.4 | 14 | 22 | 8.0 | 2.00 | 8° | 2.0 | 1 | 5 | 419-052Q22-14H | 22.0 | A | 52.0 | 45.0 | 5.0 | 0.50 | 17100 | 5 | 419R-1405 |
| 39.4 | 14 | 22 | 8.0 | 2.00 | 8° | 2.0 | 1 | 4 | 419-054Q22-14M | 22.0 | A | 54.0 | 45.0 | 5.0 | 0.47 | 16800 | 4 | 419R-1405 |
| | 14 | 22 | 8.0 | 2.00 | 8° | 2.0 | 1 | 5 | 419-054Q22-14H | 22.0 | A | 54.0 | 45.0 | 5.0 | 0.47 | 16800 | 5 | 419R-1405 |
| 48.3 | 14 | 22 | 8.0 | 2.00 | 7° | 2.0 | 1 | 4 | 419-063Q22-14L | 22.0 | A | 63.0 | 50.0 | 5.0 | 0.63 | 15100 | 4 | 419R-1405 |
| | 14 | 22 | 8.0 | 2.00 | 7° | 2.0 | 1 | 5 | 419-063Q22-14M | 22.0 | A | 63.0 | 50.0 | 5.0 | 0.58 | 15100 | 5 | 419R-1405 |
| 51.3 | 14 | 22 | 8.0 | 2.00 | 6° | 2.0 | 1 | 5 | 419-066Q22-14M | 22.0 | A | 66.0 | 50.0 | 5.0 | 0.66 | 14600 | 5 | 419R-1405 |
| | 14 | 22 | 8.0 | 2.00 | 6° | 2.0 | 1 | 6 | 419-066Q22-14H | 22.0 | A | 66.0 | 50.0 | 5.0 | 0.65 | 14600 | 6 | 419R-1405 |
| 65.3 | 14 | 27 | 8.0 | 2.00 | 5° | 2.0 | 1 | 5 | 419-080Q27-14M | 27.0 | A | 80.0 | 50.0 | 5.0 | 1.07 | 13000 | 5 | 419R-1405 |
| | 14 | 27 | 8.0 | 2.00 | 5° | 2.0 | 1 | 6 | 419-080Q27-14H | 27.0 | A | 80.0 | 50.0 | 5.0 | 1.06 | 13000 | 6 | 419R-1405 |
| 69.3 | 14 | 27 | 8.0 | 2.00 | 5° | 2.0 | 1 | 6 | 419-084Q27-14M | 27.0 | A | 84.0 | 50.0 | 5.0 | 1.12 | 12600 | 6 | 419R-1405 |
| | 14 | 27 | 8.0 | 2.00 | 5° | 2.0 | 1 | 7 | 419-084Q27-14H | 27.0 | A | 84.0 | 50.0 | 5.0 | 1.15 | 12600 | 7 | 419R-1405 |
| 85.3 | 14 | 32 | 8.0 | 2.00 | 0° | 2.0 | 1 | 6 | 419-100Q32-14M | 32.0 | B | 100.0 | 50.0 | 5.0 | 1.68 | 11400 | 6 | 419R-1405 |
| | 14 | 32 | 8.0 | 2.00 | 0° | 2.0 | 1 | 7 | 419-100Q32-14H | 32.0 | B | 100.0 | 50.0 | 5.0 | 1.69 | 11400 | 7 | 419R-1405 |

| |
|-----------------------------|
| Spare parts |
| Insert screw 5513 020-78 |

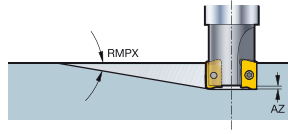
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 419 face milling cutter

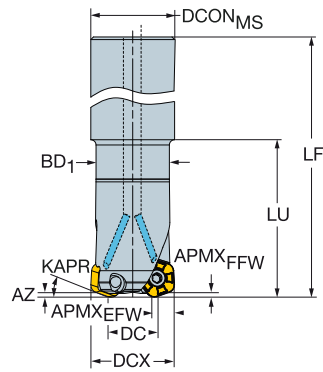
Cylindrical shank - Internal coolant supply

High-feed milling cutter



KAPR

19°



Dimensions, mm

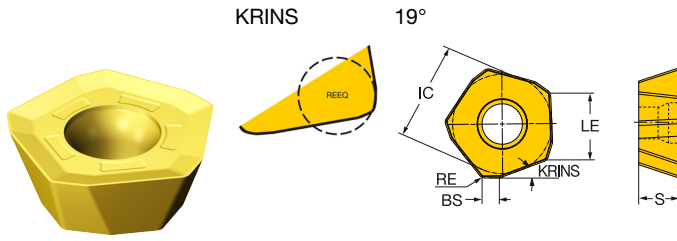
| DC | CZC _{MS} | APM _{EFW} | APM _{FFW} | RMPX | AZ | CNSC | Ordering code | DCON _{MS} | DCX | BD | LB | LF | LU | NM | KG | RPMX | CICT | MIID |
|------|-------------------|--------------------|--------------------|------|-----|------|-----------------|--------------------|------|------|------|-------|------|-----|------|-------|------|-----------|
| 17.4 | 14 | 32 | 8.0 | 2.00 | 10° | 2 | 419-032A32L-14L | 32.0 | 32.0 | 28.0 | 57.0 | 250.0 | 60.0 | 5.0 | 1.40 | 24700 | 2 | 419R-1405 |
| 25.4 | 14 | 32 | 8.0 | 2.00 | 8° | 3 | 419-040A32L-14M | 32.0 | 40.0 | 28.0 | | 250.0 | | 5.0 | 1.50 | 20600 | 3 | 419R-1405 |

| |
|--------------|
| Spare parts |
| Insert screw |
| 5513 020-78 |

For complete list of spare parts, see www.sandvik.coromant.com



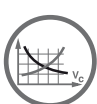
CoroMill® 419 insert for milling



| | | RE | Ordering code | P | | M | | K | | N | | S | | H | | Dimensions, mm | | | | | | |
|--------|----|----|---------------|-----------------|------|------|------|------|------|------|------|------|------|------|------|----------------|------|------|------|------|-----|------|
| | | | | 1130 | 4220 | 4330 | 4340 | 1040 | 1130 | 2040 | 1020 | 3040 | 3330 | 1130 | 1130 | S30T | S40T | 1010 | 1130 | IC | LE | S |
| Medium | MM | 14 | 0.80 | 419R-1405E-MM | ★ | ★ | ★ | ☆ | ☆ | | | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 13.5 | 9.0 | 5.47 | 2.0 | 4.50 |
| | PM | 14 | 0.80 | 419R-1405M-PM | ★ | ☆ | ★ | ★ | ☆ | ★ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 13.5 | 9.0 | 5.47 | 2.0 | 4.50 |
| | SM | 14 | 3.00 | 419N-140530E-SM | ★ | | ★ | ★ | ☆ | ☆ | | | ☆ | ☆ | ★ | ☆ | ☆ | 13.5 | 9.0 | 5.47 | | 4.50 |
| Heavy | KH | 14 | 3.00 | 419N-140530M-KH | | ☆ | ★ | | | ☆ | ★ | ★ | | | | | | 13.5 | 9.0 | 5.47 | | 4.50 |
| | PH | 14 | 0.80 | 419R-1405M-PH | | | ☆ | ★ | | | | ★ | | | | ★ | | 13.5 | 9.0 | 5.47 | 2.0 | 4.50 |



I29



I154



I175



N23



N10

CoroMill® 210

High feed face and plunge milling

Application

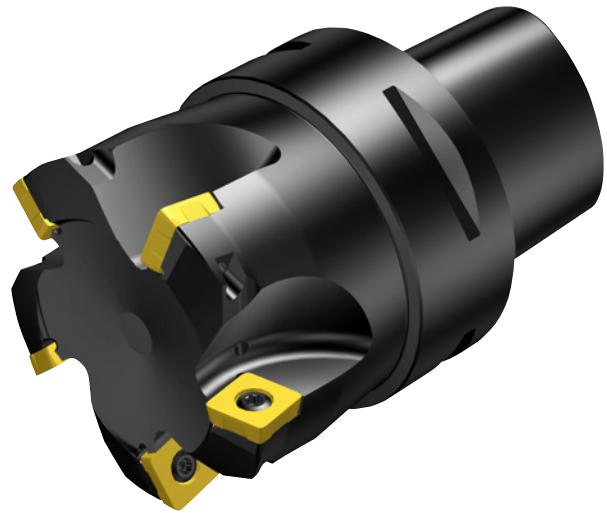
- High feed face milling
- Plunge milling
- Ramping
- Roughing to semi-finishing
- Helical interpolation
- Profiling

ISO application area:



Benefits and features

- High table feed due to the chip thinning effect – high productivity
- First choice face milling cutter in long overhang machining
- Multipurpose tool. Face milling, boring possibilities, ramping and plunge milling
- Internal coolant



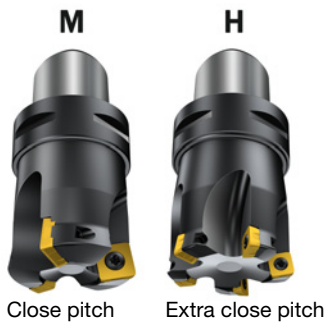
www.sandvik.coromant.com/coromill210

Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank
- Threaded coupling

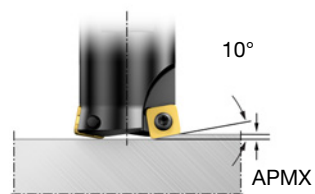
Inserts

- Four cutting edges
- Insert geometries and grades for all materials apart from ISO N
- E-xM geometry for excellent performance in titanium

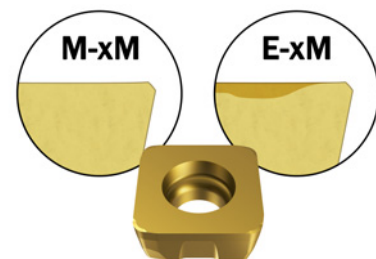


Close pitch

Extra close pitch



The 10 degree entering angle allows extreme feed rates when face milling.



Recommended feed per tooth (f_z) 1.5 mm for size 09 inserts and 2 mm feed per tooth (f_z) for size 14 inserts.



I33

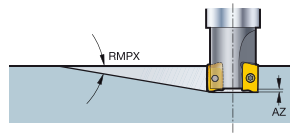


I36

CoroMill® 210 face milling cutter

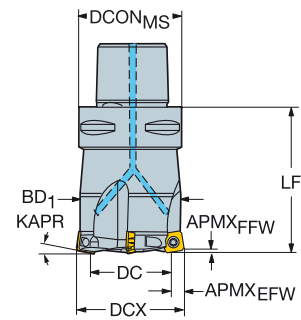
Coromant Capto® - Internal coolant supply

High-feed milling cutter



KAPR

10°



| | | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|----|------|---------------|---|--------------------|------|----------------|------|------|-----|------|-------|------|---------------|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LF | NM | KG | RPMX | CICT | MIID | | |
| 21.9 | 09 | C3 | 8.0 | 1.20 | 7° | 1.8 | 3 | 2 | R210-036C3-09M | 32.0 | 36.0 | 33.0 | 50.0 | 3.0 | 0.44 | 30900 | 2 | R210-090412M- | |
| | 09 | C3 | 8.0 | 1.20 | 7° | 1.8 | 3 | 3 | R210-036C3-09H | 32.0 | 36.0 | 33.0 | 50.0 | 3.0 | 0.37 | 30900 | 3 | R210-090412M- | |
| 27.9 | 09 | C4 | 8.0 | 1.20 | 5° | 1.8 | 3 | 3 | R210-042C4-09M | 40.0 | 42.0 | 39.0 | 60.0 | 3.0 | 0.79 | 27600 | 3 | R210-090412M- | |
| | 09 | C4 | 8.0 | 1.20 | 5° | 1.8 | 3 | 4 | R210-042C4-09H | 40.0 | 42.0 | 39.0 | 60.0 | 3.0 | 0.60 | 27600 | 4 | R210-090412M- | |
| 28.0 | 14 | C5 | 13.0 | 2.00 | 5° | 2.0 | 3 | 3 | R210-052C5-14M | 50.0 | 52.0 | 47.7 | 70.0 | 5.0 | 1.21 | 20800 | 3 | R210-140512M- | |
| | 14 | C5 | 13.0 | 2.00 | 3° | 2.0 | 3 | 4 | R210-052C5-14H | 50.0 | 52.0 | 47.7 | 70.0 | 5.0 | 1.21 | 20800 | 4 | R210-140512M- | |
| 30.0 | 14 | C5 | 13.0 | 2.00 | 5° | 2.0 | 3 | 4 | R210-054C5-14H | 50.0 | 54.0 | 49.7 | 70.0 | 5.0 | 1.35 | 23600 | 4 | R210-140512M- | |
| 37.9 | 09 | C5 | 8.0 | 1.20 | 3° | 1.8 | 3 | 4 | R210-052C5-09M | 50.0 | 52.0 | 49.0 | 70.0 | 3.0 | 1.26 | 24000 | 4 | R210-090412M- | |
| | 09 | C5 | 8.0 | 1.20 | 3° | 1.8 | 3 | 5 | R210-052C5-09H | 50.0 | 52.0 | 49.0 | 70.0 | 3.0 | 1.20 | 24000 | 5 | R210-090412M- | |
| 39.9 | 09 | C5 | 8.0 | 1.20 | 3° | 1.8 | 3 | 5 | R210-054C5-09H | 50.0 | 54.0 | 51.0 | 70.0 | 3.0 | 1.15 | 23600 | 5 | R210-090412M- | |
| 42.0 | 14 | C6 | 13.0 | 2.00 | 3° | 2.0 | 3 | 4 | R210-066C6-14M | 63.0 | 66.0 | 61.7 | 72.0 | 5.0 | 2.02 | 17700 | 4 | R210-140512M- | |
| | 14 | C6 | 13.0 | 2.00 | 3° | 2.0 | 3 | 5 | R210-066C6-14H | 63.0 | 66.0 | 61.7 | 72.0 | 5.0 | 2.03 | 17700 | 5 | R210-140512M- | |
| 51.9 | 09 | C6 | 8.0 | 1.20 | 2° | 1.8 | 3 | 6 | R210-066C6-09M | 63.0 | 66.0 | 63.0 | 72.0 | 3.0 | 2.05 | 21300 | 6 | R210-090412M- | |
| 58.0 | 14 | C8 | 13.0 | 2.00 | 2° | 2.0 | 3 | 5 | R210-082C8-14M | 80.0 | 82.0 | 77.7 | 80.0 | 5.0 | 3.50 | 15100 | 5 | R210-140512M- | |
| | 14 | C8 | 13.0 | 2.00 | 2° | 2.0 | 3 | 6 | R210-082C8-14H | 80.0 | 82.0 | 77.7 | 80.0 | 5.0 | 3.46 | 15100 | 6 | R210-140512M- | |
| 62.0 | 14 | C8 | 13.0 | 2.00 | 2° | 2.0 | 3 | 6 | R210-086C8-14H | 80.0 | 86.0 | 81.7 | 80.0 | 5.0 | 3.67 | 14700 | 6 | R210-140512M- | |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 09 | 5513 020-02 |
| 14 | 5513 020-50 |

For complete list of spare parts, see www.sandvik.coromant.com



136



L2



N23



N9



N15

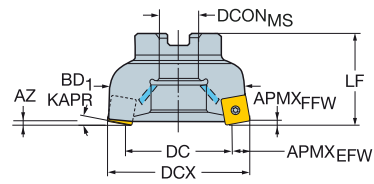
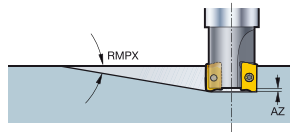
CoroMill® 210 face milling cutter

Arbor - Internal coolant supply

High-feed milling cutter

STDNO
KAPR

ISO6462
10°



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|---------------------|---------------------|------|----|------|---------------|---|--------------------|----------------|-----|-------|-------|------|-----|------|-------|------|---------------|
| DC | CZC _{MS} | APM _{XEFW} | APM _{XFFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | ISO | DCX | BD | LF | NM | KG | RPMX | CICT | MIID | |
| 35.9 | 09 | 22 | 8.0 | 1.20 | 3° | 1.8 | 1 | 4 | R210-050Q22-09M | 22.0 | A | 50.0 | 47.0 | 50.0 | 3.0 | 0.43 | 24500 | 4 | R210-090412M- |
| | 09 | 22 | 8.0 | 1.20 | 3° | 1.8 | 1 | 5 | R210-050Q22-09H | 22.0 | A | 50.0 | 47.0 | 50.0 | 3.0 | 0.63 | 24500 | 5 | R210-090412M- |
| 39.0 | 14 | 22 | 13.0 | 2.00 | 3° | 2.0 | 1 | 4 | R210-063Q22-14M | 22.0 | A | 63.0 | 58.7 | 50.0 | 5.0 | 0.76 | 18300 | 4 | R210-140512M- |
| | 14 | 27 | 13.0 | 2.00 | 3° | 2.0 | 1 | 4 | R210-063Q27-14M | 27.0 | A | 63.0 | 58.7 | 50.0 | 5.0 | 0.81 | 18300 | 4 | R210-140512M- |
| | 14 | 22 | 13.0 | 2.00 | 3° | 2.0 | 1 | 5 | R210-063Q22-14H | 22.0 | A | 63.0 | 58.7 | 50.0 | 5.0 | 0.50 | 18300 | 5 | R210-140512M- |
| 48.9 | 09 | 22 | 8.0 | 1.20 | 2° | 1.8 | 1 | 5 | R210-063Q22-09M | 22.0 | A | 63.0 | 60.0 | 50.0 | 3.0 | 0.85 | 21800 | 5 | R210-090412M- |
| | 09 | 27 | 8.0 | 1.20 | 2° | 1.8 | 1 | 5 | R210-063Q27-09M | 27.0 | A | 63.0 | 60.0 | 50.0 | 3.0 | 1.05 | 21800 | 5 | R210-090412M- |
| | 09 | 22 | 8.0 | 1.20 | 2° | 1.8 | 1 | 6 | R210-063Q22-09H | 22.0 | A | 63.0 | 60.0 | 50.0 | 3.0 | 0.81 | 21800 | 6 | R210-090412M- |
| 56.0 | 14 | 27 | 13.0 | 2.00 | 2° | 2.0 | 1 | 5 | R210-080Q27-14M | 27.0 | A | 80.0 | 75.7 | 50.0 | 5.0 | 1.10 | 15400 | 5 | R210-140512M- |
| | 14 | 27 | 13.0 | 2.00 | 2° | 2.0 | 1 | 6 | R210-080Q27-14H | 27.0 | A | 80.0 | 75.7 | 50.0 | 5.0 | 1.20 | 15400 | 6 | R210-140512M- |
| 76.0 | 14 | 32 | 13.0 | 2.00 | 1° | 2.0 | 1 | 6 | R210-100Q32-14M | 32.0 | B | 100.0 | 95.7 | 50.0 | 5.0 | 1.85 | 13400 | 6 | R210-140512M- |
| | 14 | 32 | 13.0 | 2.00 | 1° | 2.0 | 1 | 7 | R210-100Q32-14H | 32.0 | B | 100.0 | 95.7 | 50.0 | 5.0 | 1.92 | 13400 | 7 | R210-140512M- |
| 101.0 | 14 | 40 | 13.0 | 2.00 | 1° | 2.0 | 1 | 7 | R210-125Q40-14M | 40.0 | B | 125.0 | 120.7 | 63.0 | 5.0 | 3.83 | 11400 | 7 | R210-140512M- |
| 136.0 | 14 | 40 | 13.0 | 2.00 | 1° | 2.0 | 1 | 8 | R210-160Q40-14M | 40.0 | B | 160.0 | 155.7 | 63.0 | 5.0 | 5.78 | 10400 | 8 | R210-140512M- |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 09 | 5513 020-02 |
| 14 | 5513 020-50 |

For complete list of spare parts, see www.sandvik.coromant.com



I36



L2



M1



N23



N9

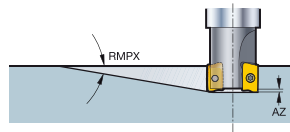


N15

CoroMill® 210 face milling cutter

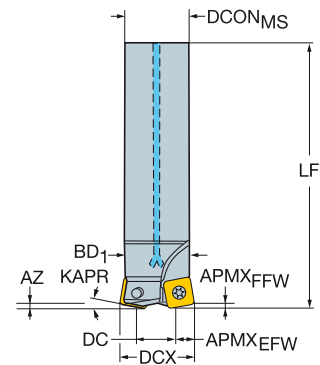
Cylindrical shank - Internal coolant supply

High-feed milling cutter



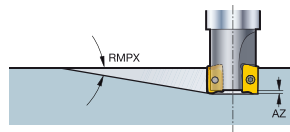
KAPR

10°



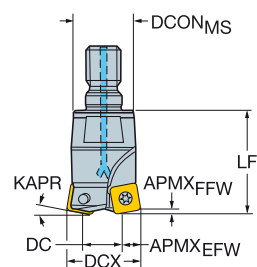
| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|-----|------|---------------|---|--------------------|----------------|------|------|------|-------|-----|------|-------|------|---------------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID | |
| 10.9 | 09 | 20 | 8.0 | 1.20 | 14° | 1.8 | 1 | 2 | R210-025A20-09M | 20.0 | 25.0 | 22.0 | 35.0 | 180.0 | 3.0 | 0.54 | 17200 | 2 | R210-090412M- |
| 17.9 | 09 | 25 | 8.0 | 1.20 | 8° | 1.8 | 1 | 2 | R210-032A25-09M | 25.0 | 32.0 | 29.0 | 45.0 | 210.0 | 3.0 | 0.88 | 11000 | 2 | R210-090412M- |
| | 09 | 25 | 8.0 | 1.20 | 8° | 1.8 | 1 | 3 | R210-032A25-09H | 25.0 | 32.0 | 29.0 | 45.0 | 210.0 | 3.0 | 0.50 | 11000 | 3 | R210-090412M- |
| 20.9 | 09 | 32 | 8.0 | 1.20 | 7° | 1.8 | 1 | 3 | R210-035A32-09H | 32.0 | 35.0 | 32.0 | 45.0 | 210.0 | 3.0 | 1.30 | 11000 | 3 | R210-090412M- |
| 27.9 | 09 | 32 | 8.0 | 1.20 | 5° | 1.8 | 1 | 3 | R210-042A32-09M | 32.0 | 42.0 | 39.0 | 50.0 | 250.0 | 3.0 | 1.83 | 8000 | 3 | R210-090412M- |
| | 09 | 32 | 8.0 | 1.20 | 5° | 1.8 | 1 | 4 | R210-042A32-09H | 32.0 | 42.0 | 39.0 | 50.0 | 250.0 | 3.0 | 1.77 | 8000 | 4 | R210-090412M- |

Threaded coupling - Internal coolant supply



KAPR

10°



| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|-----|------|---------------|---|--------------------|----------------|------|------|------|-----|------|-------|------|---------------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LF | NM | KG | RPMX | CICT | MIID | |
| 10.9 | 09 | M12 | 8.0 | 1.20 | 14° | 1.8 | 1 | 2 | R210-025T12-09M | 20.8 | 25.0 | 22.0 | 35.0 | 3.0 | 0.24 | 15000 | 2 | R210-090412M- |
| 17.9 | 09 | M16 | 8.0 | 1.20 | 8° | 1.8 | 1 | 2 | R210-032T16-09M | 28.8 | 32.0 | 29.0 | 45.0 | 3.0 | 0.36 | 15000 | 2 | R210-090412M- |
| 20.9 | 09 | M16 | 8.0 | 1.20 | 7° | 1.8 | 1 | 3 | R210-035T16-09H | 28.8 | 35.0 | 32.0 | 50.0 | 3.0 | 0.37 | 15000 | 3 | R210-090412M- |
| 27.9 | 09 | M16 | 8.0 | 1.20 | 5° | 1.8 | 1 | 4 | R210-042T16-09H | 28.8 | 42.0 | 39.0 | 50.0 | 3.0 | 0.44 | 15000 | 4 | R210-090412M- |

| |
|-----------------------------|
| Spare parts |
| Insert screw 5513 020-02 |

For complete list of spare parts, see www.sandvik.coromant.com



136



L2



N23



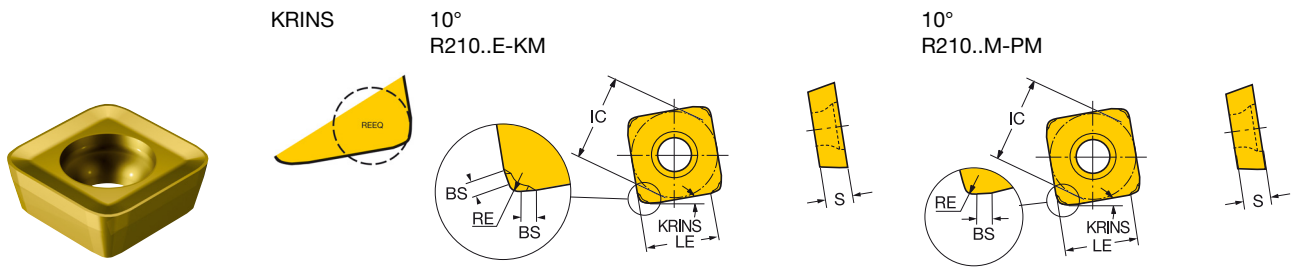
N9



N15



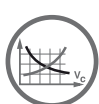
CoroMill® 210 insert for milling



| | | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | | | | | | | | | |
|--------|----|------|-------------------|-------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|----|-----|------|------|------|------|------|------|------|------|
| | | | | P | | | M | | K | | N | S | | H | | | | | | | | | | | | | | | |
| | | | | 1130 | 4220 | 4330 | 4340 | 1040 | 1130 | 2040 | 1020 | 3040 | 3330 | 1130 | 1130 | S30T | S40T | 1010 | 1130 | IC | LE | S | BS | BSR | REEQ | | | | |
| Medium | KM | 09 | 1.00 | R210-09 04 12M-KM | | | | | | | ☆ | ☆ | ★ | | | | | | | | 9.4 | 6.2 | 4.00 | 0.8 | | 2.50 | | | |
| | | 1.40 | R210-09 04 14E-KM | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | 9.5 | 5.7 | 4.50 | 0.7 | 50.0 | 2.50 | | |
| | | 14 | 1.00 | R210-14 05 12M-KM | | | | | | | | ☆ | ☆ | ★ | | | | | | | | 14.5 | 11.3 | 4.76 | 0.8 | | 3.50 | | |
| | | 1.40 | R210-14 05 14E-KM | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | 14.6 | 10.8 | 5.26 | 0.7 | 50.0 | 3.50 | | |
| | | 09 | 1.00 | R210-09 04 12M-MM | | | | | ★ | | ☆ | | | | | | | | | | | | 9.4 | 6.2 | 4.00 | 0.8 | | 2.50 | |
| | | 1.40 | R210-09 04 14E-MM | | | | | ★ | | ☆ | | | | | | | | | | | | | 9.5 | 5.7 | 4.50 | 0.7 | 50.0 | 2.50 | |
| | MM | 14 | 1.00 | R210-14 05 12M-MM | | | | | ★ | | ☆ | | | | | | | | | | | | 14.5 | 11.3 | 4.76 | 0.8 | | 3.50 | |
| | | 1.40 | R210-14 05 14E-MM | | | | | ★ | | ☆ | | | | | | | | | | | | | 14.6 | 10.8 | 5.26 | 0.7 | 50.0 | 3.50 | |
| | | 09 | 1.00 | R210-09 04 12M-PM | ★ | ☆ | ★ | ☆ | | ☆ | | | | | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | | | 9.4 | 6.2 | 4.00 | 0.8 | | 2.50 | |
| | | 1.40 | R210-09 04 14E-PM | ★ | ☆ | ★ | ☆ | | ☆ | | | | | | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | | | | 9.5 | 5.7 | 4.50 | 0.7 | 50.0 | 2.50 |
| | | 14 | 1.00 | R210-14 05 12M-PM | ★ | ☆ | ★ | ☆ | | ☆ | | | | | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | | | | 14.5 | 11.3 | 4.76 | 0.8 | | 3.50 |
| | | 1.40 | R210-14 05 14E-PM | ★ | ☆ | ★ | ☆ | | ☆ | | | | | | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | | | | 14.6 | 10.8 | 5.26 | 0.7 | 50.0 | 3.50 |



I33



I154



I175



N23



N10

CoroMill® 415

Small diameter, high feed face milling cutter

Application

- High feed face milling
- Plunge milling
- Ramping
- Roughing to semi-finishing
- Helical interpolation
- Profiling

ISO application area:



Benefits and features

- Versatile tool suitable for a wide range of applications
- Coolant channels for optimized chip evacuation
- Can be combined with the Coromant EH coupling and Silent Tools™ damped adaptors for vibration-free machining, high reliability and a significant productivity gain
- Unique iLock™ insert seat interface resulting in less scrap workpieces. The iLock™ insert seat also makes the small inserts easier to handle
- Tailor made options available



www.sandvik.coromant.com/coromill415

Couplings

- Cylindrical shank
- Coromant EH
- Threaded coupling

Inserts

- Four cutting edges
- The unique iLock™ solution provides easy and accurate insert indexing, increased reliability and considerably improved tool life



I38

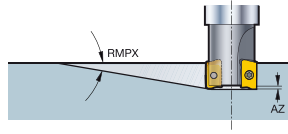


I41

CoroMill® 415 face milling cutter

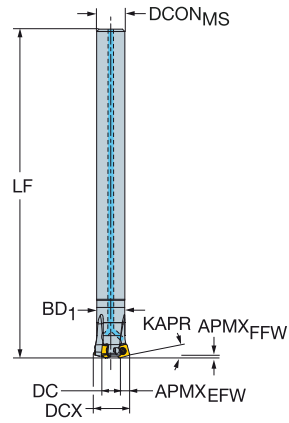
Cylindrical shank - Internal coolant supply

High-feed milling cutter



KAPR

15°



| | | | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|-------|---------------|---|--------------------|------|------|------|------|-------|-----|------|-------|------|--------------|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID | | |
| 4.6 | 05 | 12 | 3.0 | 0.85 | 0.85° | 1 | 2 | 415-013A12-05H | 12.0 | 13.0 | 11.0 | 15.0 | 140.0 | 0.6 | 0.16 | 23600 | 2 | 415N-050206M | |
| 7.6 | 05 | 12 | 3.0 | 0.85 | 0.97° | 1 | 3 | 415-016A12-05H | 12.0 | 16.0 | 12.0 | 15.0 | 140.0 | 0.6 | 0.16 | 21300 | 3 | 415N-050206M | |
| 11.6 | 05 | 16 | 3.0 | 0.85 | 0.62° | 1 | 3 | 415-020A16-05L | 16.0 | 20.0 | 16.0 | 15.0 | 200.0 | 0.6 | 0.37 | 19000 | 3 | 415N-050206M | |
| | 05 | 16 | 3.0 | 0.85 | 0.62° | 1 | 4 | 415-020A16-05M | 16.0 | 20.0 | 16.0 | 15.0 | 200.0 | 0.6 | 0.33 | 19000 | 4 | 415N-050206M | |
| | 05 | 16 | 3.0 | 0.85 | 0.62° | 1 | 5 | 415-020A16-05H | 16.0 | 20.0 | 16.0 | 15.0 | 200.0 | 0.6 | 0.27 | 19000 | 5 | 415N-050206M | |
| 13.5 | 07 | 20 | 4.5 | 1.20 | 0.61° | 1 | 4 | 415-025A20-07H | 20.0 | 25.0 | 19.0 | 15.0 | 200.0 | 1.2 | 0.50 | 15700 | 4 | 415N-070310M | |
| 16.6 | 05 | 20 | 3.0 | 0.85 | 0.64° | 1 | 5 | 415-025A20-05M | 20.0 | 25.0 | 21.0 | 15.0 | 200.0 | 0.6 | 0.50 | 17000 | 5 | 415N-050206M | |
| 20.5 | 07 | 25 | 4.5 | 1.20 | 0.63° | 1 | 5 | 415-032A25-07H | 25.0 | 32.0 | 26.0 | 15.0 | 250.0 | 1.2 | 0.95 | 13900 | 5 | 415N-070310M | |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 05 | 5513 020-28 |
| 07 | 5513 020-56 |

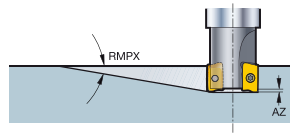
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 415 face milling cutter

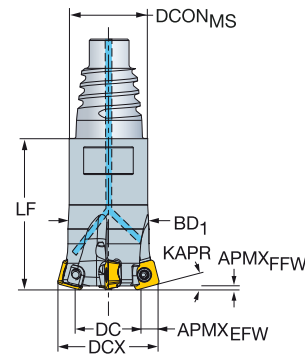
Coromant EH - Internal coolant supply

High-feed milling cutter



KAPR

15°



| | | | | | | | | Dimensions, mm | | | | | | | | | | | | |
|------|----|-------------------|---------------------|---------------------|-------|------|---|----------------|--------------------|------|------|------|------|-----|------|-------|------|--------------|--|--|
| DC | | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | CNSC | | Ordering code | DCON _{MS} | DCX | BD | LB | LF | | | RPMX | CICT | MIID | | |
| 4.6 | 05 | E12 | 3.0 | 0.85 | 0.85° | 1 | 2 | 415-13EH12-05H | 11.7 | 13.0 | 11.0 | 10.0 | 25.0 | 0.6 | 0.14 | 23600 | 2 | 415N-050206M | | |
| 7.6 | 05 | E16 | 3.0 | 0.85 | 0.97° | 1 | 3 | 415-16EH16-05H | 15.5 | 16.0 | 12.0 | 12.0 | 30.0 | 0.6 | 0.06 | 21300 | 3 | 415N-050206M | | |
| 8.6 | 07 | E16 | 4.5 | 1.20 | 0.56° | 1 | 2 | 415-20EH16-07H | 15.5 | 20.0 | 14.0 | 12.0 | 35.0 | 1.2 | 0.17 | 17500 | 2 | 415N-070310M | | |
| | 07 | E20 | 4.5 | 1.20 | 0.56° | 1 | 2 | 415-20EH20-07H | 19.3 | 20.0 | 14.0 | 15.0 | 35.0 | 1.2 | 0.13 | 17500 | 2 | 415N-070310M | | |
| 11.6 | 05 | E16 | 3.0 | 0.85 | 0.62° | 1 | 4 | 415-20EH16-05M | 15.5 | 20.0 | 16.0 | 12.0 | 30.0 | 0.6 | 0.05 | 19000 | 4 | 415N-050206M | | |
| | 05 | E20 | 3.0 | 0.85 | 0.62° | 1 | 4 | 415-20EH20-05M | 19.3 | 20.0 | 16.0 | 13.0 | 32.0 | 0.6 | 0.07 | 19000 | 4 | 415N-050206M | | |
| | 05 | E16 | 3.0 | 0.85 | 0.62° | 1 | 5 | 415-20EH16-05H | 15.5 | 20.0 | 16.0 | 12.0 | 30.0 | 0.6 | 0.16 | 19000 | 5 | 415N-050206M | | |
| | 05 | E20 | 3.0 | 0.85 | 0.62° | 1 | 5 | 415-20EH20-05H | 19.3 | 20.0 | 16.0 | 13.0 | 32.0 | 0.6 | 0.19 | 19000 | 5 | 415N-050206M | | |
| 13.5 | 07 | E20 | 4.5 | 1.20 | 0.61° | 1 | 3 | 415-25EH20-07M | 19.3 | 25.0 | 19.0 | 15.0 | 35.0 | 1.2 | 0.08 | 15700 | 3 | 415N-070310M | | |
| | 07 | E25 | 4.5 | 1.20 | 0.61° | 1 | 3 | 415-25EH25-07M | 24.2 | 25.0 | 19.0 | 18.0 | 40.0 | 1.2 | 0.12 | 15700 | 3 | 415N-070310M | | |
| | 07 | E20 | 4.5 | 1.20 | 0.61° | 1 | 4 | 415-25EH20-07H | 19.3 | 25.0 | 19.0 | 15.0 | 35.0 | 1.2 | 0.20 | 15700 | 4 | 415N-070310M | | |
| | 07 | E25 | 4.5 | 1.20 | 0.61° | 1 | 4 | 415-25EH25-07H | 24.2 | 25.0 | 19.0 | 18.0 | 40.0 | 1.2 | 0.18 | 15700 | 4 | 415N-070310M | | |
| 16.6 | 05 | E20 | 3.0 | 0.85 | 0.64° | 1 | 5 | 415-25EH20-05M | 19.3 | 25.0 | 21.0 | 13.0 | 32.0 | 0.6 | 0.08 | 17000 | 5 | 415N-050206M | | |
| | 05 | E25 | 3.0 | 0.85 | 0.64° | 1 | 5 | 415-25EH25-05M | 24.2 | 25.0 | 21.0 | 15.0 | 35.0 | 0.6 | 0.12 | 17000 | 5 | 415N-050206M | | |
| | 05 | E20 | 3.0 | 0.85 | 0.64° | 1 | 6 | 415-25EH20-05H | 19.3 | 25.0 | 21.0 | 13.0 | 32.0 | 0.6 | 0.20 | 17000 | 6 | 415N-050206M | | |
| | 05 | E25 | 3.0 | 0.85 | 0.64° | 1 | 6 | 415-25EH25-05H | 24.2 | 25.0 | 21.0 | 15.0 | 35.0 | 0.6 | 0.24 | 17000 | 6 | 415N-050206M | | |
| 20.5 | 07 | E25 | 4.5 | 1.20 | 0.63° | 1 | 4 | 415-32EH25-07M | 24.2 | 32.0 | 26.0 | 18.0 | 40.0 | 1.2 | 0.19 | 13900 | 4 | 415N-070310M | | |
| | 07 | E25 | 4.5 | 1.20 | 0.63° | 1 | 5 | 415-32EH25-07H | 24.2 | 32.0 | 26.0 | 18.0 | 40.0 | 1.2 | 0.16 | 13900 | 5 | 415N-070310M | | |
| 23.6 | 05 | E25 | 3.0 | 0.85 | 0.65° | 1 | 7 | 415-32EH25-05H | 24.2 | 32.0 | 28.0 | 15.0 | 35.0 | 0.6 | 0.16 | 15000 | 7 | 415N-050206M | | |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 05 | 5513 020-28 |
| 07 | 5513 020-56 |

For complete list of spare parts, see www.sandvik.coromant.com



141



L2



N23



N9



N15

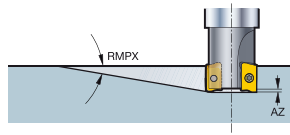


N3

CoroMill® 415 face milling cutter

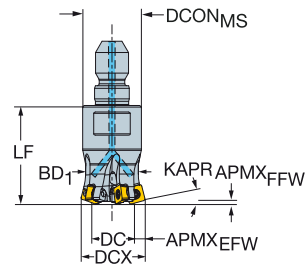
Threaded coupling - Internal coolant supply

High-feed milling cutter



KAPR

15°



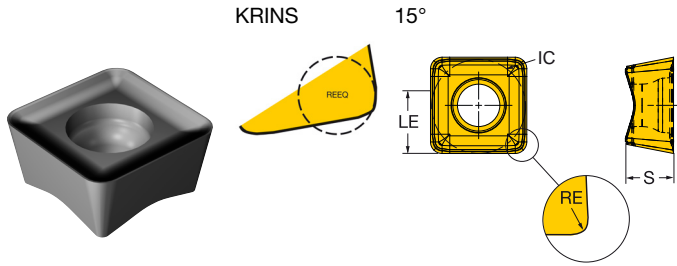
| | | | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|-------------------|--------------------|--------------------|------|-------|---------------|--------------------|----------------|------|------|------|------|-----|------|-------|------|--------------|--|--|
| DC | CZC _{MS} | APM _{EFW} | APM _{FFW} | RMPX | CNSC | Ordering code | DCON _{MS} | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID | | | |
| 4.6 | 05 | M8 | 3.0 | 0.85 | 0.85° | 1 2 | 415-13T08-05H | 12.8 | 13.0 | 11.0 | 10.0 | 25.0 | 0.6 | 0.02 | 23600 | 2 | 415N-050206M | | |
| 7.6 | 05 | M8 | 3.0 | 0.85 | 0.97° | 1 3 | 415-16T08-05H | 12.8 | 16.0 | 12.0 | 10.0 | 25.0 | 0.6 | 0.03 | 21300 | 3 | 415N-050206M | | |
| 11.6 | 05 | M10 | 3.0 | 0.85 | 0.62° | 1 5 | 415-20T10-05H | 17.8 | 20.0 | 16.0 | 12.0 | 30.0 | 0.6 | 0.05 | 19000 | 5 | 415N-050206M | | |
| 13.5 | 07 | M12 | 4.5 | 1.20 | 0.61° | 1 4 | 415-25T12-07H | 20.8 | 25.0 | 19.0 | 15.0 | 38.0 | 1.2 | 0.09 | 15700 | 4 | 415N-070310M | | |
| 16.6 | 05 | M12 | 3.0 | 0.85 | 0.64° | 1 6 | 415-25T12-05H | 20.8 | 25.0 | 21.0 | 15.0 | 35.0 | 0.6 | 0.10 | 17000 | 6 | 415N-050206M | | |
| 20.5 | 07 | M16 | 4.5 | 1.20 | 0.63° | 1 5 | 415-32T16-07H | 28.8 | 32.0 | 26.0 | 15.0 | 40.0 | 1.2 | 0.19 | 13900 | 5 | 415N-070310M | | |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 05 | 5513 020-28 |
| 07 | 5513 020-56 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 415 insert for milling



| | | RE | Ordering code | P | | | | | | | | M | | S | | | | H | | Dimensions, mm | | | |
|--------|-----|----|---------------|--------------------|------|------|------|------|------|------|------|------|------|----|----|---|------|-----|------|----------------|------|--|--|
| | | | | | | | | | | | | | | | | | | | | | | | |
| | | | | 1130 | 4340 | 1040 | 1130 | 1130 | H13A | S30T | S40T | 1010 | 1130 | IC | LE | S | REEQ | IC | LE | S | REEQ | | |
| Medium | M30 | 05 | 0.60 | 415N-05 02 06M-M30 | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ★ | ★ | ★ | ☆ | 5.0 | 3.8 | 2.21 | 1.50 | | | |
| | | 05 | 1.20 | 415N-05 02 12E-M30 | ★ | ★ | ★ | ★ | ☆ | ☆ | ★ | ★ | ★ | ★ | ★ | ☆ | 5.0 | 3.0 | 2.21 | 2.00 | | | |
| | | 05 | 1.20 | 415N-05 02 12M-M30 | ★ | ★ | ★ | ★ | ☆ | ☆ | ★ | ★ | ★ | ★ | ★ | ☆ | 5.0 | 3.0 | 2.21 | 2.00 | | | |
| | | 07 | 1.00 | 415N-07 03 10M-M30 | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ★ | ★ | ★ | ☆ | 7.0 | 5.0 | 3.07 | 2.20 | | | |
| | | 07 | 2.00 | 415N-07 03 20E-M30 | ★ | ★ | ★ | ★ | ☆ | ☆ | ★ | ★ | ★ | ★ | ★ | ☆ | 7.0 | 3.0 | 3.07 | 2.20 | | | |
| | | 07 | 2.00 | 415N-07 03 20M-M30 | ★ | ★ | ★ | ★ | ☆ | ☆ | ★ | ★ | ★ | ★ | ★ | ☆ | 7.0 | 3.0 | 3.07 | 2.80 | | | |

415N-05 02 12M-M30 increases DC by 1.0 mm and reduces DCX by 0.26 mm and LF by 0.13 mm
 415N-07 03 20M-M30 increases DC by 1.7 mm and reduces DCX by 0.44 mm and LF by 0.22 mm
 (In comparison to using the tool with MIID)



138



1154



1175



N23



N10

CoroMill® 745

Multi-edge face milling and high feed milling concepts

Application

- Face milling
- Roughing to semi-finishing
- High feed milling

ISO application area:



Benefits and features

- Multi-edge concept suitable for large batch productions, flexible transfer lines and when maximum tool utilization is important
- CoroMill 745 with 42° entering angle is used in ISO P, K, M and S applications where APMX is 5.2 mm
- CoroMill 745 high feed cutter with 25° entering angle is used as a productivity booster in ISO P and ISO K applications where APMX is 2.8 mm
- Great problem-solving abilities when machining vibration-sensitive components and in weak set-ups with the unique differential MD pitch



CoroMill® 745 face milling cutter See page I17

CoroMill® 745 high feed face milling cutter See page I43

www.sandvik.coromant.com/coromill745

Couplings

- Coromant Capto®
- Arbor

Inserts

- 14 cutting edges
- The secure tip seat and the large, robust insert with strong, light-cutting geometries are designed for reliable and predictable machining.

Ground-breaking technology

Available with 42° entering angle for larger cutting depths and as a high feed version with 25° entering angle for an even higher metal removal rate. Same inserts are used in both cutters.



Differential MD pitch

The unique differential MD pitch is first choice in roughing operations where light cutting action is required, e.g. in vibration-sensitive and weak set-ups. It is a perfect problem-solver when vibration is a limitation in the production. The length and weight of the cutter body has been reduced in order to boost the performance in low-productive applications. The cutter has a logarithmic differential pitch design, and the insert position is radially compensated to produce an even chip load on every insert.



I43



I45

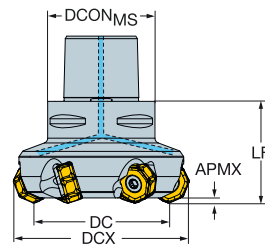
CoroMill® 745 face milling cutter

Coromant Capto® - Internal coolant supply

High-feed milling cutter

KAPR

25°



| | | | | | | Dimensions, mm | | | | | | | | |
|-------|----|-------------------|---------------------|------|----|----------------|--------------------|-------|------|------|------|------|------|-----------|
| DC | | CZC _{MS} | APMX _{FFW} | CNSC | | Ordering code | DCON _{MS} | DCX | LF | | | RPMX | CICT | MIID |
| 63.0 | 21 | C5 | 2.80 | 3 | 5 | 725-063C5-21M | 50.0 | 86.4 | 60.0 | 12.0 | 1.30 | 5894 | 5 | 745R-2109 |
| | 21 | C6 | 2.80 | 3 | 5 | 725-063C6-21M | 63.0 | 86.4 | 60.0 | 12.0 | 1.70 | 5894 | 5 | 745R-2109 |
| | 21 | C5 | 2.80 | 3 | 7 | 725-063C5-21H | 50.0 | 86.4 | 60.0 | 12.0 | 1.20 | 5894 | 7 | 745R-2109 |
| | 21 | C6 | 2.80 | 3 | 7 | 725-063C6-21H | 63.0 | 86.4 | 60.0 | 12.0 | 1.60 | 5894 | 7 | 745R-2109 |
| 80.0 | 21 | C6 | 2.80 | 3 | 5 | 725-080C6-21M | 63.0 | 103.4 | 65.0 | 12.0 | 2.06 | 5324 | 5 | 745R-2109 |
| | 21 | C8 | 2.80 | 3 | 6 | 725-080C8-21M | 80.0 | 103.4 | 65.0 | 12.0 | 3.04 | 5324 | 6 | 745R-2109 |
| | 21 | C6 | 2.80 | 3 | 9 | 725-080C6-21H | 63.0 | 103.4 | 65.0 | 12.0 | 1.93 | 5324 | 9 | 745R-2109 |
| | 21 | C8 | 2.80 | 3 | 9 | 725-080C8-21H | 80.0 | 103.4 | 65.0 | 12.0 | 2.91 | 5324 | 9 | 745R-2109 |
| 100.0 | 21 | C8 | 2.80 | 3 | 7 | 725-100C8-21M | 80.0 | 123.4 | 65.0 | 12.0 | 3.67 | 4765 | 7 | 745R-2109 |
| | 21 | C8 | 2.80 | 3 | 11 | 725-100C8-21H | 80.0 | 123.4 | 65.0 | 12.0 | 3.49 | 4765 | 11 | 745R-2109 |

| |
|--------------|
| Spare parts |
| |
| Insert screw |
| 5513 020-80 |

For complete list of spare parts, see www.sandvik.coromant.com



I45



L2



N23



N9



N15

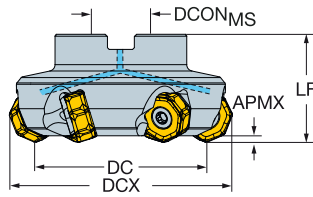
CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

High-feed milling cutter

STDNO
KAPR

ISO 6462
25°



| | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|---------------------|------|---------------|--------------------|----------------|-----|-------|------|------|------|------|------|-----------|--|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | DCON _{MS} | ISO | DCX | LF | NM | KG | RPMX | CICT | MIID | | |
| 63.0 | 21 | 22 | 2.80 | 3 5 | 725-063Q22-21M | 22.0 | A | 86.4 | 50.0 | 12.0 | 0.90 | 5894 | 5 | 745R-2109 | |
| | 21 | 22 | 2.80 | 3 7 | 725-063Q22-21H | 22.0 | A | 86.4 | 50.0 | 12.0 | 0.81 | 5894 | 7 | 745R-2109 | |
| 80.0 | 21 | 27 | 2.80 | 3 6 | 725-080Q27-21M | 27.0 | A | 103.4 | 50.0 | 12.0 | 1.36 | 5324 | 6 | 745R-2109 | |
| | 21 | 27 | 2.80 | 3 9 | 725-080Q27-21H | 27.0 | A | 103.4 | 50.0 | 12.0 | 1.23 | 5324 | 9 | 745R-2109 | |
| 100.0 | 21 | 32 | 2.80 | 3 7 | 725-100Q32-21M | 32.0 | A | 123.4 | 50.0 | 12.0 | 2.33 | 4765 | 7 | 745R-2109 | |
| | 21 | 32 | 2.80 | 3 11 | 725-100Q32-21H | 32.0 | A | 123.4 | 50.0 | 12.0 | 2.18 | 4765 | 11 | 745R-2109 | |
| 125.0 | 21 | 40 | 2.80 | 3 8 | 725-125Q40-21M | 40.0 | B | 148.4 | 63.0 | 12.0 | 3.97 | 4216 | 8 | 745R-2109 | |
| | 21 | 40 | 2.80 | 3 14 | 725-125Q40-21H | 40.0 | B | 148.4 | 63.0 | 12.0 | 3.17 | 4216 | 14 | 745R-2109 | |
| 160.0 | 21 | 40 | 2.80 | 3 10 | 725-160Q40-21M | 40.0 | B | 183.4 | 63.0 | 12.0 | 4.86 | 3675 | 10 | 745R-2109 | |
| | 21 | 40 | 2.80 | 3 16 | 725-160Q40-21H | 40.0 | B | 183.4 | 63.0 | 12.0 | 5.31 | 3675 | 16 | 745R-2109 | |

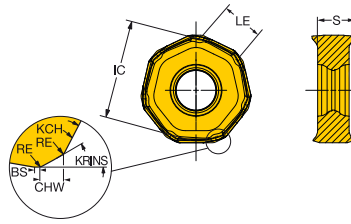
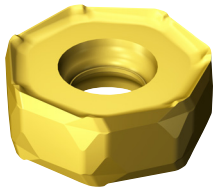
| DC | Spare parts | |
|---------------|--------------|--------------|
| | Shower screw | Insert screw |
| 63.00 | 5512 073-01 | 5513 020-80 |
| 80.00 | 5512 073-02 | 5513 020-80 |
| 100.00 | 5512 073-05 | 5513 020-80 |
| 125.00-160.00 | 5512 098-03 | 5513 020-80 |
| 250.00 | - | 5513 020-80 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 745 insert for milling

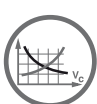
KRINS 42°



| | | | | Ordering code | P | | K | | Dimensions, mm | | | | | | | | | |
|--------|-----|------|------|---------------|----------------|----------------|------|------|----------------|------|------|------|----|------|------|------|------|------|
| | | | | | 1130 | 4220 | 4230 | 4240 | 1020 | 3040 | K20D | K20W | IC | LE | S | BS | BSR | |
| Medium | M30 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-M30 | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | 21 | 1.00 | 17° | 1.3 | 745L-2109E-M50 | | | ★ | | | ☆ | ☆ | ☆ | 21.0 | 8.5 | 9.00 | 0.3 |
| | M50 | 1.00 | 17° | 1.3 | 745R-2109E-M50 | ★ | ☆ | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| Heavy | H50 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-H50 | | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | | | | | | | | | | | | | | | | | |



143



1154



1175

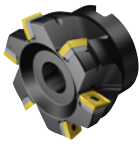


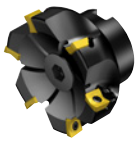








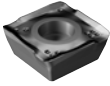
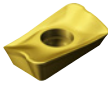

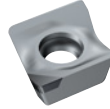





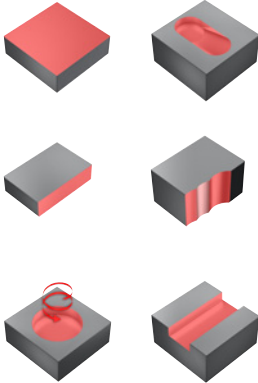




N23



N10

Shoulder milling tools

| | CoroMill® 490 | CoroMill® 390 | CoroMill® 690 | CoroMill® Century |
|------------------|---|---|--|---|
| |  |  |  |  |
| Page | I47 | I57 | I79 | I83 |
| Material |  |  |  |  |
| Main operation |  |  |  |  |
| KAPR | 90° | 90° | 90° | 90° |
| DC mm | 20 - 250 | 9.7 - 200 | 40 - 100 | 40 - 200 |
| APMX mm | 5.5 - 10.0 | 5.8 - 85 | 46 - 108 | 11 |
| Insert |  |  |  |  |
| Insert sizes | 8 & 14 | 07,11,17 & 18 | 10 & 14 | 11 |
| Couplings | Coromant Capto® Coromant EH Cylindrical shank Weldon HSK Arbor | Coromant Capto® Coromant EH Cylindrical shank Arbor Weldon Threaded coupling | Coromant Capto® HSK Arbor | Coromant Capto® HSK Arbor |
| Internal coolant |  |  |  |  |
| Options | | Damped cutter bodies available | | Exchangeable cassette design |
| Other operations |  |  |  |  |

CoroMill® 490

Face and shoulder mill for precise profiles

Application

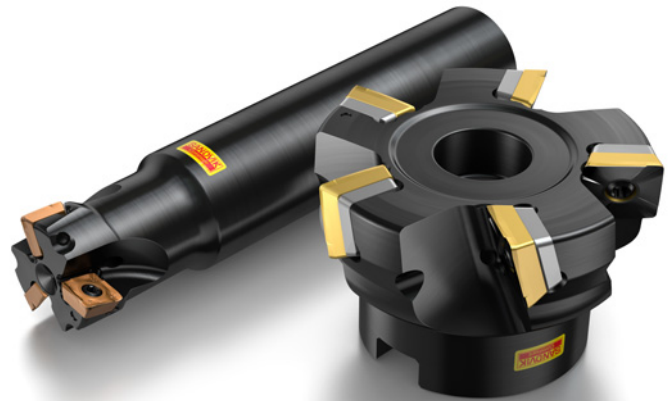
- Square shoulder milling
- Repeated shoulder milling
- Circular interpolation
- Face milling

ISO application area:



Benefits and features

- Great flexibility, high precision and good tolerances
- Light and quiet cutting with low cutting forces
- High productivity with outstanding insert geometry and grades
- Sharp edge lines and burr-free, smooth profiles
- Component feature finished in one pass
- True 90-degree cut without sharp steps
- Light cutting performance provides an optimal utilization of low-powered machine tools. This also facilitates use of the cutter on extended tool assemblies
- Undersized shanks for larger diameter cutters, using 8 mm inserts, enable these cutters to fit into smaller tool holders
- Oversized versions enhance the accessibility and provide natural clearance to tight fixtures



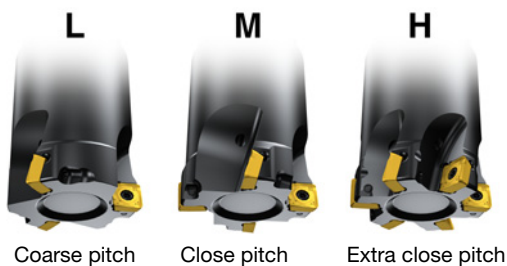
www.sandvik.coromant.com/coromill490

Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank
- Weldon
- Coromant EH
- HSK
- Undersized shanks for cylindrical cutters
- Oversized versions available on arbor, Coromant Capto® cutters, arbor and Coromant EH

Inserts

- Four cutting edges
- Cemented carbide, CBN and ceramic grades



Precision

The insert edges are slightly crowned to compensate for deflection. Due to this geometry, angular distortion during shoulder milling is minimized, and discernable steps between repeatable passes are avoided.



148



155

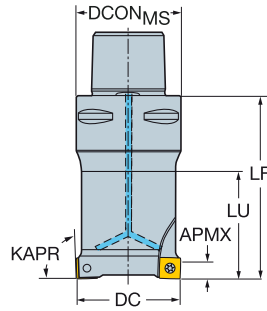


N6

CoroMill® 490 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|----|-------------------|---------------------|------|---|----------------|--------------------|------|------|------|-----|------|-------|------|-------------|--|--|
| DC | | CZC _{MS} | APMX _{FFW} | CNSC | | Ordering code | DCON _{MS} | LB | LF | LU | NM | KG | RPMX | CICT | MID | | |
| 20.0 | 08 | C3 | 5.50 | 3 | 2 | 490-020C3-08L | 32.0 | 40.0 | 80.0 | 40.0 | 1.2 | 0.37 | 48500 | 2 | 490R-08T308 | | |
| | 08 | C4 | 5.50 | 3 | 2 | 490-020C4-08L | 40.0 | 40.0 | 70.0 | 40.0 | 1.2 | 0.62 | 39000 | 2 | 490R-08T308 | | |
| 25.0 | 08 | C3 | 5.50 | 3 | 3 | 490-025C3-08M | 32.0 | 60.0 | 80.0 | 60.0 | 1.2 | 0.39 | 40400 | 3 | 490R-08T308 | | |
| | 08 | C4 | 5.50 | 3 | 3 | 490-025C4-08M | 40.0 | 45.0 | 70.0 | 45.0 | 1.2 | 0.43 | 39000 | 3 | 490R-08T308 | | |
| | 08 | C5 | 5.50 | 3 | 3 | 490-025C5-08M | 50.0 | 50.0 | 75.0 | 50.0 | 1.2 | 0.85 | 28000 | 3 | 490R-08T308 | | |
| | 08 | C6 | 5.50 | 3 | 3 | 490-025C6-08M | 63.0 | 53.0 | 80.0 | 53.0 | 1.2 | 1.41 | 20000 | 3 | 490R-08T308 | | |
| 32.0 | 08 | C3 | 5.50 | 3 | 4 | 490-032C3-08M | 32.0 | 60.0 | 80.0 | 60.0 | 1.2 | 0.50 | 33900 | 4 | 490R-08T308 | | |
| | 08 | C4 | 5.50 | 3 | 4 | 490-032C4-08M | 40.0 | 45.0 | 70.0 | 45.0 | 1.2 | 0.75 | 33900 | 4 | 490R-08T308 | | |
| | 08 | C5 | 5.50 | 3 | 4 | 490-032C5-08M | 50.0 | 50.0 | 75.0 | 50.0 | 1.2 | 0.90 | 28000 | 4 | 490R-08T308 | | |
| | 08 | C6 | 5.50 | 3 | 4 | 490-032C6-08M | 63.0 | 53.0 | 80.0 | 53.0 | 1.2 | 1.44 | 20000 | 4 | 490R-08T308 | | |
| 36.0 | 08 | C3 | 5.50 | 3 | 4 | 490-036C3-08M | 32.0 | 30.0 | 50.0 | 30.0 | 1.2 | 0.55 | 31300 | 4 | 490R-08T308 | | |
| 40.0 | 08 | C4 | 5.50 | 3 | 4 | 490-040C4-08M | 40.0 | 45.0 | 70.0 | 45.0 | 1.2 | 0.82 | 29300 | 4 | 490R-08T308 | | |
| | 08 | C5 | 5.50 | 3 | 4 | 490-040C5-08M | 50.0 | 50.0 | 75.0 | 50.0 | 1.2 | 1.09 | 28000 | 4 | 490R-08T308 | | |
| | 08 | C4 | 5.50 | 3 | 6 | 490-040C4-08H | 40.0 | 45.0 | 70.0 | 45.0 | 1.2 | 0.88 | 29300 | 6 | 490R-08T308 | | |
| | 08 | C5 | 5.50 | 3 | 6 | 490-040C5-08H | 50.0 | 50.0 | 75.0 | 50.0 | 1.2 | 1.10 | 28000 | 6 | 490R-08T308 | | |
| | 08 | C6 | 5.50 | 3 | 6 | 490-040C6-08H | 63.0 | 53.0 | 80.0 | 53.0 | 1.2 | 1.62 | 20000 | 6 | 490R-08T308 | | |
| | 14 | C4 | 10.00 | 3 | 3 | 490-040C4-14M | 40.0 | 45.0 | 70.0 | 45.0 | 3.0 | 0.82 | 26400 | 3 | 490R-1404 | | |
| | 14 | C5 | 10.00 | 3 | 3 | 490-040C5-14M | 50.0 | 50.0 | 75.0 | 50.0 | 3.0 | 1.02 | 26400 | 3 | 490R-1404 | | |
| | 14 | C6 | 10.00 | 3 | 3 | 490-040C6-14M | 63.0 | 53.0 | 80.0 | 53.0 | 3.0 | 1.56 | 20000 | 3 | 490R-1404 | | |
| | 14 | C4 | 10.00 | 3 | 4 | 490-040C4-14H | 40.0 | 70.0 | 70.0 | 45.0 | 3.0 | 0.82 | 26400 | 4 | 490R-1404 | | |
| | 14 | C5 | 10.00 | 3 | 4 | 490-040C5-14H | 50.0 | 50.0 | 75.0 | 50.0 | 3.0 | 1.03 | 26400 | 4 | 490R-1404 | | |
| | 14 | C6 | 10.00 | 3 | 4 | 490-040C6-14H | 63.0 | 53.0 | 80.0 | 53.0 | 3.0 | 1.52 | 20000 | 4 | 490R-1404 | | |
| 44.0 | 08 | C4 | 5.50 | 3 | 5 | 490-044C4-08M | 40.0 | 40.0 | 60.0 | | 1.2 | 0.83 | 27600 | 5 | 490R-08T308 | | |
| | 08 | C4 | 5.50 | 3 | 6 | 490-044C4-08H | 40.0 | 40.0 | 60.0 | | 1.2 | 0.79 | 27600 | 6 | 490R-08T308 | | |
| | 14 | C4 | 10.00 | 3 | 3 | 490-044C4-14M | 40.0 | 45.0 | 70.0 | | 3.0 | 0.89 | 24600 | 3 | 490R-1404 | | |
| | 14 | C4 | 10.00 | 3 | 4 | 490-044C4-14H | 40.0 | 70.0 | 70.0 | | 3.0 | 0.89 | 24600 | 4 | 490R-1404 | | |
| 50.0 | 08 | C5 | 5.50 | 3 | 5 | 490-050C5-08M | 50.0 | 50.0 | 75.0 | 50.0 | 1.2 | 1.28 | 25500 | 5 | 490R-08T308 | | |
| | 08 | C6 | 5.50 | 3 | 5 | 490-050C6-08M | 63.0 | 53.0 | 80.0 | 53.0 | 1.2 | 1.84 | 20000 | 5 | 490R-08T308 | | |
| | 08 | C5 | 5.50 | 3 | 7 | 490-050C5-08H | 50.0 | 50.0 | 75.0 | 50.0 | 1.2 | 1.26 | 25500 | 7 | 490R-08T308 | | |
| | 08 | C6 | 5.50 | 3 | 7 | 490-050C6-08H | 63.0 | 53.0 | 80.0 | 53.0 | 1.2 | 1.86 | 20000 | 7 | 490R-08T308 | | |
| | 14 | C5 | 10.00 | 3 | 4 | 490-050C5-14M | 50.0 | 53.0 | 75.0 | 50.0 | 3.0 | 1.26 | 13700 | 4 | 490R-1404 | | |
| | 14 | C6 | 10.00 | 3 | 4 | 490-050C6-14M | 63.0 | 53.0 | 80.0 | 53.0 | 3.0 | 1.80 | 13700 | 4 | 490R-1404 | | |
| | 14 | C5 | 10.00 | 3 | 5 | 490-050C5-14H | 50.0 | 50.0 | 75.0 | 50.0 | 3.0 | 1.23 | 22400 | 5 | 490R-1404 | | |
| | 14 | C6 | 10.00 | 3 | 5 | 490-050C6-14H | 63.0 | 53.0 | 80.0 | 53.0 | 3.0 | 1.75 | 20000 | 5 | 490R-1404 | | |
| 54.0 | 08 | C5 | 5.50 | 3 | 5 | 490-054C5-08M | 50.0 | 40.0 | 60.0 | | 1.2 | 1.34 | 24300 | 5 | 490R-08T308 | | |
| | 08 | C5 | 5.50 | 3 | 7 | 490-054C5-08H | 50.0 | 40.0 | 60.0 | | 1.2 | 1.34 | 24300 | 7 | 490R-08T308 | | |
| | 14 | C5 | 10.00 | 3 | 4 | 490-054C5-14M | 50.0 | 60.0 | 60.0 | | 3.0 | 1.31 | 13000 | 4 | 490R-1404 | | |
| | 14 | C5 | 10.00 | 3 | 5 | 490-054C5-14H | 50.0 | 60.0 | 60.0 | | 3.0 | 1.26 | 21300 | 5 | 490R-1404 | | |
| 63.0 | 08 | C6 | 5.50 | 3 | 6 | 490-063C6-08M | 63.0 | 23.0 | 50.0 | 23.0 | 1.2 | 1.69 | 20000 | 6 | 490R-08T308 | | |
| | 08 | C6 | 5.50 | 3 | 8 | 490-063C6-08H | 63.0 | 23.0 | 50.0 | 23.0 | 1.2 | 1.67 | 20000 | 8 | 490R-08T308 | | |
| | 14 | C6 | 10.00 | 3 | 5 | 490-063C6-14M | 63.0 | 53.0 | 80.0 | 53.0 | 3.0 | 2.18 | 11700 | 5 | 490R-1404 | | |
| | 14 | C6 | 10.00 | 3 | 6 | 490-063C6-14H | 63.0 | 53.0 | 80.0 | 53.0 | 3.0 | 2.16 | 11700 | 6 | 490R-1404 | | |
| 66.0 | 08 | C6 | 5.50 | 3 | 6 | 490-066C6-08M | 63.0 | 28.0 | 50.0 | | 1.2 | 1.70 | 20000 | 6 | 490R-08T308 | | |
| | 08 | C6 | 5.50 | 3 | 8 | 490-066C6-08H | 63.0 | 28.0 | 50.0 | | 1.2 | 1.72 | 20000 | 8 | 490R-08T308 | | |
| | 14 | C6 | 10.00 | 3 | 5 | 490-066C6-14M | 63.0 | 65.0 | 65.0 | | 3.0 | 1.93 | 11400 | 5 | 490R-1404 | | |
| | 14 | C6 | 10.00 | 3 | 6 | 490-066C6-14H | 63.0 | 65.0 | 65.0 | | 3.0 | 1.94 | 11400 | 6 | 490R-1404 | | |



I55



L2



N23



N6



N9

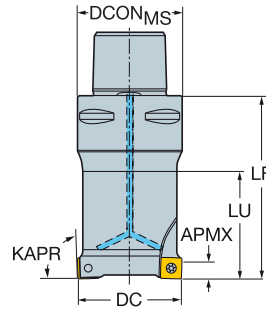






N15


CoroMill® 490 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | | |
|------|---|-------------------|---------------------|------|---|----------------|--------------------|------|------|------|---|--|-------|------|-------------|
| DC |  | CZC _{MS} | APMX _{FFW} | CNSC |  | Ordering code | DCON _{MS} | LB | LF | LU |  |  | RPMX | CICT | MIID |
| 80.0 | 08 | C8 | 5.50 | 3 | 8 | 490-080C8-08M | 80.0 | | 80.0 | 45.0 | 1.2 | 3.73 | 14000 | 8 | 490R-08T308 |
| | 08 | C8 | 5.50 | 3 | 10 | 490-080C8-08H | 80.0 | | 80.0 | 45.0 | 1.2 | 3.76 | 14000 | 10 | 490R-08T308 |
| | 14 | C6 | 10.00 | 3 | 6 | 490-080C6-14M | 63.0 | 65.0 | 65.0 | 65.0 | 3.0 | 2.33 | 10100 | 6 | 490R-1404 |
| | 14 | C8 | 10.00 | 3 | 6 | 490-080C8-14M | 80.0 | | 80.0 | 45.0 | 3.0 | 3.59 | 10100 | 6 | 490R-1404 |
| | 14 | C6 | 10.00 | 3 | 8 | 490-080C6-14H | 63.0 | 65.0 | 65.0 | 65.0 | 3.0 | 2.33 | 10100 | 8 | 490R-1404 |
| | 14 | C8 | 10.00 | 3 | 8 | 490-080C8-14H | 80.0 | | 80.0 | 45.0 | 3.0 | 3.59 | 10100 | 8 | 490R-1404 |
| 84.0 | 08 | C8 | 5.50 | 3 | 8 | 490-084C8-08M | 80.0 | | 60.0 | | 1.2 | 3.13 | 14000 | 8 | 490R-08T308 |
| | 08 | C8 | 5.50 | 3 | 10 | 490-084C8-08H | 80.0 | | 60.0 | | 1.2 | 3.19 | 14000 | 10 | 490R-08T308 |
| | 14 | C8 | 10.00 | 3 | 6 | 490-084C8-14M | 80.0 | | 70.0 | | 3.0 | 3.39 | 9800 | 6 | 490R-1404 |
| | 14 | C8 | 10.00 | 3 | 8 | 490-084C8-14H | 80.0 | | 70.0 | | 3.0 | 3.39 | 9800 | 8 | 490R-1404 |

| Spare parts | | | |
|---|--------------|-------------|-------------|
|  | Insert screw | Shim | Shim screw |
| 08 | 5513 020-35 | | |
| 14 | 5513 020-72 | 5322 471-01 | 5512 090-01 |

For complete list of spare parts, see www.sandvik.coromant.com



155



L2



N23



N6



N9



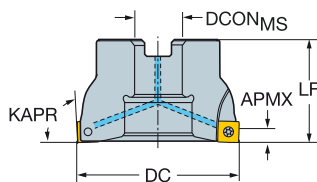
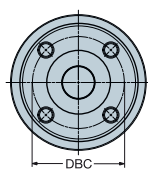
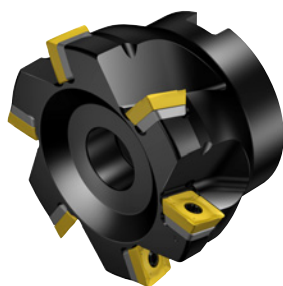
N15

CoroMill® 490 square shoulder milling cutter

Arbor - Internal coolant supply

STDNO
KAPR

ISO6462
90°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|-------------------|---------------------|-------|---------------|--------------------|----------------|------|----|-------|------|------|-------|------|-------------|-----------|--|--|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | DCON _{MS} | ISO | DBC | LF | NM | KG | RPMX | CICT | MIID | | | | |
| 40.0 | 08 | 16 | 5.50 | 1 | 4 | 490-040Q16-08M | 16.0 | A | 40.0 | 1.2 | 0.46 | 29300 | 4 | 490R-08T308 | | | |
| | 08 | 16 | 5.50 | 1 | 6 | 490-040Q16-08H | 16.0 | A | 40.0 | 1.2 | 0.23 | 29300 | 6 | 490R-08T308 | | | |
| 44.0 | 08 | 16 | 5.50 | 1 | 5 | 490-044Q16-08M | 16.0 | A | 40.0 | 1.2 | 0.50 | 27600 | 5 | 490R-08T308 | | | |
| 50.0 | 08 | 22 | 5.50 | 1 | 4 | 490-050Q22-08L | 22.0 | A | 40.0 | 1.2 | 0.66 | 25500 | 4 | 490R-08T308 | | | |
| | 08 | 22 | 5.50 | 1 | 5 | 490-050Q22-08M | 22.0 | A | 40.0 | 1.2 | 0.48 | 25500 | 5 | 490R-08T308 | | | |
| | 08 | 22 | 5.50 | 1 | 7 | 490-050Q22-08H | 22.0 | A | 40.0 | 1.2 | 0.37 | 25500 | 7 | 490R-08T308 | | | |
| | 14 | 22 | 10.00 | 1 | 4 | 490-050Q22-14M | 22.0 | A | 40.0 | 3.0 | 0.38 | 13700 | 4 | 490R-1404 | | | |
| | 14 | 22 | 10.00 | 1 | 5 | 490-050Q22-14H | 22.0 | A | 40.0 | 3.0 | 0.36 | 22400 | 5 | 490R-1404 | | | |
| 54.0 | 08 | 22 | 5.50 | 1 | 5 | 490-054Q22-08M | 22.0 | A | 40.0 | 1.2 | 0.69 | 24300 | 5 | 490R-08T308 | | | |
| | 14 | 22 | 10.00 | 1 | 4 | 490-054Q22-14M | 22.0 | A | 40.0 | 3.0 | 0.67 | 13000 | 4 | 490R-1404 | | | |
| 63.0 | 08 | 22 | 5.50 | 1 | 5 | 490-063Q22-08L | 22.0 | A | 40.0 | 1.2 | 0.77 | 22200 | 5 | 490R-08T308 | | | |
| | 08 | 22 | 5.50 | 1 | 6 | 490-063Q22-08M | 22.0 | A | 40.0 | 1.2 | 0.53 | 22200 | 6 | 490R-08T308 | | | |
| | 08 | 22 | 5.50 | 1 | 8 | 490-063Q22-08H | 22.0 | A | 40.0 | 1.2 | 0.50 | 22200 | 8 | 490R-08T308 | | | |
| | 14 | 22 | 10.00 | 1 | 5 | 490-063Q22-14M | 22.0 | A | 40.0 | 3.0 | 0.51 | 11700 | 5 | 490R-1404 | | | |
| | 14 | 22 | 10.00 | 1 | 6 | 490-063Q22-14H | 22.0 | A | 40.0 | 3.0 | 0.71 | 11700 | 6 | 490R-1404 | | | |
| 66.0 | 08 | 22 | 5.50 | 1 | 6 | 490-066Q22-08M | 22.0 | A | 40.0 | 1.2 | 0.75 | 21600 | 6 | 490R-08T308 | | | |
| | 14 | 22 | 10.00 | 1 | 5 | 490-066Q22-14M | 22.0 | A | 40.0 | 3.0 | 0.76 | 11400 | 5 | 490R-1404 | | | |
| 80.0 | 08 | 27 | 5.50 | 1 | 6 | 490-080Q27-08L | 27.0 | A | 50.0 | 1.2 | 1.43 | 19400 | 6 | 490R-08T308 | | | |
| | 08 | 27 | 5.50 | 1 | 8 | 490-080Q27-08M | 27.0 | A | 50.0 | 1.2 | 1.39 | 19400 | 8 | 490R-08T308 | | | |
| | 08 | 27 | 5.50 | 1 | 10 | 490-080Q27-08H | 27.0 | A | 50.0 | 1.2 | 1.20 | 19400 | 10 | 490R-08T308 | | | |
| | 14 | 27 | 10.00 | 1 | 6 | 490-080Q27-14M | 27.0 | A | 50.0 | 3.0 | 1.11 | 10100 | 6 | 490R-1404 | | | |
| | 14 | 27 | 10.00 | 1 | 8 | 490-080Q27-14H | 27.0 | A | 50.0 | 3.0 | 1.12 | 10100 | 8 | 490R-1404 | | | |
| 84.0 | 08 | 27 | 5.50 | 1 | 8 | 490-084Q27-08M | 27.0 | A | 50.0 | 1.2 | 1.78 | 18900 | 8 | 490R-08T308 | | | |
| | 14 | 27 | 10.00 | 1 | 6 | 490-084Q27-14M | 27.0 | A | 50.0 | 3.0 | 1.61 | 9800 | 6 | 490R-1404 | | | |
| 100.0 | 08 | 32 | 5.50 | 0 | 6 | 490-100Q32-08L | 32.0 | B | 50.0 | 1.2 | 2.15 | 17100 | 6 | 490R-08T308 | | | |
| | 08 | 32 | 5.50 | 0 | 8 | 490-100Q32-08M | 32.0 | B | 50.0 | 1.2 | 2.10 | 17100 | 8 | 490R-08T308 | | | |
| | 08 | 32 | 5.50 | 0 | 10 | 490-100Q32-08H | 32.0 | B | 50.0 | 1.2 | 2.10 | 17100 | 10 | 490R-08T308 | | | |
| | 14 | 32 | 10.00 | 1 | 5 | 490-100Q32-14L | 32.0 | B | 50.0 | 3.0 | 2.07 | 8900 | 5 | 490R-1404 | | | |
| | 14 | 32 | 10.00 | 1 | 7 | 490-100Q32-14M | 32.0 | B | 50.0 | 3.0 | 1.99 | 8900 | 7 | 490R-1404 | | | |
| | 14 | 32 | 10.00 | 1 | 10 | 490-100Q32-14H | 32.0 | B | 50.0 | 3.0 | 2.00 | 8900 | 10 | 490R-1404 | | | |
| 125.0 | 08 | 40 | 5.50 | 0 | 8 | 490-125Q40-08L | 40.0 | B | 63.0 | 1.2 | 3.51 | 15200 | 8 | 490R-08T308 | | | |
| | 08 | 40 | 5.50 | 0 | 10 | 490-125Q40-08M | 40.0 | B | 63.0 | 1.2 | 3.44 | 15200 | 10 | 490R-08T308 | | | |
| | 08 | 40 | 5.50 | 0 | 12 | 490-125Q40-08H | 40.0 | B | 63.0 | 1.2 | 3.46 | 15200 | 12 | 490R-08T308 | | | |
| | 14 | 40 | 10.00 | 1 | 6 | 490-125Q40-14L | 40.0 | B | 63.0 | 3.0 | 3.37 | 7800 | 6 | 490R-1404 | | | |
| | 14 | 40 | 10.00 | 1 | 8 | 490-125Q40-14M | 40.0 | B | 63.0 | 3.0 | 3.05 | 7800 | 8 | 490R-1404 | | | |
| | 14 | 40 | 10.00 | 1 | 12 | 490-125Q40-14H | 40.0 | B | 63.0 | 3.0 | 3.29 | 7800 | 12 | 490R-1404 | | | |
| 160.0 | 14 | 40S | 10.00 | 0 | 8 | 490-160Q40-14L | 40.0 | C | 66.7 | 63.0 | 3.0 | 5.05 | 6800 | 8 | 490R-1404 | | |
| | 14 | 40S | 10.00 | 0 | 12 | 490-160Q40-14M | 40.0 | C | 66.7 | 63.0 | 3.0 | 5.01 | 6800 | 12 | 490R-1404 | | |
| | 14 | 40S | 10.00 | 0 | 15 | 490-160Q40-14H | 40.0 | C | 66.7 | 63.0 | 3.0 | 5.06 | 6800 | 15 | 490R-1404 | | |
| 200.0 | 14 | 60 | 10.00 | 0 | 10 | 490-200Q60-14L | 60.0 | C | 101.6 | 63.0 | 3.0 | 13.11 | 6000 | 10 | 490R-1404 | | |
| | 14 | 60 | 10.00 | 0 | 16 | 490-200Q60-14M | 60.0 | C | 101.6 | 63.0 | 3.0 | 11.79 | 6000 | 16 | 490R-1404 | | |
| 250.0 | 14 | 60 | 10.00 | 0 | 12 | 490-250Q60-14L | 60.0 | C | 101.6 | 63.0 | 3.0 | 15.50 | 5300 | 12 | 490R-1404 | | |
| | 14 | 60 | 10.00 | 0 | 18 | 490-250Q60-14M | 60.0 | C | 101.6 | 63.0 | 3.0 | 17.52 | 5300 | 18 | 490R-1404 | | |

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



I55



L2



M1



N23



N6



N9

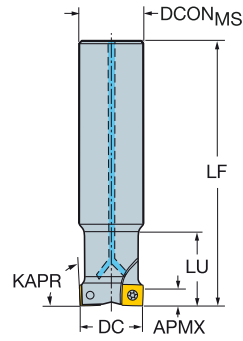


N15

CoroMill® 490 square shoulder milling cutter

Cylindrical shank - Internal coolant supply

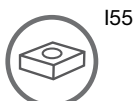
KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|-------|---------------|--------------------|-----------------|------|-------|------|------|-------|-------|-------------|-------------|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | DCON _{MS} | LF | LU | NM | KG | RPM | CICT | MID | | |
| 20.0 | 08 | 16 | 5.50 | 1 | 2 | 490-020A16-08L | 16.0 | 100.0 | 1.2 | 0.24 | 48500 | 2 | 490R-08T308 | |
| | 08 | 20 | 5.50 | 1 | 2 | 490-020A20-08L | 20.0 | 110.0 | 25.0 | 1.2 | 0.33 | 48500 | 2 | 490R-08T308 |
| 22.0 | 08 | 20 | 5.50 | 1 | 2 | 490-022A20L-08L | 20.0 | 170.0 | | 1.2 | 0.47 | 20300 | 2 | 490R-08T308 |
| 25.0 | 08 | 20 | 5.50 | 1 | 2 | 490-025A20-08L | 20.0 | 110.0 | | 1.2 | 0.34 | 40400 | 2 | 490R-08T308 |
| | 08 | 25 | 5.50 | 1 | 2 | 490-025A25-08L | 25.0 | 120.0 | 32.0 | 1.2 | 0.49 | 40400 | 2 | 490R-08T308 |
| | 08 | 20 | 5.50 | 1 | 3 | 490-025A20-08M | 20.0 | 110.0 | | 1.2 | 0.32 | 40400 | 3 | 490R-08T308 |
| | 08 | 25 | 5.50 | 1 | 3 | 490-025A25-08M | 25.0 | 120.0 | 32.0 | 1.2 | 0.46 | 40400 | 3 | 490R-08T308 |
| 28.0 | 08 | 25 | 5.50 | 1 | 2 | 490-028A25L-08L | 25.0 | 210.0 | | 1.2 | 0.84 | 11000 | 2 | 490R-08T308 |
| 32.0 | 08 | 25 | 5.50 | 1 | 3 | 490-032A25-08L | 25.0 | 120.0 | | 1.2 | 0.55 | 33900 | 3 | 490R-08T308 |
| | 08 | 32 | 5.50 | 1 | 3 | 490-032A32-08L | 32.0 | 130.0 | 40.0 | 1.2 | 0.81 | 33900 | 3 | 490R-08T308 |
| | 08 | 25 | 5.50 | 1 | 4 | 490-032A25-08M | 25.0 | 120.0 | | 1.2 | 0.55 | 33900 | 4 | 490R-08T308 |
| | 08 | 32 | 5.50 | 1 | 4 | 490-032A32-08M | 32.0 | 130.0 | 40.0 | 1.2 | 0.81 | 33900 | 4 | 490R-08T308 |
| 40.0 | 08 | 32 | 5.50 | 1 | 3 | 490-040A32-08L | 32.0 | 170.0 | | 1.2 | 1.18 | 20300 | 3 | 490R-08T308 |
| | 08 | 32 | 5.50 | 1 | 4 | 490-040A32-08M | 32.0 | 170.0 | | 1.2 | 1.16 | 20300 | 4 | 490R-08T308 |
| | 08 | 32 | 5.50 | 1 | 6 | 490-040A32-08H | 32.0 | 170.0 | | 1.2 | 1.18 | 20300 | 6 | 490R-08T308 |
| | 14 | 32 | 10.00 | 1 | 3 | 490-040A32-14M | 32.0 | 170.0 | 3.0 | 1.12 | 26400 | 3 | 490R-1404 | |
| | 14 | 32 | 10.00 | 1 | 3 | 490-040A32L-14M | 32.0 | 250.0 | 3.0 | 1.77 | 7600 | 3 | 490R-1404 | |
| | 14 | 32 | 10.00 | 1 | 4 | 490-040A32-14H | 32.0 | 170.0 | 3.0 | 1.13 | 26400 | 4 | 490R-1404 | |
| 50.0 | 14 | 32 | 10.00 | 1 | 3 | 490-050A32-14L | 32.0 | 120.0 | 3.0 | 1.07 | 13700 | 3 | 490R-1404 | |
| | 14 | 32 | 10.00 | 1 | 4 | 490-050A32-14M | 32.0 | 120.0 | 3.0 | 0.90 | 13700 | 4 | 490R-1404 | |
| 63.0 | 14 | 32 | 10.00 | 1 | 4 | 490-063A32-14L | 32.0 | 120.0 | 3.0 | 1.43 | 11700 | 4 | 490R-1404 | |
| | 14 | 32 | 10.00 | 1 | 5 | 490-063A32-14M | 32.0 | 120.0 | 3.0 | 1.43 | 11700 | 5 | 490R-1404 | |

| Spare parts | | | |
|-------------|--------------|-------------|-------------|
| | Insert screw | Shim | Shim screw |
| 08 | 5513 020-35 | | |
| 14 | 5513 020-72 | 5322 471-01 | 5512 090-01 |

For complete list of spare parts, see www.sandvik.coromant.com



I55



L2



N23



N6



N9

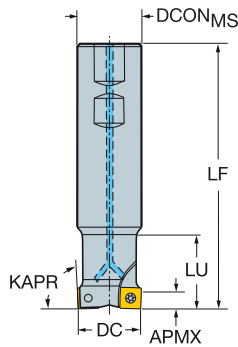


N15

CoroMill® 490 square shoulder milling cutter

Weldon - Internal coolant supply

KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|-------------------|---------------------|-------|---------------|--------------------|----------------|----|------|-------|------|-----|------|-------|------|-------------|--|--|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | DCON _{MS} | ISO | LB | LF | LU | NM | KG | RPMX | CICT | MIID | | | |
| 20.0 | 08 | 16 | 5.50 | 1 2 | 490-020B16-08L | 16.0 | WE | 25.0 | 74.0 | 25.0 | 1.2 | 0.20 | 48500 | 2 | 490R-08T308 | | |
| | 08 | 20 | 5.50 | 1 2 | 490-020B20-08L | 20.0 | WE | 25.0 | 76.0 | 25.0 | 1.2 | 0.25 | 48500 | 2 | 490R-08T308 | | |
| 25.0 | 08 | 20 | 5.50 | 1 2 | 490-025B20-08L | 20.0 | WE | 32.0 | 83.0 | | 1.2 | 0.28 | 40400 | 2 | 490R-08T308 | | |
| | 08 | 25 | 5.50 | 1 3 | 490-025B25-08M | 25.0 | WE | 32.0 | 88.0 | 32.0 | 1.2 | 0.37 | 40400 | 3 | 490R-08T308 | | |
| 32.0 | 08 | 25 | 5.50 | 1 3 | 490-032B25-08L | 25.0 | WE | 40.0 | 98.0 | | 1.2 | 0.46 | 33900 | 3 | 490R-08T308 | | |
| | 08 | 32 | 5.50 | 1 3 | 490-032B32-08L | 32.0 | WE | 40.0 | 100.0 | 40.0 | 1.2 | 0.62 | 33900 | 3 | 490R-08T308 | | |
| | 08 | 25 | 5.50 | 1 4 | 490-032B25-08M | 25.0 | WE | 40.0 | 98.0 | | 1.2 | 0.47 | 33900 | 4 | 490R-08T308 | | |
| | 08 | 32 | 5.50 | 1 4 | 490-032B32-08M | 32.0 | WE | 40.0 | 100.0 | 40.0 | 1.2 | 0.62 | 33900 | 4 | 490R-08T308 | | |
| 40.0 | 08 | 32 | 5.50 | 1 4 | 490-040B32-08M | 32.0 | WE | 50.0 | 112.0 | | 1.2 | 0.79 | 29300 | 4 | 490R-08T308 | | |
| | 08 | 32 | 5.50 | 1 6 | 490-040B32-08H | 32.0 | WE | 50.0 | 112.0 | | 1.2 | 0.81 | 29300 | 6 | 490R-08T308 | | |
| | 14 | 32 | 10.00 | 1 3 | 490-040B32-14M | 32.0 | WE | 50.0 | 112.0 | | 3.0 | 0.76 | 26400 | 3 | 490R-1404 | | |
| | 14 | 32 | 10.00 | 1 4 | 490-040B32-14H | 32.0 | WE | 50.0 | 112.0 | | 3.0 | 0.77 | 26400 | 4 | 490R-1404 | | |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 08 | 5513 020-35 |
| 14 | 5513 020-72 |

For complete list of spare parts, see www.sandvik.coromant.com



155



L2



N23



N6



N9

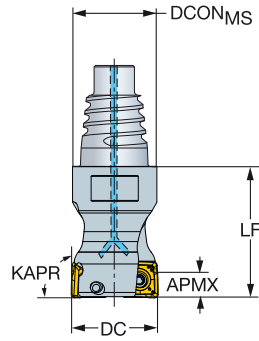


N15

CoroMill® 490 square shoulder milling cutter

Coromant EH - Internal coolant supply

KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|------|---------------|---|--------------------|------|------|-----|------|-------|------|-------------|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | | DCON _{MS} | LF | NM | KG | RPMX | CICT | MIID | |
| 20.0 | 08 | E20 | 5.50 | 1 | 2 | 490-020EH20-08L | 19.3 | 30.0 | 1.2 | 0.14 | 48500 | 2 | 490R-08T308 |
| 25.0 | 08 | E25 | 5.50 | 1 | 2 | 490-025EH25-08L | 24.2 | 35.0 | 1.2 | 0.18 | 40400 | 2 | 490R-08T308 |
| | | | | | | 3 | | | | | | | |
| 32.0 | 08 | E25 | 5.50 | 1 | 3 | 490-032EH25-08L | 24.2 | 35.0 | 1.2 | 0.21 | 33900 | 3 | 490R-08T308 |
| | | | | | | 4 | | | | | | | |

| Spare parts | | |
|-------------|----|--------------|
| DC | | Insert screw |
| 20.00 | 08 | 5513 020-36 |
| 25.00-32.00 | 08 | 5513 020-35 |

For complete list of spare parts, see www.sandvik.coromant.com



155



L2



N23



N6



N9



N15

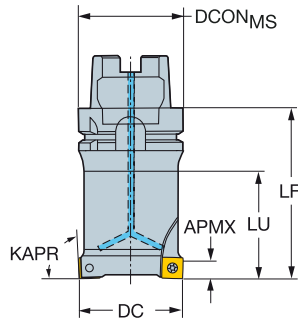


N3

CoroMill® 490 square shoulder milling cutter

HSK - Internal coolant supply

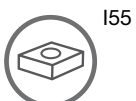
KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | | |
|------|-------------------|---------------------|------|---------------|---|--------------------|------|----|------|------|-----|------|-------|------|-------------|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | Ordering code | | DCON _{MS} | ISO | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 20.0 | 08 | 63 | 5.50 | 1 | 2 | 490-020HA06-08L | 63.0 | A | 95.0 | 40.0 | 1.2 | 1.27 | 30000 | 2 | 490R-08T308 |
| 25.0 | 08 | 63 | 5.50 | 1 | 3 | 490-025HA06-08M | 63.0 | A | 95.0 | 50.0 | 1.2 | 1.25 | 30000 | 3 | 490R-08T308 |
| 32.0 | 08 | 63 | 5.50 | 1 | 4 | 490-032HA06-08M | 63.0 | A | 95.0 | 58.0 | 1.2 | 1.33 | 30000 | 4 | 490R-08T308 |
| 40.0 | 08 | 63 | 5.50 | 1 | 6 | 490-040HA06-08H | 63.0 | A | 95.0 | 58.0 | 1.2 | 1.57 | 29300 | 6 | 490R-08T308 |
| 50.0 | 08 | 63 | 5.50 | 1 | 5 | 490-050HA06-08M | 63.0 | A | 95.0 | 63.0 | 1.2 | 1.84 | 25500 | 5 | 490R-08T308 |
| 50.0 | 08 | 63 | 5.50 | 1 | 7 | 490-050HA06-08H | 63.0 | A | 95.0 | 58.0 | 1.2 | 1.86 | 25500 | 7 | 490R-08T308 |
| 63.0 | 08 | 63 | 5.50 | 1 | 6 | 490-063HA06-08M | 63.0 | A | 70.0 | 44.0 | 1.2 | 1.81 | 22200 | 6 | 490R-08T308 |
| 63.0 | 08 | 63 | 5.50 | 1 | 8 | 490-063HA06-08H | 63.0 | A | 70.0 | 44.0 | 1.2 | 1.80 | 22200 | 8 | 490R-08T308 |
| 80.0 | 08 | 63 | 5.50 | 1 | 8 | 490-080HA06-08M | 63.0 | A | 70.0 | | 1.2 | 2.03 | 19400 | 8 | 490R-08T308 |

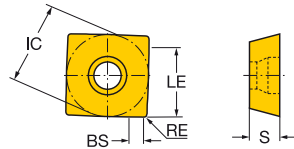
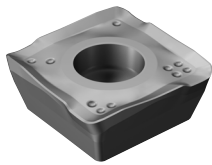
| |
|--------------|
| Spare parts |
| Insert screw |
| 5513 020-35 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 490 insert for milling

KRINS 90°



| | | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--------|-----------------|-----------------|-------------------|-----------------|------|------|------|-----|------|------|------|------|-----|------|------|------|------|------|------|------|------|------|-------|------|------|------|-----|------|------|------|------|------|------|
| | | | | P | | | | M | | | | K | | | | N | | S | | H | | | | | | | | | | | | | |
| | | | | 1130 | 4220 | 4330 | 4940 | 530 | 1040 | 1130 | 2040 | 4940 | 530 | 1020 | 3040 | 3220 | 3330 | HT3A | 1130 | HT3A | 1130 | HT3A | ES30T | S40T | 1010 | 1130 | 530 | IC | LE | S | BS | | |
| Light | KL | 08 | 0.40 | 490R-08T304M-KL | | | | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.5 | |
| | | 0.80 | 490R-08T308M-KL | | | | | | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | 0.40 | 490R-08T304E-ML | | | | | | ★ | ★ | ★ | ★ | ★ | | | | | | | ★ | ★ | ★ | | ★ | ★ | ★ | ★ | | | | 8.5 | 5.6 | 3.30 |
| | ML | 0.80 | 490R-08T308E-ML | ★ | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | ★ | ★ | ★ | ★ | | | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | 14 | 0.80 | 490R-140408E-ML | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | ★ | ★ | ★ | ★ | | | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | 0.40 | 490R-08T304M-PL | ★ | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | | ★ | ★ | | | 8.5 | 5.6 | 3.30 |
| PL | 0.80 | 490R-08T308M-PL | ★ | ★ | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | | ★ | ★ | ★ | | 8.5 | 5.6 | 3.30 | 1.2 |
| | 14 | 0.80 | 490R-140408M-PL | ★ | | ★ | ★ | ★ | | | | | | | | | | | | | | | | | | ★ | ★ | | | 13.8 | 10.3 | 3.90 | 2.0 |
| Medium | KM | 08 | 0.80 | 490R-08T308M-KM | | | | | | | | | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 | |
| | | 1.20 | 490R-08T312M-KM | | | | | | | | | | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.9 | |
| | | 1.60 | 490R-08T316M-KM | | | | | | | | | | | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 |
| | MM | 08 | 0.80 | 490R-08T308E-MM | ★ | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | ★ | ★ | | | | | 8.5 | 5.6 | 3.30 | 1.2 | |
| | | 0.80 | 490R-08T308M-MM | | | | | | | | | | | | | | | | | | | | | | | | ★ | ★ | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | 1.20 | 490R-08T312E-MM | ★ | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.9 |
| | | 1.60 | 490R-08T316E-MM | ★ | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 |
| | | 14 | 0.80 | 490R-140408E-MM | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | 0.80 | 490R-140408M-MM | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | ★ | ★ | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | 1.20 | 490R-140412E-MM | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | ★ | ★ | | 13.8 | 10.3 | 3.90 | 1.6 |
| | 1.60 | 490R-140416E-MM | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 1.2 | |
| | 2.00 | 490R-140420E-MM | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 0.9 | |
| 2.00 | 490R-140420M-MM | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 0.9 | | |
| PM | 08 | 0.80 | 490R-08T308M-PM | ★ | ★ | ★ | ★ | ★ | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 | |
| | 1.20 | 490R-08T312M-PM | ★ | ★ | ★ | ★ | ★ | | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.9 | |
| | 1.60 | 490R-08T316M-PM | ★ | ★ | ★ | ★ | ★ | | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 | |
| | 14 | 0.80 | 490R/L-140408M-PM | ★ | | ★ | | | | | | | | ★ | ★ | ★ | ★ | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 2.0 | |
| | 0.80 | 490R-140408M-PM | ★ | ★ | ★ | ★ | ★ | | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 2.0 | |
| | 1.20 | 490R-140412M-PM | ★ | | ★ | ★ | ★ | | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 2.0 | |
| | 1.60 | 490R-140416M-PM | ★ | | ★ | ★ | ★ | | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 1.2 | |
| | 2.00 | 490R-140420M-PM | ★ | | ★ | ★ | ★ | | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 0.9 | |
| Heavy | KH | 08 | 0.80 | 490R-08T308M-KH | | | | | | | | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 | | |
| | | 1.60 | 490R-08T316M-KH | | | | | | | | | | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 | |
| | PH | 08 | 0.80 | 490R-08T308M-PH | ★ | ★ | ★ | ★ | ★ | | | ★ | ★ | ★ | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 | |
| | | 1.60 | 490R-08T316M-PH | ★ | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 |
| | | 14 | 0.80 | 490R-140408M-PH | ★ | ★ | ★ | ★ | ★ | | | ★ | ★ | ★ | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | 2.00 | 490R-140420M-PH | ★ | ★ | ★ | ★ | ★ | | | | | | | | | | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 0.9 |



148



1154



1175



N23

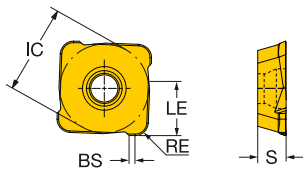
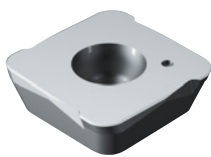


N10

CoroMill® 490 insert for milling

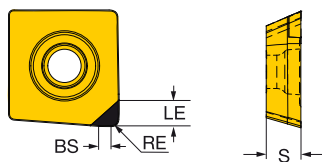
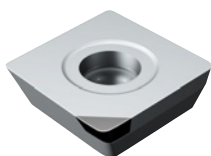
Advanced cutting materials

KRINS 90°



| | | | | K H | | Dimensions, mm | | | | |
|--------|----|----|---------------|--------------|------|----------------|------|-----|------|-----|
| | | RE | Ordering code | 0819 | 1619 | IC | LE | S | BS | |
| Medium | PO | 14 | 2.00 | 490R-140420E | ★ | ★ | 13.8 | 5.0 | 3.90 | 0.8 |
| | | | 2.00 | 490R-140408E | ★ | | 13.8 | 5.0 | 3.90 | 0.8 |

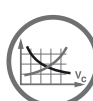
KRINS 90°



| | | | | K H | | Dimensions, mm | | | | |
|--------|----|----|---------------|--------------|------|----------------|------|-----|------|-----|
| | | RE | Ordering code | 0860 | 0860 | IC | LE | S | BS | |
| Medium | PO | 14 | 0.80 | 490R-140408E | ★ | ★ | 13.8 | 2.0 | 3.90 | 1.5 |



I48



I154



I175



N23



N10

CoroMill® 390

Versatile shoulder milling cutters with ramping capability for mixed production

Application

- Shoulder milling
- Repeated shoulder milling
- Turn milling
- Deep shoulder milling
- Edging
- Pocketing
- Linear and helical ramping

ISO application area:



Benefits and features

- Close tolerances giving excellent surface finish and minimal mismatch
- Large depth of cut and steep ramping capability
- Oversized diameter for clearance is available
- Integrated damping technology Silent Tools™ for increased metal removal and improved surface finish
- Available in a shorter version for turning centres
- Internal coolant on most cutters



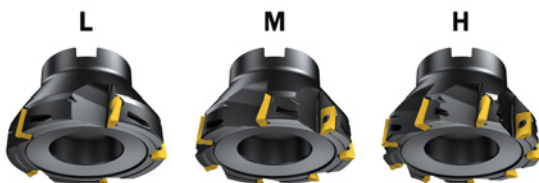
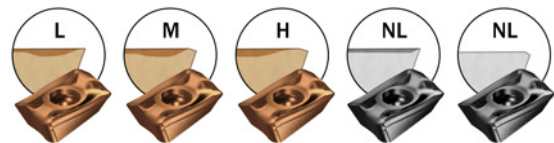
www.sandvik.coromant.com/coromill390

Cutter bodies

- Coromant Capto®
- Arbor
- Cylindrical shank
- Weldon
- Coromant EH
- Threaded coupling
- Oversized versions available on Coromant Capto® cutters, arbor and Coromant EH
- Undersized shanks on cylindrical cutters

Inserts

- Two cutting edges
- Cemented carbide and PCD grades
- The light-cutting insert geometries and high-performance grades of are designed for low cutting forces and vibration-free machining for secure milling in all materials.

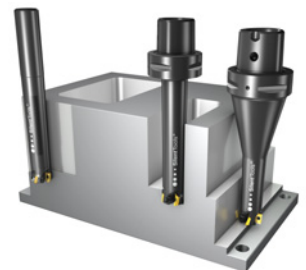


Coarse pitch

Close pitch

Extra close pitch

Silent Tools damped cutter bodies boost productivity at long overhangs



158



174



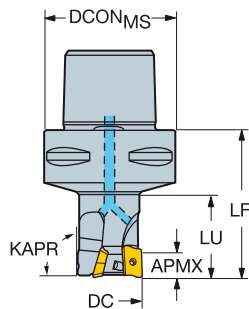
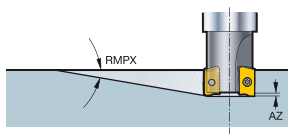
N6

CoroMill® 390 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR

90°



| | | | | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|-----|------|---|-------------------|-------------------|--------------------|-------|------|------|------|-------|-----------|-----------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | | Ordering code | DCON _{MS} | LF | LU | NM | KG | RPMX | CICT | MID |
| 16.0 | 11 | C3 | 5.5 | 10.00 | 10° | 1.0 | 3 | 2 | R390-016C3-11L050 | 32.0 | 50.0 | 25.0 | 1.2 | 0.28 | 39000 | 2 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 10° | 1.0 | 3 | 2 | R390-016C4-11L | 40.0 | 50.0 | 25.0 | 1.2 | 0.41 | 39000 | 2 | R390-11.. |
| 20.0 | 11 | C3 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-020C3-11L050 | 32.0 | 50.0 | 25.0 | 1.2 | 0.29 | 34600 | 2 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-020C4-11L | 40.0 | 50.0 | 25.0 | 1.2 | 0.42 | 34600 | 2 | R390-11.. |
| | 11 | C3 | 5.5 | 10.00 | 5° | 1.0 | 3 | 3 | R390-020C3-11M050 | 32.0 | 50.0 | 25.0 | 1.2 | 0.29 | 34600 | 3 | R390-11.. |
| | 11 | C5 | 5.5 | 10.00 | 5° | 1.0 | 3 | 3 | R390-020C5-11M095 | 50.0 | 95.0 | 40.0 | 1.2 | 1.00 | 34600 | 3 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 5° | 1.0 | 3 | 3 | R390-020C6-11M110 | 63.0 | 110.0 | 40.0 | 1.2 | 1.75 | 34600 | 3 | R390-11.. |
| 25.0 | 11 | C3 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-025C3-11L050 | 32.0 | 50.0 | 32.0 | 1.2 | 0.31 | 36500 | 2 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-025C4-11L | 40.0 | 55.0 | 32.0 | 1.2 | 0.42 | 36500 | 2 | R390-11.. |
| | 11 | C3 | 5.5 | 10.00 | 5° | 1.0 | 3 | 3 | R390-025C3-11M050 | 32.0 | 50.0 | 32.0 | 1.2 | 0.28 | 36500 | 3 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 5° | 1.0 | 3 | 3 | R390-025C4-11M | 40.0 | 55.0 | 32.0 | 1.2 | 0.44 | 36500 | 3 | R390-11.. |
| | 11 | C5 | 5.5 | 10.00 | 5° | 1.0 | 3 | 3 | R390-025C5-11M095 | 50.0 | 95.0 | 45.0 | 1.2 | 1.06 | 36500 | 3 | R390-11.. |
| 32.0 | 11 | C6 | 5.5 | 10.00 | 5° | 1.0 | 3 | 3 | R390-025C6-11M110 | 63.0 | 110.0 | 45.0 | 1.2 | 1.60 | 36500 | 3 | R390-11.. |
| | 11 | C3 | 5.5 | 10.00 | 3° | 1.0 | 3 | 2 | R390-032C3-11L050 | 32.0 | 50.0 | 35.0 | 1.2 | 0.38 | 31000 | 2 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 3° | 1.0 | 3 | 3 | R390-032C4-11M | 40.0 | 65.0 | 40.0 | 1.2 | 0.52 | 31000 | 3 | R390-11.. |
| | 11 | C5 | 5.5 | 10.00 | 3° | 1.0 | 3 | 3 | R390-032C5-11M | 50.0 | 65.0 | 40.0 | 1.2 | 0.88 | 31000 | 3 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 3° | 1.0 | 3 | 3 | R390-032C6-11M095 | 50.0 | 95.0 | 50.0 | 1.2 | 1.10 | 31000 | 3 | R390-11.. |
| 36.0 | 11 | C6 | 5.5 | 10.00 | 3° | 1.0 | 3 | 3 | R390-032C6-11M080 | 63.0 | 80.0 | 40.0 | 1.2 | 1.52 | 31000 | 3 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 3° | 1.0 | 3 | 3 | R390-032C6-11M110 | 63.0 | 110.0 | 50.0 | 1.2 | 1.81 | 31000 | 3 | R390-11.. |
| | 11 | C3 | 5.5 | 10.00 | 2° | 1.0 | 3 | 3 | R390-036C3-11M050 | 32.0 | 50.0 | | 1.2 | 0.38 | 29000 | 3 | R390-11.. |
| | 11 | C3 | 5.5 | 10.00 | 2° | 1.0 | 3 | 3 | R390-036C3-11M075 | 32.0 | 75.0 | | 1.2 | 0.54 | 29000 | 3 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 2° | 1.0 | 3 | 4 | R390-040C4-11M | 40.0 | 70.0 | 70.0 | 1.2 | 0.82 | 27000 | 4 | R390-11.. |
| 40.0 | 11 | C5 | 5.5 | 10.00 | 2° | 1.0 | 3 | 4 | R390-040C5-11M | 50.0 | 75.0 | 50.0 | 1.2 | 1.05 | 27000 | 4 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 2° | 1.0 | 3 | 4 | R390-040C6-11M080 | 63.0 | 80.0 | 40.0 | 1.2 | 1.20 | 27000 | 4 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 2° | 1.0 | 3 | 6 | R390-040C4-11H | 40.0 | 70.0 | 50.0 | 1.2 | 0.56 | 27000 | 6 | R390-11.. |
| | 11 | C5 | 5.5 | 10.00 | 2° | 1.0 | 3 | 6 | R390-040C5-11H | 50.0 | 75.0 | 50.0 | 1.2 | 1.07 | 27000 | 6 | R390-11.. |
| | 18 | C4 | 1.1 | 15.40 | 6° | 0.0 | 3 | 3 | R390-040C4-18M060 | 40.0 | 60.0 | 40.0 | 3.0 | 0.48 | 9200 | 3 | R390-18.. |
| 44.0 | 18 | C5 | 1.1 | 15.40 | 6° | 0.0 | 3 | 3 | R390-040C5-18M080 | 50.0 | 80.0 | 40.0 | 3.0 | 1.13 | 9200 | 3 | R390-18.. |
| | 18 | C6 | 1.1 | 15.40 | 6° | 0.0 | 3 | 3 | R390-040C6-18M100 | 63.0 | 100.0 | 50.0 | 3.0 | 1.91 | 9200 | 3 | R390-18.. |
| | 11 | C4 | 5.5 | 10.00 | 1° | 1.0 | 3 | 4 | R390-044C4-11M060 | 40.0 | 60.0 | | 1.2 | 0.77 | 25600 | 4 | R390-11.. |
| | 11 | C4 | 5.5 | 10.00 | 1° | 1.0 | 3 | 4 | R390-044C4-11M075 | 40.0 | 75.0 | | 1.2 | 0.88 | 25600 | 4 | R390-11.. |
| | 18 | C4 | 1.1 | 15.40 | 6° | 0.0 | 3 | 2 | R390-044C4-18L080 | 40.0 | 80.0 | | 3.0 | 1.10 | 8600 | 2 | R390-18.. |
| 50.0 | 18 | C4 | 1.1 | 15.40 | 6° | 0.0 | 3 | 3 | R390-044C4-18M060 | 40.0 | 60.0 | | 3.0 | 0.80 | 8600 | 3 | R390-18.. |
| | 18 | C4 | 1.1 | 15.40 | 6° | 0.0 | 3 | 3 | R390-044C4-18M080 | 40.0 | 80.0 | | 3.0 | 1.00 | 8600 | 3 | R390-18.. |
| | 11 | C5 | 5.5 | 10.00 | 1° | 1.0 | 3 | 5 | R390-050C5-11M060 | 50.0 | 60.0 | 40.0 | 1.2 | 1.08 | 23700 | 5 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 1° | 1.0 | 3 | 5 | R390-050C6-11M080 | 63.0 | 80.0 | 40.0 | 1.2 | 1.82 | 23700 | 5 | R390-11.. |
| | 18 | C5 | 1.1 | 15.40 | 5° | 0.0 | 3 | 4 | R390-050C5-18M060 | 50.0 | 60.0 | 40.0 | 3.0 | 1.08 | 7900 | 4 | R390-18.. |
| 54.0 | 18 | C6 | 1.1 | 15.40 | 5° | 0.0 | 3 | 4 | R390-050C6-18M080 | 63.0 | 80.0 | 40.0 | 3.0 | 1.85 | 7900 | 4 | R390-18.. |
| | 11 | C5 | 5.5 | 10.00 | 1° | 1.0 | 3 | 5 | R390-054C5-11M060 | 50.0 | 60.0 | | 1.2 | 1.09 | 22700 | 5 | R390-11.. |
| | 11 | C5 | 5.5 | 10.00 | 1° | 1.0 | 3 | 5 | R390-054C5-11M080 | 50.0 | 80.0 | | 1.2 | 1.60 | 22700 | 5 | R390-11.. |
| | 18 | C5 | 1.1 | 15.40 | 5° | 0.0 | 3 | 4 | R390-054C5-18M060 | 50.0 | 60.0 | | 3.0 | 1.28 | 7500 | 4 | R390-18.. |
| | 18 | C5 | 1.1 | 15.40 | 5° | 0.0 | 3 | 4 | R390-054C5-18M080 | 50.0 | 80.0 | | 3.0 | 1.58 | 7500 | 4 | R390-18.. |
| 63.0 | 11 | C5 | 5.5 | 10.00 | 1° | 1.0 | 3 | 6 | R390-063C5-11M060 | 50.0 | 60.0 | | 1.2 | 1.53 | 20700 | 6 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 1° | 1.0 | 3 | 6 | R390-063C6-11M080 | 63.0 | 80.0 | 40.0 | 1.2 | 2.25 | 20700 | 6 | R390-11.. |
| | 18 | C5 | 1.1 | 15.40 | 4° | 0.0 | 3 | 5 | R390-063C5-18M060 | 50.0 | 60.0 | | 3.0 | 1.45 | 6800 | 5 | R390-18.. |
| 18 | C6 | 1.1 | 15.40 | 4° | 0.0 | 3 | 5 | R390-063C6-18M060 | 63.0 | 60.0 | 38.0 | 3.0 | 1.81 | 6800 | 5 | R390-18.. | |



I74



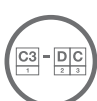
L2



N23



N6



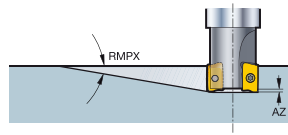
N9



N15

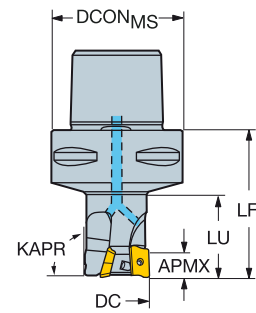
CoroMill® 390 square shoulder milling cutter

Coromant Capto® - Internal coolant supply



KAPR

90°



| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | CNSC | CNSC | Ordering code | Dimensions, mm | | | | | CICT | MIID |
|------|-------------------|---------------------|---------------------|-------|----|------|------|------|-------------------|--------------------|-------|-----|------|-------|------|-----------|
| | | | | | | | | | | DCON _{MS} | LF | LU | NM | KG | | |
| 66.0 | 11 | C6 | 5.5 | 10.00 | 1° | 1.0 | 3 | 6 | R390-066C6-11M060 | 63.0 | 60.0 | 1.2 | 1.88 | 20200 | 6 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 1° | 1.0 | 3 | 6 | R390-066C6-11M080 | 63.0 | 80.0 | 1.2 | 2.30 | 20200 | 6 | R390-11.. |
| | 18 | C6 | 1.1 | 15.40 | 3° | 0.0 | 3 | 5 | R390-066C6-18M060 | 63.0 | 60.0 | 3.0 | 1.83 | 6700 | 5 | R390-18.. |
| 80.0 | 11 | C6 | 5.5 | 10.00 | 0° | 1.0 | 3 | 7 | R390-080C6-11M060 | 63.0 | 60.0 | 1.2 | 2.14 | 18200 | 7 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 0° | 1.0 | 3 | 7 | R390-080C6-11M080 | 63.0 | 80.0 | 1.2 | 2.71 | 18200 | 7 | R390-11.. |
| | 18 | C6 | 1.1 | 15.40 | 3° | 0.0 | 3 | 6 | R390-080C6-18M060 | 63.0 | 60.0 | 3.0 | 1.80 | 5900 | 6 | R390-18.. |
| 84.0 | 18 | C8 | 1.1 | 15.40 | 2° | 0.0 | 3 | 6 | R390-084C8-18M070 | 80.0 | 70.0 | 3.0 | 3.39 | 5800 | 6 | R390-18.. |
| | 18 | C8 | 1.1 | 15.40 | 2° | 0.0 | 3 | 6 | R390-084C8-18M100 | 80.0 | 100.0 | 3.0 | 4.50 | 5800 | 6 | R390-18.. |

| Spare parts | |
|-------------|----------------|
| DC | Insert screw |
| 16.00-20.00 | 11 5513 020-36 |
| 25.00-80.00 | 11 5513 020-35 |
| 40.00-84.00 | 18 5513 020-29 |

For complete list of spare parts, see www.sandvik.coromant.com



I74



L2



N23



N6



N9

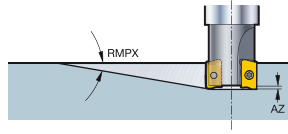
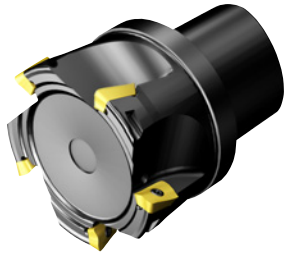


N15

CoroMill® 390 square shoulder milling cutter

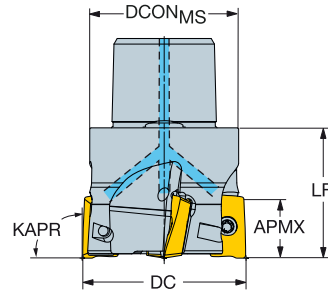
Coromant Capto® - Internal coolant supply

Short version without gripper grooves



KAPR

90°

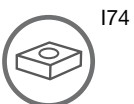


| | | | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|----|------|---------------|---|--------------------|------|------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | LF | NM | KG | RPMX | CICT | MIID | |
| 44.0 | 11 | C4 | 5.5 | 10.00 | 1° | 1.0 | 3 | 4 | R390-044C4T-11H | 40.0 | 35.0 | 1.2 | 0.40 | 25600 | 4 | R390-11.. |
| | 17 | C4 | 8.5 | 15.70 | 3° | 1.5 | 3 | 4 | R390-044C4T-17M | 40.0 | 35.0 | 3.0 | 0.35 | 20600 | 4 | R390-17.. |
| 54.0 | 11 | C5 | 5.5 | 10.00 | 1° | 1.0 | 3 | 5 | R390-054C5T-11H | 50.0 | 35.0 | 1.2 | 0.62 | 22700 | 5 | R390-11.. |
| | 17 | C5 | 8.5 | 15.70 | 2° | 1.5 | 3 | 5 | R390-054C5T-17M | 50.0 | 35.0 | 3.0 | 0.94 | 18200 | 5 | R390-17.. |

Note: Only for segment clamping.

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 11 | 5513 020-35 |
| 17 | 5513 020-39 |

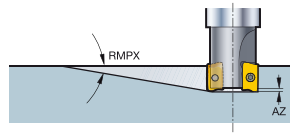
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 390 square shoulder milling cutter

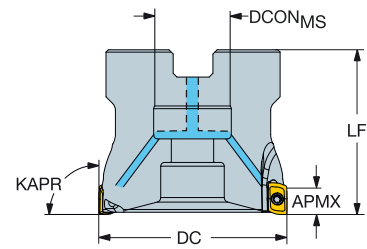
Arbor - Internal coolant supply

Lightweight shoulder milling cutter



STDNO
KAPR

ISO6462
90°



| | | | | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|----|------|---------------|---|-------------------|--------------------|-----|------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | | DCON _{MS} | ISO | LF | NM | KG | RPMX | CICT | MIID |
| 40.0 | 11 | 16 | 5.5 | 10.00 | 2° | 1.0 | 1 | 3 | R390-040Q16LW-11L | 16.0 | A | 30.0 | 1.2 | 0.05 | 10000 | 3 | R390-11.. |
| | 11 | 16 | 5.5 | 10.00 | 2° | 1.0 | 1 | 4 | R390-040Q16LW-11M | 16.0 | A | 30.0 | 1.2 | 0.05 | 10000 | 4 | R390-11.. |
| 50.0 | 11 | 22 | 5.5 | 10.00 | 1° | 1.0 | 1 | 3 | R390-050Q22LW-11L | 22.0 | A | 30.0 | 1.2 | 0.07 | 10000 | 3 | R390-11.. |
| | 11 | 22 | 5.5 | 10.00 | 1° | 1.0 | 1 | 4 | R390-050Q22LW-11M | 22.0 | A | 30.0 | 1.2 | 0.07 | 10000 | 4 | R390-11.. |

| Spare parts | | | |
|-------------|--------------|-------------|--------------|
| DC | Insert screw | Screw | |
| 40.00 | 11 | 5513 020-35 | 3213 010-412 |
| 50.00 | 11 | 5513 020-35 | 3213 010-461 |

For complete list of spare parts, see www.sandvik.coromant.com



I74



L2



M1



N23



N6



N9



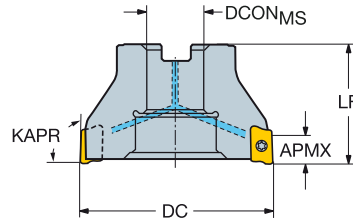
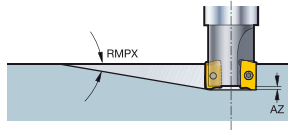
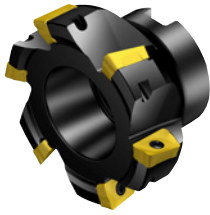
N15

CoroMill® 390 square shoulder milling cutter

Arbor - Internal coolant supply

STDNO
KAPR

ISO 6462
90°



| DC | CZC _{MS} | APM _{KEFW} | APM _{FFW} | RMPX | AZ | CNSC | Ordering code | Dimensions, mm | | | | | CICT | MIID | | | |
|-------|-------------------|---------------------|--------------------|-------|----|------|---------------|--------------------|-----------------|------|----|------|------|------|-------|----|-----------|
| | | | | | | | | DCO _{NMS} | ISO | LF | NM | KG | | | RPMX | | |
| 40.0 | 07 | 16 | 2.0 | 5.80 | 0° | 0.5 | 1 | 7 | R390-040Q16-07M | 16.0 | A | 35.0 | 0.5 | 0.20 | 21500 | 7 | 390R-07.. |
| | 07 | 16 | 2.0 | 5.80 | 0° | 0.5 | 1 | 10 | R390-040Q16-07H | 16.0 | A | 35.0 | 0.5 | 0.20 | 21500 | 10 | 390R-07.. |
| | 11 | 16 | 5.5 | 10.00 | 2° | 1.0 | 1 | 4 | R390-040Q16-11M | 16.0 | A | 40.0 | 1.2 | 0.44 | 27000 | 4 | R390-11.. |
| | 11 | 16 | 5.5 | 10.00 | 2° | 1.0 | 1 | 6 | R390-040Q16-11H | 16.0 | A | 40.0 | 1.2 | 0.50 | 27000 | 6 | R390-11.. |
| | 17 | 16 | 8.5 | 15.70 | 3° | 1.5 | 1 | 2 | R390-040Q16-17L | 16.0 | A | 40.0 | 3.0 | 0.38 | 21900 | 2 | R390-17.. |
| | 17 | 16 | 8.5 | 15.70 | 3° | 1.5 | 1 | 3 | R390-040Q16-17M | 16.0 | A | 40.0 | 3.0 | 0.46 | 21900 | 3 | R390-17.. |
| | 17 | 16 | 8.5 | 15.70 | 3° | 1.5 | 1 | 4 | R390-040Q16-17H | 16.0 | A | 40.0 | 3.0 | 0.20 | 21900 | 4 | R390-17.. |
| 44.0 | 11 | 16 | 5.5 | 10.00 | 1° | 1.0 | 1 | 4 | R390-044Q16-11M | 16.0 | A | 40.0 | 1.2 | 0.20 | 25600 | 4 | R390-11.. |
| | 17 | 16 | 8.5 | 15.70 | 3° | 1.5 | 1 | 3 | R390-044Q16-17M | 16.0 | A | 40.0 | 3.0 | 0.20 | 20600 | 3 | R390-17.. |
| 50.0 | 11 | 22 | 5.5 | 10.00 | 1° | 1.0 | 1 | 5 | R390-050Q22-11M | 22.0 | A | 40.0 | 1.2 | 0.35 | 23700 | 5 | R390-11.. |
| | 11 | 22 | 5.5 | 10.00 | 1° | 1.0 | 1 | 7 | R390-050Q22-11H | 22.0 | A | 40.0 | 1.2 | 0.38 | 23700 | 7 | R390-11.. |
| | 17 | 22 | 8.5 | 15.70 | 2° | 1.5 | 1 | 3 | R390-050Q22-17L | 22.0 | A | 40.0 | 3.0 | 0.35 | 19000 | 3 | R390-17.. |
| | 17 | 22 | 8.5 | 15.70 | 2° | 1.5 | 1 | 4 | R390-050Q22-17M | 22.0 | A | 40.0 | 3.0 | 0.32 | 19000 | 4 | R390-17.. |
| | 17 | 22 | 8.5 | 15.70 | 2° | 1.5 | 1 | 5 | R390-050Q22-17H | 22.0 | A | 40.0 | 3.0 | 0.30 | 19000 | 5 | R390-17.. |
| | 18 | 22 | 1.1 | 15.40 | 5° | 0.0 | 1 | 3 | R390-050Q22-18L | 22.0 | A | 40.0 | 3.0 | 0.59 | 7900 | 3 | R390-18.. |
| | 18 | 22 | 1.1 | 15.40 | 5° | 0.0 | 1 | 4 | R390-050Q22-18M | 22.0 | A | 40.0 | 3.0 | 0.58 | 7900 | 4 | R390-18.. |
| | 18 | 22 | 1.1 | 15.40 | 5° | 0.0 | 1 | 5 | R390-050Q22-18H | 22.0 | A | 40.0 | 3.0 | 0.30 | 7900 | 5 | R390-18.. |
| 54.0 | 11 | 22 | 5.5 | 10.00 | 1° | 1.0 | 1 | 5 | R390-054Q22-11M | 22.0 | A | 40.0 | 1.2 | 0.39 | 22600 | 5 | R390-11.. |
| | 17 | 22 | 8.5 | 15.70 | 2° | 1.5 | 1 | 4 | R390-054Q22-17M | 22.0 | A | 40.0 | 3.0 | 0.37 | 18200 | 4 | R390-17.. |
| | 18 | 22 | 1.1 | 15.40 | 5° | 0.0 | 1 | 4 | R390-054Q22-18M | 22.0 | A | 40.0 | 3.0 | 0.30 | 7500 | 4 | R390-18.. |
| 63.0 | 11 | 22 | 5.5 | 10.00 | 1° | 1.0 | 1 | 6 | R390-063Q22-11M | 22.0 | A | 40.0 | 1.2 | 0.68 | 20700 | 6 | R390-11.. |
| | 11 | 22 | 5.5 | 10.00 | 1° | 1.0 | 1 | 8 | R390-063Q22-11H | 22.0 | A | 40.0 | 1.2 | 0.48 | 20700 | 8 | R390-11.. |
| | 17 | 22 | 8.5 | 15.70 | 2° | 1.5 | 1 | 4 | R390-063Q22-17L | 22.0 | A | 40.0 | 3.0 | 0.50 | 16500 | 4 | R390-17.. |
| | 17 | 22 | 8.5 | 15.70 | 2° | 1.5 | 1 | 5 | R390-063Q22-17M | 22.0 | A | 40.0 | 3.0 | 0.48 | 16500 | 5 | R390-17.. |
| | 17 | 22 | 8.5 | 15.70 | 2° | 1.5 | 1 | 6 | R390-063Q22-17H | 22.0 | A | 40.0 | 3.0 | 0.68 | 16500 | 6 | R390-17.. |
| | 18 | 22 | 1.1 | 15.40 | 4° | 0.0 | 1 | 4 | R390-063Q22-18L | 22.0 | A | 40.0 | 3.0 | 0.81 | 6800 | 4 | R390-18.. |
| | 18 | 22 | 1.1 | 15.40 | 4° | 0.0 | 1 | 5 | R390-063Q22-18M | 22.0 | A | 40.0 | 3.0 | 0.70 | 6800 | 5 | R390-18.. |
| | 18 | 22 | 1.1 | 15.40 | 4° | 0.0 | 1 | 6 | R390-063Q22-18H | 22.0 | A | 40.0 | 3.0 | 0.70 | 6800 | 6 | R390-18.. |
| 66.0 | 11 | 22 | 5.5 | 10.00 | 3° | 1.0 | 1 | 6 | R390-066Q22-11M | 22.0 | A | 40.0 | 1.2 | 0.72 | 20200 | 6 | R390-11.. |
| | 17 | 22 | 8.5 | 15.70 | 1° | 1.5 | 1 | 5 | R390-066Q22-17M | 22.0 | A | 40.0 | 3.0 | 0.50 | 16100 | 5 | R390-17.. |
| | 18 | 22 | 1.1 | 15.40 | 3° | 0.0 | 1 | 6 | R390-066Q22-18M | 22.0 | A | 40.0 | 3.0 | 0.71 | 6700 | 5 | R390-18.. |
| 80.0 | 11 | 27 | 5.5 | 10.00 | 0° | 1.0 | 1 | 7 | R390-080Q27-11M | 27.0 | A | 50.0 | 1.2 | 1.08 | 18200 | 7 | R390-11.. |
| | 11 | 27 | 5.5 | 10.00 | 0° | 1.0 | 1 | 10 | R390-080Q27-11H | 27.0 | A | 50.0 | 1.2 | 0.72 | 18200 | 10 | R390-11.. |
| | 17 | 27 | 8.5 | 15.70 | 1° | 1.5 | 1 | 4 | R390-080Q27-17L | 27.0 | A | 50.0 | 3.0 | 1.06 | 14400 | 4 | R390-17.. |
| | 17 | 27 | 8.5 | 15.70 | 1° | 1.5 | 1 | 6 | R390-080Q27-17M | 27.0 | A | 50.0 | 3.0 | 0.96 | 14400 | 6 | R390-17.. |
| | 17 | 27 | 8.5 | 15.70 | 1° | 1.5 | 1 | 8 | R390-080Q27-17H | 27.0 | A | 50.0 | 3.0 | 0.94 | 14400 | 8 | R390-17.. |
| | 18 | 27 | 1.1 | 15.40 | 3° | 0.0 | 1 | 4 | R390-080Q27-18L | 27.0 | A | 50.0 | 3.0 | 1.05 | 5900 | 4 | R390-18.. |
| | 18 | 27 | 1.1 | 15.40 | 3° | 0.0 | 1 | 6 | R390-080Q27-18M | 27.0 | A | 50.0 | 3.0 | 1.00 | 5900 | 6 | R390-18.. |
| 84.0 | 11 | 27 | 5.5 | 10.00 | 3° | 1.0 | 1 | 7 | R390-084Q27-11M | 27.0 | A | 50.0 | 1.2 | 1.41 | 17700 | 7 | R390-11.. |
| | 17 | 27 | 8.5 | 15.70 | 1° | 1.5 | 1 | 6 | R390-084Q27-17M | 27.0 | A | 50.0 | 3.0 | 1.07 | 14100 | 6 | R390-17.. |
| | 18 | 27 | 1.1 | 15.40 | 3° | 0.0 | 1 | 6 | R390-084Q27-18M | 27.0 | A | 50.0 | 3.0 | 1.25 | 5800 | 6 | R390-18.. |
| 100.0 | 17 | 32 | 8.5 | 15.70 | 0° | 1.5 | 1 | 5 | R390-100Q32-17L | 32.0 | B | 50.0 | 3.0 | 1.77 | 12700 | 5 | R390-17.. |
| | 17 | 32 | 8.5 | 15.70 | 0° | 1.5 | 1 | 7 | R390-100Q32-17M | 32.0 | B | 50.0 | 3.0 | 1.73 | 12700 | 7 | R390-17.. |
| | 17 | 32 | 8.5 | 15.70 | 0° | 1.5 | 1 | 9 | R390-100Q32-17H | 32.0 | B | 50.0 | 3.0 | 1.57 | 12700 | 9 | R390-17.. |
| | 18 | 32 | 1.1 | 15.40 | 2° | 0.0 | 1 | 5 | R390-100Q32-18L | 32.0 | B | 50.0 | 3.0 | 1.83 | 5200 | 5 | R390-18.. |
| | 18 | 32 | 1.1 | 15.40 | 2° | 0.0 | 1 | 7 | R390-100Q32-18M | 32.0 | B | 50.0 | 3.0 | 1.75 | 5200 | 7 | R390-18.. |
| 125.0 | 17 | 40 | 8.5 | 15.70 | 0° | 1.5 | 1 | 6 | R390-125Q40-17L | 40.0 | B | 63.0 | 3.0 | 2.71 | 11200 | 6 | R390-17.. |
| | 17 | 40 | 8.5 | 15.70 | 0° | 1.5 | 1 | 8 | R390-125Q40-17M | 40.0 | B | 63.0 | 3.0 | 2.70 | 11200 | 8 | R390-17.. |
| | 17 | 40 | 8.5 | 15.70 | 0° | 1.5 | 1 | 11 | R390-125Q40-17H | 40.0 | B | 63.0 | 3.0 | 2.74 | 11200 | 11 | R390-17.. |
| | 18 | 40 | 1.1 | 15.40 | 1° | 0.0 | 1 | 6 | R390-125Q40-18L | 40.0 | B | 63.0 | 3.0 | 2.72 | 4600 | 6 | R390-18.. |
| | 18 | 40 | 1.1 | 15.40 | 1° | 0.0 | 1 | 8 | R390-125Q40-18M | 40.0 | B | 63.0 | 3.0 | 2.76 | 4600 | 8 | R390-18.. |



174



L2



M1



N23



N6



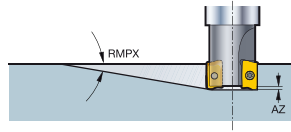
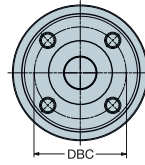
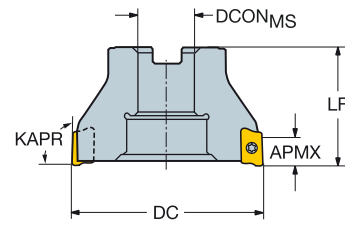
N9



N15

CoroMill® 390 square shoulder milling cutter

Arbor

STDNO
KAPRISO6462
90°

| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|-------|-------------------|---------------------|---------------------|-------|-----|------|----|-----------------|--------------------|----------------|------|-------|------|------|------|------|-----------|-----------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | Ordering code | DCON _{MS} | ISO | DBC | LF | | | RPMX | CICT | MIID | |
| 160.0 | 18 | 40S | 1.1 | 15.40 | 1° | 0.0 | 0 | 8 | R390-160Q40-18L | 40.0 | C | 66.7 | 63.0 | 3.0 | 3.33 | 4000 | 8 | R390-18.. |
| 18 | 40S | 1.1 | 15.40 | 1° | 0.0 | 0 | 12 | R390-160Q40-18M | 40.0 | C | 66.7 | 63.0 | 3.0 | 4.00 | 4000 | 12 | R390-18.. | |
| 200.0 | 18 | 60 | 1.1 | 15.40 | 1° | 0.0 | 0 | 10 | R390-200Q60-18L | 60.0 | C | 101.6 | 63.0 | 3.0 | 5.38 | 3600 | 10 | R390-18.. |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 07 | 5513 020-82 |
| 11 | 5513 020-35 |
| 17 | 5513 020-39 |
| 18 | 5513 020-29 |

For complete list of spare parts, see www.sandvik.coromant.com

I74



L2



M1



N23



N6



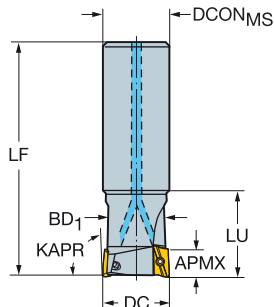
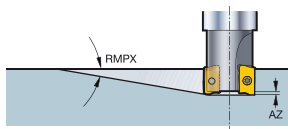
N9

CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply

KAPR

90°



| | | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|----|-------------------|---------------------|---------------------|------|-----|------|---|------------------|---------------|--------------------|-----------------|------|-----|------|-------|------|-----------|------|
| DC | | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | | Ordering code | DCON _{MS} | BD ₁ | LF | LU | NM | KG | RPMX | CICT | MIID |
| 9.7 | 07 | 10 | 2.0 | 5.80 | 7° | 0.5 | 1 | 2 | R390-0097A10-07L | 10.0 | 9.2 | 60.0 | 15.0 | 0.5 | 0.07 | 55600 | 2 | 390R-07.. | |
| 10.0 | 07 | 9 | 2.0 | 5.80 | 7° | 0.5 | 1 | 2 | R390-010A09L-07L | 9.0 | 9.3 | 100.0 | | 0.5 | 0.08 | 54100 | 2 | 390R-07.. | |
| | 07 | 10 | 2.0 | 5.80 | 7° | 0.5 | 1 | 2 | R390-010A10-07L | 10.0 | 9.3 | 60.0 | 15.0 | 0.5 | 0.07 | 54100 | 2 | 390R-07.. | |
| 11.7 | 07 | 12 | 2.0 | 5.80 | 5° | 0.5 | 1 | 2 | R390-0117A12-07L | 12.0 | 11.0 | 70.0 | 15.0 | 0.5 | 0.09 | 47400 | 2 | 390R-07.. | |
| | 07 | 12 | 2.0 | 5.80 | 5° | 0.5 | 1 | 3 | R390-0117A12-07M | 12.0 | 11.0 | 70.0 | 15.0 | 0.5 | 0.09 | 47400 | 3 | 390R-07.. | |
| 12.0 | 07 | 10 | 2.0 | 5.80 | 5° | 0.5 | 1 | 2 | R390-012A10L-07L | 10.0 | 11.3 | 120.0 | | 0.5 | 0.11 | 46500 | 2 | 390R-07.. | |
| | 07 | 12 | 2.0 | 5.80 | 5° | 0.5 | 1 | 2 | R390-012A12-07L | 12.0 | 11.3 | 70.0 | 18.0 | 0.5 | 0.09 | 46500 | 2 | 390R-07.. | |
| | 07 | 12 | 2.0 | 5.80 | 5° | 0.5 | 1 | 3 | R390-012A12-07M | 12.0 | 11.3 | 70.0 | 18.0 | 0.5 | 0.09 | 46500 | 3 | 390R-07.. | |
| 11 | 16 | 5.5 | 10.00 | 6° | 1.0 | 1 | 1 | 1 | R390-012A16-11L | 16.0 | | 95.0 | 17.2 | 1.2 | 0.24 | 68600 | 1 | R390-11.. | |
| 13.7 | 07 | 14 | 2.0 | 5.80 | 3° | 0.5 | 1 | 2 | R390-0137A14-07L | 14.0 | 12.9 | 80.0 | 15.0 | 0.5 | 0.12 | 42000 | 2 | 390R-07.. | |
| | 07 | 14 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-0137A14-07M | 14.0 | 12.9 | 80.0 | 15.0 | 0.5 | 0.12 | 42000 | 3 | 390R-07.. | |
| 14.0 | 07 | 12 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-014A12L-07M | 12.0 | 13.2 | 140.0 | | 0.5 | 0.16 | 33800 | 3 | 390R-07.. | |
| | 07 | 14 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-014A14-07M | 14.0 | 13.2 | 80.0 | 20.0 | 0.5 | 0.12 | 41400 | 3 | 390R-07.. | |
| 15.7 | 07 | 16 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-0157A16-07M | 16.0 | 14.7 | 90.0 | 18.0 | 0.5 | 0.16 | 38100 | 3 | 390R-07.. | |
| 16.0 | 07 | 14 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-016A14L-07M | 14.0 | 15.0 | 160.0 | | 0.5 | 0.23 | 24100 | 3 | 390R-07.. | |
| | 07 | 16 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-016A16-07M | 16.0 | 15.0 | 90.0 | 25.0 | 0.5 | 0.16 | 37600 | 3 | 390R-07.. | |
| | 07 | 16 | 2.0 | 5.80 | 3° | 0.5 | 1 | 4 | R390-016A16-07H | 16.0 | 15.0 | 90.0 | 25.0 | 0.5 | 0.16 | 37600 | 4 | 390R-07.. | |
| | 11 | 16 | 5.5 | 10.00 | 10° | 1.0 | 1 | 2 | R390-016A16-11L | 16.0 | | 100.0 | 25.0 | 1.2 | 0.15 | 41500 | 2 | R390-11.. | |
| | 11 | 16 | 5.5 | 10.00 | 10° | 1.0 | 1 | 2 | R390-016A16L-11L | 16.0 | | 145.0 | 25.0 | 1.2 | 0.23 | 31000 | 2 | R390-11.. | |
| 18.0 | 11 | 16 | 5.5 | 10.00 | 7° | 1.0 | 1 | 2 | R390-018A16L-11L | 16.0 | | 145.0 | | 1.2 | 0.20 | 31000 | 2 | R390-11.. | |
| 20.0 | 07 | 20 | 2.0 | 5.80 | 2° | 0.5 | 1 | 4 | R390-020A20-07M | 20.0 | 19.0 | 110.0 | 25.0 | 0.5 | 0.29 | 32500 | 4 | 390R-07.. | |
| | 07 | 20 | 2.0 | 5.80 | 2° | 0.5 | 1 | 5 | R390-020A20-07H | 20.0 | 19.0 | 110.0 | 25.0 | 0.5 | 0.27 | 32500 | 5 | 390R-07.. | |
| | 11 | 20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-020A20-11L | 20.0 | | 110.0 | 25.0 | 1.2 | 0.26 | 34600 | 2 | R390-11.. | |
| | 11 | 20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-020A20L-11L | 20.0 | | 170.0 | 40.0 | 1.2 | 0.50 | 20300 | 2 | R390-11.. | |
| | 11 | 20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-020A20-11M | 20.0 | | 110.0 | 25.0 | 1.2 | 0.34 | 34600 | 3 | R390-11.. | |
| 22.0 | 11 | 20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-022A20L-11L | 20.0 | | 170.0 | | 1.2 | 0.41 | 20300 | 2 | R390-11.. | |
| 25.0 | 07 | 25 | 2.0 | 5.80 | 1° | 0.5 | 1 | 5 | R390-025A25-07M | 25.0 | 24.0 | 120.0 | 32.0 | 0.5 | 0.46 | 28200 | 5 | 390R-07.. | |
| | 07 | 25 | 2.0 | 5.80 | 1° | 0.5 | 1 | 7 | R390-025A25-07H | 25.0 | 24.0 | 120.0 | 32.0 | 0.5 | 0.47 | 28200 | 7 | 390R-07.. | |
| | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-025A25-11L | 25.0 | | 120.0 | 32.0 | 1.2 | 0.54 | 36500 | 2 | R390-11.. | |
| | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-025A25L-11L | 25.0 | | 210.0 | 50.0 | 1.2 | 0.83 | 11000 | 2 | R390-11.. | |
| | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-025A25-11M | 25.0 | | 120.0 | 32.0 | 1.2 | 0.42 | 36500 | 3 | R390-11.. | |
| | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 4 | R390-025A25-11H | 25.0 | | 120.0 | 32.0 | 1.2 | 0.54 | 36500 | 4 | R390-11.. | |
| | 17 | 25 | 8.5 | 15.70 | 15° | 1.5 | 1 | 2 | R390-025A25-17L | 25.0 | | 120.0 | 32.0 | 3.0 | 0.50 | 30800 | 2 | R390-17.. | |
| | 17 | 25 | 8.5 | 15.70 | 15° | 1.5 | 1 | 2 | R390-025A25L-17L | 25.0 | | 210.0 | 50.0 | 3.0 | 0.84 | 11000 | 2 | R390-17.. | |
| 30.0 | 11 | 25 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-030A25L-11L | 25.0 | | 210.0 | | 1.2 | 0.86 | 11000 | 2 | R390-11.. | |
| 32.0 | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-032A32-11L | 32.0 | | 130.0 | 40.0 | 1.2 | 0.74 | 31000 | 2 | R390-11.. | |
| | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-032A32L-11L | 32.0 | | 250.0 | 65.0 | 1.2 | 1.66 | 7600 | 2 | R390-11.. | |
| | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 3 | R390-032A32-11M | 32.0 | | 130.0 | 40.0 | 1.2 | 0.82 | 31000 | 3 | R390-11.. | |
| | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 5 | R390-032A32-11H | 32.0 | | 130.0 | 40.0 | 1.2 | 0.79 | 31000 | 5 | R390-11.. | |
| | 17 | 32 | 8.5 | 15.70 | 6° | 1.5 | 1 | 2 | R390-032A32-17L | 32.0 | | 130.0 | 40.0 | 3.0 | 0.82 | 25600 | 2 | R390-17.. | |
| | 17 | 32 | 8.5 | 15.70 | 6° | 1.5 | 1 | 2 | R390-032A32L-17L | 32.0 | | 250.0 | 65.0 | 3.0 | 1.67 | 7600 | 2 | R390-17.. | |
| | 17 | 32 | 8.5 | 15.70 | 6° | 1.5 | 1 | 3 | R390-032A32-17M | 32.0 | | 130.0 | 40.0 | 3.0 | 0.81 | 25600 | 3 | R390-17.. | |



174



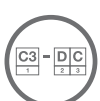
L2



N23



N6



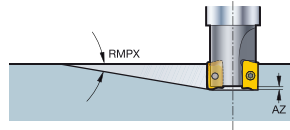
N9



N15

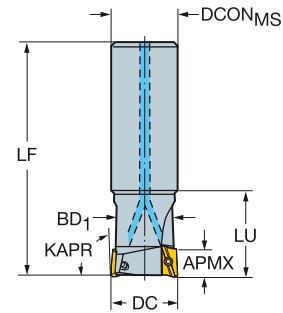
CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply



KAPR

90°



| | | | | | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|--------------------|--------------------|-------|-----|------|---------------|------------------|--------------------|-----------------|----------------|------|-------|-------|-----------|-----------|------|--|
| DC | CZC _{MS} | APM _{EFW} | APM _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | BD ₁ | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 40.0 | 11 | 32 | 5.5 | 10.00 | 2° | 1.0 | 1 | 2 | R390-040A32-11L | 32.0 | 170.0 | 1.2 | 1.19 | 27000 | 2 | R390-11.. | | |
| 11 | 32 | 5.5 | 10.00 | 2° | 1.0 | 1 | 2 | R390-040A32L-11L | 32.0 | 250.0 | 1.2 | 1.82 | 7600 | 2 | R390-11.. | | | |
| 11 | 32 | 5.5 | 10.00 | 2° | 1.0 | 1 | 4 | R390-040A32-11M | 32.0 | 170.0 | 1.2 | 1.16 | 27000 | 4 | R390-11.. | | | |
| 11 | 32 | 5.5 | 10.00 | 2° | 1.0 | 1 | 6 | R390-040A32-11H | 32.0 | 170.0 | 1.2 | 1.19 | 27000 | 6 | R390-11.. | | | |
| 17 | 32 | 8.5 | 15.70 | 3° | 1.5 | 1 | 2 | R390-040A32-17L | 32.0 | 170.0 | 3.0 | 1.19 | 21900 | 2 | R390-17.. | | | |
| 17 | 32 | 8.5 | 15.70 | 3° | 1.5 | 1 | 2 | R390-040A32L-17L | 32.0 | 250.0 | 3.0 | 1.84 | 7600 | 2 | R390-17.. | | | |
| 17 | 32 | 8.5 | 15.70 | 3° | 1.5 | 1 | 3 | R390-040A32-17M | 32.0 | 170.0 | 3.0 | 1.14 | 21900 | 3 | R390-17.. | | | |
| 17 | 32 | 8.5 | 15.70 | 3° | 1.5 | 1 | 4 | R390-040A32-17H | 32.0 | 170.0 | 3.0 | 1.14 | 21900 | 4 | R390-17.. | | | |

| | | Spare parts | |
|-------------|--------------|-------------|--|
| DC | Insert screw | | |
| 10.00-25.00 | 07 | 5513 020-82 | |
| 12.00-22.00 | 11 | 5513 020-36 | |
| 25.00-40.00 | 11 | 5513 020-35 | |
| 25.00 | 17 | 5513 020-37 | |
| 32.00-40.00 | 17 | 5513 020-39 | |

For complete list of spare parts, see www.sandvik.coromant.com



174



L2



N23



N6



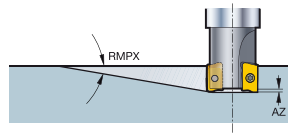
N9



N15

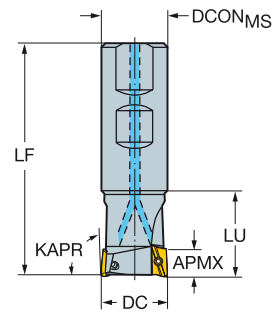
CoroMill® 390 square shoulder milling cutter

Weldon - Internal coolant supply



KAPR

90°



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|-----|------|---|---|-----------------|--------------------|-----|-------|------|-----|------|-------|------|-----------|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | | Ordering code | DCON _{MS} | ISO | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 12.0 | 11 | 16 | 5.5 | 10.00 | 6° | 1.0 | 1 | 1 | R390-012B16-11L | 16.0 | WE | 68.0 | 17.2 | 1.2 | 0.18 | 68600 | 1 | R390-11.. | |
| 16.0 | 11 | 16 | 5.5 | 10.00 | 10° | 1.0 | 1 | 2 | R390-016B16-11L | 16.0 | WE | 73.0 | 25.0 | 1.2 | 0.11 | 41500 | 2 | R390-11.. | |
| 20.0 | 11 | 20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-020B20-11L | 20.0 | WE | 81.0 | 25.0 | 1.2 | 0.19 | 34600 | 2 | R390-11.. | |
| | 11 | 20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-020B20-11M | 20.0 | WE | 81.0 | 25.0 | 1.2 | 0.29 | 34600 | 3 | R390-11.. | |
| 25.0 | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-025B25-11L | 25.0 | WE | 88.0 | 32.0 | 1.2 | 0.41 | 36500 | 2 | R390-11.. | |
| | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-025B25-11M | 25.0 | WE | 88.0 | 32.0 | 1.2 | 0.38 | 36500 | 3 | R390-11.. | |
| | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 4 | R390-025B25-11H | 25.0 | WE | 88.0 | 32.0 | 1.2 | 0.38 | 36500 | 4 | R390-11.. | |
| | 17 | 25 | 8.5 | 15.70 | 15° | 1.5 | 1 | 2 | R390-025B25-17L | 25.0 | WE | 88.0 | 32.0 | 3.0 | 0.41 | 30800 | 2 | R390-17.. | |
| 32.0 | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-032B32-11L | 32.0 | WE | 100.0 | 40.0 | 1.2 | 0.65 | 31000 | 2 | R390-11.. | |
| | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 3 | R390-032B32-11M | 32.0 | WE | 100.0 | 40.0 | 1.2 | 0.68 | 31000 | 3 | R390-11.. | |
| | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 5 | R390-032B32-11H | 32.0 | WE | 100.0 | 40.0 | 1.2 | 0.65 | 31000 | 5 | R390-11.. | |
| | 17 | 32 | 8.5 | 15.70 | 6° | 1.5 | 1 | 2 | R390-032B32-17L | 32.0 | WE | 100.0 | 40.0 | 3.0 | 0.64 | 25600 | 2 | R390-17.. | |
| | 17 | 32 | 8.5 | 15.70 | 6° | 1.5 | 1 | 3 | R390-032B32-17M | 32.0 | WE | 100.0 | 40.0 | 3.0 | 0.62 | 25600 | 3 | R390-17.. | |
| 40.0 | 11 | 32 | 5.5 | 10.00 | 2° | 1.0 | 1 | 4 | R390-040B32-11M | 32.0 | WE | 110.0 | | 1.2 | 0.81 | 27000 | 4 | R390-11.. | |
| | 11 | 32 | 5.5 | 10.00 | 2° | 1.0 | 1 | 6 | R390-040B32-11H | 32.0 | WE | 110.0 | | 1.2 | 0.84 | 27000 | 6 | R390-11.. | |
| | 17 | 32 | 8.5 | 15.70 | 3° | 1.5 | 1 | 2 | R390-040B32-17L | 32.0 | WE | 110.0 | | 3.0 | 0.82 | 21900 | 2 | R390-17.. | |
| | 17 | 32 | 8.5 | 15.70 | 3° | 1.5 | 1 | 3 | R390-040B32-17M | 32.0 | WE | 110.0 | | 3.0 | 0.80 | 21900 | 3 | R390-17.. | |
| | 17 | 32 | 8.5 | 15.70 | 3° | 1.5 | 1 | 4 | R390-040B32-17H | 32.0 | WE | 110.0 | | 3.0 | 0.80 | 21900 | 4 | R390-17.. | |

| Spare parts | | |
|-------------|----|--------------|
| DC | | Insert screw |
| 12.00-20.00 | 11 | 5513 020-36 |
| 25.00-40.00 | 11 | 5513 020-35 |
| 25.00 | 17 | 5513 020-37 |
| 32.00-40.00 | 17 | 5513 020-39 |

For complete list of spare parts, see www.sandvik.coromant.com



I74



L2



N23



N6



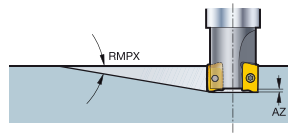
N9



N15

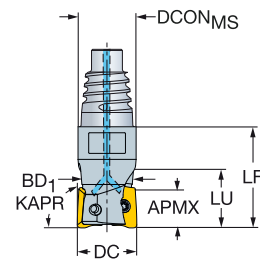
CoroMill® 390 square shoulder milling cutter

Coromant EH - Internal coolant supply



KAPR

90°



| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | CNSC | Ordering code | Dimensions, mm | | | | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|-----|------|------|---------------|-------------------|------|------|------|------|------|-----|------|-------|------|-----------|
| | | | | | | | | | DC | BD | LB | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 9.7 | 07 | E10 | 2.0 | 5.80 | 7° | 0.5 | 1 | 2 | R390-0097EH10-07L | 9.7 | 9.2 | 12.5 | 20.0 | 12.5 | 0.5 | 0.12 | 55600 | 2 | 390R-07.. |
| 10.0 | 07 | E10 | 2.0 | 5.80 | 7° | 0.5 | 1 | 2 | R390-010EH10-07L | 9.7 | 9.3 | 12.5 | 20.0 | 12.5 | 0.5 | 0.07 | 54100 | 2 | 390R-07.. |
| 11.7 | 07 | E12 | 2.0 | 5.80 | 5° | 0.5 | 1 | 2 | R390-0117EH12-07L | 11.7 | 11.0 | 11.9 | 20.0 | 11.9 | 0.5 | 0.04 | 47400 | 2 | 390R-07.. |
| 12.0 | 07 | E12 | 2.0 | 5.80 | 5° | 0.5 | 1 | 2 | R390-012EH12-07L | 11.7 | 11.3 | 11.9 | 20.0 | 11.9 | 0.5 | 0.12 | 46500 | 2 | 390R-07.. |
| | 07 | E12 | 2.0 | 5.80 | 5° | 0.5 | 1 | 3 | R390-012EH12-07M | 11.7 | 11.3 | 11.9 | 20.0 | 11.9 | 0.5 | 0.07 | 46500 | 3 | 390R-07.. |
| 13.7 | 07 | E12 | 2.0 | 5.80 | 3° | 0.5 | 1 | 2 | R390-0137EH12-07L | 11.7 | 12.9 | 20.0 | 20.0 | | 0.5 | 0.13 | 42000 | 2 | 390R-07.. |
| | 07 | E12 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-0137EH12-07M | 11.7 | 12.9 | 20.0 | 20.0 | | 0.5 | 0.12 | 42000 | 3 | 390R-07.. |
| 14.0 | 07 | E12 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-014EH12-07M | 11.7 | 13.2 | 20.0 | 20.0 | | 0.5 | 0.07 | 41400 | 3 | 390R-07.. |
| 15.7 | 07 | E16 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-0157EH16-07M | 15.5 | 14.7 | 15.7 | 25.0 | 15.7 | 0.5 | 0.10 | 38100 | 3 | 390R-07.. |
| 16.0 | 07 | E16 | 2.0 | 5.80 | 3° | 0.5 | 1 | 3 | R390-016EH16-07M | 15.5 | 15.0 | 15.7 | 25.0 | 15.7 | 0.5 | 0.09 | 37600 | 3 | 390R-07.. |
| | 07 | E16 | 2.0 | 5.80 | 3° | 0.5 | 1 | 4 | R390-016EH16-07H | 15.5 | 15.0 | 15.7 | 25.0 | 15.7 | 0.5 | 0.14 | 37600 | 4 | 390R-07.. |
| | 11 | E16 | 5.5 | 10.00 | 10° | 1.0 | 1 | 2 | R390-016EH16-11L | 15.5 | | | 27.0 | | 1.2 | 0.08 | 41500 | 2 | R390-11.. |
| 18.0 | 07 | E16 | 2.0 | 5.80 | 2° | 0.5 | 1 | 3 | R390-018EH16-07M | 15.5 | 17.0 | 25.0 | 25.0 | | 0.5 | 0.10 | 34800 | 3 | 390R-07.. |
| | 11 | E16 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-018EH16-11L | 15.5 | | | 27.0 | | 1.2 | 0.11 | 31000 | 2 | R390-11.. |
| 20.0 | 07 | E20 | 2.0 | 5.80 | 2° | 0.5 | 1 | 4 | R390-020EH20-07M | 19.3 | 19.0 | 14.4 | 25.0 | 14.4 | 0.5 | 0.10 | 32500 | 4 | 390R-07.. |
| | 07 | E20 | 2.0 | 5.80 | 2° | 0.5 | 1 | 5 | R390-020EH20-07H | 19.3 | 19.0 | 14.4 | 25.0 | 14.4 | 0.5 | 0.16 | 32500 | 5 | 390R-07.. |
| | 11 | E20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-020EH20-11L | 19.3 | | | 30.0 | | 1.2 | 0.13 | 34600 | 2 | R390-11.. |
| | 11 | E20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-020EH20-11M | 19.3 | | | 30.0 | | 1.2 | 0.13 | 34600 | 3 | R390-11.. |
| 22.0 | 11 | E20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-022EH20-11L | 19.3 | | | 30.0 | | 1.2 | 0.14 | 36500 | 2 | R390-11.. |
| | 11 | E20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-022EH20-11M | 19.3 | | | 30.0 | | 1.2 | 0.14 | 36500 | 3 | R390-11.. |
| 25.0 | 07 | E20 | 2.0 | 5.80 | 1° | 0.5 | 1 | 5 | R390-025EH20-07M | 19.3 | 24.0 | 25.0 | 25.0 | | 0.5 | 0.07 | 28200 | 5 | 390R-07.. |
| | 07 | E25 | 2.0 | 5.80 | 1° | 0.5 | 1 | 5 | R390-025EH25-07M | 24.2 | 24.0 | 13.9 | 25.0 | 13.9 | 0.5 | 0.20 | 28200 | 5 | 390R-07.. |
| | 07 | E20 | 2.0 | 5.80 | 1° | 0.5 | 1 | 7 | R390-025EH20-07H | 19.3 | 24.0 | 25.0 | 25.0 | | 0.5 | 0.07 | 28200 | 7 | 390R-07.. |
| | 07 | E25 | 2.0 | 5.80 | 1° | 0.5 | 1 | 7 | R390-025EH25-07H | 24.2 | 24.0 | 13.9 | 25.0 | 13.9 | 0.5 | 0.20 | 28200 | 7 | 390R-07.. |
| | 11 | E25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-025EH25-11L | 24.2 | | | 35.0 | | 1.2 | 0.13 | 36400 | 2 | R390-11.. |
| | 11 | E25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-025EH25-11M | 24.2 | | | 35.0 | | 1.2 | 0.14 | 36400 | 3 | R390-11.. |
| | 11 | E25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 4 | R390-025EH25-11H | 24.2 | | | 35.0 | | 1.2 | 0.19 | 36400 | 4 | R390-11.. |
| | 17 | E25 | 8.5 | 15.70 | 15° | 1.5 | 1 | 2 | R390-025EH25-17L | 24.2 | | | 40.0 | | 3.0 | 0.20 | 30800 | 2 | R390-17.. |
| 28.0 | 11 | E25 | 5.5 | 10.00 | 1° | 1.0 | 1 | 2 | R390-028EH25-11L | 24.2 | | | 35.0 | | 1.2 | 0.20 | 31000 | 2 | R390-11.. |
| | 11 | E25 | 5.5 | 10.00 | 2° | 1.0 | 1 | 3 | R390-028EH25-11M | 24.2 | | | 35.0 | | 1.2 | 0.20 | 31000 | 3 | R390-11.. |
| 32.0 | 07 | E25 | 2.0 | 5.80 | 1° | 0.5 | 1 | 6 | R390-032EH25-07M | 24.2 | 30.4 | 25.0 | 25.0 | | 0.5 | 0.12 | 24400 | 6 | 390R-07.. |
| | 07 | E25 | 2.0 | 5.80 | 1° | 0.5 | 1 | 8 | R390-032EH25-07H | 24.2 | 30.4 | 25.0 | 25.0 | | 0.5 | 0.12 | 24400 | 8 | 390R-07.. |
| | 11 | E25 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-032EH25-11L | 24.2 | | | 35.0 | | 1.2 | 0.23 | 31000 | 2 | R390-11.. |
| | 11 | E25 | 5.5 | 10.00 | 3° | 1.0 | 1 | 3 | R390-032EH25-11M | 24.2 | | | 35.0 | | 1.2 | 0.21 | 31000 | 3 | R390-11.. |
| | 11 | E25 | 5.5 | 10.00 | 3° | 1.0 | 1 | 5 | R390-032EH25-11H | 24.2 | | | 35.0 | | 1.2 | 0.21 | 31000 | 5 | R390-11.. |
| | 17 | E25 | 8.5 | 15.70 | 6° | 1.5 | 1 | 2 | R390-032EH25-17L | 24.2 | | | 40.0 | | 3.0 | 0.22 | 25600 | 2 | R390-17.. |
| | 17 | E25 | 8.5 | 15.70 | 6° | 1.5 | 1 | 3 | R390-032EH25-17M | 24.2 | | | 40.0 | | 3.0 | 0.18 | 25600 | 3 | R390-17.. |

| Spare parts | |
|-------------|----------------|
| DC | Insert screw |
| 10.00-32.00 | 07 5513 020-82 |
| 16.00-22.00 | 11 5513 020-36 |
| 25.00-32.00 | 11 5513 020-35 |
| 25.00 | 17 5513 020-37 |
| 32.00 | 17 5513 020-39 |

For complete list of spare parts, see www.sandvik.coromant.com



174



L2



N23



N6



N9



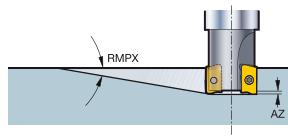
N15



N3

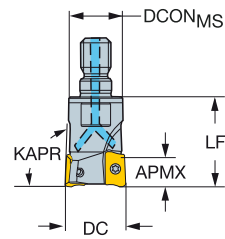
CoroMill® 390 square shoulder milling cutter

Threaded coupling - Internal coolant supply



KAPR

90°



| | | | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|-----|------|---|---------------|--------------------|------|------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | Ordering code | DCON _{MS} | LF | NM | KG | RPMX | CICT | MIID | |
| 16.0 | 11 | M8 | 5.5 | 10.00 | 10° | 1.0 | 0 | 2 | R390-16T08-11L | 12.8 | 25.0 | 1.2 | 0.13 | 10900 | 2 | R390-11.. |
| 20.0 | 11 | M10 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-20T10-11L | 17.8 | 30.0 | 1.2 | 0.16 | 9900 | 2 | R390-11.. |
| | 11 | M10 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-20T10-11M | 17.8 | 30.0 | 1.2 | 0.18 | 9900 | 3 | R390-11.. |
| 25.0 | 11 | M12 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-25T12-11L | 20.8 | 35.0 | 1.2 | 0.20 | 8100 | 2 | R390-11.. |
| | 11 | M12 | 5.5 | 10.00 | 5° | 1.0 | 1 | 3 | R390-25T12-11M | 20.8 | 35.0 | 1.2 | 0.20 | 8100 | 3 | R390-11.. |
| 32.0 | 11 | M16 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-32T16-11L | 28.8 | 45.0 | 1.2 | 0.32 | 9100 | 2 | R390-11.. |
| | 11 | M16 | 5.5 | 10.00 | 3° | 1.0 | 1 | 3 | R390-32T16-11M | 28.8 | 45.0 | 1.2 | 0.31 | 9100 | 3 | R390-11.. |
| 35.0 | 11 | M16 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-35T16-11L | 28.8 | 45.0 | 1.2 | 0.39 | 9100 | 2 | R390-11.. |
| | 11 | M16 | 5.5 | 10.00 | 3° | 1.0 | 1 | 3 | R390-35T16-11M | 28.8 | 45.0 | 1.2 | 0.34 | 9100 | 3 | R390-11.. |
| 40.0 | 11 | M16 | 5.5 | 10.00 | 2° | 1.0 | 1 | 2 | R390-40T16-11L | 28.8 | 45.0 | 1.2 | 0.40 | 9100 | 2 | R390-11.. |
| | 11 | M16 | 5.5 | 10.00 | 2° | 1.0 | 1 | 4 | R390-40T16-11M | 28.8 | 45.0 | 1.2 | 0.40 | 9100 | 4 | R390-11.. |
| 42.0 | 11 | M16 | 5.5 | 10.00 | 1° | 1.0 | 1 | 4 | R390-42T16-11M | 28.8 | 45.0 | 1.2 | 0.40 | 9100 | 4 | R390-11.. |

| Spare parts | | |
|-------------|----|--------------|
| DC | | Insert screw |
| 16.00-20.00 | 11 | 5513 020-36 |
| 25.00-42.00 | 11 | 5513 020-35 |

For complete list of spare parts, see www.sandvik.coromant.com



I74



N23



N6



N9



N15



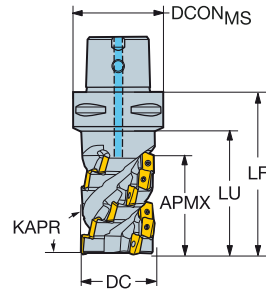
N3

CoroMill® 390 long edge square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR

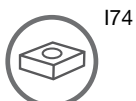
90°



| DC | CZC _{MS} | APM _{FFW} | CNSC | Ordering code | Dimensions, mm | | | | | | CICT | MID | | |
|-------|-------------------|--------------------|-------|---------------|--------------------|----------------|----------------|-------|------|------|------|-------|-------|-----------|
| | | | | | DCON _{MS} | LF | LU | NM | KG | RPMX | | | | |
| 32.0 | 11 | C5 | 36.00 | 3 | 2 | R390-032C5-36L | 50.0 | 71.7 | 46.0 | 1.2 | 1.12 | 21700 | 8 | R390-11.. |
| | 11 | C5 | 36.00 | 3 | 3 | R390-032C5-36M | 50.0 | 71.7 | 45.0 | 1.2 | 0.60 | 21700 | 12 | R390-11.. |
| | 11 | C5 | 54.00 | 3 | 2 | R390-032C5-54L | 50.0 | 89.4 | 63.0 | 1.2 | 1.14 | 21700 | 12 | R390-11.. |
| | 11 | C6 | 63.00 | 3 | 2 | R390-032C6-63L | 63.0 | 100.2 | 72.0 | 1.2 | 1.51 | 21700 | 14 | R390-11.. |
| | 11 | C6 | 45.00 | 3 | 3 | R390-032C6-45M | 63.0 | 82.5 | 54.0 | 1.2 | 1.40 | 21700 | 15 | R390-11.. |
| | 11 | C5 | 54.00 | 3 | 3 | R390-032C5-54M | 50.0 | 89.4 | 63.0 | 1.2 | 1.16 | 21700 | 18 | R390-11.. |
| 36.0 | 11 | C3 | 36.00 | 3 | 2 | R390-036C3-36L | 32.0 | 66.7 | 66.0 | 1.2 | 0.70 | 20200 | 8 | R390-11.. |
| | 11 | C3 | 36.00 | 3 | 3 | R390-036C3-36M | 32.0 | 66.7 | 66.0 | 1.2 | 0.65 | 20200 | 12 | R390-11.. |
| | 11 | C5 | 54.00 | 3 | 3 | R390-040C5-54M | 50.0 | 89.4 | 63.0 | 1.2 | 0.80 | 18900 | 18 | R390-11.. |
| 40.0 | 11 | C6 | 63.00 | 3 | 3 | R390-040C6-63M | 63.0 | 100.2 | 72.0 | 1.2 | 1.28 | 18900 | 21 | R390-11.. |
| | 11 | C5 | 54.00 | 3 | 4 | R390-040C5-54H | 50.0 | 89.4 | 63.0 | 1.2 | 1.31 | 18900 | 24 | R390-11.. |
| | 11 | C6 | 63.00 | 3 | 4 | R390-040C6-63H | 63.0 | 100.2 | 72.0 | 1.2 | 1.65 | 18900 | 28 | R390-11.. |
| | 11 | C4 | 45.00 | 3 | 3 | R390-044C4-45M | 40.0 | 80.5 | | 1.2 | 0.97 | 17800 | 15 | R390-11.. |
| | 18 | C4 | 43.00 | 3 | 2 | R390-044C4-43L | 40.0 | 78.6 | | 3.0 | 0.90 | 8600 | 6 | R390-18.. |
| 44.0 | 18 | C5 | 43.00 | 3 | 2 | R390-044C5-43L | 50.0 | 78.6 | 53.0 | 3.0 | 1.29 | 9200 | 6 | R390-18.. |
| | 18 | C5 | 57.00 | 3 | 2 | R390-044C5-57L | 50.0 | 92.6 | 67.0 | 3.0 | 1.36 | 9200 | 8 | R390-18.. |
| | 18 | C6 | 57.00 | 3 | 2 | R390-044C6-57L | 63.0 | 94.6 | 67.0 | 3.0 | 1.69 | 9200 | 8 | R390-18.. |
| | 11 | C5 | 36.00 | 3 | 3 | R390-050C5-36L | 50.0 | 71.7 | 50.0 | 1.2 | 1.31 | 16600 | 12 | R390-11.. |
| | 11 | C5 | 36.00 | 3 | 4 | R390-050C5-36M | 50.0 | 71.7 | 50.0 | 1.2 | 1.44 | 16600 | 16 | R390-11.. |
| | 11 | C5 | 54.00 | 3 | 3 | R390-050C5-54L | 50.0 | 89.4 | 67.0 | 1.2 | 1.20 | 16600 | 18 | R390-11.. |
| 50.0 | 11 | C5 | 36.00 | 3 | 5 | R390-050C5-36H | 50.0 | 71.7 | 50.0 | 1.2 | 1.29 | 16600 | 20 | R390-11.. |
| | 11 | C5 | 54.00 | 3 | 4 | R390-050C5-54M | 50.0 | 89.4 | 67.0 | 1.2 | 1.59 | 16600 | 24 | R390-11.. |
| | 11 | C6 | 63.00 | 3 | 4 | R390-050C6-63M | 63.0 | 100.2 | 72.0 | 1.2 | 1.99 | 16600 | 28 | R390-11.. |
| | 11 | C6 | 63.00 | 3 | 5 | R390-050C6-63H | 63.0 | 100.2 | 72.0 | 1.2 | 2.00 | 16600 | 35 | R390-11.. |
| | 18 | C5 | 43.00 | 3 | 2 | R390-050C5-43L | 50.0 | 78.6 | 53.0 | 3.0 | 1.00 | 7900 | 6 | R390-18.. |
| | 18 | C6 | 43.00 | 3 | 3 | R390-050C6-43M | 63.0 | 80.6 | 53.0 | 3.0 | 1.70 | 7900 | 9 | R390-18.. |
| | 18 | C6 | 71.00 | 3 | 2 | R390-050C6-71L | 63.0 | 108.7 | 81.0 | 3.0 | 2.04 | 7900 | 10 | R390-18.. |
| | 18 | C8 | 57.00 | 3 | 3 | R390-050C8-57M | 80.0 | 102.6 | 67.0 | 3.0 | 2.76 | 7900 | 12 | R390-18.. |
| | 18 | C6 | 71.00 | 3 | 3 | R390-050C6-71M | 63.0 | 108.7 | 81.0 | 3.0 | 1.50 | 7900 | 15 | R390-18.. |
| | 54.0 | 11 | C5 | 54.00 | 3 | 4 | R390-054C5-54M | 50.0 | 89.4 | | 1.2 | 1.70 | 16000 | 24 |
| 18 | | C5 | 43.00 | 3 | 3 | R390-054C5-43M | 50.0 | 78.6 | | 3.0 | 1.00 | 7500 | 9 | R390-18.. |
| 63.0 | 18 | C6 | 43.00 | 3 | 4 | R390-063C6-43M | 63.0 | 80.6 | 53.0 | 3.0 | 2.09 | 6800 | 12 | R390-18.. |
| | 18 | C6 | 57.00 | 3 | 3 | R390-063C6-57L | 63.0 | 94.6 | 67.0 | 3.0 | 2.36 | 6800 | 12 | R390-18.. |
| | 18 | C8 | 57.00 | 3 | 4 | R390-063C8-57M | 80.0 | 102.6 | 67.0 | 3.0 | 3.19 | 6800 | 16 | R390-18.. |
| | 18 | C8 | 85.00 | 3 | 3 | R390-063C8-85L | 80.0 | 130.7 | 95.0 | 3.0 | 3.73 | 6800 | 18 | R390-18.. |
| 66.0 | 11 | C6 | 45.00 | 3 | 4 | R390-066C6-45M | 63.0 | 82.5 | | 1.2 | 2.00 | 13900 | 20 | R390-11.. |
| | 18 | C6 | 57.00 | 3 | 3 | R390-066C6-57L | 63.0 | 94.6 | | 3.0 | 2.47 | 6700 | 12 | R390-18.. |
| 80.0 | 18 | C8 | 71.00 | 3 | 3 | R390-080C8-71L | 80.0 | 116.7 | 81.0 | 3.0 | 4.64 | 5900 | 15 | R390-18.. |
| | 18 | C8 | 57.00 | 3 | 5 | R390-080C8-57H | 80.0 | 102.6 | 67.0 | 3.0 | 4.04 | 5900 | 20 | R390-18.. |
| 84.0 | 18 | C8 | 57.00 | 3 | 4 | R390-084C8-57M | 80.0 | 102.6 | | 3.0 | 4.15 | 5800 | 16 | R390-18.. |
| 100.0 | 18 | C8 | 57.00 | 3 | 4 | R390-100C8-57M | 80.0 | 102.6 | | 3.0 | 5.46 | 5200 | 16 | R390-18.. |
| | 18 | C8 | 71.00 | 3 | 4 | R390-100C8-71M | 80.0 | 116.7 | | 3.0 | 6.01 | 5200 | 20 | R390-18.. |
| | 18 | C8 | 57.00 | 3 | 6 | R390-100C8-57H | 80.0 | 102.6 | | 3.0 | 5.08 | 5200 | 24 | R390-18.. |

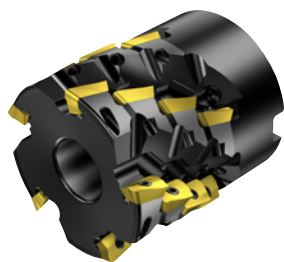
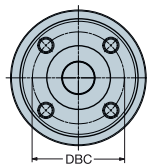
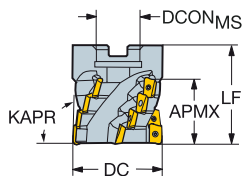
| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 11 | 5513 024-01 |
| 18 | 5513 036-01 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 390 long edge square shoulder milling cutter

Arbor

STDNO
KAPRISO6462
90°

| | | | | | | Dimensions, mm | | | | | | | | |
|-------|-------------------|---------------------|-------|---------------|--------------------|----------------|-----|------|------|------|-------|------|-----------|-----------|
| DC | CZC _{MS} | APMX _{FFW} | | Ordering code | DCON _{MS} | ISO | DBC | LF | NM | KG | RPMX | CICT | MID | |
| 40.0 | 11 | 16 | 36.00 | 3 | R390-040Q16-36M | 16.0 | A | 56.7 | 1.2 | 0.80 | 18900 | 12 | R390-11.. | |
| | 11 | 16 | 36.00 | 4 | R390-040Q16-36H | 16.0 | A | 56.7 | 1.2 | 0.30 | 18900 | 16 | R390-11.. | |
| 44.0 | 11 | 16 | 45.00 | 3 | R390-044Q16-45M | 16.0 | A | 65.5 | 1.2 | 0.98 | 17800 | 15 | R390-11.. | |
| | 18 | 16 | 43.00 | 2 | R390-044Q16-43L | 16.0 | A | 68.6 | 3.0 | 0.91 | 8600 | 6 | R390-18.. | |
| 50.0 | 11 | 22 | 36.00 | 4 | R390-050Q22-36M | 22.0 | A | 56.7 | 1.2 | 0.94 | 16600 | 16 | R390-11.. | |
| | 11 | 22 | 54.00 | 3 | R390-050Q22-54L | 22.0 | A | 74.4 | 1.2 | 1.09 | 16600 | 18 | R390-11.. | |
| | 11 | 22 | 36.00 | 5 | R390-050Q22-36H | 22.0 | A | 56.7 | 1.2 | 0.99 | 16600 | 20 | R390-11.. | |
| | 18 | 22 | 57.00 | 2 | R390-050Q22-57L | 22.0 | A | 82.6 | 3.0 | 1.09 | 7900 | 8 | R390-18.. | |
| 54.0 | 11 | 22 | 36.00 | 4 | R390-054Q22-36M | 22.0 | A | 56.7 | 1.2 | 1.08 | 16000 | 16 | R390-11.. | |
| | 18 | 22 | 57.00 | 2 | R390-054Q22-57L | 22.0 | A | 82.6 | 3.0 | 0.91 | 7500 | 8 | R390-18.. | |
| 63.0 | 18 | 27 | 57.00 | 3 | R390-063Q27-57L | 27.0 | A | 82.6 | 3.0 | 1.58 | 6800 | 12 | R390-18.. | |
| 80.0 | 18 | 32 | 71.00 | 3 | R390-080Q32-71L | 32.0 | A | 96.7 | 3.0 | 2.88 | 5900 | 15 | R390-18.. | |
| 100.0 | 18 | 40 | 57.00 | 4 | R390-100Q40-57M | 40.0 | B | 82.6 | 3.0 | 3.37 | 5200 | 16 | R390-18.. | |
| 125.0 | 18 | 40 | 43.00 | 6 | R390-125Q40-43L | 40.0 | B | 68.6 | 3.0 | 5.00 | 4600 | 18 | R390-18.. | |
| 160.0 | 18 | 40S | 43.00 | 8 | R390-160Q40-43L | 40.0 | C | 66.7 | 68.6 | 3.0 | 7.21 | 4000 | 24 | R390-18.. |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 11 | 5513 024-01 |
| 18 | 5513 036-01 |

For complete list of spare parts, see www.sandvik.coromant.com

I74



L2



M1



N23



N6



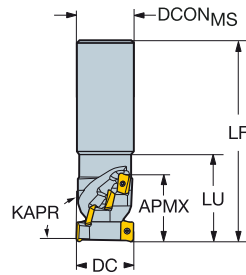
N9

CoroMill® 390 long edge square shoulder milling cutter

Cylindrical shank



KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|---------------------|-------|---------------|--------------------|----------------|-------|------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{FFW} | APMX | Ordering code | DCON _{MS} | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 32.0 | 11 | 25 | 36.00 | 2 | R390-032A25-36L | 25.0 | 108.7 | 48.0 | 1.2 | 0.59 | 21700 | 8 | R390-11.. |
| | 11 | 32 | 36.00 | 2 | R390-032A32-36L | 32.0 | 112.7 | 48.0 | 1.2 | 0.74 | 21700 | 8 | R390-11.. |
| 40.0 | 11 | 40 | 45.00 | 3 | R390-040A40-45M | 40.0 | 131.5 | 58.0 | 1.2 | 1.23 | 18900 | 15 | R390-11.. |

| |
|--------------|
| Spare parts |
| |
| Insert screw |
| 5513 024-01 |

For complete list of spare parts, see www.sandvik.coromant.com

I74



L2



N23



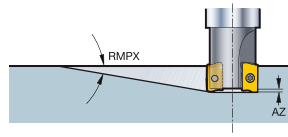
N6



N9

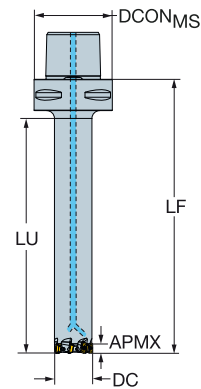
CoroMill® 390 damped square shoulder milling cutter

Coromant Capto® - Internal coolant supply



KAPR

90°



| | | | | | | | | | | Dimensions, mm | | | | | | | |
|------|-------------------|--------------------|--------------------|-------|----|------|---------------|---|--------------------|--------------------|-------|-------|-----|------|-------|------|-----------|
| DC | CZC _{MS} | APMX _{FW} | APMX _{FW} | RMPX | AZ | CNSC | Ordering code | | | DCON _{MS} | LF | LU | NM | KG | RPMX | CICT | MID |
| 20.0 | 07 | C5 | 2.0 | 5.80 | 2° | 0.5 | 3 | 5 | R390-020C5D-07H145 | 50.0 | 145.0 | 120.0 | 0.5 | 0.92 | 20000 | 5 | 390R-07.. |
| | 07 | C6 | 2.0 | 5.80 | 2° | 0.5 | 3 | 5 | R390-020C6D-07H147 | 63.0 | 147.0 | 120.0 | 0.5 | 1.25 | 20000 | 5 | 390R-07.. |
| | 11 | C5 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-020C5D-11L145 | 50.0 | 145.0 | 120.0 | 1.2 | 0.91 | 20000 | 2 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-020C6D-11L147 | 63.0 | 147.0 | 120.0 | 1.2 | 1.24 | 20000 | 2 | R390-11.. |
| 25.0 | 07 | C5 | 2.0 | 5.80 | 1° | 0.5 | 3 | 7 | R390-025C5D-07H175 | 50.0 | 175.0 | 150.0 | 0.5 | 1.19 | 20000 | 7 | 390R-07.. |
| | 07 | C6 | 2.0 | 5.80 | 1° | 0.5 | 3 | 7 | R390-025C6D-07H177 | 63.0 | 177.0 | 150.0 | 0.5 | 1.52 | 20000 | 7 | 390R-07.. |
| | 11 | C5 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-025C5D-11L175 | 50.0 | 175.0 | 150.0 | 1.2 | 1.19 | 20000 | 2 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 5° | 1.0 | 3 | 2 | R390-025C6D-11L177 | 63.0 | 177.0 | 150.0 | 1.2 | 1.53 | 20000 | 2 | R390-11.. |
| 32.0 | 07 | C5 | 2.0 | 5.80 | 1° | 0.5 | 3 | 8 | R390-032C5D-07H217 | 50.0 | 217.0 | 192.0 | 0.5 | 1.82 | 15000 | 8 | 390R-07.. |
| | 07 | C6 | 2.0 | 5.80 | 1° | 0.5 | 3 | 8 | R390-032C6D-07H219 | 63.0 | 219.0 | 192.0 | 0.5 | 2.15 | 15000 | 8 | 390R-07.. |
| | 11 | C5 | 5.5 | 10.00 | 3° | 1.0 | 3 | 2 | R390-032C5D-11L217 | 50.0 | 217.0 | 192.0 | 1.2 | 1.83 | 15000 | 2 | R390-11.. |
| | 11 | C6 | 5.5 | 10.00 | 3° | 1.0 | 3 | 2 | R390-032C6D-11L219 | 63.0 | 219.0 | 192.0 | 1.2 | 2.17 | 15000 | 2 | R390-11.. |

| | | Spare parts | |
|-------------|--------------|-------------|--|
| DC | Insert screw | | |
| 20.00-32.00 | 07 | 5513 020-82 | |
| 20.00 | 11 | 5513 020-36 | |
| 25.00-32.00 | 11 | 5513 020-35 | |

For complete list of spare parts, see www.sandvik.coromant.com



I74



L2



N23



N6



N9



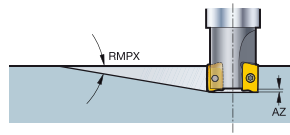
N15



L109

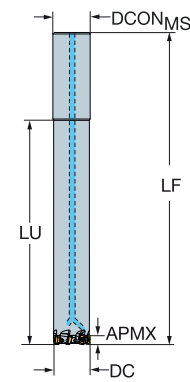
CoroMill® 390 damped square shoulder milling cutter

Cylindrical shank - Internal coolant supply



KAPR

90°



| | | | | | | | | | | Dimensions, mm | | | | | | | |
|------|----|-------------------|---------------------|---------------------|------|-----|------|---|------------------|--------------------|-------|-------|-----|------|-------|------|-----------|
| DC | | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | Ordering code | DCON _{MS} | LF | LU | | | RPMX | CICT | MIID |
| 20.0 | 07 | 20 | 2.0 | 5.80 | 2° | 0.5 | 1 | 5 | R390-020A20D-07H | 20.0 | 173.0 | 120.0 | 0.5 | 0.71 | 20000 | 5 | 390R-07.. |
| | 11 | 20 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-020A20D-11L | 20.0 | 171.0 | 120.0 | 1.2 | 0.73 | 20000 | 2 | R390-11.. |
| 25.0 | 07 | 25 | 2.0 | 5.80 | 1° | 0.5 | 1 | 7 | R390-025A25D-07H | 25.0 | 208.0 | 150.0 | 0.5 | 0.96 | 20000 | 7 | 390R-07.. |
| | 11 | 25 | 5.5 | 10.00 | 5° | 1.0 | 1 | 2 | R390-025A25D-11L | 25.0 | 208.0 | 150.0 | 1.2 | 0.95 | 20000 | 2 | R390-11.. |
| 32.0 | 07 | 32 | 2.0 | 5.80 | 1° | 0.5 | 1 | 8 | R390-032A32D-07H | 32.0 | 254.0 | 192.0 | 0.5 | 1.74 | 15000 | 8 | 390R-07.. |
| | 11 | 32 | 5.5 | 10.00 | 3° | 1.0 | 1 | 2 | R390-032A32D-11L | 32.0 | 254.0 | 192.0 | 1.2 | 1.48 | 15000 | 2 | R390-11.. |

| | | Spare parts | |
|-------------|----|--------------|--|
| DC | | Insert screw | |
| 20.00-32.00 | 07 | 5513 020-82 | |
| 20.00 | 11 | 5513 020-36 | |
| 25.00-32.00 | 11 | 5513 020-35 | |

For complete list of spare parts, see www.sandvik.coromant.com



I74



L2



N23



N6



N9



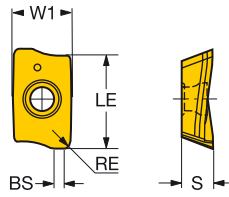
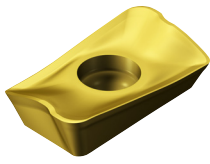
N15



L109

CoroMill® 390 insert for milling

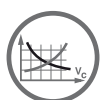
KRINS 90°



| Light | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|-------|------|-------------------|-------------------|-----------------|------|------|-----|------|------|------|-----|------|------|------|------|------|-----|------|------|------|-------|------|------|------|-----|------|------|------|------|-----|
| | | | P | | | | M | | | | K | | | | N | | | | S | | | | H | | | | | | | |
| | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2040 | 530 | 1020 | 3040 | 3330 | H13A | 1130 | 530 | H13A | 1130 | H13A | ES30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS | |
| KL | 07 | 0.40 | 390R-070204E-KL | | | | | | | * | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | | 0.80 | 390R-070208E-KL | | | | | | | * | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | 11 | 0.80 | R390-11 T3 08E-KL | | | | | | | | | | | * | | | | * | | | | | | | | 6.8 | 10.0 | 3.59 | 1.5 | |
| | | 0.80 | R390-11 T3 08M-KL | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 1.2 |
| | 17 | 0.80 | R390-17 04 08E-KL | | | | | | | | | | | * | | | | * | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 | |
| | | 0.80 | R390-17 04 08M-KL | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 1.5 |
| | 18 | 0.80 | R390-18 06 08H-KL | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 1.20 | R390-18 06 12H-KL | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 3.10 | R390-18 06 31H-KL | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | ML | 07 | 0.20 | 390R-070202E-ML | | | | | * | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | 0.40 | 390R-070204E-ML | | | | | * | | | | | | | | | | * | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | | 0.80 | 390R-070208E-ML | | | | | * | | | | | | | | | | * | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | | 1.20 | 390R-070212E-ML | | | | | * | | | | | | | | | | * | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | | 1.60 | 390R-070216E-ML | | | | | * | | | | | | | | | | * | | | | | | | | 4.0 | 5.9 | 2.40 | 0.2 | |
| 11 | | 0.80 | R390-11 T3 08E-ML | | | | | * | * | | | | | | | | | * | * | | | | | | | 6.8 | 10.0 | 3.59 | 1.5 | |
| | | 1.60 | R390-11 T3 16E-ML | | | | | * | * | * | | | | | | | | * | * | * | | | | | | 6.8 | 10.0 | 3.59 | 0.8 | |
| | | 2.40 | R390-11 T3 24E-ML | | | | | * | * | * | * | | | | | | | * | * | * | * | | | | | 6.8 | 10.0 | 3.59 | | |
| | | 3.10 | R390-11 T3 31E-ML | | | | | * | * | * | * | * | | | | | | * | * | * | * | * | | | | 6.8 | 10.0 | 3.59 | | |
| 17 | | 0.80 | R390-17 04 08E-ML | | | | | * | * | | | | | | | | | * | * | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 | |
| 18 | | 0.80 | R390-18 06 08H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 1.20 | R390-18 06 12H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 1.60 | R390-18 06 16H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 2.00 | R390-18 06 20H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 2.40 | R390-18 06 24H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 3.10 | R390-18 06 31H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 4.00 | R390-18 06 40H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | | 5.00 | R390-18 06 50H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 |
| | 6.00 | R390-18 06 60H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | |
| | 6.40 | R390-18 06 64H-ML | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | |
| NL | 07 | 0.20 | 390R-070202E-NL | | | | | | | | | | | | | | * | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | | 0.40 | 390R-070204E-NL | | | | | | | | | | | | | | * | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | | 0.80 | 390R-070208E-NL | | | | | | | | | | | | | | * | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | 11 | 0.40 | R390-11 T3 04E-NL | | | | | | | | | | | | | | * | | | | | | | | | 6.8 | 10.0 | 3.59 | 0.9 | |
| | | 0.80 | R390-11 T3 08E-NL | | | | | | | | | | | | | | * | | | | | | | | | 6.8 | 10.0 | 3.59 | 1.5 | |
| | | 2.00 | R390-11 T3 20E-NL | | | | | | | | | | | | | | * | | | | | | | | | 6.8 | 10.0 | 3.59 | | |
| | | 3.10 | R390-11 T3 31E-NL | | | | | | | | | | | | | | * | | | | | | | | | 6.8 | 10.0 | 3.59 | | |
| | 17 | 0.80 | R390-17 04 08E-NL | | | | | | | | | | | | | | * | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 | |
| | | 2.00 | R390-17 04 20E-NL | | | | | | | | | | | | | | * | | | | | | | | | 9.6 | 15.7 | 4.76 | 0.3 | |
| | | 3.10 | R390-17 04 31E-NL | | | | | | | | | | | | | | * | | | | | | | | | 9.6 | 15.7 | 4.76 | | |
| | 4.00 | R390-17 04 40E-NL | | | | | | | | | | | | | | * | | | | | | | | | 9.6 | 15.7 | 4.76 | | | |
| | 5.00 | R390-17 04 50E-NL | | | | | | | | | | | | | | * | | | | | | | | | 9.6 | 15.7 | 4.76 | | | |



158



1154



1175



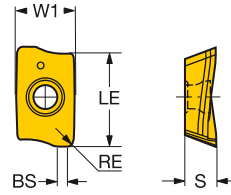
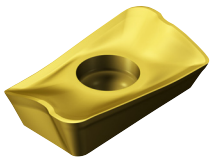
N23



N10

CoroMill® 390 insert for milling

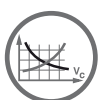
KRINS 90°



| | | | | RE | Ordering code | P | M | K | N | S | H | Dimensions, mm | | | | | | | | | | | | | | | | | | | | | |
|--------|------|------|-------------------|--------------------|-------------------|-----|-----|-----|-----|------|------|----------------|-----|------|------|------|------|------|-----|------|------|------|-------|------|------|------|------|------|------|------|------|------|-----|
| | | 1130 | 420 | | | 430 | 430 | 490 | 530 | 1090 | 1130 | 2040 | 530 | 1020 | 3040 | 3330 | H13A | 1130 | 530 | H13A | 1130 | H13A | ES30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS | | |
| | | * | * | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * |
| Light | PL | 07 | 0.20 | 390R-070202E-PL | * | | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | | | |
| | | | 0.40 | 390R-070204E-PL | * | | | | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | | | 0.80 | 390R-070208E-PL | * | | | | | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | 1.20 | 390R-070212E-PL | * | | | | | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | 1.60 | 390R-070216E-PL | * | | | | | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.2 |
| | | 11 | 0.40 | R390-11 T3 04E-PL | * | | | | | | | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 0.9 | |
| | | | | 0.80 | R390-11 T3 08E-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 1.5 |
| | | | | 0.80 | R390-11 T3 08M-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 1.2 |
| | | | | 0.80 | R390-17 04 08E-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | | 0.80 | R390-17 04 08M-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 1.5 |
| | 18 | | 0.80 | R390-18 06 08H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | |
| | | | | 1.20 | R390-18 06 12H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | |
| | | | | 1.60 | R390-18 06 16H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | |
| | | | | 2.00 | R390-18 06 20H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | |
| | | | | 2.40 | R390-18 06 24H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | |
| | | 3.10 | R390-18 06 31H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | | |
| | | | 4.00 | R390-18 06 40H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | | |
| | | | 5.00 | R390-18 06 50H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | | |
| | | | 6.00 | R390-18 06 60H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | | |
| | | | 6.40 | R390-18 06 64H-PL | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.0 | | |
| Medium | KM | 07 | 0.40 | 390R-070204M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 4.0 | 5.9 | 2.40 | 0.7 | | | |
| | | | 0.80 | 390R-070208M-KM | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 4.0 | 5.9 | 2.40 | 0.7 | | |
| | | | 1.60 | 390R-070216M-KM | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 4.0 | 5.9 | 2.40 | 0.2 | | |
| | | 11 | 0.40 | R390-11 T3 02E-KM | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 0.7 | | |
| | | | | R390-11 T3 04M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 0.9 | | |
| | | | | 0.80 | R390-11 T3 08M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 1.2 | |
| | | | | 1.20 | R390-11 T3 12E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 0.8 | |
| | | | | 1.60 | R390-11 T3 16E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 0.8 | |
| | | | 1.60 | R390-11 T3 16M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 0.4 | |
| | | | | 2.00 | R390-11 T3 20E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | 0.4 | |
| | | | | 2.40 | R390-11 T3 24E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | | |
| | | | | 3.10 | R390-11 T3 31E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | | |
| | | | | 3.10 | R390-11 T3 31M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 6.8 | 10.0 | 3.59 | | |
| | | 17 | 0.40 | R390-17 04 04E-KM | | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 1.0 | | |
| | | | | R390-17 04 04M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 1.0 | | |
| | | | | 0.80 | R390-17 04 08M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 1.5 | | |
| | | | | 1.20 | R390-17 04 12E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 1.1 | | |
| | | | | 1.60 | R390-17 04 16E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 0.7 | | |
| | | | | 1.60 | R390-17 04 16M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 0.7 | | |
| | | | 2.00 | R390-17 04 20E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | 0.3 | | |
| | 2.40 | | | R390-17 04 24E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | | | | |
| | 3.10 | | | R390-17 04 31E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | | | | |
| | 3.10 | | | R390-17 04 31M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | | | | |
| | 4.00 | | | R390-17 04 40E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | | | | |
| | 4.80 | | | R390-17 04 48E-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 9.6 | 15.7 | 4.76 | | | | |
| | 18 | 0.80 | R390-18 06 08M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.1 | | | | |
| | | | 1.20 | R390-18 06 12M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.1 | | | | |
| | | | 1.60 | R390-18 06 16M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 1.1 | | | | |
| | | 2.00 | R390-18 06 20M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 0.5 | | | |
| | | | 3.10 | R390-18 06 31M-KM | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 0.5 | | | |
| | | | 1.20 | R390-18 06 12M-KMR | | | | | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | * | 11.0 | 15.4 | 6.33 | 0.3 | | | |



158



154



175



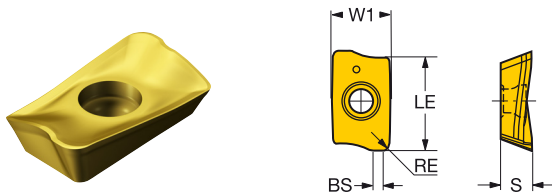
N23



N10

CoroMill® 390 insert for milling

KRINS 90°



| RE | Ordering code | P | | | | | | | | | | | M | | | | K | | | N | | S | | H | | Dimensions, mm | | | |
|------|-------------------|-------------------|--------------------|------|------|-----|------|------|------|-----|------|------|------|------|------|-----|------|------|------|-------|-------|------|------|------|------|----------------|------|-----|--|
| | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2040 | 530 | 1020 | 3040 | 3330 | H13A | 1130 | 530 | H13A | 1130 | H13A | ES30T | ES40T | 1010 | 1130 | 530 | W1 | LE | S | BS | |
| | | | | | | | | | | | | | | | | | | | | | | | | W1 | LE | S | BS | | |
| 07 | 0.20 | 390R-070202M-MM | | | | | * | | | | | | | | | | | | * | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | 0.40 | 390R-070204E-MM | | | | | * | | | | | | | | | | | | * | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | 0.40 | 390R-070204M-MM | | | | | * | | | | | | | | | | | | * | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | 0.80 | 390R-070208E-MM | | | | | * | | | | | | | | | | | | * | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | 0.80 | 390R-070208M-MM | | | | | * | | | | | | | | | | | | * | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | 1.20 | 390R-070212M-MM | | | | | * | | | | | | | | | | | | * | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | |
| | 1.60 | 390R-070216M-MM | | | | | * | | | | | | | | | | | | * | | | | | | 4.0 | 5.9 | 2.40 | 0.2 | |
| | 11 | 0.20 | R390-11 T3 02E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 6.8 | 10.0 | 3.59 | 0.7 | |
| | | 0.80 | R390-11 T3 08M-MM | | | | | * | * | | | | | | | | | | | * | * | | | | 6.8 | 10.0 | 3.59 | 1.2 | |
| | | 1.20 | R390-11 T3 12E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 6.8 | 10.0 | 3.59 | 0.8 | |
| | | 1.60 | R390-11 T3 16E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 6.8 | 10.0 | 3.59 | 0.4 | |
| | | 2.00 | R390-11 T3 20E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 6.8 | 10.0 | 3.59 | | |
| | | 2.40 | R390-11 T3 24E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 6.8 | 10.0 | 3.59 | | |
| | | 3.10 | R390-11 T3 31E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 6.8 | 10.0 | 3.59 | | |
| | 17 | 0.40 | R390-17 04 04E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | 1.0 | |
| | | 0.80 | R390-17 04 08M-MM | | | | | * | * | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | 1.5 | |
| | | 1.20 | R390-17 04 12E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | 1.1 | |
| | | 1.60 | R390-17 04 16E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | 0.7 | |
| 2.00 | | R390-17 04 20E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | 0.3 | | |
| 2.40 | | R390-17 04 24E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | | | |
| 3.10 | | R390-17 04 31E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | | | |
| 4.00 | | R390-17 04 40E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | | | |
| 4.80 | | R390-17 04 48E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | | | |
| 5.00 | | R390-17 04 50E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | | | |
| 6.00 | | R390-17 04 60E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | | | |
| 6.35 | R390-17 04 64E-MM | | | | | * | | | | | | | | | | | | * | * | | | | 9.6 | 15.7 | 4.76 | | | | |
| 18 | 0.80 | R390-18 06 08M-MM | | | | | * | * | | | | | | | | | | | * | * | | | | 11.0 | 15.4 | 6.33 | 1.1 | | |
| | 1.20 | R390-18 06 12M-MM | | | | | * | * | * | | | | | | | | | | * | * | | | | 11.0 | 15.4 | 6.33 | 1.1 | | |
| | 1.60 | R390-18 06 16M-MM | | | | | * | * | * | | | | | | | | | | * | * | | | | 11.0 | 15.4 | 6.33 | 1.1 | | |
| | 2.00 | R390-18 06 20M-MM | | | | | * | * | * | * | | | | | | | | | * | * | | | | 11.0 | 15.4 | 6.33 | 0.5 | | |
| | 3.10 | R390-18 06 31M-MM | | | | | * | * | * | * | | | | | | | | | * | * | | | | 11.0 | 15.4 | 6.33 | 0.5 | | |
| MMR | 18 | 1.20 | R390-18 06 12M-MMR | | | | * | * | | | | | | | | | | * | * | | | | 11.0 | 15.4 | 6.33 | 0.3 | | | |



158



1154



1175



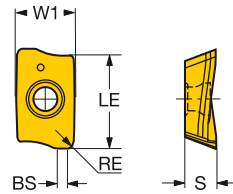
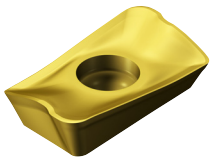
N23



N10

CoroMill® 390 insert for milling

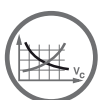
KRINS 90°



| | | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|--------|----|------|--------------------|-------------------|------|------|------|-----|------|------|------|-----|------|------|------|------|------|-----|------|------|------|-------|-------|------|------|-----|------|------|------|------|------|------|------|-----|
| | | | | P | | | | M | | | | K | | | | N | | | | S | | | | H | | | | | | | | | | |
| | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2040 | 530 | 1020 | 3040 | 3330 | H13A | 1130 | 530 | H13A | 1130 | H13A | ES30T | ES40T | 1010 | 1130 | 530 | W1 | LE | S | BS | | | | |
| Medium | PM | 07 | 0.20 | 390R-070202M-PM | * | | * | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | | | | | |
| | | | 0.40 | 390R-070204M-PM | * | * | * | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | | | | |
| | | | 0.80 | 390R-070208M-PM | * | * | * | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | | | |
| | | | 1.20 | 390R-070212M-PM | * | * | * | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 | | | |
| | | | 1.60 | 390R-070216M-PM | * | * | * | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.2 | | | |
| | | | 0.20 | R390-11 T3 02E-PM | * | | * | | | | | | | | | | | | | | | | | | | | | 6.8 | 10.0 | 3.59 | 0.7 | | | |
| | | | 0.40 | R390-11 T3 04M-PM | * | * | * | | | | | | | | | | | | | | | | | | | | | 6.8 | 10.0 | 3.59 | 0.9 | | | |
| | | | 0.80 | R390-11 T3 08M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | 1.2 | | | |
| | | | 1.20 | R390-11 T3 12E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | 0.8 | | | |
| | | | 1.60 | R390-11 T3 16E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | 0.4 | | | |
| | | | 1.60 | R390-11 T3 16M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | 0.4 | | | |
| | | | 2.00 | R390-11 T3 20E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | | | | |
| | | | 2.40 | R390-11 T3 24E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | | | | |
| | | | 3.10 | R390-11 T3 31E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | | | | |
| | | | 3.10 | R390-11 T3 31M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 6.8 | 10.0 | 3.59 | | | | |
| | | 0.40 | R390-17 04 04E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | 1.0 | | | | |
| | | 0.40 | R390-17 04 04M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | 1.0 | | | | |
| | | 0.80 | R390-17 04 08M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | 1.5 | | | | |
| | | 1.20 | R390-17 04 12E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | 1.1 | | | | |
| | | 1.60 | R390-17 04 16E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | 0.7 | | | | |
| | | 1.60 | R390-17 04 16M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | 0.7 | | | | |
| | | 2.00 | R390-17 04 20E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | 0.3 | | | | |
| | | 2.40 | R390-17 04 24E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 3.10 | R390-17 04 31E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 3.10 | R390-17 04 31M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 4.00 | R390-17 04 40E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 4.80 | R390-17 04 48E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 5.00 | R390-17 04 50E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 6.00 | R390-17 04 60E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 6.35 | R390-17 04 64E-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 9.6 | 15.7 | 4.76 | | | | | |
| | | 0.80 | R390-18 06 08M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 11.0 | 15.4 | 6.33 | 1.1 | | | | |
| | | 1.20 | R390-18 06 12M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 11.0 | 15.4 | 6.33 | 1.1 | | | | |
| | | 1.60 | R390-18 06 16M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 11.0 | 15.4 | 6.33 | 1.1 | | | | |
| | | 2.00 | R390-18 06 20M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 11.0 | 15.4 | 6.33 | 0.5 | | | | |
| | | 3.10 | R390-18 06 31M-PM | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 11.0 | 15.4 | 6.33 | 0.5 | | | | |
| | | 1.20 | R390-18 06 12M-PMR | * | * | * | | | | | | | | | | | | | | * | * | * | * | * | * | | 11.0 | 15.4 | 6.33 | 0.3 | | | | |
| Heavy | KH | 11 | 1.00 | R390-11 T3 10M-KH | | | | | | | | | | | | | | | | | | | | | | | | | | 6.8 | 10.0 | 3.59 | 1.0 | |
| | | 17 | 0.80 | R390-17 04 08M-KH | | | | | | | | | | | | | | | | | | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 | |
| | MH | 11 | 1.00 | R390-11 T3 10M-MH | | | | | * | | * | | | | | | | | | | | | | | | | | | | 6.8 | 10.0 | 3.59 | 1.0 | |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | PH | 11 | 1.00 | R390-11 T3 10M-PH | * | * | * | * | | | | | | | | | | | | | | | | | | | | | | | 6.8 | 10.0 | 3.59 | 1.0 |
| | | 17 | 0.80 | R390-17 04 08M-PH | * | * | * | * | | | | | | | | | | | | | | | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | 1.60 | R390-17 04 16M-PH | * | * | * | * | | | | | | | | | | | | | | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 | |



158



154



175



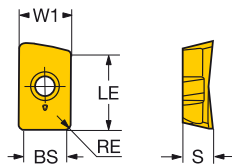
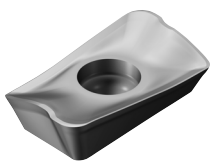
N23



N10

CoroMill® 390 insert for milling

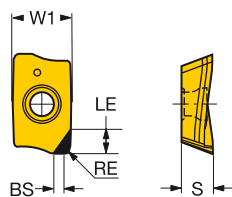
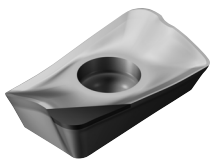
KRINS 90°



Wiper TECHNOLOGY

| | | | P | M | K | N | S | H | Dimensions, mm | | | |
|-------|-----|----|------|--------------------|------|------|------|------|----------------|------|------|-----|
| | | | 1130 | 1130 | 1020 | 1130 | 1130 | 1130 | W1 | LE | S | BS |
| Light | KTW | 18 | 1.60 | R390-18 06 16H-KTW | * | * | * | * | 11.0 | 15.4 | 6.33 | 8.6 |
| | | 11 | 0.80 | R390-11 T3 08E-PLW | * | * | * | * | 6.8 | 10.0 | 3.59 | 5.0 |
| | | 18 | 1.60 | R390-18 06 16H-PTW | * | * | * | * | 11.0 | 15.4 | 6.33 | 8.6 |

KRINS 90°



Advanced cutting materials

| | | | N | Dimensions, mm | | | | | |
|-------|----|----|------|--------------------|----|-----|-----|------|-----|
| | | | CD10 | W1 | LE | S | BS | | |
| Light | NL | 11 | 0.40 | R390-11T304E-P4-NL | * | 6.8 | 4.0 | 3.59 | 2.2 |
| | | 17 | 0.80 | R390-170408E-P6-NL | * | 9.6 | 6.0 | 4.76 | 1.8 |



158



1154



1175



N23



N10



N2

CoroMill® 690

The cutting edge for titanium milling

Application

- 2D profile milling of titanium
- Edging and full slotting

ISO application area:

S

Benefits and features

- High-productivity milling of titanium
- iLock™ interface gives a secure process, increased feed and longer tool life
- Cutting fluid supply, individual to each insert pocket
- Fully controlled flow and pressure through threaded holes - either for nozzles or plug screws
- Unique end- and side inserts for optimum performance



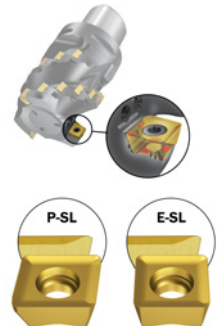
www.sandvik.coromant.com/coromill690

Couplings

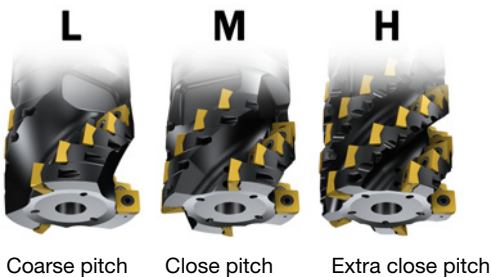
- Coromant Capto®
- Arbor
- HSK
- Oversized version available

Inserts

- Four cutting edges
- SL geometry optimized for titanium



P-SL = Side (or Periphery) insert
E-SL = End insert



Coarse pitch

Close pitch

Extra close pitch

Coolant supply

During cutting, the chips can be prone to sticking to the cutting edge. This means that the next cutter rotation is re-cutting the chip. By equipping every insert pocket with threaded coolant holes with nozzles for high pressure coolant delivery, you can apply maximum coolant where required. This effectively eliminates the problem for a constant cutting edge performance. Supplying cutting fluid to all the insert pockets in the long edge cutter requires high pump volumes and pressure capability.



180

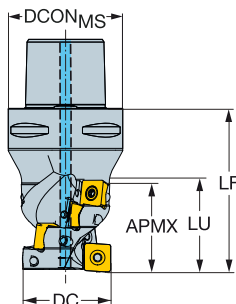


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CoroMill® 690 long edge square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



| | | | | | | | | Dimensions, mm | | | | | | | | |
|-------|--------------------|-------------------|------|---------------|---|--------------------|------|----------------|-------|-------|------|------|------|------------------|------------------|------------------|
| DC | APMX _{FW} | CZC _{MS} | CNSC | Ordering code | | DCON _{MS} | DCX | LF | LU | NM | KG | RPMX | CICT | MID _E | MID _P | |
| 40.0 | 53.0 | 10E 10P | C6 | 3 | 2 | 690-040C6-1053H | 63.0 | 40.0 | 95.0 | 55.0 | 3.0 | 1.54 | 5000 | 10 | 690-100508M-E-SL | 690-100510M-P-SL |
| 44.0 | 46.0 | 10E 10P | C4 | 3 | 3 | 690-044C4-1046H | 40.0 | 44.0 | 82.0 | 3.0 | 0.81 | 5000 | 15 | 690-100508M-E-SL | 690-100510M-P-SL | |
| 50.0 | 53.0 | 10E 10P | C5 | 3 | 3 | 690-050C5-1053H | 50.0 | 50.0 | 90.0 | 70.0 | 3.0 | 1.16 | 5000 | 3 | 690-100508M-E-SL | 690-100510M-P-SL |
| 54.0 | 53.0 | 10E 10P | C5 | 3 | 3 | 690-054C5-1053H | 50.0 | 54.0 | 90.0 | 3.0 | 1.31 | 5000 | 3 | 690-100508M-E-SL | 690-100510M-P-SL | |
| | 61.0 | 14E 14P | C5 | 3 | 3 | 690-054C5-1461H | 50.0 | 54.0 | 97.0 | 5.0 | 1.39 | 5000 | 3 | 690-140608M-E-SL | 690-140610M-P-SL | |
| 63.0 | 60.0 | 10E 10P | C6 | 3 | 3 | 690-063C6-1060M | 63.0 | 63.0 | 100.0 | 78.0 | 3.0 | 2.21 | 5000 | 3 | 690-100508M-E-SL | 690-100510M-P-SL |
| | 61.0 | 14E 14P | C6 | 3 | 3 | 690-063C6-1461H | 63.0 | 63.0 | 103.0 | 79.0 | 5.0 | 2.13 | 5000 | 3 | 690-140608M-E-SL | 690-140610M-P-SL |
| | 112.0 | 10E 10P | C6 | 3 | 4 | 690-063C6-10112H | 63.0 | 63.0 | 156.0 | 134.0 | 3.0 | 2.85 | 5000 | 56 | 690-100508M-E-SL | 690-100510M-P-SL |
| 66.0 | 49.0 | 14E 14P | C6 | 3 | 3 | 690-066C6-1449H | 63.0 | 66.0 | 90.0 | 5.0 | 2.01 | 5000 | 3 | 690-140608M-E-SL | 690-140610M-P-SL | |
| | 53.0 | 10E 10P | C6 | 3 | 4 | 690-066C6-1053H | 63.0 | 66.0 | 92.0 | 3.0 | 2.19 | 5000 | 24 | 690-100508M-E-SL | 690-100510M-P-SL | |
| | 105.0 | 10E 10P | C6 | 3 | 4 | 690-066C6-10105H | 63.0 | 66.0 | 150.0 | 3.0 | 2.88 | 5000 | 52 | 690-100508M-E-SL | 690-100510M-P-SL | |
| 80.0 | 73.0 | 14E 14P | C8 | 3 | 4 | 690-080C8-1473H | 80.0 | 80.0 | 128.0 | 92.0 | 5.0 | 4.24 | 5000 | 4 | 690-140608M-E-SL | 690-140610M-P-SL |
| 84.0 | 61.0 | 14E 14P | C8 | 3 | 4 | 690-084C8-1461M | 80.0 | 84.0 | 110.0 | 5.0 | 3.93 | 5000 | 4 | 690-140608M-E-SL | 690-140610M-P-SL | |
| | 61.0 | 14E 14P | C8 | 3 | 3 | 690-084C8-1461L | 80.0 | 84.0 | 112.0 | 5.0 | 3.99 | 5000 | 3 | 690-140608M-E-SL | 690-140610M-P-SL | |
| | 84.0 | 14E 14P | C8 | 3 | 5 | 690-084C8-1484H | 80.0 | 84.0 | 132.0 | 5.0 | 4.57 | 5000 | 5 | 690-140608M-E-SL | 690-140610M-P-SL | |
| 100.0 | 108.0 | 14E 14P | C8 | 3 | 4 | 690-100C8-14108M | 80.0 | 100.0 | 160.0 | 5.0 | 6.80 | 5000 | 4 | 690-140608M-E-SL | 690-140610M-P-SL | |

| Spare parts | | | |
|--------------|--------------|-------------|--------------|
| DC | Insert screw | Plug screw | |
| 40.00 | 10 | 5513 020-68 | 3214 010-202 |
| 44.00 | 10 | 5513 020-68 | 3214 010-202 |
| 50.00-66.00 | 10 | 5513 020-68 | 3214 010-253 |
| 54.00-100.00 | 14 | 5513 020-55 | 3214 010-253 |

For complete list of spare parts, see www.sandvik.coromant.com



182



L2



N23



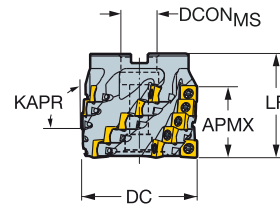
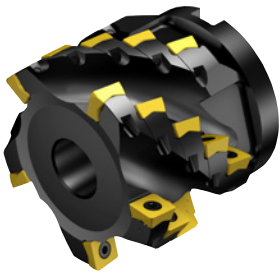
N9



N15

CoroMill® 690 long edge square shoulder milling cutter

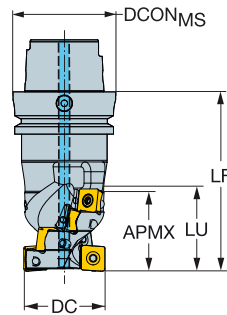
Arbor

STDNO
KAPRISO6462
90°

| | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|---------------------|-----|-----|-------------------|---------------|------------------|--------------------|-----|-------|------|-----|------|------|------|-------------------|-------------------|
| DC | APMX _{FFW} | 10E | 10P | CZC _{MS} | Ordering code | | DCON _{MS} | ISO | DCX | LF | NM | KG | RPMX | CICT | MIID _E | MIID _P |
| 50.0 | 46.0 | 10E | 10P | 22 | 3 | 690-050Q22-1046H | 22.0 | A | 50.0 | 75.0 | 3.0 | 0.98 | 5000 | 3 | 690-100508M-E-SL | 690-100510M-P-SL |
| 63.0 | 46.0 | 10E | 10P | 27 | 3 | 690-063Q27-1046M | 27.0 | A | 63.0 | 80.0 | 3.0 | 1.48 | 5000 | 3 | 690-100508M-E-SL | 690-100510M-P-SL |
| | 49.0 | 14E | 14P | 27 | 3 | 690-063Q27-1449H | 27.0 | A | 63.0 | 80.0 | 5.0 | 1.30 | 5000 | 9 | 690-140608M-E-SL | 690-140610M-P-SL |
| 80.0 | 61.0 | 14E | 14P | 32 | 3 | 690-080Q32-1461M | 32.0 | A | 80.0 | 98.0 | 5.0 | 2.42 | 5000 | 3 | 690-140608M-E-SL | 690-140610M-P-SL |
| 100.0 | 61.0 | 14E | 14P | 32 | 5 | 690-100Q32-1461H | 32.0 | A | 100.0 | 90.0 | 5.0 | 3.56 | 5000 | 5 | 690-140608M-E-SL | 690-140610M-P-SL |

HSK - Internal coolant supply

KAPR 90°



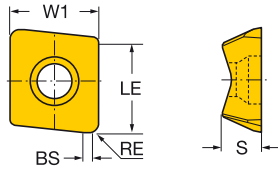
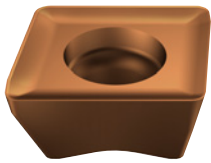
| | | | | | | | Dimensions, mm | | | | | | | | | |
|------|---------------------|-----|-----|-------------------|------|--------------------|--------------------|------|-------|-------|-----|------|------|------|-------------------|-------------------|
| DC | APMX _{FFW} | 10E | 10P | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | DCX | LF | LU | NM | KG | RPMX | CICT | MIID _E | MIID _P |
| 63.0 | 105.0 | 10E | 10P | 125 | 1 | 690-063HA12-10105H | 125.0 | 63.0 | 180.0 | 110.0 | 3.0 | 7.51 | 5000 | 4 | 690-100508M-E-SL | 690-100510M-P-SL |

| Spare parts | | | |
|--------------|--------------|-------------|--------------|
| DC | Insert screw | Plug screw | |
| 50.00-63.00 | 10 | 5513 020-68 | 3214 010-253 |
| 63.00-100.00 | 14 | 5513 020-55 | 3214 010-253 |

For complete list of spare parts, see www.sandvik.coromant.com
SANDVIK
Coromant

CoroMill® 690 insert for milling

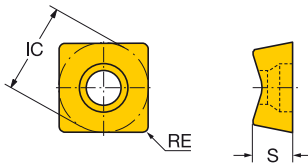
KRINS 90°



End insert

| | RE | Ordering code | S | | | | Dimensions, mm | | | | |
|-------------|-----|---------------|------------------|------|------|------|----------------|------|------|------|-----|
| | | | 1030 | 2040 | S30T | S40T | W1 | LE | S | BS | |
| Light SL | 10E | 0.80 | 690-100508M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | 1.20 | 690-100512M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | 1.60 | 690-100516M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | 2.00 | 690-100520M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | 3.10 | 690-100531M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | 14E | 0.80 | 690-140608M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | 1.20 | 690-140612M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | 1.60 | 690-140616M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | 2.00 | 690-140620M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | 2.40 | 690-140624M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | 3.10 | 690-140631M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | 5.00 | 690-140650M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 15.7 | 6.35 | 1.0 |
| | | 6.00 | 690-140660M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 16.5 | 6.35 | 1.0 |
| | | 6.35 | 690-140664M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 16.7 | 6.35 | 1.0 |

KRINS 90°



Peripheral insert

| | RE | Ordering code | S | | | | Dimensions, mm | | | |
|-------------|-----|---------------|------------------|------|------|------|----------------|------|------|------|
| | | | 1030 | 2040 | S30T | S40T | IC | LE | S | |
| Light SL | 10P | 1.00 | 690-100510M-P-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 9.0 | 5.20 |
| | 14P | 1.00 | 690-140610M-P-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 13.5 | 6.35 |



180



1154



1175



N23



N10

CoroMill® Century

Light cutting face mill for high speed finishing

Application

- Square shoulder milling
- Face milling

ISO application area:



Benefits and features

- High speed machining security by design
- Intensified chip evacuation through accelerated cutting fluid
- Easy setting to micro precision within 0.1 mm setting range
- High-alloy aluminium body with Arbor mounting
- Wiper insert option for high feed finishing



www.sandvik.coromant.com/coromillcentury

Couplings

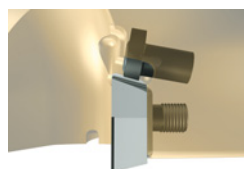
- Coromant Capto®
- Arbor
- HSK

Inserts

- One or two cutting edges
- Wide assortment of corner radii and chamfer
- Insert geometries and grades for all materials including PCD and CBN

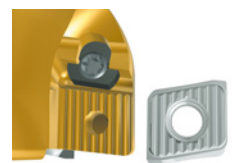
Micro setting

Micro precision setting of insert within 0.1 mm setting range on cassette solution.



Insert setting

Serrated insert location gives very high security against insert movement.



Macro setting

Macro setting of insert within 1 mm setting range.



184



187

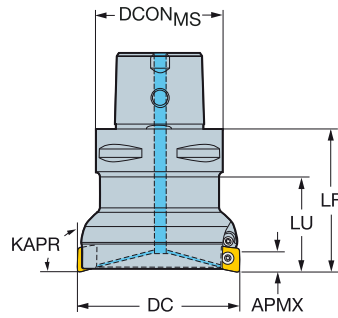


N6

CoroMill® Century square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|-------|------|---------------|--------------------|------|------|------|-----|------|-------|------|-------------|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | ZADJ | Ordering code | DCON _{MS} | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 40.0 | 11 | C3 | 11.00 | 3 | 3 | R590-040C3-11M | 32.0 | 55.0 | 40.0 | 3.0 | 0.65 | 48000 | 3 | R590-1105.. |
| 40.0 | 11 | C4 | 11.00 | 3 | 3 | R590-040C4-11M | 40.0 | 63.0 | 40.0 | 3.0 | 0.83 | 39000 | 3 | R590-1105.. |
| 50.0 | 11 | C5 | 11.00 | 3 | 4 | R590-050C5-11M | 50.0 | 63.0 | 40.0 | 3.0 | 1.38 | 28000 | 4 | R590-1105.. |
| 63.0 | 11 | C5 | 11.00 | 3 | 5 | R590-063C5-11M | 50.0 | 63.0 | 40.0 | 3.0 | 1.50 | 28000 | 5 | R590-1105.. |
| 80.0 | 11 | C6 | 11.00 | 3 | 6 | R590-080C6-11M | 63.0 | 71.0 | 40.0 | 3.0 | 2.38 | 20000 | 6 | R590-1105.. |

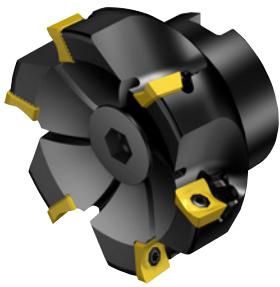
| Spare parts | | |
|--------------|----------------|----------------------|
| Insert screw | Setting device | Setting device screw |
| 5513 020-25 | 5513 014-021 | 5513 014-02 |

For complete list of spare parts, see www.sandvik.coromant.com

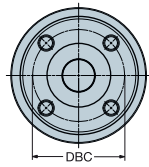


CoroMill® Century square shoulder milling cutter

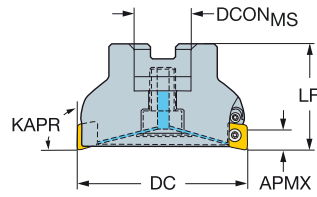
Arbor - Internal coolant supply



STDNO
KAPR



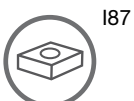
ISO6462
90°



| | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|---------------------|-------|------|---------------|--------------------|----------------|-----|-------|------|------|-------|-------|-------------|-------------|--|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | ZADJ | Ordering code | DCON _{MS} | ISO | DBC | LF | NM | KG | RPMX | CICT | MIID | | |
| 50.0 | 11 | 22 | 11.00 | 1 | 4 4 | R590-050Q22S-11M | 22.0 | A | 40.0 | 3.0 | 0.68 | 41600 | 4 | R590-1105.. | | |
| 63.0 | 11 | 22 | 11.00 | 1 | 5 5 | R590-063Q22S-11M | 22.0 | A | 40.0 | 3.0 | 0.81 | 35100 | 5 | R590-1105.. | | |
| 80.0 | 11 | 27 | 11.00 | 1 | 6 6 | R590-080Q27A-11M | 27.0 | A | 50.0 | 3.0 | 1.04 | 27500 | 6 | R590-1105.. | | |
| | 11 | 27 | 11.00 | 1 | 6 6 | R590-080Q27S-11M | 27.0 | A | 50.0 | 3.0 | 1.57 | 27500 | 6 | R590-1105.. | | |
| 100.0 | 11 | 32 | 11.00 | 1 | 6 6 | R590-100Q32A-11M | 32.0 | A | 50.0 | 3.0 | 1.37 | 23800 | 6 | R590-1105.. | | |
| | 11 | 32 | 11.00 | 1 | 6 6 | R590-100Q32S-11M | 32.0 | A | 50.0 | 3.0 | 2.21 | 23800 | 6 | R590-1105.. | | |
| 125.0 | 11 | 40 | 11.00 | 1 | 8 8 | R590-125Q40A-11M | 40.0 | B | 63.0 | 3.0 | 1.84 | 20700 | 8 | R590-1105.. | | |
| | 11 | 40 | 11.00 | 1 | 8 8 | R590-125Q40S-11M | 40.0 | B | 63.0 | 3.0 | 3.34 | 20700 | 8 | R590-1105.. | | |
| 160.0 | 11 | 40 | 11.00 | 1 | 10 10 | R590-160Q40A-11M | 40.0 | B | 63.0 | 3.0 | 2.74 | 17900 | 10 | R590-1105.. | | |
| | 11 | 40 | 11.00 | 1 | 10 10 | R590-160Q40S-11M | 40.0 | B | 63.0 | 3.0 | 5.65 | 17900 | 10 | R590-1105.. | | |
| 200.0 | 11 | 60 | 11.00 | 0 | 16 16 | R590-200Q60A-11M | 60.0 | C | 101.6 | 63.0 | 3.0 | 7.26 | 15700 | 16 | R590-1105.. | |
| | 11 | 60 | 11.00 | 0 | 16 16 | R590-200Q60S-11M | 60.0 | C | 101.6 | 63.0 | 3.0 | 12.00 | 15700 | 16 | R590-1105.. | |

| Spare parts | | | | | |
|---------------|----------------|--------------|----------------|----------------------|--|
| DC | Insert screw | Shower screw | Setting device | Setting device screw | |
| 50.00-63.00 | 11 5513 020-25 | 5512 087-01 | 5513 014-021 | 5513 014-02 | |
| 80.00 | 11 5513 020-25 | 5512 087-02 | 5513 014-021 | 5513 014-02 | |
| 100.00 | 11 5513 020-25 | 5512 087-03 | 5513 014-021 | 5513 014-02 | |
| 125.00-160.00 | 11 5513 020-25 | 5512 098-03 | 5513 014-021 | 5513 014-02 | |
| 200.00 | 11 5513 020-25 | | 5513 014-021 | 5513 014-02 | |

For complete list of spare parts, see www.sandvik.coromant.com



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L2



M1



N23



N9

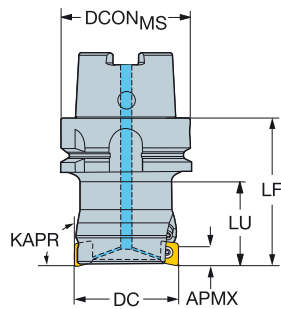


N15

CoroMill® Century square shoulder milling cutter

HSK - Internal coolant supply

KAPR 90°



| | | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|-------|-------|------------------|--------------------|----------------|------|------|-----|------|-------|------|-------------|--|
| DC | CZC _{MS} | APMX _{FFW} | CNSC | ZADJ | Ordering code | DCON _{MS} | ISO | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 40.0 | 11 | 63 | 11.00 | 1 3 3 | R590-040HA06-11M | 63.0 | A | 71.0 | 40.0 | 3.0 | 1.41 | 20000 | 3 | R590-1105.. | |
| 50.0 | 11 | 63 | 11.00 | 1 4 4 | R590-050HA06-11M | 63.0 | A | 71.0 | 40.0 | 3.0 | 1.58 | 20000 | 4 | R590-1105.. | |

| Spare parts | | |
|--------------|----------------|----------------------|
| Insert screw | Setting device | Setting device screw |
| 5513 020-25 | 5513 014-021 | 5513 014-02 |

For complete list of spare parts, see www.sandvik.coromant.com



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L2



N23



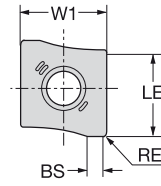
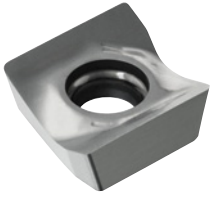
N9



N15

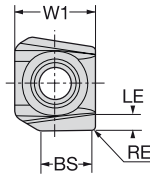
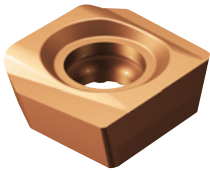
CoroMill® Century insert for milling

KRINS 90°



| | | RE | Ordering code | K | | | N | | H | | Dimensions, mm | | | |
|-------|----|----|---------------|-----------------|-----|-----|------|------|------|----|----------------|------|------|-----|
| | | | | 1020 | H10 | H10 | 1130 | 1130 | 1130 | W1 | LE | S | BS | |
| Light | KL | 11 | 0.80 | R590-110508H-KL | ★ | | | | | | 11.5 | 11.0 | 5.00 | 1.7 |
| | | 11 | 0.40 | R590-110504H-NL | | ☆ | ★ | | | | 11.5 | 11.0 | 5.00 | 2.0 |
| | | 11 | 0.80 | R590-110508H-PL | | | | | ☆ | | 11.5 | 11.0 | 5.00 | 1.7 |

KRINS 90°



TECHNOLOGY
Wiper

| | | RE | Ordering code | P | | M | | K | | N | | S | | H | | Dimensions, mm | | | | |
|-------|-----|----|---------------|------------------|------|------|------|------|-----|------|------|------|----|----|---|----------------|------|------|-----|-------|
| | | | | 1130 | 1130 | 1130 | 1020 | 1130 | H10 | 1130 | 1130 | 1130 | W1 | LE | S | BS | BSR | | | |
| Light | KTW | 11 | 0.40 | R590-110504H-KTW | | | | | | | | | | | | 11.5 | 11.0 | 5.00 | 7.0 | |
| | | 11 | 0.80 | R590-110508H-KW | | | | | | | | | | | | 11.5 | 11.0 | 5.00 | 7.0 | 500.0 |
| | | 11 | 0.40 | R590-110504H-NW | | | | | | | | | | | | 11.5 | 11.0 | 5.00 | 7.0 | 500.0 |
| | | 11 | 0.40 | R590-110504H-PTW | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 11.5 | 11.0 | 5.00 | 7.0 | |
| | | 11 | 0.80 | R590-110508H-PW | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 11.5 | 11.0 | 5.00 | 7.0 | 500.0 |

Make sure to choose working insert and wiper insert with the same RE/KCH values



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1175



N23



N6



N10

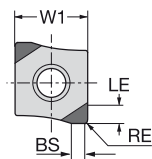
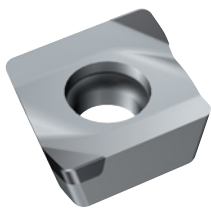


N2

CoroMill® Century insert for milling

Advanced cutting materials

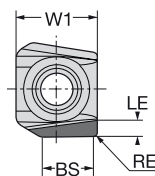
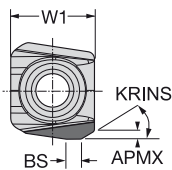
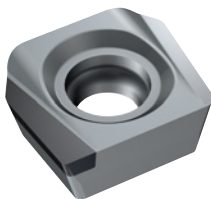
KRINS 90°



| | | RE | KCH | CHW | Ordering code | K | | H | | | | |
|--------|----|----|------|-----|---------------------|------|------|------|-----|------|-----|-------|
| | | | | | | CB50 | CB50 | W1 | LE | S | BS | BSR |
| Light | KL | 11 | 30° | 1.0 | L590-1105H-ZC2-KL | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 2.3 | 200.0 |
| | | | 60° | 1.5 | R590-1105H-ZC2-KL | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 2.3 | 200.0 |
| Medium | KM | 11 | 0.80 | | R590-110508H-PR2-KM | ☆ | ☆ | 11.5 | 2.0 | 5.00 | 1.5 | 25.0 |

KRINS 90°
R/L590..H-Z..-KW

90°
R590..PR2-KW



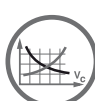
Wiper TECHNOLOGY

| | | RE | KCH | CHW | Ordering code | K | | H | | | | |
|-------|----|----|------|-----|---------------------|------|------|------|-----|------|-----|-------|
| | | | | | | CB50 | CB50 | W1 | LE | S | BS | BSR |
| Light | KW | 11 | 30° | 1.0 | L590-1105H-ZC2-KW | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 5.9 | 390.0 |
| | | | 60° | 1.5 | R590-1105H-ZC2-KW | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 5.9 | 390.0 |
| | NW | 11 | 0.80 | | R590-110508H-PR2-KW | ☆ | ☆ | 11.5 | 2.0 | 5.00 | 7.1 | 393.0 |

Make sure to choose working insert and wiper insert with the same RE/KCH values



I84



I154



I175



N23



N6



N10

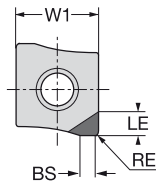


N2

CoroMill® Century insert for milling

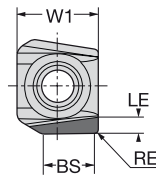
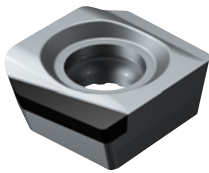
Advanced cutting materials

KRINS 90°



| | | N | | | | | Dimensions, mm | | | | |
|-------|------|-----|-----|-------------------|---------------|------|----------------|------|-----|-------|-----|
| Light | NL | RE | KCH | CHW | Ordering code | CD10 | W1 | LE | S | BS | BSR |
| | | | | | | | | | | | |
| | | 45° | 1.0 | R590-1105H-PC5-NL | ★ | 11.5 | 6.0 | 5.00 | 1.5 | 200.0 | |
| | 0.40 | | | R590-1105H-PR2-NL | ★ | 11.5 | 3.0 | 5.00 | 2.2 | 200.0 | |
| | 0.40 | | | R590-1105H-PR5-NL | ★ | 11.5 | 6.0 | 5.00 | 2.2 | 200.0 | |
| | | 45° | 0.3 | R590-1105H-PS2-NL | ★ | 11.5 | 3.0 | 5.00 | 2.2 | 200.0 | |
| | | 45° | 0.1 | R590-1105H-PS5-NL | ★ | 11.5 | 6.0 | 5.00 | 2.2 | 200.0 | |

KRINS 90°



Wiper TECHNOLOGY

| | | N | | | | | Dimensions, mm | | | | |
|-------|------|-----|-----|-------------------|---------------|------|----------------|------|-----|-------|-----|
| Light | NW | RE | KCH | CHW | Ordering code | CD10 | W1 | LE | S | BS | BSR |
| | | | | | | | | | | | |
| | 0.40 | | | R590-1105H-RR2-NW | ☆ | 11.5 | 3.0 | 5.00 | 6.8 | 500.0 | |
| | | 45° | 0.3 | R590-1105H-RS2-NW | ☆ | 11.5 | 3.0 | 5.00 | 7.0 | 500.0 | |

Make sure to choose working insert and wiper insert with the same RE/KCH values



184



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N23



N6







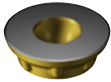




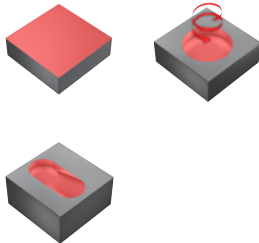
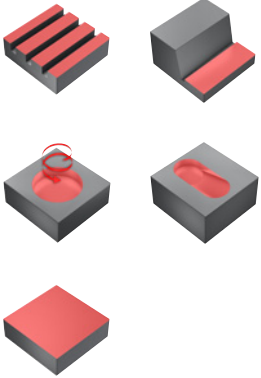
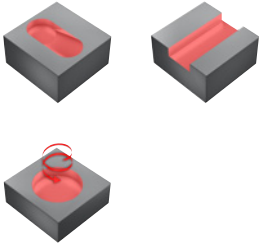


N10



N2

Profile milling tools

| | CoroMill® 300 | CoroMill® 200 | CoroMill® 216 |
|------------------|---|---|---|
| |  |  |  |
| Page | I91 | I100 | I105 |
| Material | P M K N S H | P M K N S H | P M K N S H |
| Main operation |  |  |  |
| KAPR | 0° | 0° | 90° |
| DC mm | 5 - 180 | 15 - 140 | 10 - 50 |
| DCX mm | 10 - 200 | 25 - 160 | 10 - 50 |
| APMX mm | 2.5 - 10 | 5 - 10 | 8.6 - 44.6 |
| Insert |  |  |  |
| Insert sizes | 05,07,08,10,12,16 & 20 | 10,12,16 & 20 | 10,12,16,20,25,30,32,40 & 50 |
| Couplings | Coromant Capto® Coromant EH Cylindrical Arbor Weldon Threaded coupling | Cylindrical shank Arbor | Coromant Capto® Cylindrical shank Coromant EH Threaded coupling Weldon |
| Internal coolant |  | |  |
| Options | | Shim protection tipseat | |
| Other operations |  |  |  |

CoroMill® 300

Light cutting face and profile milling cutters

Application

- Full slot milling
- Face milling
- Ramping
- Profiling
- Pocket milling

ISO application area:



Benefits and features

- Universal product with a wide application window
- Large assortment covering many applications
- Cutters with positive design have light cutting action and generates low cutting forces, which allows for extra close pitched face mill versions with small inserts for high productivity at high speeds combined with high table feeds
- End mills with great accessibility and cutting action in all feed directions for multi-axis machining of complicated forms



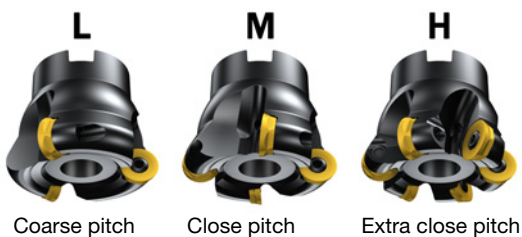
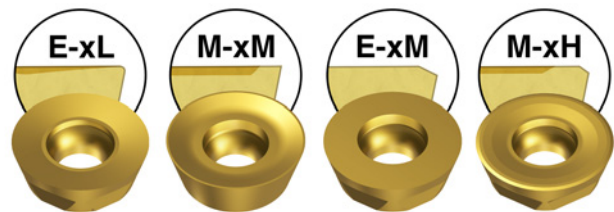
www.sandvik.coromant.com/coromill300

Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank
- Weldon
- Coromant EH
- Threaded couplings and grades for all materials

Inserts

- Insert geometries and grades for all materials



Specific insert indexing solution for size 20 inserts prevents insert movement and enables all cutting edges to be utilized.



192



199

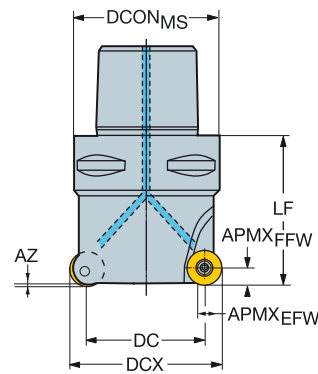
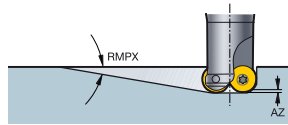


N6

CoroMill® 300 face milling cutter

Coromant Capto® - Internal coolant supply

Positive design



| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|-----|------|---------------|----------------|--------------------|----------------|------|------|------|-------|-------|-------------|-------------|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LF | NM | KG | RPMX | CICT | MIID | |
| 23.0 | 12 | C3 | 9.0 | 6.00 | 10° | 3.0 | 3 | R300-035C3-12M | 32.0 | 35.0 | 28.3 | 43.0 | 3.0 | 0.36 | 32900 | 3 | R300-1240.. | |
| | 12 | C3 | 9.0 | 6.00 | 10° | 3.0 | 3 | R300-035C3-12H | 32.0 | 35.0 | 28.3 | 43.0 | 3.0 | 0.30 | 32900 | 4 | R300-1240.. | |
| 25.0 | 10 | C3 | 7.5 | 5.00 | 7° | 2.3 | 3 | R300-035C3-10H | 32.0 | 35.0 | 29.1 | 40.0 | 3.0 | 0.36 | 43200 | 4 | R300-1032.. | |
| 27.0 | 08 | C3 | 6.0 | 4.00 | 4° | 1.9 | 3 | R300-035C3-08M | 32.0 | 35.0 | 30.3 | 40.0 | 1.2 | 0.31 | 33800 | 4 | R300-0828.. | |
| | 08 | C3 | 6.0 | 4.00 | 4° | 1.9 | 3 | R300-035C3-08H | 32.0 | 35.0 | 30.3 | 40.0 | 1.2 | 0.31 | 33800 | 5 | R300-0828.. | |
| 30.0 | 12 | C4 | 9.0 | 6.00 | 7° | 3.0 | 3 | R300-042C4-12M | 40.0 | 42.0 | 35.3 | 50.0 | 3.0 | 0.60 | 28300 | 3 | R300-1240.. | |
| | 12 | C4 | 9.0 | 6.00 | 7° | 3.0 | 3 | R300-042C4-12H | 40.0 | 42.0 | 35.3 | 50.0 | 3.0 | 0.58 | 28300 | 4 | R300-1240.. | |
| 32.0 | 10 | C4 | 7.5 | 5.00 | 5° | 2.3 | 3 | R300-042C4-10H | 40.0 | 42.0 | 36.1 | 50.0 | 3.0 | 0.58 | 37200 | 5 | R300-1032.. | |
| 34.0 | 08 | C4 | 6.0 | 4.00 | 3° | 1.9 | 3 | R300-042C4-08H | 40.0 | 42.0 | 37.3 | 50.0 | 1.2 | 0.40 | 29800 | 6 | R300-0828.. | |
| 36.0 | 16 | C5 | 12.0 | 8.00 | 7° | 3.8 | 3 | R300-052C5-16M | 50.0 | 52.0 | 40.9 | 60.0 | 5.0 | 1.04 | 20600 | 4 | R300-1648.. | |
| | 16 | C5 | 12.0 | 8.00 | 7° | 3.8 | 3 | R300-052C5-16H | 50.0 | 52.0 | 40.9 | 60.0 | 5.0 | 1.04 | 20600 | 5 | R300-1648.. | |
| 40.0 | 12 | C5 | 9.0 | 6.00 | 5° | 3.0 | 3 | R300-052C5-12M | 50.0 | 52.0 | 45.3 | 50.0 | 3.0 | 0.98 | 24400 | 4 | R300-1240.. | |
| | 12 | C5 | 9.0 | 6.00 | 5° | 3.0 | 3 | R300-052C5-12H | 50.0 | 52.0 | 45.3 | 50.0 | 3.0 | 0.99 | 24000 | 5 | R300-1240.. | |
| 44.0 | 08 | C5 | 6.0 | 4.00 | 2° | 1.9 | 3 | R300-052C5-08H | 50.0 | 52.0 | 47.3 | 50.0 | 1.2 | 1.00 | 26100 | 8 | R300-0828.. | |
| 46.0 | 20 | C6 | 15.0 | 10.00 | 9° | 6.0 | 3 | R300-066C6-20M | 63.0 | 66.0 | 60.0 | 80.0 | 7.5 | 1.88 | 18478 | 4 | R300-2060.. | |
| | 20 | C6 | 15.0 | 10.00 | 9° | 6.0 | 3 | R300-066C6-20H | 63.0 | 66.0 | 60.0 | 80.0 | 7.5 | 1.83 | 18478 | 5 | R300-2060.. | |
| 50.0 | 16 | C6 | 12.0 | 8.00 | 4° | 3.8 | 3 | R300-066C6-16M | 63.0 | 66.0 | 54.9 | 60.0 | 5.0 | 1.77 | 17600 | 5 | R300-1648.. | |
| | 16 | C6 | 12.0 | 8.00 | 4° | 3.8 | 3 | R300-066C6-16H | 63.0 | 66.0 | 54.9 | 60.0 | 5.0 | 1.75 | 17600 | 6 | R300-1648.. | |
| 54.0 | 12 | C6 | 9.0 | 6.00 | 3° | 3.0 | 3 | R300-066C6-12M | 63.0 | 66.0 | 59.3 | 50.0 | 3.0 | 1.65 | 21700 | 5 | R300-1240.. | |
| | 12 | C6 | 9.0 | 6.00 | 3° | 3.0 | 3 | R300-066C6-12H | 63.0 | 66.0 | 59.3 | 50.0 | 3.0 | 1.67 | 21700 | 7 | R300-1240.. | |
| 58.0 | 08 | C6 | 6.0 | 4.00 | 1° | 1.9 | 3 | R300-066C6-08H | 63.0 | 66.0 | 61.3 | 50.0 | 1.2 | 1.65 | 23100 | 10 | R300-0828.. | |
| 60.0 | 20 | C6 | 15.0 | 10.00 | 6° | 6.0 | 3 | R300-080C6-20M | 63.0 | 80.0 | 80.0 | 7.5 | 2.24 | 15622 | 5 | R300-2060.. | | |
| | 20 | C6 | 15.0 | 10.00 | 6° | 6.0 | 3 | R300-080C6-20H | 63.0 | 80.0 | 80.0 | 7.5 | 2.20 | 15622 | 6 | R300-2060.. | | |
| 64.0 | 16 | C6 | 12.0 | 8.00 | 3° | 3.8 | 3 | R300-080C6-16M | 63.0 | 80.0 | 68.9 | 60.0 | 5.0 | 2.02 | 15400 | 5 | R300-1648.. | |
| | 16 | C6 | 12.0 | 8.00 | 3° | 3.8 | 3 | R300-080C6-16H | 63.0 | 80.0 | 68.9 | 60.0 | 5.0 | 2.02 | 15400 | 7 | R300-1648.. | |
| 68.0 | 12 | C6 | 9.0 | 6.00 | 2° | 3.0 | 3 | R300-080C6-12M | 63.0 | 80.0 | 73.3 | 50.0 | 3.0 | 1.82 | 18900 | 6 | R300-1240.. | |
| | 12 | C6 | 9.0 | 6.00 | 2° | 3.0 | 3 | R300-080C6-12H | 63.0 | 80.0 | 73.3 | 50.0 | 3.0 | 1.72 | 18900 | 8 | R300-1240.. | |
| 72.0 | 08 | C6 | 6.0 | 4.00 | 1° | 1.9 | 3 | R300-080C6-08H | 63.0 | 80.0 | 75.3 | 50.0 | 1.2 | 1.84 | 20500 | 12 | R300-0828.. | |
| 80.0 | 20 | C8 | 15.0 | 10.00 | 4° | 6.0 | 3 | R300-100C8-20M | 80.0 | 100.0 | 80.0 | 7.5 | 3.72 | 12843 | 6 | R300-2060.. | | |
| | 20 | C8 | 15.0 | 10.00 | 4° | 6.0 | 3 | R300-100C8-20H | 80.0 | 100.0 | 80.0 | 7.5 | 3.48 | 12843 | 7 | R300-2060.. | | |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 08 | 5513 020-56 |
| 10 | 5513 020-09 |
| 12 | 5513 020-09 |
| 16 | 5513 020-50 |
| 20 | 5513 020-31 |

For complete list of spare parts, see www.sandvik.coromant.com



I99



L2



N23



N6



N9

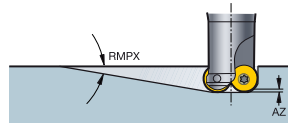


N15

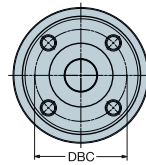
CoroMill® 300 face milling cutter

Arbor - Internal coolant supply

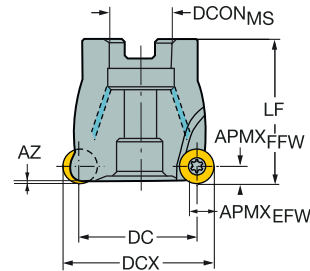
Positive design



STDNO



ISO6462



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|----|-------------------|---------------------|---------------------|------|-----|------|----|-----------------|--------------------|-----|-------|-------|------|------|-------|------|-------------|-------------|
| DC | | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | Ordering code | DCON _{MS} | ISO | DBC | DCX | LF | | | RPMX | CICT | MID |
| 32.0 | 08 | 16 | 6.0 | 4.00 | 3° | 1.9 | 1 | 5 | R300-040Q16-08M | 16.0 | A | 40.0 | 40.0 | 1.2 | 0.44 | 30800 | 5 | R300-0828.. | |
| | 08 | 16 | 6.0 | 4.00 | 3° | 1.9 | 1 | 6 | R300-040Q16-08H | 16.0 | A | 40.0 | 40.0 | 1.2 | 0.20 | 30800 | 6 | R300-0828.. | |
| 38.0 | 12 | 22 | 9.0 | 6.00 | 5° | 3.0 | 1 | 4 | R300-050Q22-12M | 22.0 | A | 50.0 | 50.0 | 3.0 | 0.44 | 25000 | 4 | R300-1240.. | |
| | 12 | 22 | 9.0 | 6.00 | 5° | 3.0 | 1 | 5 | R300-050Q22-12H | 22.0 | A | 50.0 | 50.0 | 3.0 | 0.40 | 25000 | 5 | R300-1240.. | |
| 40.0 | 12 | 22 | 9.0 | 6.00 | 5° | 3.0 | 1 | 4 | R300-052Q22-12M | 22.0 | A | 52.0 | 50.0 | 3.0 | 0.79 | 24400 | 4 | R300-1240.. | |
| | 12 | 22 | 9.0 | 6.00 | 5° | 3.0 | 1 | 5 | R300-052Q22-12H | 22.0 | A | 52.0 | 50.0 | 3.0 | 0.46 | 24400 | 5 | R300-1240.. | |
| 42.0 | 08 | 22 | 6.0 | 4.00 | 2° | 1.9 | 1 | 8 | R300-050Q22-08H | 22.0 | A | 50.0 | 50.0 | 1.2 | 0.45 | 26700 | 8 | R300-0828.. | |
| 44.0 | 08 | 22 | 6.0 | 4.00 | 2° | 1.9 | 1 | 8 | R300-052Q22-08H | 22.0 | A | 52.0 | 50.0 | 1.2 | 0.85 | 26100 | 8 | R300-0828.. | |
| 47.0 | 16 | 22 | 12.0 | 8.00 | 5° | 3.8 | 1 | 4 | R300-063Q22-16M | 22.0 | A | 63.0 | 50.0 | 5.0 | 0.72 | 18200 | 4 | R300-1648.. | |
| | 16 | 22 | 12.0 | 8.00 | 5° | 3.8 | 1 | 6 | R300-063Q22-16H | 22.0 | A | 63.0 | 50.0 | 5.0 | 0.86 | 18200 | 6 | R300-1648.. | |
| 51.0 | 12 | 22 | 9.0 | 6.00 | 3° | 3.0 | 1 | 4 | R300-063Q22-12L | 22.0 | A | 63.0 | 50.0 | 3.0 | 0.97 | 22100 | 4 | R300-1240.. | |
| | 12 | 22 | 9.0 | 6.00 | 3° | 3.0 | 1 | 5 | R300-063Q22-12M | 22.0 | A | 63.0 | 50.0 | 3.0 | 0.60 | 22100 | 5 | R300-1240.. | |
| | 12 | 22 | 9.0 | 6.00 | 3° | 3.0 | 1 | 7 | R300-063Q22-12H | 22.0 | A | 63.0 | 50.0 | 3.0 | 0.57 | 22100 | 7 | R300-1240.. | |
| 55.0 | 08 | 22 | 6.0 | 4.00 | 1° | 1.9 | 1 | 10 | R300-063Q22-08H | 22.0 | A | 63.0 | 50.0 | 1.2 | 0.82 | 23700 | 10 | R300-0828.. | |
| 60.0 | 20 | 27 | 15.0 | 10.00 | 6° | 6.0 | 1 | 5 | R300-080Q27-20M | 27.0 | A | 80.0 | 50.0 | 7.5 | 0.95 | 15622 | 5 | R300-2060.. | |
| | 20 | 27 | 15.0 | 10.00 | 6° | 6.0 | 1 | 6 | R300-080Q27-20H | 27.0 | A | 80.0 | 50.0 | 7.5 | 1.07 | 15622 | 6 | R300-2060.. | |
| 64.0 | 16 | 27 | 12.0 | 8.00 | 3° | 3.8 | 1 | 5 | R300-080Q27-16M | 27.0 | A | 80.0 | 50.0 | 5.0 | 0.98 | 15400 | 5 | R300-1648.. | |
| | 16 | 27 | 12.0 | 8.00 | 3° | 3.8 | 1 | 7 | R300-080Q27-16H | 27.0 | A | 80.0 | 50.0 | 5.0 | 1.15 | 15400 | 7 | R300-1648.. | |
| 68.0 | 12 | 27 | 9.0 | 6.00 | 2° | 3.0 | 1 | 6 | R300-080Q27-12M | 27.0 | A | 80.0 | 50.0 | 3.0 | 0.90 | 18900 | 6 | R300-1240.. | |
| | 12 | 27 | 9.0 | 6.00 | 2° | 3.0 | 1 | 8 | R300-080Q27-12H | 27.0 | A | 80.0 | 50.0 | 3.0 | 1.06 | 18900 | 8 | R300-1240.. | |
| 72.0 | 08 | 27 | 6.0 | 4.00 | 1° | 1.9 | 1 | 12 | R300-080Q27-08H | 27.0 | A | 80.0 | 50.0 | 1.2 | 1.31 | 20500 | 12 | R300-0828.. | |
| 80.0 | 20 | 32 | 15.0 | 10.00 | 4° | 6.0 | 1 | 5 | R300-100Q32-20L | 32.0 | A | 100.0 | 63.0 | 7.5 | 2.46 | 12843 | 5 | R300-2060.. | |
| | 20 | 32 | 15.0 | 10.00 | 4° | 6.0 | 1 | 6 | R300-100Q32-20M | 32.0 | A | 100.0 | 63.0 | 7.5 | 2.40 | 12843 | 6 | R300-2060.. | |
| | 20 | 32 | 15.0 | 10.00 | 4° | 6.0 | 1 | 7 | R300-100Q32-20H | 32.0 | A | 100.0 | 63.0 | 7.5 | 2.41 | 12843 | 7 | R300-2060.. | |
| 84.0 | 16 | 32 | 12.0 | 8.00 | 2° | 3.8 | 1 | 6 | R300-100Q32-16M | 32.0 | A | 100.0 | 50.0 | 5.0 | 1.68 | 13300 | 6 | R300-1648.. | |
| | 16 | 32 | 12.0 | 8.00 | 2° | 3.8 | 1 | 8 | R300-100Q32-16H | 32.0 | A | 100.0 | 50.0 | 5.0 | 1.67 | 13300 | 8 | R300-1648.. | |
| 105.0 | 20 | 40 | 15.0 | 10.00 | 3° | 6.0 | 1 | 7 | R300-125Q40-20M | 40.0 | B | 125.0 | 63.0 | 7.5 | 3.03 | 10768 | 7 | R300-2060.. | |
| | 20 | 40 | 15.0 | 10.00 | 3° | 6.0 | 1 | 9 | R300-125Q40-20H | 40.0 | B | 125.0 | 63.0 | 7.5 | 2.93 | 10768 | 9 | R300-2060.. | |
| 109.0 | 16 | 32 | 12.0 | 8.00 | 1° | 3.8 | 1 | 8 | R300-125Q32-16M | 32.0 | A | 125.0 | 63.0 | 5.0 | 2.55 | 11900 | 8 | R300-1648.. | |
| | 16 | 32 | 12.0 | 8.00 | 1° | 3.8 | 1 | 10 | R300-125Q32-16H | 32.0 | A | 125.0 | 63.0 | 5.0 | 2.88 | 11900 | 10 | R300-1648.. | |
| 140.0 | 20 | 40 | 15.0 | 10.00 | 2° | 6.0 | 1 | 9 | R300-160Q40-20M | 40.0 | B | 160.0 | 63.0 | 7.5 | 4.93 | 9106 | 9 | R300-2060.. | |
| | 20 | 40 | 15.0 | 10.00 | 2° | 6.0 | 1 | 11 | R300-160Q40-20H | 40.0 | B | 160.0 | 63.0 | 7.5 | 4.83 | 9106 | 11 | R300-2060.. | |
| 180.0 | 20 | 60 | 15.0 | 10.00 | 1° | 6.0 | 0 | 11 | R300-200Q60-20M | 60.0 | C | 101.6 | 200.0 | 63.0 | 7.5 | 11.20 | 7799 | 11 | R300-2060.. |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 08 | 5513 020-56 |
| 12 | 5513 020-09 |
| 16 | 5513 020-50 |
| 20 | 5513 020-31 |

For complete list of spare parts, see www.sandvik.coromant.com



199



L2



M1



N23



N6



N9

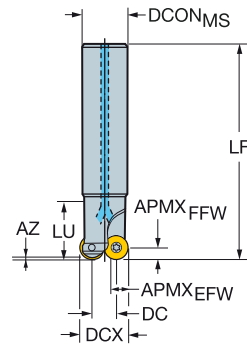
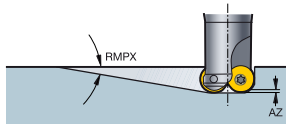


N15

CoroMill® 300 face milling cutter

Cylindrical shank - Internal coolant supply

Positive design



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|------|-------------------|--------------------|--------------------|------|-----|------|---------------|---|--------------------|----------------|------|------|------|-------|-----|------|------|------|-------------|
| DC | CZC _{MS} | APM _{EFW} | APM _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID | |
| 15.0 | 10 | 20 | 7.5 | 5.00 | 13° | 2.3 | 1 | 2 | R300-025A20-10M | 20.0 | 25.0 | 19.1 | 33.0 | 150.0 | 3.0 | 0.50 | 2850 | 2 | R300-1032.. |
| 17.0 | 08 | 20 | 6.0 | 4.00 | 8° | 1.9 | 1 | 3 | R300-025A20-08M | 20.0 | 25.0 | 20.3 | 25.0 | 150.0 | 1.2 | 0.44 | 7200 | 3 | R300-0828.. |
| 20.0 | 12 | 25 | 9.0 | 6.00 | 12° | 3.0 | 1 | 2 | R300-032A25-12M | 25.0 | 32.0 | 25.3 | 25.0 | 190.0 | 3.0 | 0.82 | 8900 | 2 | R300-1240.. |
| | 12 | 25 | 9.0 | 6.00 | 12° | 3.0 | 1 | 3 | R300-032A25-12H | 25.0 | 32.0 | 25.3 | 25.0 | 150.0 | 3.0 | 0.65 | 3550 | 3 | R300-1240.. |
| 22.0 | 10 | 25 | 7.5 | 5.00 | 7° | 2.3 | 1 | 3 | R300-032A25-10M | 25.0 | 32.0 | 26.1 | 25.0 | 190.0 | 3.0 | 0.82 | 1470 | 3 | R300-1032.. |
| | 10 | 25 | 7.5 | 5.00 | 7° | 2.3 | 1 | 4 | R300-032A25-10H | 25.0 | 32.0 | 26.1 | 25.0 | 150.0 | 3.0 | 0.70 | 2850 | 4 | R300-1032.. |
| 24.0 | 08 | 25 | 6.0 | 4.00 | 5° | 1.9 | 1 | 4 | R300-032A25-08M | 25.0 | 32.0 | 27.3 | 25.0 | 190.0 | 1.2 | 0.79 | 9000 | 4 | R300-0828.. |
| | 08 | 25 | 6.0 | 4.00 | 5° | 1.9 | 1 | 5 | R300-032A25-08H | 25.0 | 32.0 | 27.3 | 25.0 | 150.0 | 1.2 | 0.61 | 3590 | 5 | R300-0828.. |
| 28.0 | 12 | 32 | 9.0 | 6.00 | 8° | 3.0 | 1 | 3 | R300-040A32-12M | 32.0 | 40.0 | 33.3 | 25.0 | 250.0 | 3.0 | 1.78 | 1140 | 3 | R300-1240.. |
| | 12 | 32 | 9.0 | 6.00 | 8° | 3.0 | 1 | 4 | R300-040A32-12H | 32.0 | 40.0 | 33.3 | 25.0 | 150.0 | 3.0 | 1.01 | 2850 | 4 | R300-1240.. |

| | | Spare parts |
|-------------|----|--------------|
| DC | | Insert screw |
| 17.00-24.00 | 08 | 5513 020-56 |
| 15.00 | 10 | 5513 020-43 |
| 22.00 | 10 | 5513 020-09 |
| 20.00-28.00 | 12 | 5513 020-09 |

For complete list of spare parts, see www.sandvik.coromant.com



I99



L2



N23



N6



N9

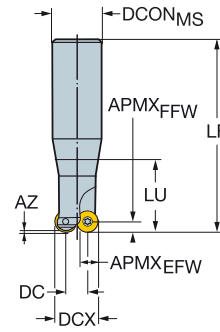
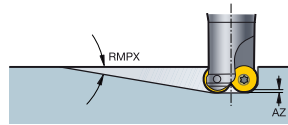


N15

CoroMill® 300 face milling cutter

Cylindrical shank

Neutral design



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|-----|-----|--------------------|--------------------|------|----------------|------|-------|------|-----|------|-------|------|-------------|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | AZ | Ordering code | DCON _{MS} | DCX | BD | LB | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 5.0 | 05 | 16 | 3.8 | 2.50 | 20° | 1.8 | 2 R300-010A16L-05L | 16.0 | 10.0 | 9.1 | 18.0 | 160.0 | 25.4 | 0.6 | 0.32 | 15900 | 2 | R300-0517.. | |
| | 07 20 | 16 | 5.3 | 3.50 | 20° | 1.0 | 2 R300-012A16L-07L | 16.0 | 12.0 | 10.4 | 21.0 | 200.0 | 37.8 | 0.9 | 0.38 | 8900 | 2 | R300-0720.. | |
| 8.0 | 07 24 | 20 | 5.3 | 3.50 | 20° | 0.9 | 2 R300-015A20L-07L | 20.0 | 15.0 | 13.4 | 25.0 | 200.0 | 43.8 | 0.9 | 0.54 | 12700 | 2 | R300-0724.. | |
| | 08 | 20 | 6.0 | 4.00 | 20° | 1.8 | 2 R300-016A20L-08L | 20.0 | 16.0 | 14.1 | 25.0 | 200.0 | 51.9 | 1.2 | 0.54 | 12700 | 2 | R300-0828.. | |
| 10.0 | 10 | 25 | 7.5 | 5.00 | 20° | 3.4 | 2 R300-020A25L-10L | 25.0 | 20.0 | 18.1 | 30.0 | 250.0 | 48.8 | 3.0 | 0.87 | 8100 | 2 | R300-1032.. | |
| 12.0 | 12 | 25 | 9.0 | 6.00 | 20° | 2.7 | 2 R300-024A25L-12L | 25.0 | 24.0 | 22.1 | 30.0 | 250.0 | 76.0 | 3.0 | 1.20 | 8900 | 2 | R300-1240.. | |
| 13.0 | 12 | 32 | 9.0 | 6.00 | 20° | 1.4 | 2 R300-025A32L-12L | 32.0 | 25.0 | 23.1 | 30.0 | 250.0 | 42.9 | 3.0 | 1.69 | 15800 | 2 | R300-1240.. | |
| 16.0 | 16 | 32 | 12.0 | 8.00 | 20° | 4.8 | 2 R300-032A32L-16L | 32.0 | 32.0 | 29.0 | 40.0 | 250.0 | 72.2 | 5.0 | 1.76 | 8700 | 2 | R300-1648.. | |

| | | Spare parts |
|-------------|-------|--------------|
| DC | | Insert screw |
| 5.00 | 05 | 5513 020-40 |
| 5.00 | 07 20 | 5513 020-41 |
| 8.00 | 07 24 | 5513 020-42 |
| 8.00 | 08 | 5513 020-36 |
| 10.00 | 10 | 5513 020-43 |
| 12.00-13.00 | 12 | 5513 020-39 |
| 16.00 | 16 | 5513 020-50 |

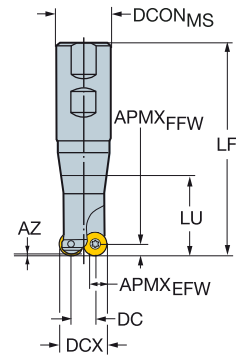
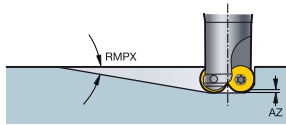
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 300 face milling cutter

Weldon

Neutral design



| | | | | | | | | | | Dimensions, mm | | | | | | | | | | |
|------|-------------------|--------------------|--------------------|------|-----|-----|---------------|--------------------|------|----------------|------|------|------|-------|------|-----|------|-------|------|-------------|
| DC | CZC _{MS} | APM _{EFW} | APM _{FFW} | RMPX | AZ | | Ordering code | DCON _{MS} | ISO | DCX | BD | LB | LF | LU | NM | KG | RPMX | CICT | MIID | |
| 5.0 | 07 20 | 16 | 5.3 | 3.50 | 20° | 1.0 | 2 | R300-012B16L-07L | 16.0 | WE | 12.0 | 10.4 | 21.0 | 109.0 | 37.6 | 0.9 | 0.24 | 34000 | 2 | R300-0720.. |
| 8.0 | 07 24 | 20 | 5.3 | 3.50 | 20° | 0.9 | 2 | R300-015B20L-07L | 20.0 | WE | 15.0 | 13.4 | 25.0 | 131.0 | 43.6 | 0.9 | 0.38 | 25000 | 2 | R300-0724.. |
| | 08 | 20 | 6.0 | 4.00 | 20° | 1.8 | 2 | R300-016B20L-08L | 20.0 | WE | 16.0 | 14.1 | 25.0 | 131.0 | 51.6 | 1.2 | 0.38 | 24700 | 2 | R300-0828.. |
| 10.0 | 10 | 25 | 7.5 | 5.00 | 20° | 3.4 | 2 | R300-020B25L-10L | 25.0 | WE | 20.0 | 18.1 | 30.0 | 137.0 | 48.4 | 3.0 | 0.58 | 34000 | 2 | R300-1032.. |
| 13.0 | 12 | 32 | 9.0 | 6.00 | 20° | 1.4 | 2 | R300-025B32L-12L | 32.0 | WE | 25.0 | 23.1 | 30.0 | 141.0 | 42.8 | 3.0 | 0.82 | 20200 | 2 | R300-1240.. |

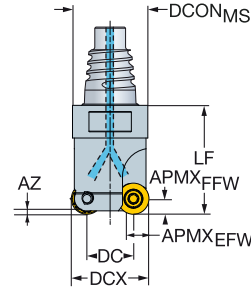
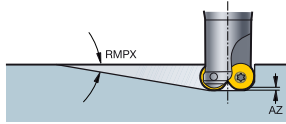
| Spare parts | | |
|-------------|-------|--------------|
| DC | | Insert screw |
| 5.00 | 07 20 | 5513 020-41 |
| 8.00 | 07 24 | 5513 020-42 |
| 8.00 | 08 | 5513 020-36 |
| 10.00 | 10 | 5513 020-43 |
| 13.00 | 12 | 5513 020-39 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 300 face milling cutter

Coromant EH - Internal coolant supply



Neutral design

| | | | | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|------|------|---------------|---|--------------------|-----------------|------|------|------|------|------|------|-------|-------|-------------|-------------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID | | |
| 5.0 | 05 | E10 | 3.8 | 2.50 | 20° | 1.8 | 1 | 2 | R300-10EH10-05L | 9.7 | 10.0 | 9.0 | 13.1 | 20.0 | 0.6 | 0.06 | 20000 | 2 | R300-0517.. | |
| | 07 | 20 | E12 | 5.3 | 3.50 | 20° | 1.0 | 1 | 2 | R300-12EH12-07L | 11.7 | 12.0 | 10.3 | 17.5 | 25.0 | 0.9 | 0.07 | 20000 | 2 | R300-0720.. |
| 7.0 | 05 | E12 | 3.8 | 2.50 | 10° | 1.0 | 1 | 3 | R300-12EH12-05M | 11.7 | 12.0 | 11.0 | 12.5 | 20.0 | 0.6 | 0.10 | 20000 | 3 | R300-0517.. | |
| 8.0 | 07 | 20 | E12 | 5.3 | 3.50 | 20° | 1.1 | 1 | 3 | R300-15EH12-07M | 11.7 | 15.0 | 13.3 | 17.5 | 25.0 | 0.9 | 0.10 | 20000 | 3 | R300-0720.. |
| | 07 | 24 | E12 | 5.3 | 3.50 | 20° | 0.9 | 1 | 2 | R300-15EH12-07L | 11.7 | 15.0 | 13.3 | 17.5 | 25.0 | 0.9 | 0.10 | 20000 | 2 | R300-0724.. |
| | 08 | E16 | 6.0 | 4.00 | 20° | 1.8 | 1 | 2 | R300-16EH16-08L | 15.5 | 16.0 | 14.0 | 21.3 | 30.0 | 1.2 | 0.09 | 20000 | 2 | R300-0828.. | |
| 9.0 | 07 | 20 | E16 | 5.3 | 3.50 | 15° | 0.9 | 1 | 3 | R300-16EH16-07M | 15.5 | 16.0 | 14.3 | 16.3 | 25.0 | 0.9 | 0.11 | 20000 | 3 | R300-0720.. |
| 10.0 | 10 | E20 | 7.5 | 5.00 | 20° | 3.4 | 1 | 2 | R300-20EH20-10L | 19.3 | 20.0 | 18.0 | 25.0 | 35.0 | 3.0 | 0.12 | 20000 | 2 | R300-1032.. | |
| 12.0 | 08 | E20 | 6.0 | 4.00 | 12° | 1.5 | 1 | 3 | R300-20EH20-08M | 19.3 | 20.0 | 18.0 | 20.0 | 30.0 | 1.2 | 0.13 | 20000 | 3 | R300-0828.. | |
| | 12 | E20 | 9.0 | 6.00 | 20° | 2.7 | 1 | 2 | R300-24EH20-12L | 19.3 | 24.0 | 22.0 | 25.0 | 35.0 | 3.0 | 0.17 | 15000 | 2 | R300-1240.. | |
| 15.0 | 10 | E25 | 7.5 | 5.00 | 15° | 1.1 | 1 | 2 | R300-25EH25-10L | 24.2 | 25.0 | 23.0 | 24.5 | 35.0 | 3.0 | 0.20 | 15000 | 2 | R300-1032.. | |
| | 10 | E25 | 7.5 | 5.00 | 15° | 1.3 | 1 | 3 | R300-25EH25-10M | 24.2 | 25.0 | 23.0 | 24.5 | 35.0 | 3.0 | 0.19 | 15000 | 3 | R300-1032.. | |
| 16.0 | 16 | E25 | 12.0 | 8.00 | 20° | 4.8 | 1 | 2 | R300-32EH25-16L | 24.2 | 32.0 | 28.9 | 29.5 | 40.0 | 5.0 | 0.23 | 15000 | 2 | R300-1648.. | |
| 20.0 | 12 | E25 | 9.0 | 6.00 | 15° | 1.4 | 1 | 3 | R300-32EH25-12M | 24.2 | 32.0 | 30.0 | 24.5 | 35.0 | 3.0 | 0.21 | 15000 | 3 | R300-1240.. | |
| 22.0 | 10 | E25 | 7.5 | 5.00 | 10° | 1.7 | 1 | 4 | R300-32EH25-10H | 24.2 | 32.0 | 30.0 | 24.5 | 35.0 | 3.0 | 0.23 | 15000 | 4 | R300-1032.. | |

Positive design

| | | | | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|----|------|---------------|---|--------------------|------|------|------|------|------|-----|------|-------|------|-------------|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID | | |
| 17.0 | 08 | E25 | 6.0 | 4.00 | 5° | 0.6 | 1 | 3 | R300-25EH25-08M | 24.2 | 25.0 | 20.3 | 24.5 | 35.0 | 1.2 | 0.17 | 15000 | 3 | R300-0828.. | |
| 24.0 | 08 | E25 | 6.0 | 4.00 | 5° | 2.0 | 1 | 4 | R300-32EH25-08M | 24.2 | 32.0 | 27.3 | 24.5 | 35.0 | 1.2 | 0.21 | 15000 | 4 | R300-0828.. | |
| | 08 | E25 | 6.0 | 4.00 | 5° | 2.0 | 1 | 5 | R300-32EH25-08H | 24.2 | 32.0 | 27.3 | 24.5 | 35.0 | 1.2 | 0.20 | 15000 | 5 | R300-0828.. | |

Neutral design

| | | Spare parts |
|-------------|-------|--------------|
| DC | | Insert screw |
| 5.00-9.00 | 07 20 | 5513 020-41 |
| 8.00 | 07 24 | 5513 020-42 |
| 5.00-7.00 | 05 | 5513 020-40 |
| 8.00-12.00 | 08 | 5513 020-36 |
| 10.00-22.00 | 10 | 5513 020-43 |
| 12.00-20.00 | 12 | 5513 020-39 |
| 16.00 | 16 | 5513 020-50 |

Positive design

| Spare parts |
|--------------|
| Insert screw |
| 5513 020-56 |

For complete list of spare parts, see www.sandvik.coromant.com



199



L2



N23



N6



N9



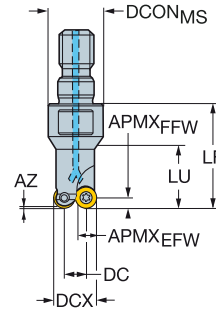
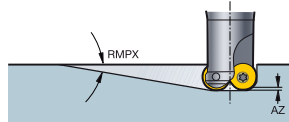
N15



N3

CoroMill® 300 face milling cutter

Threaded coupling - Internal coolant supply



Neutral design

| | | | | | | | | | | Dimensions, mm | | | | | | | | | | |
|------|-------------------|--------------------|--------------------|------|-----|------|---|---------------|----------------|--------------------|------|------|------|------|------|-----|------|------|------|-------------|
| DC | CZC _{MS} | APM _{EFW} | APM _{FFW} | RMPX | AZ | CNSC | | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | LU | NM | KG | RPMX | CICT | MIID |
| 5.0 | 07 20 | M8 | 5.3 | 3.50 | 20° | 1.0 | 0 | 2 | R300-12T08-07L | 12.8 | 12.0 | 10.4 | 21.0 | 25.0 | 17.3 | 0.9 | 0.09 | 9100 | 2 | R300-0720.. |
| 7.0 | 05 | M8 | 3.8 | 2.50 | 10° | 1.0 | 0 | 3 | R300-12T08-05M | 12.8 | 12.0 | 11.1 | 18.0 | 25.0 | | 0.6 | 0.05 | 9100 | 3 | R300-0517.. |
| 8.0 | 07 24 | M8 | 5.3 | 3.50 | 20° | 0.9 | 0 | 2 | R300-15T08-07L | 12.8 | 15.0 | 13.4 | | 25.0 | | 0.9 | 0.10 | 9100 | 2 | R300-0724.. |
| | 08 | M8 | 6.0 | 4.00 | 20° | 1.8 | 0 | 2 | R300-16T08-08L | 12.8 | 16.0 | 14.0 | | 25.0 | | 1.2 | 0.05 | 9100 | 2 | R300-0828.. |
| 10.0 | 10 | M10 | 7.5 | 5.00 | 20° | 3.4 | 1 | 2 | R300-20T10-10L | 17.8 | 20.0 | 18.1 | | 30.0 | | 3.0 | 0.09 | 9100 | 2 | R300-1032.. |
| 12.0 | 08 | M10 | 6.0 | 4.00 | 12° | 1.5 | 1 | 3 | R300-20T10-08M | 17.8 | 20.0 | 18.1 | | 30.0 | | 1.2 | 0.03 | 9100 | 3 | R300-0828.. |
| | 12 | M12 | 9.0 | 6.00 | 20° | 2.7 | 1 | 2 | R300-24T12-12L | 20.8 | 24.0 | 22.1 | | 35.0 | | 3.0 | 0.18 | 9100 | 2 | R300-1240.. |
| 15.0 | 10 | M12 | 7.5 | 5.00 | 15° | 1.1 | 1 | 2 | R300-25T12-10L | 20.8 | 25.0 | 23.1 | | 35.0 | | 3.0 | 0.16 | 9100 | 2 | R300-1032.. |
| | 10 | M12 | 7.5 | 5.00 | 15° | 1.3 | 1 | 3 | R300-25T12-10M | 20.8 | 25.0 | 23.1 | | 35.0 | | 3.0 | 0.20 | 9100 | 3 | R300-1032.. |
| 20.0 | 12 | M16 | 9.0 | 6.00 | 15° | 1.4 | 1 | 3 | R300-32T16-12M | 28.8 | 32.0 | 30.1 | | 45.0 | | 3.0 | 0.31 | 9100 | 3 | R300-1240.. |
| 22.0 | 10 | M16 | 7.5 | 5.00 | 10° | 1.7 | 1 | 4 | R300-32T16-10H | 28.8 | 32.0 | 30.1 | | 45.0 | | 3.0 | 0.33 | 9100 | 4 | R300-1032.. |
| 23.0 | 12 | M16 | 9.0 | 6.00 | 16° | 5.0 | 1 | 3 | R300-35T16-12M | 28.8 | 35.0 | 33.1 | | 45.0 | | 3.0 | 0.34 | 9100 | 3 | R300-1240.. |
| 25.0 | 10 | M16 | 7.5 | 5.00 | 10° | 3.6 | 1 | 4 | R300-35T16-10H | 28.8 | 35.0 | 33.1 | | 45.0 | | 3.0 | 0.38 | 9100 | 4 | R300-1032.. |
| 28.0 | 12 | M16 | 9.0 | 6.00 | 13° | 5.0 | 1 | 4 | R300-40T16-12M | 28.8 | 40.0 | 38.1 | | 45.0 | | 3.0 | 0.35 | 9100 | 4 | R300-1240.. |
| 30.0 | 10 | M16 | 7.5 | 5.00 | 8° | 3.6 | 1 | 5 | R300-40T16-10H | 28.8 | 40.0 | 38.1 | | 45.0 | | 3.0 | 0.37 | 9100 | 5 | R300-1032.. |
| | 12 | M16 | 9.0 | 6.00 | 12° | 5.0 | 1 | 4 | R300-42T16-12M | 28.8 | 42.0 | 40.1 | | 45.0 | | 3.0 | 0.04 | 9100 | 4 | R300-1240.. |
| 32.0 | 10 | M16 | 7.5 | 5.00 | 7° | 3.6 | 1 | 5 | R300-42T16-10H | 28.8 | 42.0 | 40.1 | | 45.0 | | 3.0 | 0.41 | 9100 | 5 | R300-1032.. |

Positive design

| | | | | | | | | | | Dimensions, mm | | | | | | | | | | |
|------|-------------------|--------------------|--------------------|------|----|------|---|---------------|----------------|--------------------|------|------|------|------|----|-----|------|------|------|-------------|
| DC | CZC _{MS} | APM _{EFW} | APM _{FFW} | RMPX | AZ | CNSC | | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | LU | NM | KG | RPMX | CICT | MIID |
| 17.0 | 08 | M12 | 6.0 | 4.00 | 8° | 1.9 | 1 | 3 | R300-25T12-08M | 20.8 | 25.0 | 20.3 | 18.0 | 35.0 | | 1.2 | 0.18 | 9100 | 3 | R300-0828.. |
| 24.0 | 08 | M16 | 6.0 | 4.00 | 5° | 1.9 | 1 | 4 | R300-32T16-08M | 28.8 | 32.0 | 27.3 | 28.0 | 45.0 | | 1.2 | 0.30 | 9100 | 4 | R300-0828.. |
| | 08 | M16 | 6.0 | 4.00 | 5° | 1.9 | 1 | 5 | R300-32T16-08H | 28.8 | 32.0 | 27.3 | 28.0 | 45.0 | | 1.2 | 0.30 | 9100 | 5 | R300-0828.. |
| 32.0 | 08 | M16 | 6.0 | 4.00 | 3° | 1.9 | 1 | 6 | R300-40T16-08H | 28.8 | 40.0 | 35.3 | 28.0 | 45.0 | | 1.2 | 0.38 | 9100 | 6 | R300-0828.. |

Neutral design

| | | Spare parts |
|-------------|-------|--------------|
| DC | | Insert screw |
| 5.00 | 07 20 | 5513 020-41 |
| 8.00 | 07 24 | 5513 020-42 |
| 7.00 | 05 | 5513 020-40 |
| 8.00-12.00 | 08 | 5513 020-36 |
| 10.00-32.00 | 10 | 5513 020-43 |
| 12.00-30.00 | 12 | 5513 020-39 |

Positive design

| Spare parts |
|--------------|
| Insert screw |
| 5513 020-56 |

For complete list of spare parts, see www.sandvik.coromant.com



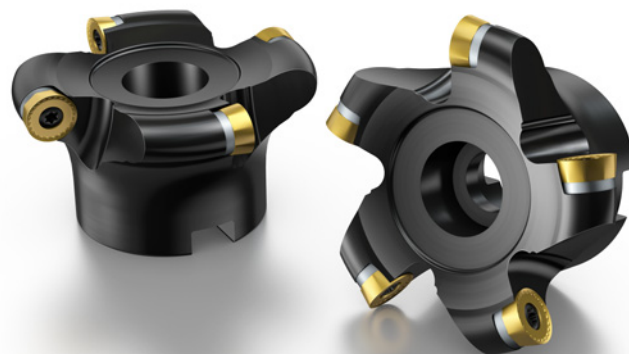
CoroMill® 200

Robust face milling and profile cutter

Application

- Full slot milling
- Face milling
- Ramping
- Profiling
- Pocket milling

ISO application area:



Benefits and features

- Process security and reliability
- High metal removal rate
- Shim protection available

www.sandvik.coromant.com/coromill200

Couplings

- Arbor
- Cylindrical shank

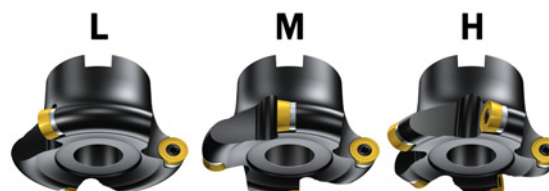
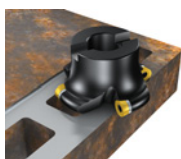
Inserts

- 8 cutting edges
- Insert geometries and grades for all materials
- Insert geometries for high chip removal rates – large AP and f_z



Reliability and process security

Strong cutting edges make the cutter resistant to tough conditions with interruptions (holes, gaps etc.) and/or abrasive scale (skin).



Coarse pitch

Close pitch

Extra close pitch



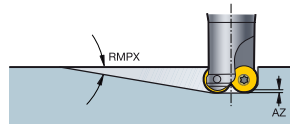
I101



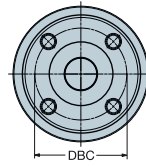
I103

CoroMill® 200 face milling cutter

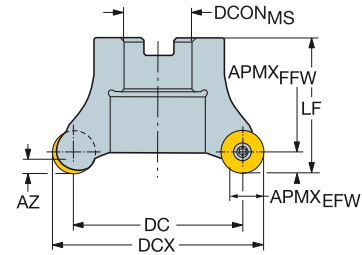
Arbor



STDNO



ISO6462



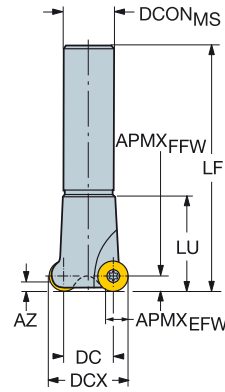
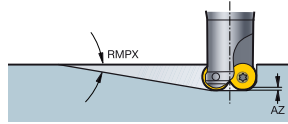
| | | | | | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|-------------------|---------------------|---------------------|-------|----|-----|---------------|--------------------|------|----------------|-------|-------|-------|------|------|-------|------|---------------|---------------|--|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | | Ordering code | DCON _{MS} | ISO | DBC | DCX | BD | LF | NM | KG | RPMX | CICT | MIID | | | |
| 38.0 | 12 | 22 | 9.0 | 6.00 | 6° | 3.7 | 3 | R200-038Q22-12L | 22.0 | A | 50.0 | 50.0 | 50.0 | 3.0 | 0.65 | 18800 | 3 | RCKT 12 04 M0 | | | |
| | 12 | 22 | 9.0 | 6.00 | 6° | 3.7 | 4 | R200-038Q22-12M | 22.0 | A | 50.0 | 50.0 | 50.0 | 3.0 | 0.66 | 18800 | 4 | RCKT 12 04 M0 | | | |
| | 12 | 22 | 9.0 | 6.00 | 6° | 3.7 | 5 | R200-038Q22-12H | 22.0 | A | 50.0 | 50.0 | 50.0 | 3.0 | 0.78 | 18800 | 5 | RCKT 12 04 M0 | | | |
| 40.0 | 12 | 22 | 9.0 | 6.00 | 6° | 3.7 | 3 | R200-040Q22-12L | 22.0 | A | 52.0 | 52.0 | 50.0 | 3.0 | 0.70 | 18000 | 3 | RCKT 12 04 M0 | | | |
| | 12 | 22 | 9.0 | 6.00 | 6° | 3.7 | 4 | R200-040Q22-12M | 22.0 | A | 52.0 | 52.0 | 50.0 | 3.0 | 0.68 | 18000 | 4 | RCKT 12 04 M0 | | | |
| | 12 | 22 | 9.0 | 6.00 | 6° | 3.7 | 5 | R200-040Q22-12H | 22.0 | A | 52.0 | 52.0 | 50.0 | 3.0 | 0.66 | 18000 | 5 | RCKT 12 04 M0 | | | |
| 47.0 | 16 | 22 | 12.0 | 8.00 | 7° | 4.9 | 4 | R200-047Q22-16M | 22.0 | A | 63.0 | 63.0 | 50.0 | 5.0 | 0.80 | 15300 | 4 | RCKT 16 06 M0 | | | |
| 50.0 | 16 | 27 | 12.0 | 8.00 | 6° | 4.9 | 4 | R200-050Q27-16M | 27.0 | A | 66.0 | 66.0 | 50.0 | 5.0 | 0.86 | 14500 | 4 | RCKT 16 06 M0 | | | |
| | 16 | 27 | 12.0 | 8.00 | 6° | 4.9 | 5 | R200-050Q27-16H | 27.0 | A | 66.0 | 66.0 | 50.0 | 5.0 | 0.75 | 14500 | 5 | RCKT 16 06 M0 | | | |
| 51.0 | 12 | 22 | 9.0 | 6.00 | 4° | 3.7 | 3 | R200-051Q22-12L | 22.0 | A | 63.0 | 63.0 | 50.0 | 3.0 | 0.81 | 16200 | 3 | RCKT 12 04 M0 | | | |
| | 12 | 22 | 9.0 | 6.00 | 4° | 3.7 | 4 | R200-051Q22-12M | 22.0 | A | 63.0 | 63.0 | 50.0 | 3.0 | 0.74 | 16200 | 4 | RCKT 12 04 M0 | | | |
| | 12 | 22 | 9.0 | 6.00 | 4° | 3.7 | 5 | R200-051Q22-12H | 22.0 | A | 63.0 | 63.0 | 50.0 | 3.0 | 0.82 | 16200 | 5 | RCKT 12 04 M0 | | | |
| 60.0 | 20 | 27 | 15.0 | 10.00 | 7° | 6.1 | 3 | R200-060Q27-20L | 27.0 | A | 80.0 | 80.0 | 50.0 | 7.5 | 1.00 | 10600 | 3 | RCKT 20 06 M0 | | | |
| | 20 | 27 | 15.0 | 10.00 | 7° | 6.1 | 4 | R200-060Q27-20M | 27.0 | A | 80.0 | 80.0 | 50.0 | 7.5 | 0.89 | 10600 | 4 | RCKT 20 06 M0 | | | |
| 64.0 | 16 | 27 | 12.0 | 8.00 | 5° | 4.9 | 4 | R200-064Q27-16L | 27.0 | A | 80.0 | 80.0 | 50.0 | 5.0 | 1.16 | 13100 | 4 | RCKT 16 06 M0 | | | |
| | 16 | 27 | 12.0 | 8.00 | 5° | 4.9 | 5 | R200-064Q27-16M | 27.0 | A | 80.0 | 80.0 | 50.0 | 5.0 | 1.02 | 13100 | 5 | RCKT 16 06 M0 | | | |
| | 16 | 27 | 12.0 | 8.00 | 5° | 4.9 | 6 | R200-064Q27-16H | 27.0 | A | 80.0 | 80.0 | 50.0 | 5.0 | 0.96 | 13100 | 6 | RCKT 16 06 M0 | | | |
| 68.0 | 12 | 27 | 9.0 | 6.00 | 3° | 3.7 | 4 | R200-068Q27-12L | 27.0 | A | 80.0 | 80.0 | 50.0 | 3.0 | 1.05 | 14000 | 4 | RCKT 12 04 M0 | | | |
| | 12 | 27 | 9.0 | 6.00 | 3° | 3.7 | 6 | R200-068Q27-12M | 27.0 | A | 80.0 | 80.0 | 50.0 | 3.0 | 0.92 | 14000 | 6 | RCKT 12 04 M0 | | | |
| 80.0 | 20 | 32 | 15.0 | 10.00 | 5° | 6.1 | 4 | R200-080Q32-20L | 32.0 | B | 100.0 | 100.0 | 63.0 | 7.5 | 1.73 | 9200 | 4 | RCKT 20 06 M0 | | | |
| | 20 | 32 | 15.0 | 10.00 | 5° | 6.1 | 6 | R200-080Q32-20M | 32.0 | B | 100.0 | 100.0 | 63.0 | 7.5 | 1.54 | 9200 | 6 | RCKT 20 06 M0 | | | |
| 84.0 | 16 | 32 | 12.0 | 8.00 | 3° | 4.9 | 6 | R200-084Q32-16M | 32.0 | B | 100.0 | 100.0 | 50.0 | 5.0 | 1.62 | 11400 | 6 | RCKT 16 06 M0 | | | |
| 88.0 | 12 | 32 | 9.0 | 6.00 | 2° | 3.7 | 4 | R200-088Q32-12L | 32.0 | B | 100.0 | 100.0 | 50.0 | 3.0 | 1.66 | 12300 | 4 | RCKT 12 04 M0 | | | |
| | 12 | 32 | 9.0 | 6.00 | 2° | 3.7 | 6 | R200-088Q32-12M | 32.0 | B | 100.0 | 100.0 | 50.0 | 3.0 | 1.50 | 12300 | 6 | RCKT 12 04 M0 | | | |
| 105.0 | 20 | 32 | 15.0 | 10.00 | 3° | 6.1 | 5 | R200-105Q32-20L | 32.0 | B | 125.0 | 125.0 | 63.0 | 7.5 | 2.44 | 8000 | 5 | RCKT 20 06 M0 | | | |
| | 20 | 32 | 15.0 | 10.00 | 3° | 6.1 | 6 | R200-105Q32-20M | 32.0 | B | 125.0 | 125.0 | 63.0 | 7.5 | 2.28 | 8000 | 6 | RCKT 20 06 M0 | | | |
| 109.0 | 16 | 32 | 12.0 | 8.00 | 2° | 4.9 | 5 | R200-109Q32-16L | 32.0 | B | 125.0 | 125.0 | 50.0 | 5.0 | 2.26 | 10000 | 5 | RCKT 16 06 M0 | | | |
| | 16 | 32 | 12.0 | 8.00 | 2° | 4.9 | 6 | R200-109Q32-16M | 32.0 | B | 125.0 | 125.0 | 50.0 | 5.0 | 2.33 | 10000 | 6 | RCKT 16 06 M0 | | | |
| 140.0 | 20 | 40S | 15.0 | 10.00 | 2° | 6.1 | 6 | R200-140Q40-20L | 40.0 | C | 66.7 | 160.0 | 160.0 | 63.0 | 7.5 | 3.72 | 6900 | 6 | RCKT 20 06 M0 | | |
| | 20 | 40S | 15.0 | 10.00 | 2° | 6.1 | 8 | R200-140Q40-20M | 40.0 | C | 66.7 | 160.0 | 160.0 | 63.0 | 7.5 | 3.60 | 6900 | 8 | RCKT 20 06 M0 | | |

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



CoroMill® 200 face milling cutter

Cylindrical shank



| | | | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|-------------------|---------------------|---------------------|-------|-----|---------------|---|--------------------|------|------|------|------|-------|-----|------|-------|------|---------------|--|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | Ordering code | | DCON _{MS} | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID | | |
| 15.0 | 10 | 20 | 7.5 | 5.00 | 13° | 2.9 | 2 | R200-015A20-10M | 20.0 | 25.0 | 25.0 | 25.0 | 150.0 | 3.0 | 0.54 | 37500 | 2 | RCKT 10 T3 M0 | |
| | 10 | 20 | 7.5 | 5.00 | 13° | 2.9 | 3 | R200-015A20-10H | 20.0 | 25.0 | 25.0 | 25.0 | 150.0 | 3.0 | 0.49 | 37500 | 3 | RCKT 10 T3 M0 | |
| 20.0 | 12 | 25 | 9.0 | 6.00 | 13° | 3.7 | 2 | R200-020A25-12M | 25.0 | 32.0 | 32.0 | 32.0 | 190.0 | 3.0 | 0.84 | 31100 | 2 | RCKT 12 04 M0 | |
| | 12 | 25 | 9.0 | 6.00 | 13° | 3.7 | 3 | R200-020A25-12H | 25.0 | 32.0 | 32.0 | 32.0 | 190.0 | 3.0 | 0.86 | 31100 | 3 | RCKT 12 04 M0 | |
| 24.0 | 16 | 32 | 12.0 | 8.00 | 13° | 4.9 | 2 | R200-024A32-16L | 32.0 | 40.0 | 40.0 | 40.0 | 240.0 | 5.0 | 1.72 | 21800 | 2 | RCKT 16 06 M0 | |
| | 16 | 32 | 12.0 | 8.00 | 13° | 4.9 | 3 | R200-024A32-16M | 32.0 | 40.0 | 40.0 | 40.0 | 240.0 | 5.0 | 1.64 | 21800 | 3 | RCKT 16 06 M0 | |
| 28.0 | 12 | 32 | 9.0 | 6.00 | 9° | 3.7 | 2 | R200-028A32-12L | 32.0 | 40.0 | 40.0 | 40.0 | 240.0 | 3.0 | 1.76 | 26300 | 2 | RCKT 12 04 M0 | |
| | 12 | 32 | 9.0 | 6.00 | 9° | 3.7 | 3 | R200-028A32-12M | 32.0 | 40.0 | 40.0 | 40.0 | 240.0 | 3.0 | 1.74 | 26300 | 3 | RCKT 12 04 M0 | |
| 30.0 | 20 | 32 | 15.0 | 10.00 | 13° | 6.1 | 2 | R200-030A32-20L | 32.0 | 50.0 | 50.0 | 50.0 | 240.0 | 7.5 | 1.88 | 20900 | 2 | RCKT 20 06 M0 | |
| | 20 | 32 | 15.0 | 10.00 | 13° | 6.1 | 3 | R200-030A32-20M | 32.0 | 50.0 | 50.0 | 50.0 | 240.0 | 7.5 | 1.79 | 20900 | 3 | RCKT 20 06 M0 | |
| 34.0 | 16 | 32 | 12.0 | 8.00 | 11° | 4.9 | 3 | R200-034A32-16M | 32.0 | 50.0 | 50.0 | 50.0 | 240.0 | 5.0 | 1.81 | 18300 | 3 | RCKT 16 06 M0 | |
| 38.0 | 12 | 32 | 9.0 | 6.00 | 6° | 3.7 | 3 | R200-038A32-12L | 32.0 | 50.0 | 50.0 | 50.0 | 240.0 | 3.0 | 1.86 | 22500 | 3 | RCKT 12 04 M0 | |
| | 12 | 32 | 9.0 | 6.00 | 6° | 3.7 | 4 | R200-038A32-12M | 32.0 | 50.0 | 50.0 | 50.0 | 240.0 | 3.0 | 1.84 | 22500 | 4 | RCKT 12 04 M0 | |

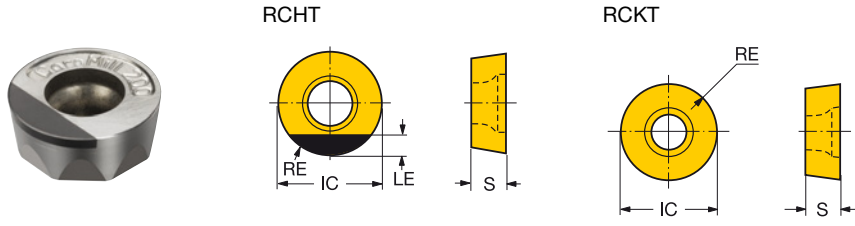
| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 10 | 5513 020-09 |
| 12 | 5513 020-09 |
| 16 | 5513 020-07 |
| 20 | 5513 020-08 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 200 insert for milling

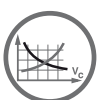
Advanced cutting materials



| | | | | Dimensions, mm | | | | | | |
|--------|------|----|---------------|----------------|------|------|------|------|-----|------|
| | | RE | Ordering code | 6190 | CB50 | 6190 | CB50 | IC | LE | S |
| Light | PO | 12 | 6.00 | RCHT 12 04 MO | ☆ | ☆ | ☆ | 12.0 | 3.0 | 4.76 |
| | | | | | | | | | | |
| Medium | SK15 | 12 | 6.00 | RCKT 12 04 MO | ☆ | ☆ | ☆ | 12.0 | | 4.76 |
| | | 16 | 8.00 | RCKT 16 06 MO | ☆ | ☆ | ☆ | 16.0 | | 6.35 |
| | | | | | | | | | | |



I101



I154



I175



N23



N10

CoroMill® 216

A metal remover for rough and semi-finish profiling

Application

- Profiling
- Copy milling
- Contour milling
- Roughing to semi-finishing

ISO application area:



Benefits and features

- Maximum security and reliability
- High metal removal rate
- Easy to apply



www.sandvik.coromant.com/coromill216

Couplings

- Coromant Capto®
- Cylindrical shank
- Weldon
- Coromant EH
- Threaded coupling

Inserts

- Two cutting edges
- Insert geometries and grades for all materials



inserts for higher security



inserts with sharper edges and higher precision

Insert location

Same inserts for both central and peripheral locations.



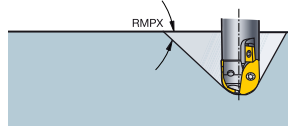
I106



I111

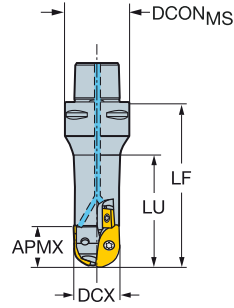
CoroMill® 216 ball nose milling cutter

Coromant Capto® - Internal coolant supply



KAPR

90°



| | | | | | | | | | | Dimensions, mm | | | | | | | | | | | | |
|------|--------------------|---------------------|----|----|-------------------|------|------|------|---|----------------|--------------------|------|-----------------|-------|------|------|------|-------|----------------------|---------------------|--------------------|-------------------|
| DC | APMX _{FW} | APMX _{EFW} | | | CZC _{MS} | RMPX | AZ | CNSC | | Ordering code | DCON _{MS} | DCX | BD _i | LF | LU | | | RPMX | CICT _{BALL} | MID _{BALL} | CICT _{SP} | MID _{SP} |
| 30.0 | 28.3 | 15.0 | 30 | | C3 | 85° | 15.0 | 3 | 2 | R216-30C3-070 | 32.0 | 30.0 | 26.8 | 70.0 | 50.6 | 5.0 | 0.39 | 18500 | 2 | R216-30 06 | | |
| 32.0 | 28.6 | 16.0 | 32 | | C3 | 85° | 16.0 | 3 | 2 | R216-32C3-070 | 32.0 | 32.0 | 29.0 | 70.0 | | 5.0 | 0.42 | 18500 | 2 | R216-32 06 | | |
| 40.0 | 31.6 | 20.0 | 40 | | C4 | 85° | 20.0 | 3 | 2 | R216-40C4-080 | 40.0 | 40.0 | 37.0 | 80.0 | | 7.5 | 0.87 | 8000 | 2 | R216-40 07 | | |
| 50.0 | 44.6 | 25.0 | 50 | 16 | C5 | 85° | 25.0 | 3 | 2 | R216-50C5-125 | 50.0 | 50.0 | 46.4 | 125.0 | | 10.0 | 1.65 | 7000 | 2 | R216-50 07 | 2 | APMT 160408-M |

| Spare parts | | | |
|-------------|--------------|-------------|-------------------------|
| | Insert screw | Shim | Protection insert screw |
| 30 | 5513 020-07 | | |
| 32 | 5513 020-07 | | |
| 40 | 5513 020-31 | | |
| 50 | 5513 021-03 | 5322 475-01 | 5513 020-09 |

For complete list of spare parts, see www.sandvik.coromant.com



I111



L2



N23



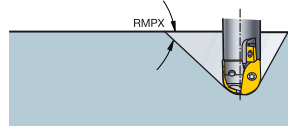
N9



N15

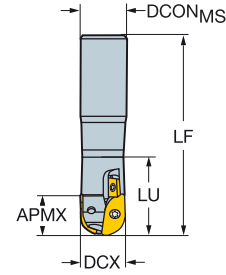
CoroMill® 216 ball nose milling cutter

Cylindrical shank - Internal coolant supply



KAPR

90°



| | | | | | | | | | | Dimensions, mm | | | | | | | | | | | | |
|------|---------------------|---------------------|----|-------------------|------|------|------|---|----------------|--------------------|------|-----------------|-------|-------|------|------|-------|----------------------|---------------------|--------------------|-------------------|---------------|
| DC | APMX _{FFW} | APMX _{EFW} | | CZC _{MS} | RMPX | AZ | CNSC | | Ordering code | DCON _{MS} | DCX | BD ₁ | LF | LU | | | RPMX | CICT _{BALL} | MID _{BALL} | CICT _{SP} | MID _{SP} | |
| 10.0 | 8.6 | 5.0 | 10 | 16 | 85° | 5.0 | 0 | 2 | R216-10A16-050 | 16.0 | 10.0 | 9.2 | 160.0 | 22.1 | 0.6 | 0.31 | 15900 | 2 | R216-10 02 | | | |
| 12.0 | 10.8 | 6.0 | 12 | 20 | 85° | 6.0 | 0 | 2 | R216-12A20-045 | 20.0 | 12.0 | 10.8 | 200.0 | 22.0 | 1.2 | 0.54 | 21000 | 2 | R216-12 02 | | | |
| 16.0 | 14.4 | 8.0 | 16 | 20 | 85° | 8.0 | 1 | 2 | R216-16A20-045 | 20.0 | 16.0 | 14.7 | 200.0 | 29.6 | 1.2 | 0.54 | 20000 | 2 | R216-16 03 | | | |
| 20.0 | 17.9 | 10.0 | 20 | 25 | 85° | 10.0 | 1 | 2 | R216-20A25-055 | 25.0 | 20.0 | 18.4 | 200.0 | 36.5 | 2.0 | 0.68 | 24000 | 2 | R216-20 T3 | | | |
| 25.0 | 22.3 | 12.5 | 25 | 32 | 85° | 12.5 | 1 | 2 | R216-25A32-065 | 32.0 | 25.0 | 23.2 | 250.0 | 43.4 | 3.0 | 1.69 | 24000 | 2 | R216-25 04 | | | |
| 30.0 | 26.9 | 15.0 | 30 | 16 | 32 | 85° | 15.0 | 1 | 2 | R216-30A32-070 | 32.0 | 30.0 | 26.8 | 250.0 | 60.4 | 5.0 | 1.74 | 19500 | 2 | R216-30 06 | 1 | APMT 160408-M |
| 32.0 | 28.6 | 16.0 | 32 | 32 | 85° | 16.0 | 1 | 2 | R216-32A32-070 | 32.0 | 32.0 | 29.0 | 250.0 | 70.0 | 5.0 | 1.56 | 18500 | 2 | R216-32 06 | | | |

| Spare parts | | | |
|-------------|----|--------------|-------------------------|
| | | Insert screw | Protection insert screw |
| 10 | | 5513 020-40 | |
| 12 | | 5513 020-36 | |
| 16 | | 5513 020-36 | |
| 20 | | 5513 020-16 | |
| 25 | | 5513 020-52 | |
| 30 | 16 | 5513 020-07 | 5513 020-09 |
| 32 | | 5513 020-07 | |

For complete list of spare parts, see www.sandvik.coromant.com



I111



L2



N23



N9



N15

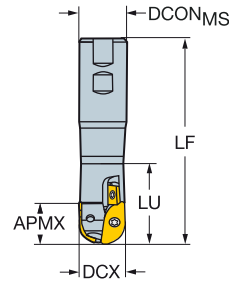
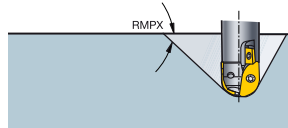


CoroMill® 216 ball nose milling cutter

Weldon - Internal coolant supply

KAPR

90°



| | | | | | | | | | | Dimensions, mm | | | | | | | | | | | | | |
|------|--------------------|--------------------|----|-------------------|------|------|------|-----------------------|-----------------------|-----------------------|------|------|-----------------|-------|-------|-------|-------|-------|----------------------|---------------------|--------------------|-------------------|---------------|
| DC | APMX _{FW} | APMX _{EW} | | CZC _{MS} | RMPX | AZ | CNSC | | Ordering code | DCON _{MS} | ISO | DCX | BD ₁ | LF | LU | | | RPMX | CICT _{BALL} | MID _{BALL} | CICT _{SP} | MID _{SP} | |
| 12.0 | 10.8 | 6.0 | 12 | 20 | 85° | 6.0 | 0 | 2 | R216-12B20-060 | 20.0 | WE | 12.0 | 10.8 | 111.0 | 24.0 | 1.2 | 0.30 | 21000 | 2 | R216-12 02 | | | |
| 10.8 | 6.0 | 12 | 20 | 85° | 6.0 | 0 | 2 | R216-12B20-040 | 20.0 | WE | 12.0 | 10.8 | 91.0 | 21.2 | 1.2 | 0.27 | 21000 | 2 | R216-12 02 | | | | |
| 16.0 | 14.4 | 8.0 | 16 | 20 | 85° | 8.0 | 1 | 2 | R216-16B20-040 | 20.0 | WE | 16.0 | 14.7 | 91.0 | 28.2 | 1.2 | 0.28 | 20000 | 2 | R216-16 03 | | | |
| | 14.4 | 8.0 | 16 | 20 | 85° | 8.0 | 1 | 2 | R216-16B20-060 | 20.0 | WE | 16.0 | 14.7 | 111.0 | 33.8 | 1.2 | 0.31 | 20000 | 2 | R216-16 03 | | | |
| 20.0 | 17.9 | 10.0 | 20 | 25 | 85° | 10.0 | 1 | 2 | R216-20B25-050 | 25.0 | WE | 20.0 | 18.4 | 107.0 | 35.2 | 2.0 | 0.42 | 24000 | 2 | R216-20 T3 | | | |
| | 17.9 | 10.0 | 20 | 25 | 85° | 10.0 | 1 | 2 | R216-20B25-070 | 25.0 | WE | 20.0 | 18.4 | 127.0 | 40.6 | 2.0 | 0.47 | 24000 | 2 | R216-20 T3 | | | |
| 25.0 | 22.3 | 12.5 | 25 | 25 | 85° | 12.5 | 1 | 2 | R216-25B25-060 | 25.0 | WE | 25.0 | 23.2 | 117.0 | 60.0 | 3.0 | 0.49 | 24000 | 2 | R216-25 04 | | | |
| | 22.3 | 12.5 | 25 | 25 | 85° | 12.5 | 1 | 2 | R216-25B25-080 | 25.0 | WE | 25.0 | 23.2 | 137.0 | 80.0 | 3.0 | 0.55 | 24000 | 2 | R216-25 04 | | | |
| 30.0 | 26.9 | 15.0 | 30 | 16 | 32 | 85° | 15.0 | 1 | 2 | R216-30B32-070 | 32.0 | WE | 30.0 | 26.8 | 131.0 | 60.4 | 5.0 | 0.78 | 19500 | 2 | R216-30 06 | 1 | APMT 160408-M |
| | 26.9 | 15.0 | 30 | 16 | 32 | 85° | 15.0 | 1 | 2 | R216-30B32-100 | 32.0 | WE | 30.0 | 26.8 | 161.0 | 90.4 | 5.0 | 0.86 | 19500 | 2 | R216-30 06 | 1 | APMT 160408-M |
| 32.0 | 28.6 | 16.0 | 32 | 32 | 85° | 16.0 | 1 | 2 | R216-32B32-100 | 32.0 | WE | 32.0 | 29.0 | 161.0 | 100.0 | 5.0 | 0.87 | 18500 | 2 | R216-32 06 | | | |
| | 28.6 | 16.0 | 32 | 32 | 85° | 16.0 | 1 | 2 | R216-32B32-070 | 32.0 | WE | 32.0 | 29.0 | 131.0 | 70.0 | 5.0 | 0.77 | 18500 | 2 | R216-32 06 | | | |
| 40.0 | 36.5 | 20.0 | 40 | 16 | 40 | 85° | 20.0 | 1 | 2 | R216-40B40-100 | 40.0 | WE | 40.0 | 37.0 | 171.0 | 100.0 | 7.5 | 1.37 | 8000 | 2 | R216-40 07 | 2 | APMT 160408-M |
| | 36.5 | 20.0 | 40 | 16 | 40 | 85° | 20.0 | 1 | 2 | R216-40B40-150 | 40.0 | WE | 40.0 | 37.0 | 221.0 | 150.0 | 7.5 | 1.94 | 8000 | 2 | R216-40 07 | 2 | APMT 160408-M |
| 50.0 | 44.6 | 25.0 | 50 | 40 | 85° | 25.0 | 1 | 2 | R216-50B40-100 | 40.0 | WE | 50.0 | 47.0 | 171.0 | 100.0 | 10.0 | 1.88 | 7000 | 2 | R216-50 07 | 2 | APMT 160408-M | |
| | 44.6 | 25.0 | 50 | 16 | 50 | 85° | 25.0 | 1 | 2 | R216-50B50-125 | 50.0 | WE | 50.0 | 46.4 | 206.0 | 125.0 | 10.0 | 2.80 | 7000 | 2 | R216-50 07 | 2 | APMT 160408-M |
| | 44.6 | 25.0 | 50 | 16 | 50 | 85° | 25.0 | 1 | 2 | R216-50B50-175 | 50.0 | WE | 50.0 | 46.4 | 256.0 | 175.0 | 10.0 | 3.43 | 7000 | 2 | R216-50 07 | 2 | APMT 160408-M |

| Spare parts | | | | |
|-------------|--------------|-------------|-------------|-------------------------|
| | Insert screw | Shim | Shim screw | Protection insert screw |
| 12 | 5513 020-36 | | | |
| 16 | 5513 020-36 | | | |
| 20 | 5513 020-16 | | | |
| 25 | 5513 020-52 | | | |
| 32 | 5513 020-07 | | | |
| 30 16 | 5513 020-07 | | | 5513 020-09 |
| 40 16 | 5513 020-31 | | | 5513 020-09 |
| 50 16 | 5513 021-03 | 5322 475-01 | 5513 020-09 | |

For complete list of spare parts, see www.sandvik.coromant.com



1111



L2



N23



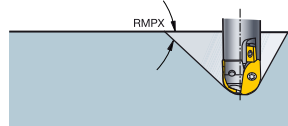
N9



N15

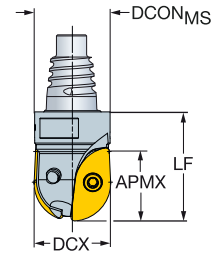
CoroMill® 216 ball nose milling cutter

Coromant EH - Internal coolant supply



KAPR

90°



| DC | CZC _{MS} | APMX _{FFW} | RMPX | CN5C | Ordering code | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|-------|------|---------------|--------------------|-------------|------|------|------|------|-------|---|------------|
| | | | | | | DCON _{MS} | LF | NM | KG | RPMX | CICT | MIID | | |
| 10.0 | 10 | E10 | 8.60 | 85° | 0 | 2 | R216-10EH10 | 9.7 | 20.0 | 0.6 | 0.09 | 12700 | 2 | R216-10 02 |
| 12.0 | 12 | E12 | 10.80 | 85° | 0 | 2 | R216-12EH12 | 11.7 | 20.0 | 1.2 | 0.09 | 12700 | 2 | R216-12 02 |
| 16.0 | 16 | E16 | 14.40 | 85° | 1 | 2 | R216-16EH16 | 15.5 | 25.0 | 1.2 | 0.11 | 12700 | 2 | R216-16 03 |
| 20.0 | 20 | E20 | 17.90 | 85° | 1 | 2 | R216-20EH20 | 19.3 | 30.0 | 2.0 | 0.13 | 12700 | 2 | R216-20 T3 |
| 25.0 | 25 | E25 | 22.30 | 85° | 1 | 2 | R216-25EH25 | 24.2 | 35.0 | 3.0 | 0.17 | 12700 | 2 | R216-25 04 |
| 30.0 | 30 | E25 | 26.90 | 85° | 1 | 2 | R216-30EH25 | 24.2 | 50.0 | 5.0 | 0.20 | 12700 | 2 | R216-30 06 |
| 32.0 | 32 | E25 | 28.60 | 85° | 1 | 2 | R216-32EH25 | 24.2 | 50.0 | 5.0 | 0.24 | 12700 | 2 | R216-32 06 |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 10 | 5513 020-40 |
| 12 | 5513 020-36 |
| 16 | 5513 020-36 |
| 20 | 5513 020-16 |
| 25 | 5513 020-52 |
| 30 | 5513 020-07 |
| 32 | 5513 020-07 |

For complete list of spare parts, see www.sandvik.coromant.com



I111



L2



N23



N9



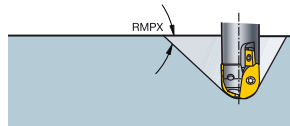
N15



N3

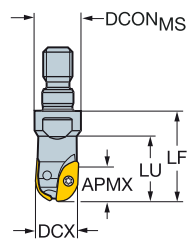
CoroMill® 216 ball nose milling cutter

Threaded coupling - Internal coolant supply



KAPR

90°



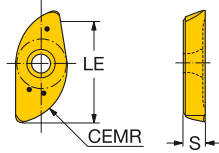
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | Dimensions, mm | | | | | | CICT | MID | | | |
|------|-------------------|---------------------|---------------------|-------|-----|------|---------------|--------------------|-------------------|------|------|------|------|------|------|-------|---|------------|
| | | | | | | | | DCON _{MS} | BD ₁ | LF | LU | NM | KG | | | RPMX | | |
| 10.0 | 10 | M8 | 5.0 | 8.60 | 85° | 5.0 | 0 | 2 | R216-10T08 | 12.8 | 9.2 | 25.0 | 17.8 | 0.6 | 0.05 | 12700 | 2 | R216-10 02 |
| 12.0 | 12 | M8 | 6.0 | 10.80 | 85° | 6.0 | 0 | 2 | R216-12T08 | 12.8 | 10.8 | 25.0 | 18.3 | 1.2 | 0.09 | 12700 | 2 | R216-12 02 |
| 16.0 | 16 | M8 | 8.0 | 14.40 | 85° | 8.0 | 0 | 2 | R216-16T08 | 12.8 | 14.7 | 25.0 | | 1.2 | 0.11 | 12700 | 2 | R216-16 03 |
| 20.0 | 20 | M10 | 10.0 | 17.90 | 85° | 10.0 | 1 | 2 | R216-20T10 | 17.8 | 18.4 | 30.0 | | 2.0 | 0.14 | 12700 | 2 | R216-20 T3 |
| 25.0 | 25 | M12 | 12.5 | 22.30 | 85° | 12.5 | 1 | 2 | R216-25T12 | 20.8 | 23.2 | 35.0 | | 3.0 | 0.17 | 12700 | 2 | R216-25 04 |
| 30.0 | 30 | M16 | 15.0 | 26.90 | 85° | 15.0 | 1 | 2 | R216-30T16 | 28.8 | 26.8 | 45.0 | | 5.0 | 0.25 | 12700 | 2 | R216-30 06 |
| 32.0 | 32 | M16 | 16.0 | 28.60 | 85° | 16.0 | 1 | 2 | R216-32T16 | 28.8 | 29.0 | 45.0 | | 5.0 | 0.26 | 12700 | 2 | R216-32 06 |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 10 | 5513 020-40 |
| 12 | 5513 020-36 |
| 16 | 5513 020-36 |
| 20 | 5513 020-16 |
| 25 | 5513 020-52 |
| 30 | 5513 020-07 |
| 32 | 5513 020-07 |

For complete list of spare parts, see www.sandvik.coromant.com

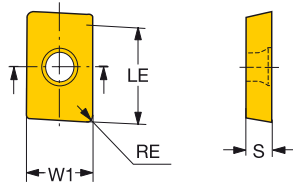
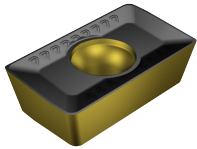


CoroMill® 216 ball nose insert



| Medium | CEMR | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | |
|--------|------|----------------|----------------|------|------|------|------|------|------|------|------|------|------|------|------|------|----|------|------|
| | | | P | | | M | | | K | | N | | S | | H | | LE | S | |
| | | | 1130 | 4220 | 4340 | 1130 | 2040 | 4340 | 4220 | 4340 | H13A | 1130 | H13A | 1130 | H13A | S30T | | | 1010 |
| 10 | 4.9 | R216-10 02 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 8.6 | 1.70 |
| 12 | 5.9 | R216-12 02 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 10.8 | 2.38 |
| | 6.0 | R216-12 02 M-M | ★ | ★ | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 10.8 | 2.38 |
| 16 | 7.8 | R216-16 03 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 14.4 | 3.18 |
| | 8.0 | R216-16 03 M-M | ★ | ☆ | ★ | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 14.4 | 3.18 |
| 20 | 9.8 | R216-20 T3 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 17.9 | 3.97 |
| | 10.0 | R216-20 T3 M-M | ★ | ☆ | ★ | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 17.9 | 3.97 |
| 25 | 12.3 | R216-25 04 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 22.3 | 4.76 |
| | 12.5 | R216-25 04 M-M | ★ | ☆ | ★ | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 22.3 | 4.76 |
| 30 | 14.7 | R216-30 06 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 26.9 | 6.35 |
| | 15.0 | R216-30 06 M-M | ★ | ☆ | ★ | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 26.9 | 6.35 |
| 32 | 15.7 | R216-32 06 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 28.6 | 6.35 |
| | 16.0 | R216-32 06 M-M | ★ | ☆ | ★ | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 28.6 | 6.35 |
| 40 | 19.7 | R216-40 07 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 36.5 | 7.94 |
| | 20.0 | R216-40 07 M-M | ★ | ★ | ★ | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 36.5 | 7.94 |
| 50 | 24.6 | R216-50 07 E-M | ★ | | | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 44.6 | 7.94 |
| | 25.0 | R216-50 07 M-M | ★ | ★ | ★ | ☆ | ★ | | | | | ☆ | ★ | | ☆ | ★ | ☆ | 44.6 | 7.94 |

Shank protection insert



| Medium | W1 | RE | Ordering code | Dimensions, mm | | | | | |
|--------|----|------|-----------------|----------------|------|------|-----|------|------|
| | | | | P | M | K | | | |
| | | | | 4340 | 4340 | 4340 | | | |
| | 16 | 0.80 | APMT 16 04 08-M | ☆ | ☆ | ☆ | 9.2 | 16.0 | 4.76 |



1106



1154



1175














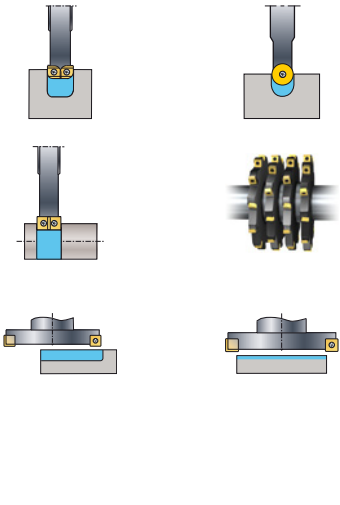
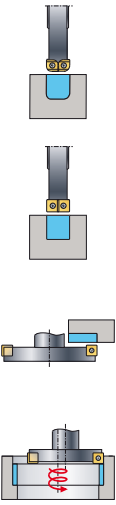
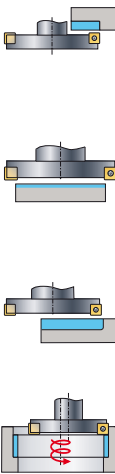


N23



N10

Disc milling tools

| | | | | | | |
|------------------|--|--|---|--|---|--|
| | | | | CoroMill® 331 | | |
| | Adjustable full side and face disc milling cutter | | | Full side and face disc milling cutter | | Adjustable half side and face disc milling cutter |
| |  | | |  | |  |
| Page | I121-I123 | | | I125 | | I126-I127 |
| Material |  | | | | | |
| Main operation |  | | |  | |  |
| KAPR | 90° | | | 90° | | 90° |
| DC mm | 80 - 315 | | | 40 - 125 | | 80 - 315 |
| APMX mm | 6.0 - 26.5 | | | 6.0 - 10 | | 7.6 - 10.6 |
| CDX mm | 114.5 | | | 34 | | 114.5 |
| Insert |  N331.1A |  R/L331.1A |  RCHT, RCKT |  N331.1A |  N331.1A |  R/L331.1A |
| Insert sizes | 04,05,08,11 & 14 | * 04,05,08,11 & 14 | 10,12 & 16 | 04,05 & 08 | 11 | * 04,05,08,11 & 14 |
| Couplings | Arbor Cylindrical Bore with keyway Weldon | | | Arbor Cylindrical Bore with keyway | | Arbor Cylindrical Bore with keyway Weldon |
| Other operations |  | | |  | |  |

* R/L331.1A insert – only with Tailor made cutter

CoroMill® 331

Multi-purpose side and face milling cutter

Application

- Grooving
- Parting off
- Double half side milling
- Shoulder milling
- Face milling
- Gang milling
- Circular ramping

ISO application area:



Benefits and features

- Wide range of mounting options
- Wedge type cassette locking
- Accuracy, security and stability due to serrations
- Sometimes that exact dimension you require might be missing.
If so, simply turn to our Tailor Made service.
- Easy setting for desired width
- Spring-loaded cassette
- Security with pin-controlled setting range
- Internal coolant



www.sandvik.coromant.com/coromill331

Couplings

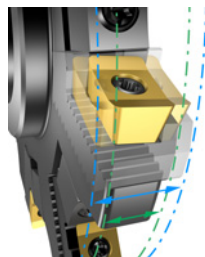
- Bore with keyway
- Arbor
- Cylindrical shank
- Adjustable pockets for high precision
- Fixed pockets for high teeth density

Inserts

- Light cutting insert with H tolerance for most materials
- Round insert options and a vast assortment of corner radii
- Inserts with eight edges for face milling operations available.
- Insert geometries and grades for all materials



Accuracy, security and stability due to serrations.



Wide setting range

Adjustable pockets for flexibility.



I116

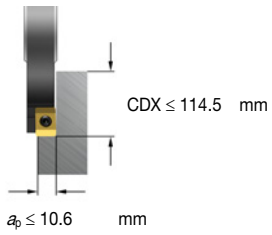


I130

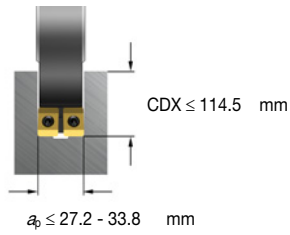


N6

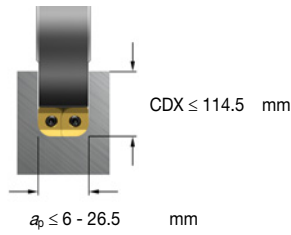
Half side



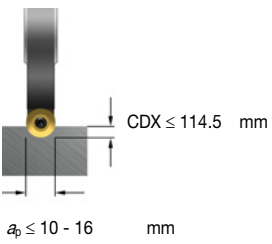
Double half side



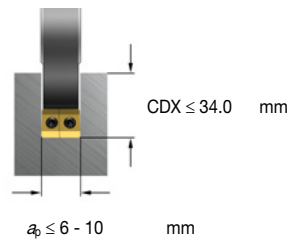
Full slot with radius



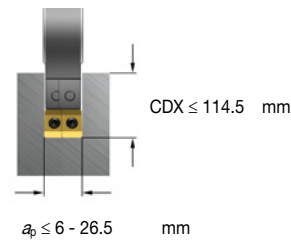
Full radius



Full slot fixed pocket



Full slot cassette



Tailor Made

Cassette cutters are delivered set to min. groove width. Tailor Made for cutters set to other widths.

Cutters for different groove widths and available inserts

| Cutter bodies | | Insert size | Neutral inserts | | Right and left hand inserts | | | | |
|-----------------------|-------------------------------|-------------|--------------------|--------------------|-----------------------------|---------------------|---------------------|---------------------|---------------------|
| Groove width range mm | Cutter versions (end of code) | | Radius (RE) 0.5 mm | Radius (RE) 0.8 mm | Radius (RE) 1.52 mm | Radius (RE) 2.29 mm | Radius (RE) 3.05 mm | Radius (RE) 4.83 mm | Radius (RE) 6.35 mm |
| 6-8 | CM | 04 | | | | | | | |
| 8-10 | DM | 05 | | | | | | | |
| 10-12 | EM | 08 | | | | | | | |
| 12-15 | FM | 08 | | | | | | | |
| 15-17.5 | KM | 11 | | | | | | | |
| 17.5-20.5 | LM | 11 | | | | | | | |
| 20.5-23.5 | QM | 14 | | | | | | | |
| 23.5-26.5 | RM | 14 | | | | | | | |

Tailor Made

Other insert radii available as Tailor Made.

J

K

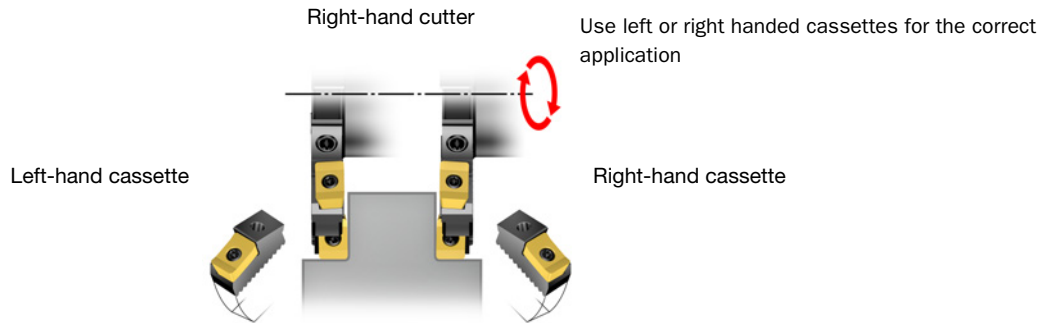
L

M

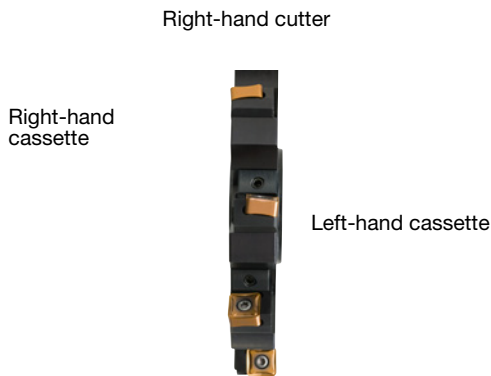
N

Cutter bodies, cassettes and inserts to combine for all applications

Half side and face mill



Full side and face mill

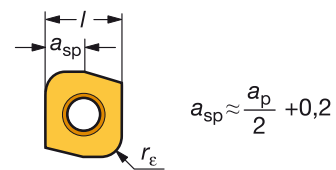
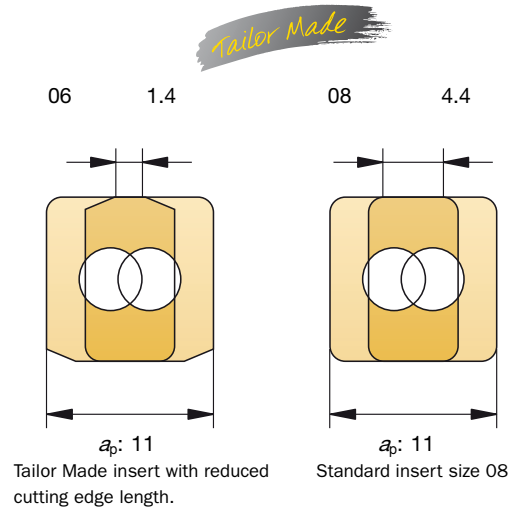


Reduced cutting edge length for Tailor Made inserts

When slotting use the smallest width of the cutter.
The overlap is the most critical factor to optimize.

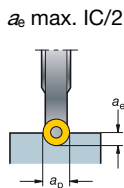
Reduced cutting edge length reduces overlapping, which in turn reduces wear in the overlapping zone, producing better chip control and reducing power consumption by up to 10%.

Tailor Made insert options with reduced cutting edge length and available on request.



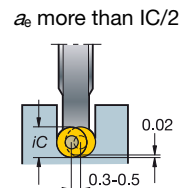
Facilitated chip evacuation

Full slot milling with round insert cutter



Max. axial depth of cut $a_p = IC$
Max. radial depth of cut $a_e = IC/2$

Note: The contact length of the cutting edge is 180°

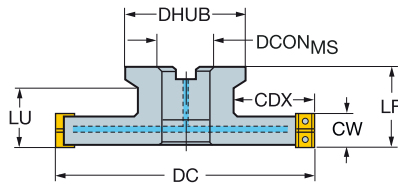


For slots deeper than $IC/2$, a 0.3 - 0.5 mm adjustment of each cassette is recommended. This will widen the slot 0.3 - 0.5 mm and reduce the contact length for each insert to 90°, which produces a more favorable chip formation and evacuation, and reduces vibration and power consumption.

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462
KAPR 90°



Dimensions, mm

| CW | CWX | DC | CDX | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ISO | LF | LU | DHUB | BAR | NM | KG | RPMX | CICT | MIID | |
|-------|------|-----|------|-------------------|------|---------------|--------------------|------|----|-------|------|------|----|-----|------|-------|------|------------|
| 6.00 | 8.0 | 80 | 20.0 | 04 | 27 | 1 3 | R331.32C-080Q27CM | 27.0 | A | 50.00 | 26 | 51.0 | 80 | 0.8 | 0.51 | 19300 | 6 | N331.1A-04 |
| | | 100 | 22.0 | 04 | 27 | 1 4 | R331.32C-100Q27CM | 27.0 | A | 50.00 | | 51.0 | 80 | 0.8 | 0.75 | 17100 | 8 | N331.1A-04 |
| | | 125 | 29.5 | 04 | 32 | 1 5 | R331.32C-125Q32CM | 32.0 | B | 50.00 | | 61.0 | 80 | 0.8 | 0.92 | 15100 | 10 | N331.1A-04 |
| | | 160 | 41.0 | 04 | 40 | 1 6 | R331.32C-160Q40CM | 40.0 | B | 50.00 | | 73.0 | 80 | 0.8 | 1.38 | 13200 | 12 | N331.1A-04 |
| 8.00 | 10.0 | 80 | 20.0 | 05 | 27 | 1 3 | R331.32C-080Q27DM | 27.0 | A | 50.00 | | 51.0 | 80 | 1.2 | 0.54 | 15000 | 6 | N331.1A-05 |
| | | 100 | 22.0 | 05 | 27 | 1 4 | R331.32C-100Q27DM | 27.0 | A | 50.00 | | 51.0 | 80 | 1.2 | 1.01 | 13200 | 8 | N331.1A-05 |
| | | 125 | 29.5 | 05 | 32 | 1 5 | R331.32C-125Q32DM | 32.0 | B | 50.00 | | 61.0 | 80 | 1.2 | 1.09 | 11700 | 10 | N331.1A-05 |
| | | 160 | 41.0 | 05 | 40 | 1 6 | R331.32C-160Q40DM | 40.0 | B | 50.00 | 26 | 73.0 | 80 | 1.2 | 1.53 | 10200 | 12 | N331.1A-05 |
| 10.00 | 12.0 | 80 | 20.0 | 08 | 27 | 1 3 | R331.32C-080Q27EM | 27.0 | A | 50.00 | 26 | 51.0 | 80 | 1.2 | 0.70 | 18100 | 6 | N331.1A-08 |
| | | 100 | 22.0 | 08 | 27 | 1 4 | R331.32C-100Q27EM | 27.0 | A | 50.00 | | 51.0 | 80 | 1.2 | 1.10 | 15900 | 8 | N331.1A-08 |
| | | 125 | 29.5 | 08 | 32 | 1 5 | R331.32C-125Q32EM | 32.0 | B | 50.00 | | 61.0 | 80 | 1.2 | 1.30 | 14100 | 10 | N331.1A-08 |
| | | 160 | 41.0 | 08 | 40 | 1 6 | R331.32C-160Q40EM | 40.0 | B | 50.00 | | 73.0 | 80 | 1.2 | 1.98 | 12400 | 12 | N331.1A-08 |
| 12.00 | 15.0 | 80 | 20.0 | 08 | 27 | 1 3 | R331.32C-080Q27FM | 27.0 | A | 50.00 | 26 | 51.0 | 80 | 1.2 | 0.62 | 18100 | 6 | N331.1A-08 |
| | | 100 | 22.0 | 08 | 27 | 1 4 | R331.32C-100Q27FM | 27.0 | A | 50.00 | | 51.0 | 80 | 1.2 | 0.92 | 15900 | 8 | N331.1A-08 |
| | | 125 | 29.5 | 08 | 32 | 1 5 | R331.32C-125Q32FM | 32.0 | B | 50.00 | | 61.0 | 80 | 1.2 | 1.21 | 14100 | 10 | N331.1A-08 |
| | | 160 | 41.0 | 08 | 40 | 1 6 | R331.32C-160Q40FM | 40.0 | B | 50.00 | | 73.0 | 80 | 1.2 | 1.94 | 12400 | 12 | N331.1A-08 |
| 15.00 | 17.5 | 100 | 25.5 | 11 | 27 | 1 3 | R331.32C-100Q27KM | 27.0 | A | 50.00 | 32.5 | 51.0 | 80 | 3.0 | 0.98 | 14000 | 6 | N331.1A-11 |
| | | 125 | 29.5 | 11 | 32 | 1 4 | R331.32C-125Q32KM | 32.0 | B | 50.00 | | 61.0 | 80 | 3.0 | 1.23 | 12400 | 8 | N331.1A-11 |
| | | 160 | 41.0 | 11 | 40 | 1 5 | R331.32C-160Q40KM | 40.0 | B | 50.00 | | 73.0 | 80 | 3.0 | 2.17 | 10800 | 10 | N331.1A-11 |
| 17.50 | 20.5 | 125 | 29.5 | 11 | 32 | 1 4 | R331.32C-125Q32LM | 32.0 | B | 50.00 | | 61.0 | 80 | 3.0 | 1.42 | 12400 | 8 | N331.1A-11 |
| | | 160 | 41.0 | 11 | 40 | 1 5 | R331.32C-160Q40LM | 40.0 | B | 50.00 | | 73.0 | 80 | 3.0 | 2.35 | 10800 | 10 | N331.1A-11 |
| 20.50 | 23.5 | 160 | 41.0 | 14 | 40 | 1 5 | R331.32C-160Q40QM | 40.0 | B | 50.00 | | 73.0 | 80 | 3.0 | 2.63 | 9000 | 10 | N331.1A-14 |
| 23.50 | 26.5 | 160 | 41.0 | 14 | 40 | 1 5 | R331.32C-160Q40RM | 40.0 | B | 50.00 | | 73.0 | 80 | 3.0 | 3.00 | 9000 | 10 | N331.1A-14 |

Spare parts

| CW | DC | Insert screw | Wedge | Screw |
|-------|--------------|--------------|-------------|-------------|
| 6.00 | 80.00-100.00 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| 6.00 | 125.00 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| 6.00 | 160.00 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| 7.90 | 160.00 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| 8.00 | 80.00-100.00 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| 8.00 | 125.00 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| 10.00 | 80.00-100.00 | 5513 020-24 | 5431 105-01 | 269-832 |
| 10.00 | 125.00 | 5513 020-24 | 5431 105-01 | 269-832 |
| 10.00 | 160.00 | 5513 020-24 | 5431 105-01 | 269-832 |
| 12.00 | 80.00-100.00 | 5513 020-24 | 5431 105-02 | 269-832 |
| 12.00 | 125.00 | 5513 020-24 | 5431 105-02 | 269-832 |
| 12.00 | 160.00 | 5513 020-24 | 5431 105-02 | 269-832 |
| 15.00 | 100.00 | 5513 020-29 | 5431 105-04 | 339-831 |
| 15.00 | 125.00 | 5513 020-29 | 5431 105-04 | 339-831 |
| 15.00 | 160.00 | 5513 020-29 | 5431 105-04 | 339-831 |
| 17.50 | 125.00 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| 17.50 | 160.00 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| 20.50 | 160.00 | 5513 020-29 | 5431 105-05 | 5516 010-02 |
| 23.50 | 160.00 | 5513 020-29 | 5431 105-05 | 5516 010-02 |

For complete list of spare parts, see www.sandvik.coromant.com

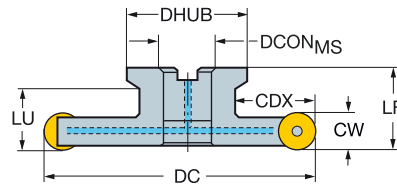
| Accessories | |
|-------------------|---------------|
| CZC _{MS} | Coolant screw |
| 27 | 5512 098-05 |
| 32 | 5512 098-04 |
| 40 | 5512 098-03 |



CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462



| | | | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------|-----|------|-------------------|------|---------------|--------------------|--------------------|------|----|-------|------|------|----|------|------|-------|------|----|---------------|
| CW | DC | CDX | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ISO | LF | LU | DHUB | BAR | NM | KG | RPMX | RE | CICT | MIID | | |
| 10.00 | 82 | 21.6 | 10 | 27 | 1 | 6 | R331.32C-082Q27EMQ | 27.0 | A | 50.00 | 26 | 51.0 | 80 | 1.2 | 0.59 | 19500 | 5.0 | 6 | RCKT 10 T3 M0 |
| | 102 | 23.0 | 10 | 27 | 1 | 8 | R331.32C-102Q27EMQ | 27.0 | A | 50.00 | | 51.0 | 80 | 3.0 | 0.95 | 15900 | 5.0 | 8 | RCKT 10 T3 M0 |
| | 127 | 30.5 | 10 | 32 | 1 | 10 | R331.32C-127Q32EMQ | 32.0 | B | 50.00 | | 61.0 | 80 | 3.0 | 1.20 | 14100 | 5.0 | 10 | RCKT 10 T3 M0 |
| | 162 | 42.0 | 10 | 40 | 1 | 12 | R331.32C-162Q40EMQ | 40.0 | B | 50.00 | | 73.0 | 80 | 3.0 | 1.85 | 12400 | 5.0 | 12 | RCKT 10 T3 M0 |
| 12.00 | 82 | 21.0 | 12 | 27 | 1 | 6 | R331.32C-082Q27FMQ | 27.0 | A | 50.00 | 26 | 51.0 | 80 | 3.0 | 0.66 | 18100 | 6.0 | 6 | RCKT 12 04 M0 |
| | 102 | 23.0 | 12 | 27 | 1 | 8 | R331.32C-102Q27FMQ | 27.0 | A | 50.00 | | 51.0 | 80 | 3.0 | 1.00 | 15900 | 6.0 | 8 | RCKT 12 04 M0 |
| | 127 | 30.5 | 12 | 32 | 1 | 10 | R331.32C-127Q32FMQ | 32.0 | B | 50.00 | | 61.0 | 80 | 3.0 | 1.29 | 14100 | 6.0 | 10 | RCKT 12 04 M0 |
| | 162 | 42.0 | 12 | 40 | 1 | 12 | R331.32C-162Q40FMQ | 40.0 | B | 50.00 | | 73.0 | 80 | 3.0 | 2.03 | 12400 | 6.0 | 12 | RCKT 12 04 M0 |
| 16.00 | 102 | 26.5 | 16 | 27 | 1 | 6 | R331.32C-102Q27KMQ | 27.0 | A | 50.00 | 32.5 | 51.0 | 80 | 5.0 | 0.90 | 14000 | 8.0 | 6 | RCKT 16 06 M0 |
| | 127 | 30.5 | 16 | 32 | 1 | 8 | R331.32C-127Q32KMQ | 32.0 | B | 50.00 | | 61.0 | 80 | 5.0 | 1.38 | 12400 | 8.0 | 8 | RCKT 16 06 M0 |
| | 162 | 42.0 | 16 | 40 | 1 | 10 | R331.32C-162Q40KMQ | 40.0 | B | 50.00 | | 73.0 | 80 | 5.0 | 2.22 | 10800 | 8.0 | 10 | RCKT 16 06 M0 |

| Spare parts | | | | | |
|-------------|---------------|------------------|--------------|-------------|-------------|
| CW | DC | Cassette neutral | Insert screw | Wedge | Screw |
| 10.0 | 82.00 | 5521 250-02 | 5513 020-09 | 5431 105-01 | 269-832 |
| 10.0 | 102.00 | 5521 250-02 | 5513 020-09 | 5431 105-01 | 5516 010-02 |
| 10.0 | 127.00-162.00 | 5521 250-02 | 5513 020-09 | 5431 105-01 | 339-831 |
| 12.0 | 82.00 | 5521 250-03 | 5513 020-09 | 5431 105-02 | 269-832 |
| 12.0 | 102.00 | 5521 250-03 | 5513 020-09 | 5431 105-02 | 5516 010-02 |
| 12.0 | 127.00-162.00 | 5521 250-03 | 5513 020-09 | 5431 105-02 | 339-831 |
| 16.0 | 102.00-162.00 | 5521 250-05 | 5513 020-07 | 5431 105-04 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com

| Accessories | |
|-------------------|---------------|
| CZC _{MS} | Coolant screw |
| 27 | 5512 098-05 |
| 32 | 5512 098-04 |
| 40 | 5512 098-03 |



I130



L2



M1



N23



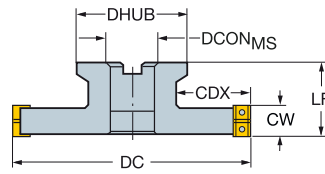
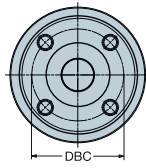
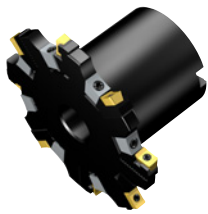
N6

CoroMill® 331 adjustable full side and face disc milling cutter





Arbor

STDNO
KAPR

ISO6462
90°



N331.1A

| | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|------|------|------|---|---|---------------|-----------------------|--------------------|-----|-------|-------|-------|---|--|-------|------|------------|
| CW | CWX | DC | CDX |  |  | Ordering code | | DCON _{MS} | ISO | DBC | LF | DHUB |  |  | RPMX | CICT | MIID |
| 6.00 | 8.0 | 200 | 51.0 | 04 | 40S | 8 | R331.32-200Q40CM06.00 | 40.0 | C | 66.7 | 63.10 | 96.0 | 0.8 | 6.70 | 11700 | 16 | N331.1A-04 |
| 8.00 | 10.0 | 200 | 51.0 | 05 | 40S | 8 | R331.32-200Q40DM08.00 | 40.0 | C | 66.7 | 63.10 | 96.0 | 1.2 | 8.61 | 9100 | 16 | N331.1A-05 |
| 10.00 | 12.0 | 200 | 51.0 | 08 | 40S | 8 | R331.32-200Q40EM10.00 | 40.0 | C | 66.7 | 63.00 | 96.0 | 1.2 | 8.88 | 11000 | 16 | N331.1A-08 |
| 12.00 | 15.0 | 200 | 51.0 | 08 | 40S | 8 | R331.32-200Q40FM12.00 | 40.0 | C | 66.7 | 63.00 | 96.0 | 1.2 | 7.64 | 11000 | 16 | N331.1A-08 |
| 15.00 | 17.5 | 200 | 51.0 | 11 | 40S | 6 | R331.32-200Q40KM15.00 | 40.0 | C | 66.7 | 63.00 | 96.0 | 3.0 | 9.46 | 9600 | 12 | N331.1A-11 |
| | 250 | 56.0 | 11 | 60 | 8 | 8 | R331.32-250Q60KM15.00 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 12.73 | 8500 | 16 | N331.1A-11 |
| | 315 | 88.5 | 11 | 60 | 10 | 10 | R331.32-315Q60KM15.00 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 18.32 | 7600 | 20 | N331.1A-11 |
| 17.50 | 20.5 | 200 | 51.0 | 11 | 40S | 6 | R331.32-200Q40LM17.50 | 40.0 | C | 66.7 | 63.00 | 96.0 | 3.0 | 8.44 | 9600 | 12 | N331.1A-11 |
| | 250 | 56.0 | 11 | 60 | 8 | 8 | R331.32-250Q60LM17.50 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 12.76 | 8500 | 16 | N331.1A-11 |
| | 315 | 88.5 | 11 | 60 | 10 | 10 | R331.32-315Q60LM17.50 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 20.00 | 7600 | 20 | N331.1A-11 |
| 20.50 | 23.5 | 200 | 51.0 | 14 | 40S | 6 | R331.32-200Q40QM20.50 | 40.0 | C | 66.7 | 63.00 | 96.0 | 3.0 | 10.30 | 8000 | 12 | N331.1A-14 |
| | 250 | 56.0 | 14 | 60 | 8 | 8 | R331.32-250Q60QM20.50 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 13.30 | 7100 | 16 | N331.1A-14 |
| | 315 | 88.5 | 14 | 60 | 10 | 10 | R331.32-315Q60QM20.50 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 19.20 | 6300 | 20 | N331.1A-14 |
| 23.50 | 26.5 | 200 | 51.0 | 14 | 40S | 6 | R331.32-200Q40RM23.50 | 40.0 | C | 66.7 | 63.00 | 96.0 | 3.0 | 10.80 | 8000 | 12 | N331.1A-14 |
| | 250 | 56.0 | 14 | 60 | 8 | 8 | R331.32-250Q60RM23.50 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 14.00 | 7100 | 16 | N331.1A-14 |
| | 315 | 88.5 | 14 | 60 | 10 | 10 | R331.32-315Q60RM23.50 | 60.0 | C | 101.6 | 63.00 | 136.0 | 3.0 | 20.44 | 6300 | 20 | N331.1A-14 |

| | | Spare parts | | |
|-------------|---------------|--------------|-------------|-------------|
| CW | DC | Insert screw | Wedge | Screw |
| 6.00 | 200.00 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| 8.00 | 200.00 | 5513 020-34 | 5431 105-06 | 5516 014-04 |
| 10.00 | 200.00 | 5513 020-24 | 5431 105-01 | 339-831 |
| 12.00 | 200.00 | 5513 020-24 | 5431 105-02 | 339-831 |
| 15.00-17.50 | 200.00-315.00 | 5513 020-29 | 5431 105-04 | 339-831 |
| 20.50-23.50 | 200.00-315.00 | 5513 020-29 | 5431 105-05 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com



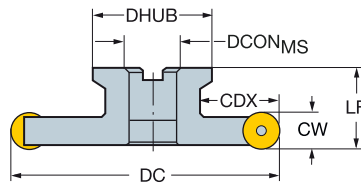
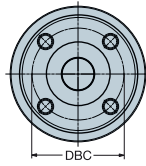
CoroMill® 331 adjustable full side and face disc milling cutter





Arbor



STDNO

ISO6462

RCKT
RCHT

| | | Dimensions, mm | | | | | | | | | | | | | | | |
|-------|-----|----------------|---|-------------------|---|-------------------|--------------------|-----|------|-------|------|---|---|-------|-----|------|---------------|
| CW | DC | CDX |  | CZC _{MS} |  | Ordering code | DCON _{MS} | ISO | DBC | LF | DHUB |  |  | RPMX | RE | CICT | MIID |
| 10.00 | 202 | 52.0 | 10 | 40S | 16 | R331.32-202Q40EMQ | 40.0 | C | 66.7 | 63.00 | 96.0 | 3.0 | 8.79 | 11000 | 5.0 | 16 | RCKT 10 T3 M0 |
| 12.00 | 202 | 52.0 | 12 | 40S | 16 | R331.32-202Q40FMQ | 40.0 | C | 66.7 | 63.00 | 96.0 | 3.0 | 9.07 | 11000 | 6.0 | 16 | RCKT 12 04 M0 |
| 16.00 | 202 | 52.0 | 16 | 40S | 12 | R331.32-202Q40KMQ | 40.0 | C | 66.7 | 63.50 | 96.0 | 5.0 | 10.00 | 9600 | 8.0 | 12 | RCKT 16 06 M0 |

| | | Spare parts | | |
|-------|--------|--------------|-------------|---------|
| CW | DC | Insert screw | Wedge | Screw |
| 10.00 | 202.00 | 5513 020-09 | 5431 105-01 | 339-831 |
| 12.00 | 202.00 | 5513 020-09 | 5431 105-02 | 339-831 |
| 16.00 | 202.00 | 5513 020-07 | 5431 105-04 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com

1103



L2



M1



N23

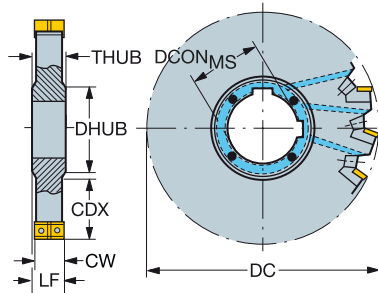


N6

CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|------|------|------|------|-------------------|------|-------------------|-------------------|--------------------|-------------------|-------|-------|------|------|------|-------|-------|------------|------------|
| CW | CWX | DC | CDX | | CZC _{MS} | CNSC | | Ordering code | DCON _{MS} | LF | DRVCT | DHUB | THUB | | | | RPMX | CICT | MIID |
| 6.00 | 8.0 | 80 | 19.5 | 04 | 27 | 1 | 3 | N331.32C-080S27CM | 27.0 | 10.00 | 1 | 39.0 | 14.0 | 80 | 0.8 | 0.37 | 19300 | 6 | N331.1A-04 |
| | | 100 | 25.5 | 04 | 32 | 1 | 4 | N331.32C-100S32CM | 32.0 | 10.00 | 1 | 47.0 | 14.0 | 80 | 0.8 | 0.49 | 17100 | 8 | N331.1A-04 |
| | 125 | 34.0 | 04 | 40 | 1 | 5 | N331.32C-125S40CM | 40.0 | 10.00 | 2 | 55.0 | 14.0 | 80 | 0.8 | 0.63 | 15100 | 10 | N331.1A-04 | |
| | | 160 | 51.5 | 04 | 40 | 1 | 6 | N331.32C-160S40CM | 40.0 | 10.00 | 2 | 55.0 | 14.0 | 80 | 0.8 | 1.02 | 13200 | 12 | N331.1A-04 |
| 8.00 | 10.0 | 80 | 19.5 | 05 | 27 | 1 | 3 | N331.32C-080S27DM | 27.0 | 12.00 | 1 | 39.0 | 16.0 | 80 | 1.2 | 0.46 | 15000 | 6 | N331.1A-05 |
| | | 100 | 25.5 | 05 | 32 | 1 | 4 | N331.32C-100S32DM | 32.0 | 12.00 | 1 | 47.0 | 16.0 | 80 | 1.2 | 0.59 | 13200 | 8 | N331.1A-05 |
| | 125 | 34.0 | 05 | 40 | 1 | 5 | N331.32C-125S40DM | 40.0 | 12.00 | 2 | 55.0 | 16.0 | 80 | 1.2 | 0.75 | 11700 | 10 | N331.1A-05 | |
| | 160 | 51.5 | 05 | 40 | 1 | 6 | N331.32C-160S40DM | 40.0 | 12.00 | 2 | 55.0 | 16.0 | 80 | 1.2 | 1.24 | 10200 | 12 | N331.1A-05 | |
| 10.00 | 12.0 | 80 | 19.5 | 08 | 27 | 1 | 3 | N331.32C-080S27EM | 27.0 | 13.00 | 1 | 39.0 | 16.0 | 80 | 1.2 | 0.42 | 18100 | 6 | N331.1A-08 |
| | | 100 | 25.5 | 08 | 32 | 1 | 4 | N331.32C-100S32EM | 32.0 | 13.00 | 1 | 47.0 | 16.0 | 80 | 1.2 | 0.62 | 15900 | 8 | N331.1A-08 |
| | 125 | 34.0 | 08 | 40 | 1 | 5 | N331.32C-125S40EM | 40.0 | 13.00 | 2 | 55.0 | 16.0 | 80 | 1.2 | 0.93 | 14100 | 10 | N331.1A-08 | |
| | 160 | 51.5 | 08 | 40 | 1 | 6 | N331.32C-160S40EM | 40.0 | 13.00 | 2 | 55.0 | 16.0 | 80 | 1.2 | 1.46 | 12400 | 12 | N331.1A-08 | |
| 12.00 | 15.0 | 80 | 19.5 | 08 | 27 | 1 | 3 | N331.32C-080S27FM | 27.0 | 14.00 | 1 | 39.0 | 16.0 | 80 | 1.2 | 0.52 | 18100 | 6 | N331.1A-08 |
| | | 100 | 25.5 | 08 | 32 | 1 | 4 | N331.32C-100S32FM | 32.0 | 14.00 | 1 | 47.0 | 16.0 | 80 | 1.2 | 0.69 | 15900 | 8 | N331.1A-08 |
| | 125 | 34.0 | 08 | 40 | 1 | 5 | N331.32C-125S40FM | 40.0 | 14.00 | 2 | 55.0 | 16.0 | 80 | 1.2 | 1.04 | 14100 | 10 | N331.1A-08 | |
| | 160 | 51.5 | 08 | 40 | 1 | 6 | N331.32C-160S40FM | 40.0 | 14.00 | 2 | 55.0 | 16.0 | 80 | 1.2 | 1.68 | 12400 | 12 | N331.1A-08 | |
| 15.00 | 17.5 | 100 | 25.5 | 11 | 32 | 1 | 3 | N331.32C-100S32KM | 32.0 | 16.75 | 1 | 47.0 | 18.5 | 80 | 3.0 | 0.82 | 14000 | 6 | N331.1A-11 |
| | | 125 | 34.0 | 11 | 40 | 1 | 4 | N331.32C-125S40KM | 40.0 | 16.75 | 1 | 55.0 | 18.5 | 80 | 3.0 | 1.23 | 12400 | 8 | N331.1A-11 |
| | 160 | 51.5 | 11 | 40 | 1 | 5 | N331.32C-160S40KM | 40.0 | 16.75 | 2 | 55.0 | 18.5 | 80 | 3.0 | 2.01 | 10800 | 10 | N331.1A-11 | |
| | 17.5 | 20.5 | 125 | 34.0 | 11 | 40 | 1 | 4 | N331.32C-125S40LM | 40.0 | 19.50 | 1 | 55.0 | 21.5 | 80 | 3.0 | 1.41 | 12400 | 8 |
| 20.50 | 23.5 | 160 | 51.5 | 14 | 40 | 1 | 5 | N331.32C-160S40QM | 40.0 | 19.50 | 2 | 55.0 | 21.5 | 80 | 3.0 | 2.20 | 10800 | 10 | N331.1A-11 |
| | | 23.5 | 26.5 | 160 | 51.5 | 14 | 40 | 1 | 5 | N331.32C-160S40RM | 40.0 | 22.50 | 2 | 55.0 | 24.5 | 80 | 3.0 | 2.55 | 9000 |
| 23.50 | 26.5 | 160 | 51.5 | 14 | 40 | 1 | 5 | N331.32C-160S40RM | 40.0 | 25.50 | 2 | 55.0 | 27.5 | 80 | 3.0 | 2.78 | 9000 | 10 | N331.1A-14 |

| Spare parts | | | | |
|-------------|---------|--------------|-------------|-------------|
| CW | DC | Insert screw | Wedge | Screw |
| 6.0 | 80-160 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| 8.0 | 80-160 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| 10.0 | 80-160 | 5513 020-24 | 5431 105-01 | 269-832 |
| 12.0 | 80-160 | 5513 020-24 | 5431 105-02 | 269-832 |
| 15.0 | 100-160 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| 17.5 | 125-160 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| 20.5 | 160 | 5513 020-29 | 5431 105-05 | 5516 010-02 |
| 23.5 | 160 | 5513 020-29 | 5431 105-05 | 5516 010-02 |

For complete list of spare parts, see www.sandvik.coromant.com

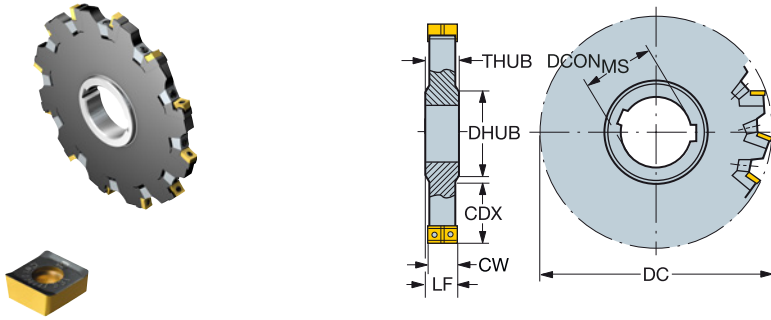
| Accessories | | |
|-------------------|-------------------|------------------|
| CZC _{MS} | Coolant screw set | Spacing ring set |
| 27 | 5512 076-101 | 5549 091-032 |
| 32 | 5512 076-102 | 5549 091-042 |
| 40 | 5512 076-103 | 5549 091-052 |



CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway

KAPR 90°



N331.1A

| | | | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|------|-----|-------|----|-------------------|----|-----------------------|--------------------|-------|-------|------|------|-----|-------|-------|------|------------|--|--|
| CW | CWX | DC | CDX | | CZC _{MS} | | Ordering code | DCON _{MS} | LF | DRVCT | DHUB | THUB | | | RPMX | CICT | MIID | | |
| 6.00 | 8.0 | 200 | 64.5 | 04 | 50 | 8 | N331.32-200S50CM06.00 | 50.0 | 10.00 | 2 | 69.0 | 14.0 | 0.8 | 1.34 | 11700 | 16 | N331.1A-04 | | |
| 8.00 | 10.0 | 200 | 64.5 | 05 | 50 | 8 | N331.32-200S50DM08.00 | 50.0 | 12.00 | 2 | 69.0 | 16.0 | 1.2 | 1.67 | 9100 | 16 | N331.1A-05 | | |
| 10.00 | 12.0 | 200 | 64.5 | 08 | 50 | 8 | N331.32-200S50EM10.00 | 50.0 | 13.00 | 2 | 69.0 | 16.0 | 1.2 | 1.98 | 11000 | 16 | N331.1A-08 | | |
| 12.00 | 15.0 | 200 | 64.5 | 08 | 50 | 8 | N331.32-200S50FM12.00 | 50.0 | 14.00 | 2 | 69.0 | 16.0 | 1.2 | 2.38 | 11000 | 16 | N331.1A-08 | | |
| 15.00 | 17.5 | 200 | 64.5 | 11 | 50 | 6 | N331.32-200S50KM15.00 | 50.0 | 16.75 | 2 | 69.0 | 18.5 | 3.0 | 2.88 | 9600 | 12 | N331.1A-11 | | |
| | | 250 | 89.5 | 11 | 50 | 8 | N331.32-250S50KM15.00 | 50.0 | 16.75 | 2 | 69.0 | 18.5 | 3.0 | 7.74 | 8500 | 16 | N331.1A-11 | | |
| | | 315 | 114.5 | 11 | 60 | 10 | N331.32-315S60KM15.00 | 60.0 | 16.75 | 2 | 84.0 | 18.5 | 3.0 | 13.20 | 7600 | 20 | N331.1A-11 | | |
| 17.50 | 20.5 | 200 | 64.5 | 11 | 50 | 6 | N331.32-200S50LM17.50 | 50.0 | 19.50 | 2 | 69.0 | 21.5 | 3.0 | 3.29 | 9600 | 12 | N331.1A-11 | | |
| | | 250 | 89.5 | 11 | 50 | 8 | N331.32-250S50LM17.50 | 50.0 | 19.50 | 2 | 69.0 | 21.5 | 3.0 | 8.42 | 8500 | 16 | N331.1A-11 | | |
| | | 315 | 114.5 | 11 | 60 | 10 | N331.32-315S60LM17.50 | 60.0 | 19.50 | 2 | 84.0 | 21.5 | 3.0 | 12.94 | 7600 | 20 | N331.1A-11 | | |
| 20.50 | 23.5 | 200 | 64.5 | 14 | 50 | 6 | N331.32-200S50QM20.50 | 50.0 | 22.50 | 2 | 69.0 | 24.5 | 3.0 | 3.86 | 8000 | 12 | N331.1A-14 | | |
| | | 250 | 89.5 | 14 | 50 | 8 | N331.32-250S50QM20.50 | 50.0 | 22.50 | 2 | 69.0 | 24.5 | 3.0 | 7.10 | 7100 | 16 | N331.1A-14 | | |
| | | 315 | 114.5 | 14 | 60 | 10 | N331.32-315S60QM20.50 | 60.0 | 22.50 | 2 | 84.0 | 24.5 | 3.0 | 14.28 | 6300 | 20 | N331.1A-14 | | |
| 23.50 | 26.5 | 200 | 64.5 | 14 | 50 | 6 | N331.32-200S50RM23.50 | 50.0 | 25.50 | 2 | 69.0 | 27.5 | 3.0 | 4.35 | 8000 | 12 | N331.1A-14 | | |
| | | 250 | 89.5 | 14 | 50 | 8 | N331.32-250S50RM23.50 | 50.0 | 25.50 | 2 | 69.0 | 27.5 | 3.0 | 10.16 | 7100 | 16 | N331.1A-14 | | |
| | | 315 | 114.5 | 14 | 60 | 10 | N331.32-315S60RM23.50 | 60.0 | 25.50 | 2 | 84.0 | 27.5 | 3.0 | 19.26 | 6300 | 20 | N331.1A-14 | | |

| Spare parts | | | | |
|-------------|---------------|--------------|-------------|-------------|
| CW | DC | Insert screw | Wedge | Screw |
| 6.00 | 200.00 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| 8.00 | 200.00 | 5513 020-34 | 5431 105-06 | 5516 014-04 |
| 10.00 | 200.00 | 5513 020-24 | 5431 105-01 | 5516 010-02 |
| 12.00 | 200.00 | 5513 020-24 | 5431 105-02 | 5516 010-02 |
| 15.00-17.50 | 200.00-315.00 | 5513 020-29 | 5431 105-04 | 339-831 |
| 20.50-23.50 | 200.00-315.00 | 5513 020-29 | 5431 105-05 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com

1130



L2



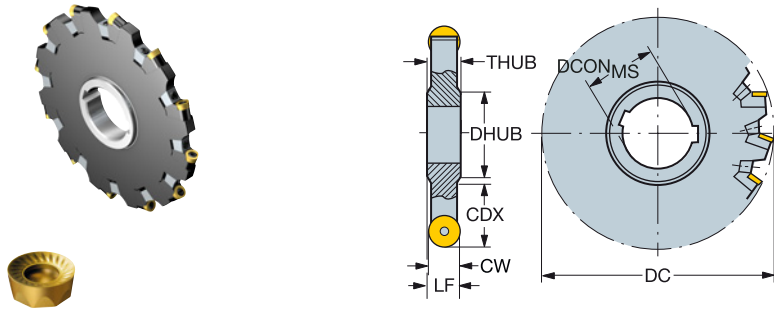
N23








N6

CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway



RCKT
RCHT

| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|-----|------|---|---|---|-------------------|--------------------|-------|-------|------|------|---|---|-------|-----|------|---------------|
| CW | DC | CDX |  |  |  | Ordering code | DCON _{MS} | LF | DRVCT | DHUB | THUB |  |  | RPMX | RE | CICT | MIID |
| 10.00 | 82 | 20.5 | 10 | 27 | 6 | N331.32-082S27EMQ | 27.0 | 13.00 | 1 | 39.0 | 16.0 | 3.0 | 0.56 | 18100 | 5.0 | 6 | RCKT 10 T3 M0 |
| | 102 | 26.5 | 10 | 32 | 8 | N331.32-102S32EMQ | 32.0 | 13.00 | 1 | 47.0 | 16.0 | 3.0 | 0.50 | 15900 | 5.0 | 8 | RCKT 10 T3 M0 |
| | 127 | 35.0 | 10 | 40 | 10 | N331.32-127S40EMQ | 40.0 | 13.00 | 2 | 55.0 | 16.0 | 3.0 | 1.03 | 14100 | 5.0 | 10 | RCKT 10 T3 M0 |
| | 162 | 52.5 | 10 | 40 | 12 | N331.32-162S40EMQ | 40.0 | 13.00 | 2 | 55.0 | 16.0 | 3.0 | 1.51 | 12400 | 5.0 | 12 | RCKT 10 T3 M0 |
| | 202 | 65.5 | 10 | 50 | 16 | N331.32-202S50EMQ | 50.0 | 13.00 | 2 | 69.0 | 16.0 | 3.0 | 2.03 | 11000 | 5.0 | 16 | RCKT 10 T3 M0 |
| 12.00 | 82 | 20.5 | 12 | 27 | 6 | N331.32-082S27FMQ | 27.0 | 14.00 | 1 | 39.0 | 16.0 | 3.0 | 0.62 | 18100 | 6.0 | 6 | RCKT 12 04 M0 |
| | 102 | 26.5 | 12 | 32 | 8 | N331.32-102S32FMQ | 32.0 | 14.00 | 1 | 47.0 | 16.0 | 3.0 | 0.89 | 15900 | 6.0 | 8 | RCKT 12 04 M0 |
| | 127 | 35.0 | 12 | 40 | 10 | N331.32-127S40FMQ | 40.0 | 14.00 | 2 | 55.0 | 16.0 | 3.0 | 1.15 | 14100 | 6.0 | 10 | RCKT 12 04 M0 |
| | 162 | 52.5 | 12 | 40 | 12 | N331.32-162S40FMQ | 40.0 | 14.00 | 2 | 55.0 | 16.0 | 3.0 | 1.73 | 12400 | 6.0 | 12 | RCKT 12 04 M0 |
| | 202 | 65.5 | 12 | 50 | 16 | N331.32-202S50FMQ | 50.0 | 14.00 | 2 | 69.0 | 16.0 | 3.0 | 3.21 | 11000 | 6.0 | 16 | RCKT 12 04 M0 |
| 16.00 | 102 | 26.5 | 16 | 32 | 6 | N331.32-102S32KMQ | 32.0 | 17.25 | 1 | 47.0 | 18.5 | 5.0 | 0.96 | 14000 | 8.0 | 6 | RCKT 16 06 M0 |
| | 127 | 35.0 | 16 | 40 | 8 | N331.32-127S40KMQ | 40.0 | 17.25 | 1 | 55.0 | 18.5 | 5.0 | 1.27 | 12400 | 8.0 | 8 | RCKT 16 06 M0 |
| | 162 | 52.5 | 16 | 40 | 10 | N331.32-162S40KMQ | 40.0 | 17.25 | 2 | 55.0 | 18.5 | 5.0 | 1.97 | 10800 | 8.0 | 10 | RCKT 16 06 M0 |
| | 202 | 65.5 | 16 | 50 | 12 | N331.32-202S50KMQ | 50.0 | 17.25 | 2 | 69.0 | 18.5 | 5.0 | 3.20 | 9600 | 8.0 | 12 | RCKT 16 06 M0 |

| Spare parts | | | | |
|-------------|---------------|--------------|-------------|-------------|
| CW | DC | Insert screw | Wedge | Screw |
| 10.00 | 82.00 | 5513 020-09 | 5431 105-01 | 269-832 |
| 10.00 | 102.00-202.00 | 5513 020-09 | 5431 105-01 | 339-831 |
| 12.00 | 82.00 | 5513 020-09 | 5431 105-02 | 269-832 |
| 12.00 | 102.00-202.00 | 5513 020-09 | 5431 105-02 | 339-831 |
| 16.00 | 102.00 | 5513 020-07 | 5431 105-04 | 5516 010-02 |
| 16.00 | 127.00-202.00 | 5513 020-07 | 5431 105-04 | 339-831 |

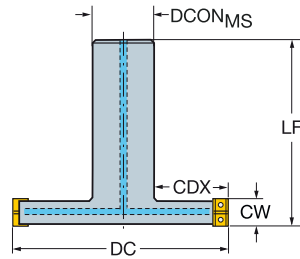
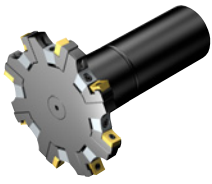
For complete list of spare parts, see www.sandvik.coromant.com








CoroMill® 331 adjustable full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



| | | | | | | | | | | | Dimensions, mm | | | | | | | |
|-------|------|-----|------|---|-------------------|------|---|-------------------|--------------------|--------|---|---|---|-------|------|------------|--|--|
| CW | CWX | DC | CDX |  | CZC _{MS} | CNSC |  | Ordering code | DCON _{MS} | LF |  |  |  | RPMX | CICT | MIID | | |
| 6.00 | 8.0 | 80 | 23.0 | 04 | 32 | 1 | 3 | R331.32C-080A32CM | 32.0 | 115.00 | 80 | 0.8 | 0.90 | 19300 | 6 | N331.1A-04 | | |
| | | 100 | 28.0 | 04 | 40 | 1 | 4 | R331.32C-100A40CM | 40.0 | 125.00 | 80 | 0.8 | 1.50 | 17100 | 8 | N331.1A-04 | | |
| 8.00 | 10.0 | 80 | 23.0 | 05 | 32 | 1 | 3 | R331.32C-080A32DM | 32.0 | 115.00 | 80 | 1.2 | 1.02 | 15000 | 6 | N331.1A-05 | | |
| | | 100 | 28.0 | 05 | 40 | 1 | 4 | R331.32C-100A40DM | 40.0 | 125.00 | 80 | 1.2 | 1.65 | 13200 | 8 | N331.1A-05 | | |
| 10.00 | 12.0 | 80 | 23.0 | 08 | 32 | 1 | 3 | R331.32C-080A32EM | 32.0 | 115.00 | 80 | 1.2 | 1.04 | 18100 | 6 | N331.1A-08 | | |
| | | 100 | 28.0 | 08 | 40 | 1 | 4 | R331.32C-100A40EM | 40.0 | 125.00 | 80 | 1.2 | 1.72 | 15900 | 8 | N331.1A-08 | | |

| | | Spare parts | | |
|------|--------|--------------|-------------|-------------|
| CW | DC | Insert screw | Wedge | Screw |
| 6.0 | 80-100 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| 8.0 | 80-100 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| 10.0 | 80-100 | 5513 020-24 | 5431 105-01 | 269-832 |

For complete list of spare parts, see www.sandvik.coromant.com



1130



L2



N23

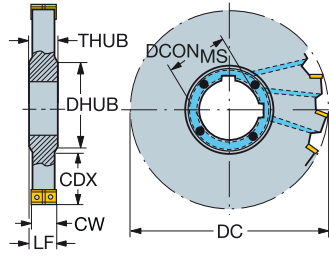







N6

CoroMill® 331 full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



| | | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------|-----|------|---|-------------------|------|---|----------------------|--------------------|-------|-------|------|------|---|--|---|-------|------|------------|
| CW | DC | CDX |  | CZC _{MS} | CNSC |  | Ordering code | DCON _{MS} | LF | DRVCT | DHUB | THUB |  |  |  | RPMX | CICT | MIID |
| 6.00 | 100 | 25.5 | 04 | 32 | 4 | 5 | N331.35C-100S32CM060 | 32.0 | 7.00 | 2 | 47.0 | 8.0 | 80 | 0.8 | 0.21 | 17000 | 10 | N331.1A-04 |
| 8.00 | 100 | 25.5 | 05 | 32 | 4 | 5 | N331.35C-100S32DM080 | 32.0 | 9.00 | 2 | 47.0 | 10.0 | 80 | 1.2 | 0.28 | 13000 | 10 | N331.1A-05 |
| | 125 | 34.0 | 05 | 40 | 4 | 6 | N331.35C-125S40DM080 | 40.0 | 9.00 | 2 | 55.0 | 10.0 | 80 | 1.2 | 0.47 | 15000 | 12 | N331.1A-05 |
| 10.00 | 125 | 34.0 | 08 | 40 | 4 | 6 | N331.35C-125S40EM100 | 40.0 | 11.00 | 2 | 55.0 | 12.0 | 80 | 1.2 | 0.61 | 11500 | 12 | N331.1A-08 |

| Spare parts | | |
|-------------|---------------|--------------|
| CW | DC | Insert screw |
| 6.0 | 100.00 | 5513 020-19 |
| 8.0 | 100.00-125.00 | 5513 020-34 |
| 10.0 | 125.00 | 5513 020-24 |

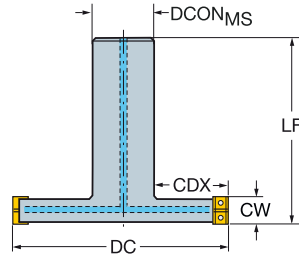
For complete list of spare parts, see www.sandvik.coromant.com








CoroMill® 331 full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



| | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------|------|---|-------------------|------|---|----------------------|----------------------|--------|---|--|--|-------|-------|------------|------------|
| CW | DC | CDX |  | CZC _{MS} | CNSC |  | Ordering code | DCON _{MS} | LF |  BAR |  NM |  KG | RPMX | CICT | MIID | |
| 6.00 | 40 | 11.0 | 04 | 16 | 1 | 2 | R331.35C-040A16CM060 | 16.0 | 120.00 | 80 | 0.8 | 0.19 | 29500 | 4 | N331.1A-04 | |
| | 50 | 14.0 | 04 | 20 | 1 | 3 | R331.35C-050A20CM060 | 20.0 | 130.00 | 80 | 0.8 | 0.33 | 25000 | 6 | N331.1A-04 | |
| | 63 | 18.0 | 04 | 25 | 1 | 3 | R331.35C-063A25CM060 | 25.0 | 140.00 | 80 | 0.8 | 0.58 | 22000 | 6 | N331.1A-04 | |
| 8.00 | 40 | 11.0 | 04 | 16 | 1 | 4 | R331.35C-080A32CM060 | 32.0 | 150.00 | 80 | 0.8 | 1.03 | 19000 | 8 | N331.1A-04 | |
| | 50 | 14.0 | 05 | 16 | 1 | 2 | R331.35C-040A16DM080 | 16.0 | 120.00 | 80 | 1.2 | 0.19 | 22300 | 4 | N331.1A-05 | |
| | 50 | 14.0 | 05 | 20 | 1 | 3 | R331.35C-050A20DM080 | 20.0 | 130.00 | 80 | 1.2 | 0.34 | 19500 | 6 | N331.1A-05 | |
| 8.00 | 63 | 18.0 | 05 | 25 | 1 | 3 | R331.35C-063A25DM080 | 25.0 | 140.00 | 80 | 1.2 | 0.60 | 17000 | 6 | N331.1A-05 | |
| | 80 | 23.0 | 05 | 32 | 1 | 4 | R331.35C-080A32DM080 | 32.0 | 150.00 | 80 | 1.2 | 1.06 | 15000 | 8 | N331.1A-05 | |
| | 10.00 | 40 | 11.0 | 08 | 16 | 1 | 2 | R331.35C-040A16EM100 | 16.0 | 120.00 | 80 | 1.2 | 0.20 | 27000 | 4 | N331.1A-08 |
| 10.00 | 50 | 14.0 | 08 | 20 | 1 | 3 | R331.35C-050A20EM100 | 20.0 | 130.00 | 80 | 1.2 | 0.42 | 23500 | 6 | N331.1A-08 | |
| | 63 | 18.0 | 08 | 25 | 1 | 3 | R331.35C-063A25EM100 | 25.0 | 140.00 | 80 | 1.2 | 0.62 | 21000 | 6 | N331.1A-08 | |
| | 80 | 23.0 | 08 | 32 | 1 | 4 | R331.35C-080A32EM100 | 32.0 | 150.00 | 80 | 1.2 | 1.11 | 18000 | 8 | N331.1A-08 | |

| Spare parts | | |
|-------------|-------------|--------------|
| CW | DC | Insert screw |
| 6.0 | 40.00-80.00 | 5513 020-19 |
| 8.0 | 40.00-80.00 | 5513 020-34 |
| 10.0 | 40.00-80.00 | 5513 020-24 |

For complete list of spare parts, see www.sandvik.coromant.com



1130



L2



N23



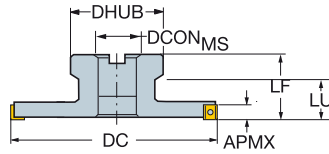
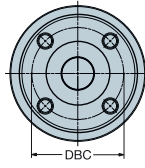
N6

CoroMill® 331 adjustable half side and face disc milling cutter

Arbor

STDNO
KAPR

ISO6462
90°



N331.1A

| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-----|-------------------|------|---------------|--------------------|-------------------|----------------|----|-------|-------|------|-----|-------|-------|------|------------|--|--|
| DC | CZC _{MS} | APMX | Ordering code | DCON _{MS} | ISO | DBC | LF | LU | DHUB | NM | KG | RPMX | CICT | MIID | | | |
| 80 | 08 | 27 | 7.6 | 6 | R331.52-080Q27FMR | 27.0 | A | 63.00 | 40 | 54.0 | 1.2 | 1.12 | 18100 | 6 | N331.1A-08 | | |
| 80 | 08 | 27 | 7.6 | 6 | R331.52-080Q27EMR | 27.0 | A | 63.00 | 40 | 54.0 | 1.2 | 0.80 | 18100 | 6 | N331.1A-08 | | |
| 100 | 08 | 27 | 7.6 | 8 | R331.52-100Q27FMR | 27.0 | A | 63.00 | | 54.0 | 1.2 | 1.30 | 15900 | 8 | N331.1A-08 | | |
| 125 | 08 | 32 | 7.6 | 10 | R331.52-125Q32FMR | 32.0 | B | 63.00 | | 64.0 | 1.2 | 1.95 | 14100 | 10 | N331.1A-08 | | |
| 125 | 08 | 32 | 7.6 | 10 | R331.52-125Q32EMR | 32.0 | B | 63.00 | | 64.0 | 1.2 | 1.86 | 14100 | 10 | N331.1A-08 | | |
| 160 | 08 | 40 | 7.6 | 12 | R331.52-160Q40EMR | 40.0 | B | 63.00 | | 76.0 | 1.2 | 2.69 | 12400 | 12 | N331.1A-08 | | |
| 100 | 11 | 27 | 10.6 | 6 | R331.52-100Q27KMR | 27.0 | A | 63.00 | 40 | 54.0 | 3.0 | 1.77 | 14000 | 6 | N331.1A-11 | | |
| 125 | 11 | 32 | 10.6 | 8 | R331.52-125Q32KMR | 32.0 | B | 63.00 | | 64.0 | 3.0 | 2.30 | 12000 | 8 | N331.1A-11 | | |
| 160 | 11 | 40 | 10.6 | 10 | R331.52-160Q40KMR | 40.0 | B | 63.00 | | 76.0 | 3.0 | 3.30 | 10800 | 10 | N331.1A-11 | | |
| 200 | 11 | 40S | 10.6 | 12 | R331.52-200Q40MMR | 40.0 | C | 66.7 | 63.00 | 96.0 | 3.0 | 11.50 | 9600 | 12 | N331.1A-11 | | |

| Spare parts | | | |
|-------------------|--------------|-------------|-------------|
| Ordering code | Insert screw | Wedge | Screw |
| R331.52-080Q27EMR | 5513 020-24 | 5431 105-01 | 269-832 |
| R331.52-080Q27FMR | 5513 020-24 | 5431 105-02 | 269-832 |
| R331.52-100Q27FMR | 5513 020-24 | 5431 105-02 | 5516 010-02 |
| R331.52-125Q32EMR | 5513 020-24 | 5431 105-01 | 339-831 |
| R331.52-125Q32FMR | 5513 020-24 | 5431 105-02 | 339-831 |
| R331.52-160Q40EMR | 5513 020-24 | 5431 105-01 | 339-831 |
| R331.52-160Q40FMR | 5513 020-24 | 5431 105-02 | 339-831 |
| R331.52-100Q27KMR | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-125Q32KMR | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-160Q40KMR | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-200Q40MMR | 5513 020-29 | 5431 105-03 | 339-831 |
| R331.52-250Q60MMR | 5513 020-29 | 5431 105-03 | 339-831 |
| R331.52-315Q60NMR | 5513 020-29 | 5431 105-04 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com



I130



L2



M1



N23

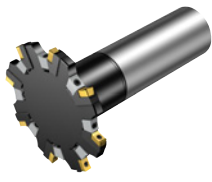


N6

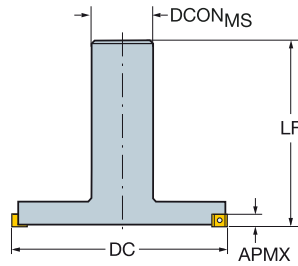
CoroMill® 331 adjustable half side and face disc milling cutter

Cylindrical shank

KAPR 90°



N331.1A



| | | | | | Dimensions, mm | | | | | | | |
|-----|----|-------------------|------|---|-------------------|--------------------|--------|-----|------|-------|------|------------|
| DC | | CZC _{MS} | APMX | | Ordering code | DCON _{MS} | LF | | | RPMX | CICT | MIID |
| 100 | 08 | 42 | 7.6 | 8 | R331.52-100A42EMR | 42.0 | 152.00 | 1.2 | 1.90 | 15900 | 8 | N331.1A-08 |

Spare parts

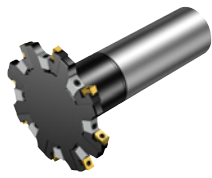
| Insert screw | Wedge | Screw |
|--------------|-------------|---------|
| 5513 020-24 | 5431 105-01 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com

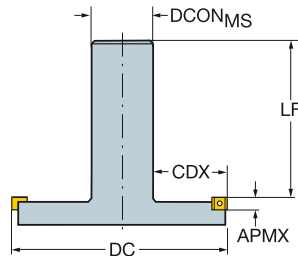
CoroMill® 331 adjustable half side and back face disc milling cutter

Cylindrical shank

KAPR 90°



N331.1A



| | | | | | | Dimensions, mm | | | | | | | |
|-----|------|----|-------------------|------|---|-------------------|--------------------|--------|-----|------|-------|------|------------|
| DC | CDX | | CZC _{MS} | APMX | | Ordering code | DCON _{MS} | LF | | | RPMX | CICT | MIID |
| 80 | 19.5 | 08 | 32 | 7.6 | 6 | R331.52-080A32EML | 32.0 | 122.00 | 1.2 | 1.19 | 18100 | 6 | N331.1A-08 |
| 100 | 25.5 | 08 | 42 | 7.6 | 8 | R331.52-100A42EML | 42.0 | 142.00 | 1.2 | 1.90 | 15900 | 8 | N331.1A-08 |

Spare parts

| Insert screw | Wedge | Screw |
|--------------|-------------|---------|
| 5513 020-24 | 5431 105-01 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com

I130



L2



M1



N23

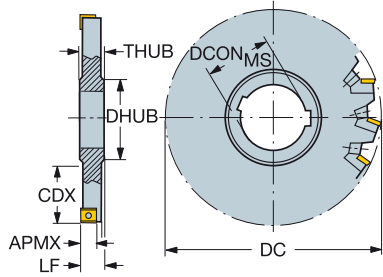


N6

CoroMill® 331 adjustable half side and back face disc milling cutter

Bore with keyway

KAPR 90°



N331.1A

| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-----|-------|-------------------|------|---------------|----|--------------------|------|-------|------|------|------|-----|-------|-------|------|------------|--|
| DC | CDX | CZC _{MS} | APMX | Ordering code | | DCON _{MS} | LF | DRVCT | DHUB | THUB | NM | KG | RPMX | CICT | MIID | | |
| 80 | 19.5 | 08 | 27 | 7.6 | 6 | R/L331.52-080S27EM | 27.0 | 13.00 | 1 | 39.0 | 16.0 | 1.2 | 0.54 | 18100 | 6 | N331.1A-08 | |
| 80 | 19.5 | 08 | 27 | 7.6 | 6 | R/L331.52-080S27FM | 27.0 | 14.00 | 1 | 39.0 | 16.0 | 1.2 | 0.56 | 18100 | 6 | N331.1A-08 | |
| 100 | 25.5 | 08 | 32 | 7.6 | 8 | R/L331.52-100S32EM | 32.0 | 13.00 | 1 | 47.0 | 16.0 | 1.2 | 0.84 | 15900 | 8 | N331.1A-08 | |
| 100 | 25.5 | 08 | 32 | 7.6 | 8 | R/L331.52-100S32FM | 32.0 | 14.00 | 1 | 47.0 | 16.0 | 1.2 | 0.60 | 15900 | 8 | N331.1A-08 | |
| 125 | 34.0 | 08 | 40 | 7.6 | 10 | R/L331.52-125S40EM | 40.0 | 13.00 | 2 | 55.0 | 16.0 | 1.2 | 1.02 | 14100 | 10 | N331.1A-08 | |
| 125 | 34.0 | 08 | 40 | 7.6 | 10 | R/L331.52-125S40FM | 40.0 | 14.00 | 2 | 55.0 | 16.0 | 1.2 | 1.13 | 14100 | 10 | N331.1A-08 | |
| 160 | 51.5 | 08 | 40 | 7.6 | 12 | R/L331.52-160S40EM | 40.0 | 13.00 | 2 | 55.0 | 16.0 | 1.2 | 1.50 | 12400 | 12 | N331.1A-08 | |
| 160 | 51.5 | 08 | 40 | 7.6 | 12 | R/L331.52-160S40FM | 40.0 | 14.00 | 2 | 55.0 | 16.0 | 1.2 | 1.73 | 12400 | 12 | N331.1A-08 | |
| 100 | 25.5 | 11 | 32 | 10.6 | 6 | L331.52-100S32KM | 32.0 | 16.75 | 1 | 47.0 | 18.5 | 3.0 | 0.94 | 14000 | 6 | N331.1A-11 | |
| 125 | 34.0 | 11 | 40 | 10.6 | 8 | R/L331.52-125S40KM | 40.0 | 16.75 | 1 | 55.0 | 18.5 | 3.0 | 1.30 | 12000 | 8 | N331.1A-11 | |
| 160 | 51.5 | 11 | 40 | 10.6 | 10 | R/L331.52-160S40KM | 40.0 | 16.75 | 2 | 55.0 | 18.5 | 3.0 | 2.00 | 10000 | 10 | N331.1A-11 | |
| 200 | 64.5 | 11 | 50 | 10.6 | 12 | R/L331.52-200S50MM | 50.0 | 29.20 | 2 | 69.0 | 31.2 | 3.0 | 9.90 | 9600 | 12 | N331.1A-11 | |
| 250 | 89.5 | 11 | 50 | 10.6 | 16 | L331.52-250S50MM | 50.0 | 29.20 | 2 | 69.0 | 31.2 | 3.0 | 12.96 | 8500 | 16 | N331.1A-11 | |
| 315 | 114.5 | 11 | 60 | 10.6 | 20 | R/L331.52-315S60NM | 60.0 | 32.80 | 2 | 84.0 | 34.8 | 3.0 | 17.30 | 7600 | 20 | N331.1A-11 | |

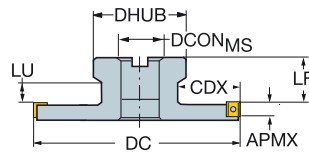
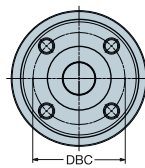
| Spare parts | | | |
|--------------------|--------------|-------------|-------------|
| Ordering code | Insert screw | Wedge | Screw |
| R/L331.52-125S40EM | 5513 020-24 | 5431 105-01 | 339-831 |
| R/L331.52-125S40FM | 5513 020-24 | 5431 105-02 | 339-831 |
| R/L331.52-160S40EM | 5513 020-24 | 5431 105-01 | 339-831 |
| R/L331.52-160S40FM | 5513 020-24 | 5431 105-02 | 339-831 |
| R/L331.52-080S27EM | 5513 020-24 | 5431 105-01 | 269-832 |
| R/L331.52-080S27FM | 5513 020-24 | 5431 105-02 | 269-832 |
| R/L331.52-100S32EM | 5513 020-24 | 5431 105-01 | 339-831 |
| R/L331.52-100S32FM | 5513 020-24 | 5431 105-02 | 339-831 |
| R/L331.52-160S40KM | 5513 020-29 | 5431 105-04 | 339-831 |
| R/L331.52-200S50MM | 5513 020-29 | 5431 105-03 | 339-831 |
| R/L331.52-250S50MM | 5513 020-29 | 5431 105-03 | 339-831 |
| R/L331.52-315S60NM | 5513 020-29 | 5431 105-04 | 339-831 |
| R/L331.52-100S32KM | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| R/L331.52-125S40KM | 5513 020-29 | 5431 105-04 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com







CoroMill® 331 adjustable half side and back face disc milling cutter

Arbor

STDNO
KAPRISO6462
90°

N331.1A

| | | | | | | Dimensions, mm | | | | | | | | | | | | |
|-----|------|---|-------------------|------|---|-------------------|--------------------|-----|-------|-------|------|------|---|---|------|------------|------------|--|
| DC | CDX |  | CZC _{MS} | APMX |  | Ordering code | DCON _{MS} | ISO | DBC | LF | LU | DHUB |  |  | RPMX | CICT | MIID | |
| 80 | 20.0 | 08 | 27 | 7.6 | 6 | R331.52-080Q27EML | 27.0 | A | 53.00 | 30 | 54.0 | 1.2 | 0.80 | 18100 | 6 | N331.1A-08 | | |
| 80 | 20.0 | 08 | 27 | 7.6 | 6 | R331.52-080Q27FML | 27.0 | A | 51.00 | 28 | 54.0 | 1.2 | 0.98 | 18100 | 6 | N331.1A-08 | | |
| 100 | 22.0 | 08 | 27 | 7.6 | 8 | R331.52-100Q27EML | 27.0 | A | 53.00 | | 54.0 | 1.2 | 1.20 | 15900 | 8 | N331.1A-08 | | |
| 100 | 22.0 | 08 | 27 | 7.6 | 8 | R331.52-100Q27FML | 27.0 | A | 51.00 | | 54.0 | 1.2 | 1.30 | 15900 | 8 | N331.1A-08 | | |
| 125 | 29.5 | 08 | 32 | 7.6 | 10 | R331.52-125Q32EML | 32.0 | B | 51.00 | | 64.0 | 1.2 | 1.95 | 14100 | 10 | N331.1A-08 | | |
| 125 | 29.5 | 08 | 32 | 7.6 | 10 | R331.52-125Q32FML | 32.0 | B | 53.00 | | 64.0 | 1.2 | 1.81 | 14100 | 10 | N331.1A-08 | | |
| 160 | 41.0 | 08 | 40 | 7.6 | 12 | R331.52-160Q40EML | 40.0 | B | 51.00 | | 76.0 | 1.2 | 2.90 | 12400 | 12 | N331.1A-08 | | |
| 160 | 41.0 | 08 | 40 | 7.6 | 12 | R331.52-160Q40FML | 40.0 | B | 53.00 | | 76.0 | 1.2 | 2.60 | 12400 | 12 | N331.1A-08 | | |
| 100 | 25.7 | 11 | 27 | 10.6 | 6 | R331.52-100Q27KML | 27.0 | A | 48.00 | 25 | 54.0 | 3.0 | 1.77 | 14000 | 6 | N331.1A-11 | | |
| 125 | 29.5 | 11 | 32 | 10.6 | 8 | R331.52-125Q32KML | 32.0 | B | 48.00 | | 64.0 | 3.0 | 2.09 | 12000 | 8 | N331.1A-11 | | |
| 160 | 41.0 | 11 | 40 | 10.6 | 10 | R331.52-160Q40KML | 40.0 | B | 48.00 | | 76.0 | 3.0 | 3.02 | 10800 | 10 | N331.1A-11 | | |
| 200 | 51.0 | 11 | 40S | 10.6 | 12 | R331.52-200Q40MML | 40.0 | C | 66.7 | 35.80 | | 96.0 | 3.0 | 11.12 | 9600 | 12 | N331.1A-11 | |

| Spare parts | | | |
|-------------------|--------------|-------------|-------------|
| Ordering code | Insert screw | Wedge | Screw |
| R331.52-080Q27EML | 5513 020-24 | 5431 105-01 | 269-832 |
| R331.52-080Q27FML | 5513 020-24 | 5431 105-02 | 269-832 |
| R331.52-100Q27EML | 5513 020-24 | 5431 105-01 | 5516 010-02 |
| R331.52-100Q27FML | 5513 020-24 | 5431 105-02 | 5516 010-02 |
| R331.52-125Q32EML | 5513 020-24 | 5431 105-01 | 339-831 |
| R331.52-125Q32FML | 5513 020-24 | 5431 105-02 | 339-831 |
| R331.52-160Q40EML | 5513 020-24 | 5431 105-01 | 339-831 |
| R331.52-160Q40FML | 5513 020-24 | 5431 105-02 | 339-831 |
| R331.52-100Q27KML | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-125Q32KML | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-160Q40KML | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-200Q40MML | 5513 020-29 | 5431 105-03 | 339-831 |
| R331.52-250Q60MML | 5513 020-29 | 5431 105-03 | 339-831 |
| R331.52-315Q60NML | 5513 020-29 | 5431 105-04 | 339-831 |

For complete list of spare parts, see www.sandvik.coromant.com

1130



L2



M1



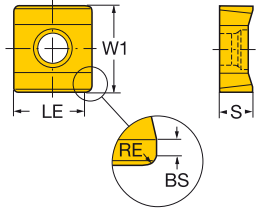
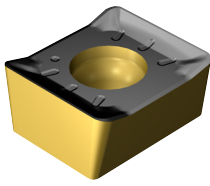
N23



N6

CoroMill® 331 insert for side and face milling

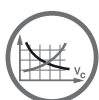
KRINS 90°



| | | P | | M | | K | | N | | S | | H | | Dimensions, mm | | | | | | | | | | | | | | | | |
|--------------------------|---------------------------|---------------------------|---------------------------|------|------|-----|------|------|------|-----|------|------|------|----------------|------|-----|-----|------|------|------|------|------|------|-----|----|------|------|------|------|------|
| | RE | Ordering code | 1130 | 4330 | 4940 | 530 | 1190 | 1300 | 2040 | 530 | 1020 | 3040 | 3220 | 3330 | 1130 | 530 | H10 | H13A | 1130 | 2040 | H13A | S30T | 1130 | 530 | W1 | LE | S | BS | | |
| Light | 04 | 0.50 N331.1A-04 35 05E-KL | | | | | ☆ | ☆ | ☆ | | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 | |
| | | 0.50 N331.1A-04 35 05H-NL | ☆ | ☆ | | | | | ☆ | | | | | | | | | | ☆ | | | | | | | | 9.5 | 4.6 | 3.50 | 0.2 |
| | | 0.50 N331.1A-04 35 05H-PL | | | ☆ | | | | | | | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | 0.50 N331.1A-04 35 05H-WL | ☆ | | | | | | | ☆ | | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | 0.50 N331.1A-043505E-L30 | | | | | | | | | ☆ | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.49 | 0.4 |
| | | 0.50 N331.1A-043505E-L50 | ★ | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.49 | 0.4 |
| | 05 | 0.80 N331.1A-05 45 08E-KL | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-05 45 08H-NL | ☆ | | | | | | | ☆ | | | | | | | | | | ☆ | | | | | | | 9.5 | 5.7 | 4.45 | 0.8 |
| | | 0.80 N331.1A-05 45 08H-PL | | ☆ | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-05 45 08H-WL | ☆ | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-054508E-L30 | | | | | | | | ☆ | | ☆ | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.49 | 1.2 |
| | | 0.80 N331.1A-054508E-L50 | ★ | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.49 | 1.2 |
| | 08 | 0.80 N331.1A-08 45 08E-KL | | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-08 45 08H-NL | ☆ | | | | | | | | | | | | | | | | | ☆ | | | | | | | 9.5 | 7.7 | 4.45 | 0.9 |
| | | 0.80 N331.1A-08 45 08H-PL | | ☆ | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-08 45 08H-WL | ☆ | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | 2.00 N331.1A-08 45 20E-KL | | | | | | | | | | ★ | | | | | | | | | | | | | | | 9.5 | 6.5 | 4.50 | 1.2 |
| | | 2.00 N331.1A-08 45 20H-PL | ★ | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 6.5 | 4.50 | 1.2 |
| 0.80 N331.1A-084508E-L30 | | | | | | | | | | | ☆ | | ☆ | | | | | | | | | | | | | 9.5 | 7.7 | 4.49 | 1.2 | |
| 0.80 N331.1A-084508E-L50 | | ★ | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.49 | 1.2 | |
| 11 | | 0.80 N331.1A-11 50 08E-KL | | | | | | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | 0.80 N331.1A-11 50 08H-NL | ☆ | | | | | | | | | | | | | | | | | | ☆ | | | | | | 11.5 | 10.7 | 4.95 | 1.3 |
| | 0.80 N331.1A-11 50 08H-PL | | ☆ | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 | |
| | 0.80 N331.1A-11 50 08H-WL | ☆ | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 | |
| | 2.00 N331.1A-11 50 20E-KL | | | | | | | | | | ★ | | | | | | | | | | | | | | | 11.5 | 9.5 | 5.00 | 1.2 | |
| | 2.00 N331.1A-11 50 20H-PL | ★ | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 9.5 | 5.00 | 1.2 | |
| 14 | 0.80 N331.1A-14 50 08E-KL | | | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 | |
| | 0.80 N331.1A-14 50 08H-NL | ☆ | | | | | | | | | | | | | | | | | | ☆ | | | | | | 11.5 | 13.7 | 4.95 | 1.1 | |
| | 0.80 N331.1A-14 50 08H-PL | | ☆ | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 | |
| | 0.80 N331.1A-14 50 08H-WL | ☆ | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 | |
| | 0.80 N331.1A-145008E-L30 | | | | | | | | | | ☆ | | ☆ | | | | | | | | | | | | | 11.5 | 13.7 | 4.98 | 1.2 | |
| | 0.80 N331.1A-145008E-L50 | ★ | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.98 | 1.2 | |
| Medium | 04 | 0.50 N331.1A-04 35 05M-KM | | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 | |
| | | 0.50 N331.1A-04 35 05M-PM | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | 0.50 N331.1A-043505E-M30 | ★ | ★ | | | | | | | | | ★ | ★ | | | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | 05 | 0.80 N331.1A-05 45 08E-KM | | | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-05 45 08H-PM | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-05 45 08M-KM | | | | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-05 45 08M-PM | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 0.80 N331.1A-054508E-M30 | ★ | ★ | | | | | | | | | ★ | ★ | | | | | | | | | | | | | 9.5 | 5.7 | 4.50 | 1.2 |
| | | 08 | 0.80 N331.1A-08 45 08E-KM | | | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 7.7 | 4.45 |
| | 0.80 N331.1A-08 45 08H-PM | | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | 0.80 N331.1A-08 45 08H-WM | | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | 0.80 N331.1A-08 45 08M-KM | | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | 0.80 N331.1A-08 45 08M-PM | | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | 2.00 N331.1A-08 45 20E-KM | | | | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 6.5 | 4.45 | 1.2 |
| | 2.00 N331.1A-08 45 20H-PM | | ★ | ★ | | | | | | | | | | | | | | | | | | | | | | | 9.5 | 6.5 | 4.45 | 1.2 |
| | 0.80 N331.1A-084508E-M30 | | ★ | ★ | | | | | | | | | | ★ | ★ | | | | | | | | | | | | 9.5 | 7.7 | 4.50 | 1.2 |



116



1154



1175



N23



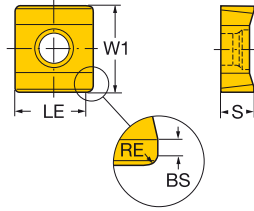
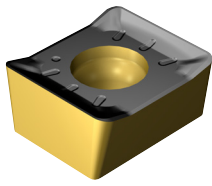
N6



N10

CoroMill® 331 insert for side and face milling

KRINS 90°



| | RE | Ordering code | P | | M | | K | | N | | S | | H | | Dimensions, mm | | | | | | | | | | | | | | | | | | | |
|--------|----------------------|---------------|----------------------|------|----------------------|-----|------|------|------|-----|------|------|------|------|----------------|-----|-----|------|------|------|------|------|------|-----|----|----|------|------|------|------|------|------|------|------|
| | | | 1130 | 4930 | 4940 | 530 | 1040 | 1130 | 2040 | 530 | 1020 | 3040 | 3320 | 3330 | 1130 | 530 | H10 | H13A | 1130 | 2040 | H13A | S30T | 1130 | 530 | W1 | LE | S | BS | | | | | | |
| Medium | 11 | 0.80 | N331.1A-11 50 08E-KM | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 | | | | |
| | | 0.80 | N331.1A-11 50 08H-PM | ☆ | | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 | | |
| | | 0.80 | N331.1A-11 50 08H-WM | | | ☆ | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 | |
| | | 0.80 | N331.1A-11 50 08M-KM | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 | |
| | | 0.80 | N331.1A-11 50 08M-PM | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 | |
| | | 2.00 | N331.1A-11 50 20E-KM | | | | | | | ★ | ★ | | | | | | | | | | | | | | | | | | | 11.5 | 9.5 | 4.95 | 1.2 | |
| | | 2.00 | N331.1A-11 50 20H-PM | ★ | ★ | | | ☆ | | | | | | | | | | | | | | | | | | | | | | 11.5 | 9.5 | 4.95 | 1.2 | |
| | | 0.80 | N331.1A-115008E-M30 | ★ | ★ | | | | | ★ | ★ | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 5.00 | 1.2 | |
| | | Medium | 14 | 0.80 | N331.1A-14 50 08E-KM | | | | | | | ☆ | ☆ | ☆ | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | | 0.80 | N331.1A-14 50 08H-PM | | | ☆ | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 |
| 0.80 | N331.1A-14 50 08H-WM | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 | |
| 0.80 | N331.1A-14 50 08M-KM | | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 | |
| 0.80 | N331.1A-14 50 08M-PM | | | | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| 0.80 | N331.1A-145008E-M30 | | | ★ | ★ | | | | | ★ | ★ | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 5.00 | 1.2 |



1116



1154



1175



N23



N6

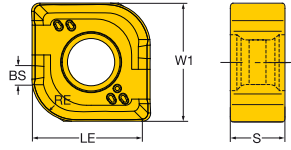
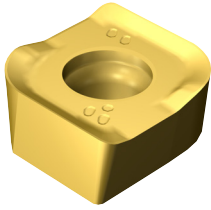


N10

CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor made.

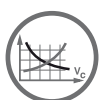
KRINS 90°



| | | SSC | RE | Ordering code | P | | M | | | | | K | N | S | | H | Dimensions, mm | | | |
|--------|-----|-----|------|------------------------|------|------|------|------|------|------|------|------|------|------|------|------|----------------|------|------|-----|
| | | | | | 1130 | 4330 | 1040 | 1130 | 2040 | S30T | 1020 | 3040 | 1130 | 1130 | 2040 | S30T | 1130 | W1 | LE | S |
| Light | L50 | 11 | 3.05 | R/L331.1A-115030E-L50 | | | ★ | ☆ | ☆ | | | | | | ☆ | ★ | 11.5 | 10.7 | 5.00 | 1.3 |
| | | | 4.00 | R/L331.1A-115040E-L50 | | | ★ | ☆ | ☆ | | | | | | ☆ | ★ | 11.5 | 10.7 | 5.00 | 1.4 |
| | | | 4.83 | R/L331.1A-115048E-L50 | | | ★ | ☆ | ☆ | | | | | | ☆ | ★ | 11.5 | 10.7 | 5.00 | 1.5 |
| | | | 6.35 | R/L331.1A-115063E-L50 | | | ★ | ☆ | ☆ | | | | | | ☆ | ★ | 11.5 | 10.7 | 5.00 | 1.6 |
| Medium | M30 | 11 | 1.52 | R/L331.1A-115015E-M30 | ★ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | | ☆ | ☆ | 11.5 | 10.7 | 5.00 | 1.2 |
| | | | 2.29 | R/L331.1A-115023E-M30 | ★ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | | ☆ | ☆ | 11.5 | 10.7 | 5.00 | 1.2 |
| | | | 3.05 | R/L331.1A-115030E-M30 | ★ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | | ☆ | ☆ | 11.5 | 10.7 | 5.00 | 1.3 |
| | WM | 08 | 4.00 | R/L331.1A-08 45 40H-WM | ★ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | | ☆ | ☆ | 9.5 | 7.7 | 4.45 | 1.4 |
| | | 11 | 4.00 | R/L331.1A-11 50 40H-WM | ★ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | | ☆ | ☆ | 11.5 | 10.7 | 4.95 | 1.4 |
| | | 14 | 4.00 | R/L331.1A-14 50 40H-WM | ★ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | | ☆ | ☆ | 11.5 | 13.7 | 4.95 | 1.4 |



I116



I154



I175



N23



N6

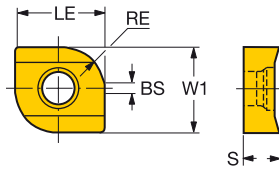
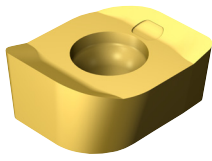


N10

CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor made.

KRINS 90°

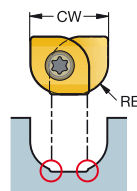


| Light | WL | RE | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | |
|-------|------|----------------------|----------------------|----------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|-----|
| | | | | P | | M | | K | | N | | S | | H | | | | | |
| | | | | 1130 | 4340 | 1040 | 1130 | 1025 | 4340 | 1130 | H10F | 1040 | 1130 | S30T | H10F | 1130 | W1 | LE | S |
| 04 | 1.52 | L331.1A-04 35 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 4.6 | 3.50 | 0.4 | |
| | 2.29 | L331.1A-04 35 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 4.6 | 3.50 | 0.4 | |
| | 1.52 | R331.1A-04 35 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 4.6 | 3.50 | 0.4 | |
| | 2.29 | R331.1A-04 35 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 4.6 | 3.50 | 0.4 | |
| | 05 | 1.52 | L331.1A-05 45 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 2.29 | L331.1A-05 45 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 3.05 | L331.1A-05 45 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 5.7 | 4.45 | 1.3 |
| | | 1.52 | R331.1A-05 45 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 2.29 | R331.1A-05 45 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 5.7 | 4.45 | 1.2 |
| | | 3.05 | R331.1A-05 45 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 5.7 | 4.45 | 1.3 |
| | 08 | 1.52 | L331.1A-08 45 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 7.7 | 4.45 | 1.2 |
| | | 2.29 | L331.1A-08 45 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 7.7 | 4.45 | 1.2 |
| 3.05 | | L331.1A-08 45 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 7.7 | 4.45 | 1.3 | |
| 1.52 | | R331.1A-08 45 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 7.7 | 4.45 | 1.2 | |
| 2.29 | | R331.1A-08 45 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 7.7 | 4.45 | 1.2 | |
| 3.05 | | R331.1A-08 45 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 9.5 | 7.7 | 4.45 | 1.3 | |
| 11 | 1.52 | L331.1A-11 50 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.2 | |
| | 2.29 | L331.1A-11 50 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.2 | |
| | 3.05 | L331.1A-11 50 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.3 | |
| | 4.83 | L331.1A-11 50 48H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.5 | |
| | 6.35 | L331.1A-11 50 63H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.6 | |
| | 1.52 | R331.1A-11 50 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.2 | |
| | 2.29 | R331.1A-11 50 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.2 | |
| | 3.05 | R331.1A-11 50 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.3 | |
| | 4.83 | R331.1A-11 50 48H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.5 | |
| | 6.35 | R331.1A-11 50 63H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 10.7 | 4.95 | 1.6 | |
| | 14 | 1.52 | L331.1A-14 50 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.2 |
| | | 2.29 | L331.1A-14 50 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.2 |
| 3.05 | | L331.1A-14 50 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.3 | |
| 4.83 | | L331.1A-14 50 48H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.5 | |
| 6.35 | | L331.1A-14 50 63H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.6 | |
| 1.52 | | R331.1A-14 50 15H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.2 | |
| 2.29 | | R331.1A-14 50 23H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.2 | |
| 3.05 | | R331.1A-14 50 30H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.3 | |
| 4.83 | | R331.1A-14 50 48H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.5 | |
| 6.35 | | R331.1A-14 50 63H-WL | * | * | * | * | * | * | * | * | * | * | * | * | 11.5 | 13.7 | 4.95 | 1.6 | |

Limitations when using inserts with large corner radius

Full slot milling

| Insert size | Calculated CW |
|-------------|-----------------|
| 04 | $CW = RE + 4.6$ |
| 05 | $CW = RE + 6$ |
| 08 | $CW = RE + 8$ |
| 11 | $CW = RE + 11$ |



1116



1154



1175



N23



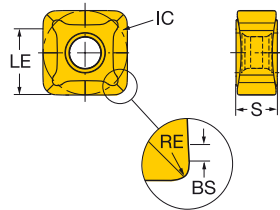
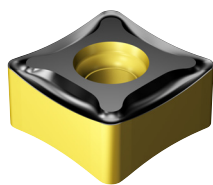
N6



N10

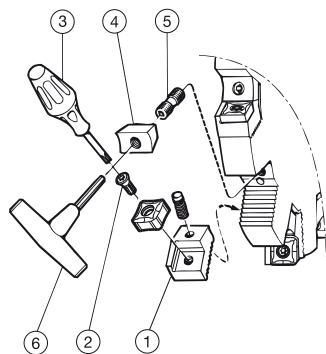
CoroMill® 331 insert for side and face milling

KRINS 88°



| | RE | Ordering code | Dimensions, mm | | | | | | | IC | LE | S | BS | | | | |
|--------------|----|---------------|--------------------|------|------|------|------|------|------|----|----|---|----|------|------|------|------|
| | | | 1130 | 4220 | 4330 | 4340 | 1130 | 1020 | 3040 | | | | | 3330 | 1130 | 1130 | 1130 |
| Medium PM | 13 | 0.80 | N331.1D-136508E-PM | ☆ | | ★ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | 13.4 | 11.4 | 6.55 | 1.2 |
| | | 0.80 | N331.1D-136508M-PM | | ☆ | ★ | | ☆ | ☆ | ★ | | ☆ | ☆ | 13.4 | 11.4 | 6.55 | 1.2 |
| | | 1.20 | N331.1D-136512M-PM | | ☆ | | | ☆ | ☆ | ★ | | ☆ | ☆ | 13.4 | 11.0 | 6.55 | 1.2 |
| | | 2.00 | N331.1D-136520E-PM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | 13.4 | 10.2 | 6.55 | 1.2 |
| | | 2.00 | N331.1D-136520M-PM | | ☆ | | | ☆ | ☆ | ★ | | ☆ | ☆ | 13.4 | 10.2 | 6.55 | 1.2 |

These double sided inserts need optional cassettes. See below for more information.



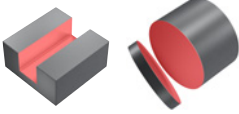
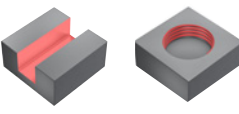
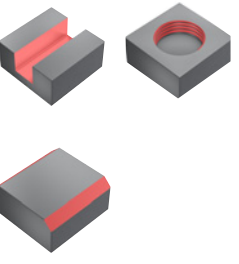


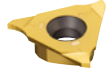


Note that the diameter of the cutter increases by 3.2 mm when using the cassettes for double sided inserts.

| Cutter type | 1 | 1 | 2 | 3 | 4 | 5 | 6 |
|----------------------------------|----------------|---------------|-------------|--------------------|-----------------------------|-------------|---------|
| | | | | | | | |
| | Cassette Right | Cassette Left | Screw | Key (Torx Plus) | Torque wrench ¹⁾ | Wedge | Screw |
| QM (a _b 20.5–23.5 mm) | 5321 260-01 | 5321 260-02 | 5513 020-25 | 5680 046-02 (15IP) | 5680 100-06 | 5431 105-05 | 339-831 |
| RM (a _b 23.5–26.5 mm) | 5321 260-01 | 5321 260-02 | 5513 020-25 | 5680 046-02 (15IP) | 5680 100-06 | 5431 105-05 | 339-831 |

1) Optional part to be ordered separately.



Groove- thread- and chamfer milling tools

| | CoroMill® QD | CoroMill® 328 | CoroMill® 327 | CoroMill® 495 |
|------------------|---|---|--|---|
| Page | Groove milling I136 | Groove milling I142 Thread milling I148 | Groove milling I145 Thread milling I149 Chamfer milling I150 | Chamfer milling I151 |
| Material | P M K N S H | P M K N S | P M K N S | P M K N S |
| Main operation |  |  |  |  |
| DC mm | 63 - 315 | 39 - 80 | 9.7 - 34.7 | 12 - 63 |
| APMX mm | | 6 | 6 - 10 | 3.8 - 7.7 |
| CW mm | 2 - 6.35 | 1.3 - 5.15 | 0.7 - 5.15 | |
| CDX mm | 21.0 - 117.5 | 3.0 - 5.0 | 0.5 - 10.0 | |
| Insert |  |  |  |  |
| Insert sizes | E,F,G,H,J,K | 13 | 06, 09, 12, 14 | 09 |
| Couplings | Arbor with driving screws Cylindrical shank | Bore with keyway Weldon Arbor | Coromant Capto® Short Weldon Integrated ER collets | Coromant Capto® Cylindrical shank Weldon Coromant EH |
| Internal coolant | ✓ | ✗ | ✓ | ✓ |
| Options | | | | Angles available: 15°, 30°, 45°, 60° |

CoroMill® QD

High-security groove milling and parting off

Application

- Deep grooving
- Parting off
- External and internal machining
- Roughing to finishing

ISO application area:



Benefits and features

- Quality grooves without chip issues
- Very secure tools with great reliability
- Quick and easy insert changes



www.sandvik.coromant.com/coromillqd

Couplings

- Cylindrical shank
- Arbor

Inserts

E- and M-tolerance inserts for a wide range of widths and materials. Inserts with extra long parallel land available for extra high-quality surface finish. Available in steel milling grade GC1130 with Zertivo™ technology for long and predictable tool life.

Driving collar

By using driving collars for extra stability, groove milling with high cutting depth/width ratio (exceeding 15) can be performed with maintained excellent quality.

Smaller driving collars can be used together with face mill adapters in large machining centers as a cost-efficient solution.



Internal coolant

The internal coolant solution provides great chip evacuation. By getting rid of chip issues, surface quality is improved and machining security ensured. Internal coolant also helps regulate the heat at the cutting zone, which is especially beneficial for ISO S materials.



I137



I140

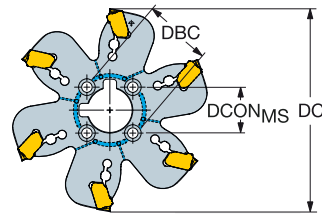
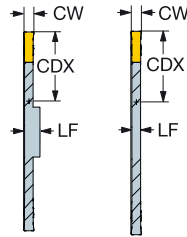


N6

CoroMill® QD indexable grooving and parting off cutter

Arbor - Internal coolant supply

KAPR 90°



SSC: E, F G, H, J, K

| | | | | | | | Dimensions, mm | | | | | | | | | |
|------|-----|------|-----|-------------------|------|----|----------------|--------------------|------|------|-------|----|------|------|--------------------|--|
| CW | DC | CDX | SSC | CZC _{MS} | CNSC | | Ordering code | DCON _{MS} | DBC | LF | DRVCT | | | RPMX | MIID | |
| 2.00 | 80 | 24.0 | E | X10 | 4 | 5 | QD-EC080X10-M | 10.0 | 22.0 | 2.65 | 0 | 50 | 0.12 | 4300 | QD-NE-0200-020E-PM | |
| | 100 | 30.0 | E | X22 | 4 | 8 | QD-EC100X22-M | 22.0 | 32.0 | 2.65 | 2 | 50 | 0.14 | 3900 | QD-NE-0200-020E-PM | |
| | 125 | 31.0 | E | X32 | 4 | 10 | QD-EC125X32-M | 32.0 | 45.0 | 2.65 | 2 | 50 | 0.25 | 3500 | QD-NE-0200-020E-PM | |
| | 160 | 40.0 | E | X40 | 4 | 12 | QD-EC160X40-M | 40.0 | 63.0 | 2.65 | 2 | 50 | 0.32 | 3000 | QD-NE-0200-020E-PM | |
| 2.50 | 80 | 24.0 | F | X10 | 4 | 5 | QD-FC080X10-M | 10.0 | 22.0 | 2.65 | 0 | 50 | 0.13 | 5000 | QD-NF-0250-020E-PM | |
| | 100 | 30.0 | F | X22 | 4 | 8 | QD-FC100X22-M | 22.0 | 32.0 | 2.65 | 2 | 50 | 0.15 | 4400 | QD-NF-0250-020E-PM | |
| | 125 | 31.0 | F | X32 | 4 | 10 | QD-FC125X32-M | 32.0 | 45.0 | 2.65 | 2 | 50 | 0.28 | 4000 | QD-NF-0250-020E-PM | |
| | 160 | 40.0 | F | X40 | 4 | 12 | QD-FC160X40-M | 40.0 | 63.0 | 2.65 | 2 | 50 | 0.36 | 3500 | QD-NF-0250-020E-PM | |
| 3.00 | 80 | 24.0 | G | X10 | 4 | 5 | QD-GC080X10-M | 10.0 | 22.0 | 2.70 | 0 | 70 | 0.14 | 6100 | QD-NG-0300-020E-PM | |
| | 100 | 30.0 | G | X22 | 4 | 8 | QD-GC100X22-M | 22.0 | 32.0 | 2.70 | 2 | 70 | 0.17 | 5500 | QD-NG-0300-020E-PM | |
| | 125 | 31.0 | G | X32 | 4 | 10 | QD-GC125X32-M | 32.0 | 45.0 | 2.70 | 2 | 70 | 0.30 | 4900 | QD-NG-0300-020E-PM | |
| | 160 | 40.0 | G | X40 | 4 | 12 | QD-GC160X40-M | 40.0 | 63.0 | 2.70 | 2 | 70 | 0.40 | 4300 | QD-NG-0300-020E-PM | |
| 4.00 | 80 | 24.0 | H | X10 | 4 | 4 | QD-HC080X10-M | 10.0 | 22.0 | 3.65 | 0 | 70 | 0.14 | 5000 | QD-NH-0400-025E-PM | |
| | 100 | 30.0 | H | X22 | 4 | 6 | QD-HC100X22-M | 22.0 | 32.0 | 3.65 | 2 | 70 | 0.19 | 4400 | QD-NH-0400-025E-PM | |
| | 125 | 31.0 | H | X32 | 4 | 8 | QD-HC125X32-M | 32.0 | 45.0 | 3.65 | 2 | 70 | 0.33 | 4000 | QD-NH-0400-025E-PM | |
| | 160 | 40.0 | H | X40 | 4 | 12 | QD-HC160X40-M | 40.0 | 63.0 | 3.65 | 2 | 70 | 0.48 | 3500 | QD-NH-0400-025E-PM | |
| 5.00 | 100 | 30.0 | J | X22 | 4 | 6 | QD-JC100X22-M | 22.0 | 32.0 | 4.65 | 2 | 70 | 0.22 | 3800 | QD-NJ-0500-030E-PM | |
| | 125 | 31.0 | J | X32 | 4 | 8 | QD-JC125X32-M | 32.0 | 45.0 | 4.65 | 2 | 70 | 0.39 | 3400 | QD-NJ-0500-030E-PM | |
| | 160 | 40.0 | J | X40 | 4 | 10 | QD-JC160X40-M | 40.0 | 63.0 | 4.65 | 2 | 70 | 0.56 | 3000 | QD-NJ-0500-030E-PM | |
| 6.00 | 100 | 30.0 | K | X22 | 4 | 6 | QD-KC100X22-M | 22.0 | 32.0 | 5.65 | 2 | 70 | 0.24 | 3900 | QD-NK-0600-035E-PM | |
| | 125 | 31.0 | K | X32 | 4 | 8 | QD-KC125X32-M | 32.0 | 45.0 | 5.65 | 2 | 70 | 0.44 | 3500 | QD-NK-0600-035E-PM | |
| | 160 | 40.0 | K | X40 | 4 | 10 | QD-KC160X40-M | 40.0 | 63.0 | 5.65 | 2 | 70 | 0.65 | 3000 | QD-NK-0600-035E-PM | |

Note: coupling X40 uses cap screws, these are included with the adaptor.

| Spare parts | |
|-------------|-------------|
| DC | Screw |
| 80.00 | 5513 015-11 |
| 100.00 | 5513 015-10 |
| 125.00 | 5513 015-09 |

For complete list of spare parts, see www.sandvik.coromant.com



1140



L2



N23



N6

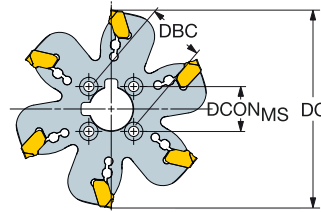
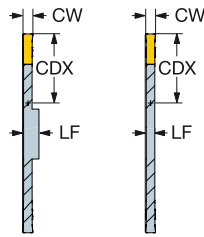


N15

CoroMill® QD indexable grooving and parting off cutter

Arbor

KAPR 90°



SSC: E, F G, H, J, K

| | | Dimensions, mm | | | | | | | | | | | |
|------|-----|----------------|-----|-------------------|----|---------------|--------------------|------|------|-------|------|------|--------------------|
| CW | DC | CDX | SSC | CZC _{MS} | | Ordering code | DCON _{MS} | DBC | LF | DRVCT | | RPMX | MIID |
| 2.00 | 80 | 24.0 | E | X10 | 5 | QD-E-080X10-M | 10.0 | 22.0 | 2.65 | 0 | 0.12 | 4300 | QD-NE-0200-020E-PM |
| | 100 | 30.0 | E | X22 | 8 | QD-E-100X22-M | 22.0 | 32.0 | 2.65 | 2 | 0.14 | 3900 | QD-NE-0200-020E-PM |
| | 125 | 31.0 | E | X32 | 10 | QD-E-125X32-M | 32.0 | 45.0 | 2.65 | 2 | 0.25 | 3500 | QD-NE-0200-020E-PM |
| | 160 | 40.0 | E | X40 | 12 | QD-E-160X40-M | 40.0 | 63.0 | 2.65 | 2 | 0.32 | 3000 | QD-NE-0200-020E-PM |
| | 200 | 60.0 | E | X40 | 16 | QD-E-200X40-M | 40.0 | 63.0 | 2.65 | 2 | 0.64 | 2700 | QD-NE-0200-020E-PM |
| 2.50 | 80 | 24.0 | F | X10 | 5 | QD-F-080X10-M | 10.0 | 22.0 | 2.65 | 0 | 0.13 | 5000 | QD-NF-0250-020E-PM |
| | 100 | 30.0 | F | X22 | 8 | QD-F-100X22-M | 22.0 | 32.0 | 2.65 | 2 | 0.16 | 4400 | QD-NF-0250-020E-PM |
| | 125 | 31.0 | F | X32 | 10 | QD-F-125X32-M | 32.0 | 45.0 | 2.65 | 2 | 0.28 | 4000 | QD-NF-0250-020E-PM |
| | 160 | 40.0 | F | X40 | 12 | QD-F-160X40-M | 40.0 | 63.0 | 2.65 | 2 | 0.36 | 3500 | QD-NF-0250-020E-PM |
| | 200 | 60.0 | F | X40 | 16 | QD-F-200X40-M | 40.0 | 63.0 | 2.65 | 2 | 0.73 | 3100 | QD-NF-0250-020E-PM |
| | 250 | 85.0 | F | X40 | 20 | QD-F-250X40-M | 40.0 | 63.0 | 2.70 | 2 | 0.98 | 2800 | QD-NF-0250-020E-PM |
| 3.00 | 80 | 24.0 | G | X10 | 5 | QD-G-080X10-M | 10.0 | 22.0 | 2.70 | 0 | 0.14 | 6100 | QD-NG-0300-020E-PM |
| | 100 | 30.0 | G | X22 | 8 | QD-G-100X22-M | 22.0 | 32.0 | 2.70 | 2 | 0.17 | 5500 | QD-NG-0300-020E-PM |
| | 125 | 31.0 | G | X32 | 10 | QD-G-125X32-M | 32.0 | 45.0 | 2.70 | 2 | 0.30 | 4900 | QD-NG-0300-020E-PM |
| | 160 | 40.0 | G | X40 | 12 | QD-G-160X40-M | 40.0 | 63.0 | 2.70 | 2 | 0.40 | 4300 | QD-NG-0300-020E-PM |
| | 200 | 60.0 | G | X40 | 16 | QD-G-200X40-M | 40.0 | 63.0 | 2.70 | 2 | 0.79 | 3800 | QD-NG-0300-020E-PM |
| | 250 | 85.0 | G | X40 | 20 | QD-G-250X40-M | 40.0 | 63.0 | 2.70 | 2 | 1.09 | 3400 | QD-NG-0300-020E-PM |
| | 315 | 117.5 | G | X40 | 24 | QD-G-315X40-M | 40.0 | 63.0 | 2.70 | 2 | 1.90 | 3100 | QD-NG-0300-020E-PM |
| 4.00 | 80 | 24.0 | H | X10 | 4 | QD-H-080X10-M | 10.0 | 22.0 | 3.65 | 0 | 0.15 | 5000 | QD-NH-0400-025E-PM |
| | 100 | 30.0 | H | X22 | 6 | QD-H-100X22-M | 22.0 | 32.0 | 3.65 | 2 | 0.19 | 4400 | QD-NH-0400-025E-PM |
| | 125 | 31.0 | H | X32 | 8 | QD-H-125X32-M | 32.0 | 45.0 | 3.65 | 2 | 0.34 | 4000 | QD-NH-0400-025E-PM |
| | 160 | 40.0 | H | X40 | 12 | QD-H-160X40-M | 40.0 | 63.0 | 3.65 | 2 | 0.48 | 3500 | QD-NH-0400-025E-PM |
| | 200 | 60.0 | H | X40 | 14 | QD-H-200X40-M | 40.0 | 63.0 | 3.65 | 2 | 0.94 | 3100 | QD-NH-0400-025E-PM |
| | 250 | 85.0 | H | X40 | 20 | QD-H-250X40-M | 40.0 | 63.0 | 3.65 | 2 | 1.41 | 2800 | QD-NH-0400-025E-PM |
| | 315 | 117.5 | H | X40 | 24 | QD-H-315X40-M | 40.0 | 63.0 | 3.65 | 2 | 2.39 | 2500 | QD-NH-0400-025E-PM |
| 5.00 | 100 | 30.0 | J | X22 | 6 | QD-J-100X22-M | 22.0 | 32.0 | 4.65 | 2 | 0.22 | 3800 | QD-NJ-0500-030E-PM |
| | 125 | 31.0 | J | X32 | 8 | QD-J-125X32-M | 32.0 | 45.0 | 4.65 | 2 | 0.39 | 3400 | QD-NJ-0500-030E-PM |
| | 160 | 40.0 | J | X40 | 10 | QD-J-160X40-M | 40.0 | 63.0 | 4.65 | 2 | 0.55 | 3000 | QD-NJ-0500-030E-PM |
| | 200 | 60.0 | J | X40 | 14 | QD-J-200X40-M | 40.0 | 63.0 | 4.65 | 2 | 1.10 | 2700 | QD-NJ-0500-030E-PM |
| | 250 | 85.0 | J | X40 | 18 | QD-J-250X40-M | 40.0 | 63.0 | 4.65 | 2 | 1.62 | 2400 | QD-NJ-0500-030E-PM |
| | 315 | 117.5 | J | X40 | 24 | QD-J-315X40-M | 40.0 | 63.0 | 4.65 | 2 | 2.85 | 2100 | QD-NJ-0500-030E-PM |
| 6.00 | 100 | 30.0 | K | X22 | 6 | QD-K-100X22-M | 22.0 | 32.0 | 5.65 | 2 | 0.25 | 3900 | QD-NK-0600-035E-PM |
| | 125 | 31.0 | K | X32 | 8 | QD-K-125X32-M | 32.0 | 45.0 | 5.65 | 2 | 0.44 | 3500 | QD-NK-0600-035E-PM |
| | 160 | 40.0 | K | X40 | 10 | QD-K-160X40-M | 40.0 | 63.0 | 5.65 | 2 | 0.65 | 3000 | QD-NK-0600-035E-PM |
| | 200 | 60.0 | K | X40 | 14 | QD-K-200X40-M | 40.0 | 63.0 | 5.65 | 2 | 1.27 | 2700 | QD-NK-0600-035E-PM |
| | 250 | 85.0 | K | X40 | 18 | QD-K-250X40-M | 40.0 | 63.0 | 5.65 | 2 | 1.92 | 2400 | QD-NK-0600-035E-PM |
| | 315 | 117.5 | K | X40 | 24 | QD-K-315X40-M | 40.0 | 63.0 | 5.65 | 2 | 3.32 | 2200 | QD-NK-0600-035E-PM |

Note: coupling X40 uses cap screws, these are included with the adaptor.

| | |
|--------|-------------|
| | Spare parts |
| DC | Screw |
| 80.00 | 5513 015-11 |
| 100.00 | 5513 015-10 |
| 125.00 | 5513 015-09 |

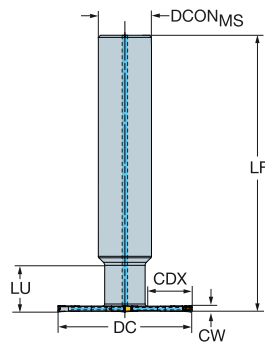
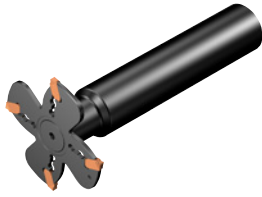
For complete list of spare parts, see www.sandvik.coromant.com






CoroMill® QD indexable grooving and parting off cutter

Cylindrical shank - Internal coolant supply

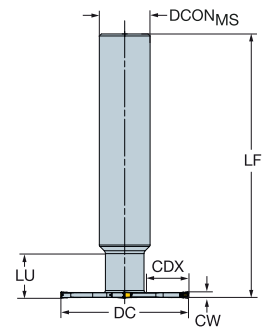
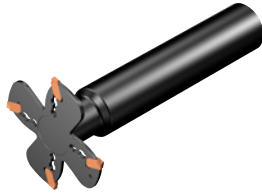
KAPR 90°





| | | | | | | | Dimensions, mm | | | | | | | | | |
|------|----|------|-----|-------------------|------|---|----------------|--------------------|--------|----|---|---|------|------|------|--------------------|
| CW | DC | CDX | SSC | CZC _{MS} | CNSC |  | Ordering code | DCON _{MS} | LF | LU |  |  | RPMX | BD | LB | MIID |
| 2.00 | 63 | 21.0 | E | 25 | 4 | 4 | QD-EC063A25-M | 25.0 | 130.00 | 23 | 70 | 0.67 | 4900 | 19.0 | 21.8 | QD-NE-0200-020E-PM |
| 2.50 | 63 | 21.0 | F | 25 | 4 | 4 | QD-FC063A25-M | 25.0 | 130.00 | 23 | 70 | 0.68 | 5600 | 19.0 | 22.3 | QD-NF-0250-020E-PM |
| 3.00 | 63 | 21.0 | G | 25 | 4 | 4 | QD-GC063A25-M | 25.0 | 130.00 | 24 | 70 | 0.68 | 6900 | 19.0 | 22.7 | QD-NG-0300-020E-PM |
| 5.00 | 80 | 26.5 | J | 32 | 4 | 4 | QD-JC080A32-M | 32.0 | 130.00 | 26 | 70 | 1.05 | 4200 | 25.0 | 24.7 | QD-NJ-0500-030E-PM |
| 6.00 | 80 | 26.5 | K | 32 | 4 | 4 | QD-KC080A32-M | 32.0 | 130.00 | 27 | 70 | 1.06 | 4300 | 25.0 | 25.7 | QD-NK-0600-035E-PM |

Cylindrical shank

KAPR 90°



| | | | | | | | Dimensions, mm | | | | | | | | | |
|------|----|------|-----|-------------------|------|---|----------------|--------------------|--------|----|---|------|------|------|--------------------|--|
| CW | DC | CDX | SSC | CZC _{MS} | CNSC |  | Ordering code | DCON _{MS} | LF | LU |  | RPMX | BD | LB | MIID | |
| 2.00 | 63 | 21.0 | E | 25 | 4 | 4 | QD-E-063A25-M | 25.0 | 130.00 | 23 | 0.69 | 4900 | 19.0 | 21.8 | QD-NE-0200-020E-PM | |
| 2.50 | 63 | 21.0 | F | 25 | 4 | 4 | QD-F-063A25-M | 25.0 | 130.00 | 23 | 0.68 | 5600 | 19.0 | 22.3 | QD-NF-0250-020E-PM | |
| 3.00 | 63 | 21.0 | G | 25 | 4 | 4 | QD-G-063A25-M | 25.0 | 130.00 | 24 | 0.70 | 6900 | 19.0 | 22.7 | QD-NG-0300-020E-PM | |
| 5.00 | 80 | 26.5 | J | 32 | 4 | 4 | QD-J-080A32-M | 32.0 | 130.00 | 26 | 1.08 | 4200 | 25.0 | 24.7 | QD-NJ-0500-030E-PM | |
| 6.00 | 80 | 26.5 | K | 32 | 4 | 4 | QD-K-080A32-M | 32.0 | 130.00 | 27 | 1.07 | 4300 | 25.0 | 25.7 | QD-NK-0600-035E-PM | |

Spare parts

Coolant plug
5643 028-02

For complete list of spare parts, see www.sandvik.coromant.com



I140



L2



N23

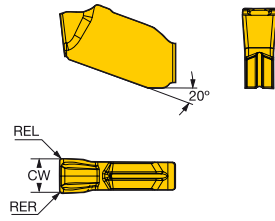
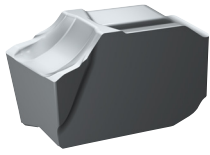


N6



N15

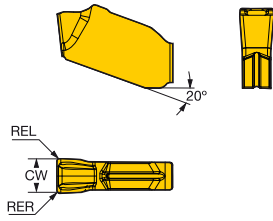
CoroMill® QD insert for grooving



| SSC | CW | REL | RER | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | |
|------|------|------|------|--------------------|--------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|----|--------|--------|-------|
| | | | | | P | | M | | K | | N | | S | | H | | | | | | | |
| | | | | | 1130 | 4340 | 1040 | 1130 | 2040 | 1020 | 3330 | 1130 | H13A | 1130 | H13A | S30T | S40T | 1130 | AN | CWTOLL | CWTOLU | |
| E | 2.00 | 0.10 | 0.10 | QD-NE-0200-010E-NL | | | | | | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-KL | | | | | | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-ML | | | * | | | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-PL | * | * | | * | | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-SL | * | * | | * | | | | | | | | * | | * | 7° | 0.005 | 0.055 | |
| | F | 2.39 | 0.10 | 0.10 | QD-NF-0239-010E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 |
| 2.50 | | 0.10 | 0.10 | QD-NF-0250-010E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| 2.50 | | 0.20 | 0.20 | QD-NF-0250-020E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| 2.50 | | 0.20 | 0.20 | QD-NF-0250-020E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| 2.50 | | 0.20 | 0.20 | QD-NF-0250-020E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| 2.50 | | 0.20 | 0.20 | QD-NF-0250-020E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |
| G | 3.00 | 0.10 | 0.10 | QD-NG-0300-010E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |
| | 3.18 | 0.10 | 0.10 | QD-NG-0318-010E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |
| H | 4.00 | 0.15 | 0.15 | QD-NH-0400-015E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |
| J | 4.76 | 0.20 | 0.20 | QD-NJ-0476-020E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |
| | 5.00 | 0.20 | 0.20 | QD-NJ-0500-020E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |
| K | 6.00 | 0.25 | 0.25 | QD-NK-0600-025E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |
| | 6.35 | 0.25 | 0.25 | QD-NK-0635-025E-NL | | | | | | | | | * | | * | | | | 7° | 0.005 | 0.055 | |
| | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-KL | | | | | | * | * | | | | | | | | 7° | 0.005 | 0.055 | |
| | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-ML | | | * | | * | | | | | | | | | | 7° | 0.005 | 0.055 | |
| | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-PL | * | * | | * | | | | | * | | * | | | * | 7° | 0.005 | 0.055 | |
| | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-SL | * | * | | * | | | | | * | | * | | * | * | 7° | 0.005 | 0.055 | |



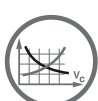
CoroMill® QD insert for grooving



| SSC | CW | REL | RER | Ordering code | Material | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|--------|------|------|------|--------------------|--------------------|------|------|--------------------|------|------|------|------|------|------|----------------|------|----|--------|---------|-------|-------|-------|-------|-------|
| | | | | | P | | M | | K | | N | | S | | H | | AN | CWTOLL | CWTOLLU | | | | | |
| | | | | | 1130 | 4340 | 1040 | 1130 | 2040 | 1020 | 3330 | 1130 | H13A | 1130 | H13A | S30T | | | | SAOT | 1130 | | | |
| Medium | E | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-MM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | | | |
| | | | | | QD-NE-0200-020E-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | |
| | | | | | QD-NE-0200-020E-SM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | |
| | | | | | QD-NE-0200-020M-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | |
| | | | | | QD-NE-0200-035M-KM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | |
| | F | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-MM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | | | |
| | | | | | QD-NF-0239-020E-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | | |
| | | | | | QD-NF-0239-020E-SM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | | |
| | | | | | QD-NF-0239-020M-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | | | | | QD-NF-0239-035M-KM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | | | | | QD-NF-0250-020E-MM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | |
| | | | | | QD-NF-0250-020E-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | |
| H | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-MM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | | | | |
| | | | | QD-NH-0400-025E-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | | | |
| | | | | QD-NH-0400-025E-SM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | | | | |
| | | | | QD-NH-0400-025M-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | | |
| | | | | QD-NH-0400-040M-KM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | | |
| | | | | J | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-MM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | |
| | | | | | | | | QD-NJ-0476-030E-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 |
| | | | | | | | | QD-NJ-0476-030E-SM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 |
| | | | | | | | | QD-NJ-0476-030M-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 |
| | | | | | | | | QD-NJ-0476-045M-KM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 |
| K | 6.00 | 0.35 | 0.35 | | | | | QD-NK-0600-035E-MM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 | |
| | | | | | | | | QD-NK-0600-035E-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 |
| | | | | | | | | QD-NK-0600-035E-SM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.055 |
| | | | | | | | | QD-NK-0600-035M-PM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 |
| | | | | | | | | QD-NK-0600-050M-KM | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 |
| Heavy | E | 2.00 | 0.35 | 0.35 | QD-NE-0200-035M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | | | |
| | | | | | QD-NF-0239-035M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | | |
| | | | | | QD-NF-0250-035M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | | | | | QD-NG-0300-035M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | | | | | QD-NG-0318-035M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | F | 2.39 | 0.35 | 0.35 | QD-NH-0400-040M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | | |
| | | | | | QD-NJ-0476-045M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | | | | | QD-NJ-0500-045M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | | | | | QD-NK-0600-050M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |
| | | | | | QD-NK-0635-050M-PH | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | ★ | 7° | 0.005 | 0.105 | | | |



1137



1154



1175



N23



N6



N10



CoroMill® 328

Grooving, threading and circlip grooving

Application

- Thread milling
- Grooving
- Circlip grooving

ISO application area:



Benefits and features

- Inserts mounted in pockets for safe and stable mounting
- Large programme of inserts covering circlips, slots, threads, etc.
- Sharp precision-ground insert
- Different thread pitches possible with one tool
- Excellent for both internal and external machining
- Comes in four tool holder sizes with the same insert size
- Sharp cutting edges for high quality grooves without burr
- One grade; PVD coated GC1025 for all materials
- Multiple edges for economic machining



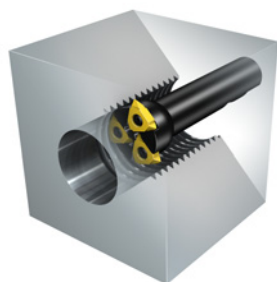
www.sandvik.coromant.com/coromill328

Couplings

- Arbor
- Weldon
- Bore with keyway

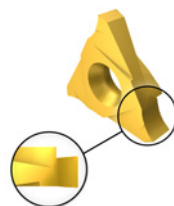
Inserts

- Three cutting edges

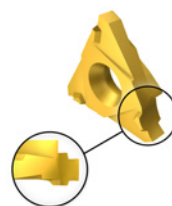


Thread forms: V-profile 60°, M 60° and UN 60°

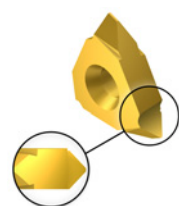
Circlip grooving



Circlip grooving with chamfer



Thread milling



I143

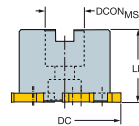
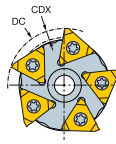


I144

CoroMill® 328 groove milling cutter

Arbor

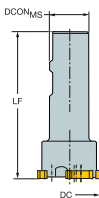
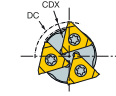
STDNO ISO6462
KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|----|-----|----|-------------------|---|----------------|--------------------|-----|-------|------|-----|------|-------|------|------|------------------|--|
| CW | DC | CDX | | CZC _{MS} | | Ordering code | DCON _{MS} | ISO | LF | DHUB | | | RPMX | BD | LB | MIID | |
| 1.30 | 63 | 5.0 | 13 | 22 | 5 | 328-063Q22-13M | 22.0 | A | 40.00 | 51.0 | 6.5 | 0.84 | 11900 | 51.0 | 40.0 | 328R13-130 00-GM | |

Weldon

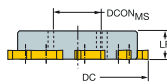
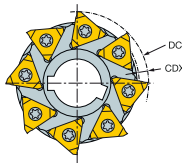
KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|----|-----|----|-------------------|---|----------------|--------------------|-----|--------|-----|------|-------|------|------|------------------|--|--|
| CW | DC | CDX | | CZC _{MS} | | Ordering code | DCON _{MS} | ISO | LF | | | RPMX | BD | LB | MIID | | |
| 1.30 | 39 | 3.0 | 13 | 25 | 2 | 328-039B25-13M | 25.0 | WE | 125.00 | 6.5 | 0.59 | 19300 | 32.0 | 69.0 | 328R13-130 00-GM | | |
| | 44 | 4.0 | 13 | 25 | 3 | 328-044B25-13M | 25.0 | WE | 125.00 | 6.5 | 0.61 | 17100 | 34.0 | 69.0 | 328R13-130 00-GM | | |

Bore with keyway

KAPR 90°



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|------|----|-----|----|-------------------|---|----------------|--------------------|-------|-------|------|-----|------|-------|------|------|------------------|--|
| CW | DC | CDX | | CZC _{MS} | | Ordering code | DCON _{MS} | LF | DRVCT | DHUB | | | RPMX | BD | LB | MIID | |
| 1.30 | 63 | 5.0 | 13 | 22 | 5 | 328-063S22-13M | 22.0 | 14.00 | 1 | 51.0 | 6.5 | 0.22 | 11900 | 51.0 | 14.0 | 328R13-130 00-GM | |
| | 80 | 5.0 | 13 | 27 | 8 | 328-080S27-13M | 27.0 | 16.00 | 1 | 68.0 | 6.5 | 0.64 | 9400 | 68.0 | 16.0 | 328R13-130 00-GM | |

Spare parts

Insert screw
5513 039-05

For complete list of spare parts, see www.sandvik.coromant.com



I144



L2



M1

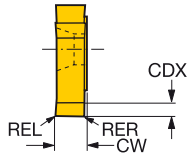
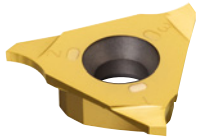


N23



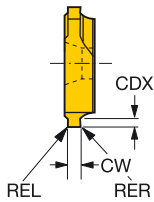
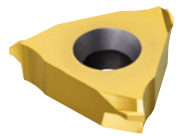
N12

CoroMill® 328 insert for groove milling



For circlip grooves

| | | | | | | P | M | K | N | S | H | Dimensions, mm | | | | |
|--------|------|------|------|------|------------------|------------------|------|------|------|------|----|----------------|--------|--------|--------|--------|
| | | | | | | 1025 | 1025 | 1025 | 1025 | 1025 | | AN | CWTOLL | CWTOLU | RETOLL | RETOLU |
| SSC | CW | REL | RER | CDX | Ordering code | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | |
| Medium | 13 | 1.30 | 0.10 | 0.10 | 5.00 | 328R13-130 00-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 1.60 | 0.10 | 0.10 | 5.00 | 328R13-160 00-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 1.85 | 0.15 | 0.15 | 5.00 | 328R13-185 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 2.15 | 0.15 | 0.15 | 5.00 | 328R13-215 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 2.65 | 0.15 | 0.15 | 5.00 | 328R13-265 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 3.15 | 0.15 | 0.15 | 5.00 | 328R13-315 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 4.15 | 0.15 | 0.15 | 5.00 | 328R13-415 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | 5.15 | 0.15 | 0.15 | 5.00 | 328R13-515 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 | |

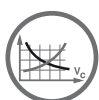


For circlip grooves and chamfering

| | | | | | | P | M | K | N | S | H | Dimensions, mm | | | | |
|--------|----|------|------|------|---------------|--------------------|------|------|------|------|---|----------------|--------|--------|--------|--------|
| | | | | | | 1025 | 1025 | 1025 | 1025 | 1025 | | AN | CWTOLL | CWTOLU | RETOLL | RETOLU |
| SSC | CW | REL | RER | CDX | Ordering code | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | |
| Medium | 13 | 1.85 | 0.15 | 0.15 | 1.25 | 328R13-185 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 2.15 | 0.15 | 0.15 | 1.50 | 328R13-215 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 2.65 | 0.15 | 0.15 | 1.50 | 328R13-265 4515-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 2.65 | 0.15 | 0.15 | 1.75 | 328R13-265 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 3.15 | 0.15 | 0.15 | 1.75 | 328R13-315 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 4.15 | 0.15 | 0.15 | 2.00 | 328R13-415 4520-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 4.15 | 0.15 | 0.15 | 2.50 | 328R13-415 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | 5.15 | 0.15 | 0.15 | 3.00 | 328R13-515 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |



I143



I154



I175



N23



N12

CoroMill® 327

Groove- and thread milling cutters

Application

- Thread milling
- Groove milling
- Circlip grooving
- Chamfering

ISO application area:



Benefits and features

- Low cutting forces
- Sharp cutting edges for high quality grooves without burr
- Multiple edges for highly productive and economic machining
- Large programme with different shank lengths and diameters
- Large programme of inserts covering for instance circlips, o-rings, slots and threads
- Secure locking of insert
- Through coolant
- Different thread pitches possible with one tool



www.sandvik.coromant.com/coromill327

Couplings

- Coromant Capto®
- Integrated ER collets
- Weldon steel or solid carbide shanks

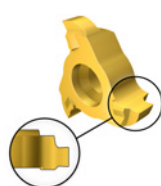
Inserts

- Insert geometries and one grade for all materials
- Sharp precision-ground insert
- Three or six teeth
- Thread forms: V-profile 60°, M 60°, UN 60° and Whitworth 55°

Grooving and circlip
grooving



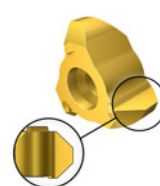
Circlip grooving with
chamfer



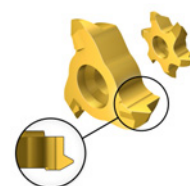
Grooving full radius



Chamfer milling



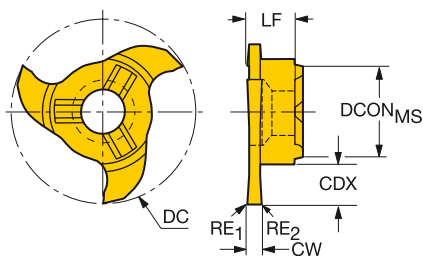
Thread milling



I146

CoroMill® 327 solid carbide head for grooving

ENG



| | | | | | | | P | M | K | N | S | Dimensions, mm | | | | | |
|------|-----------------|-----------------|-------------------|------|------|---------------------|------|------|------|------|------|--------------------|-------|------|--------|--------|-------|
| CW | RE ₁ | RE ₂ | CZC _{MS} | CDX | ZEFP | Ordering code | 1025 | 1025 | 1025 | 1025 | 1025 | DCON _{MS} | DC | LF | CWTOLL | CWTOLU | RPMX |
| 1.00 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 10000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| 1.50 | 0.20 | 0.20 | 6.0 | 1.5 | 3 | 327R06-10 15002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| 2.00 | 0.20 | 0.20 | 6.0 | 1.5 | 3 | 327R06-10 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| 2.50 | 0.20 | 0.20 | 6.0 | 1.5 | 3 | 327R06-10 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| 1.50 | 0.10 | 0.10 | 9.0 | 3.5 | 6 | 327R09-18 15001-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 1.50 | 0.20 | 0.20 | 9.0 | 3.5 | 3 | 327R09-18 15002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 2.00 | 0.20 | 0.20 | 9.0 | 3.5 | 3 | 327R09-18 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 2.00 | 0.20 | 0.20 | 9.0 | 3.5 | 6 | 327R09-18 20002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 2.50 | 0.20 | 0.20 | 9.0 | 3.5 | 3 | 327R09-18 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 2.50 | 0.20 | 0.20 | 9.0 | 3.5 | 6 | 327R09-18 25002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 3.00 | 0.20 | 0.20 | 9.0 | 3.5 | 3 | 327R09-18 30002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 3.00 | 0.20 | 0.20 | 9.0 | 3.5 | 6 | 327R09-18 30002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| 1.50 | 0.20 | 0.20 | 12.0 | 4.5 | 3 | 327R12-22 15002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| 2.00 | 0.20 | 0.20 | 12.0 | 4.5 | 3 | 327R12-22 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| 2.50 | 0.20 | 0.20 | 12.0 | 4.5 | 3 | 327R12-22 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| 3.00 | 0.20 | 0.20 | 12.0 | 4.5 | 3 | 327R12-22 30002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| 4.00 | 0.20 | 0.20 | 12.0 | 4.5 | 3 | 327R12-22 40002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| 1.50 | 0.10 | 0.10 | 12.0 | 6.5 | 6 | 327R12-28 15001-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.45 | 0.000 | 0.020 | 50000 |
| 2.00 | 0.20 | 0.20 | 12.0 | 6.4 | 6 | 327R12-28 20002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.40 | 0.000 | 0.020 | 50000 |
| 2.50 | 0.20 | 0.20 | 12.0 | 6.5 | 6 | 327R12-28 25002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.25 | 0.000 | 0.020 | 50000 |
| 3.00 | 0.20 | 0.20 | 12.0 | 6.5 | 6 | 327R12-28 30002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.25 | 0.000 | 0.020 | 50000 |
| 4.00 | 0.20 | 0.20 | 12.0 | 6.5 | 6 | 327R12-28 40002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.25 | 0.000 | 0.020 | 50000 |
| 1.50 | 0.00 | 0.00 | 14.0 | 6.5 | 3 | 327R14-28 15000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| 2.00 | 0.20 | 0.20 | 14.0 | 6.5 | 3 | 327R14-28 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| 2.50 | 0.20 | 0.20 | 14.0 | 6.5 | 3 | 327R14-28 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| 3.00 | 0.20 | 0.20 | 14.0 | 6.5 | 3 | 327R14-28 30002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| 3.50 | 0.20 | 0.20 | 14.0 | 6.5 | 3 | 327R14-28 35002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| 4.00 | 0.20 | 0.20 | 14.0 | 6.5 | 3 | 327R14-28 40002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| 1.50 | 0.10 | 0.10 | 14.0 | 10.0 | 6 | 327R14-35 15001-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |
| 2.00 | 0.20 | 0.20 | 14.0 | 10.0 | 6 | 327R14-35 20002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |
| 2.50 | 0.20 | 0.20 | 14.0 | 10.0 | 6 | 327R14-35 25002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |
| 3.00 | 0.20 | 0.20 | 14.0 | 10.0 | 6 | 327R14-35 30002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |

For circlip grooves

| | | | | | | | P | M | K | N | S | Dimensions, mm | | | | | |
|------|-----------------|-----------------|-------------------|-----|------|--------------------|------|------|------|------|------|--------------------|-------|------|--------|--------|-------|
| CW | RE ₁ | RE ₂ | CZC _{MS} | CDX | ZEFP | Ordering code | 1025 | 1025 | 1025 | 1025 | 1025 | DCON _{MS} | DC | LF | CWTOLL | CWTOLU | RPMX |
| 0.70 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 07000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.050 | 0.070 | 50000 |
| 0.80 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 08000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.050 | 0.070 | 50000 |
| 0.90 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 09000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.050 | 0.070 | 50000 |
| 1.10 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 11000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.090 | 0.110 | 50000 |
| 1.30 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 13000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.090 | 0.110 | 50000 |
| 1.60 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 16000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.090 | 0.110 | 50000 |
| 1.10 | 0.00 | 0.00 | 9.0 | 3.5 | 3 | 327R09-18 11000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.090 | 0.110 | 50000 |
| 1.30 | 0.00 | 0.00 | 9.0 | 3.5 | 3 | 327R09-18 13000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.090 | 0.110 | 50000 |
| 1.60 | 0.00 | 0.00 | 9.0 | 3.5 | 3 | 327R09-18 16000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.090 | 0.110 | 50000 |
| 1.60 | 0.00 | 0.00 | 12.0 | 4.5 | 3 | 327R12-22 16000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| 1.85 | 0.15 | 0.15 | 12.0 | 4.5 | 3 | 327R12-22 18502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| 2.15 | 0.20 | 0.20 | 12.0 | 4.5 | 3 | 327R12-22 21502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| 2.65 | 0.15 | 0.15 | 12.0 | 4.5 | 3 | 327R12-22 26502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| 3.15 | 0.15 | 0.15 | 12.0 | 4.5 | 3 | 327R12-22 31502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| 4.15 | 0.15 | 0.15 | 12.0 | 4.5 | 3 | 327R12-22 41502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| 5.15 | 0.15 | 0.15 | 12.0 | 4.5 | 3 | 327R12-22 51502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |



L2



I154



I175

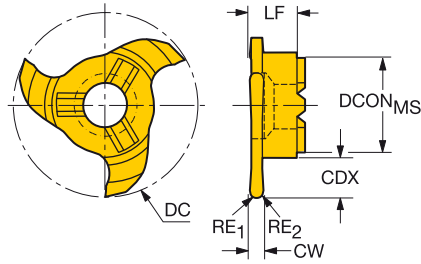


N23



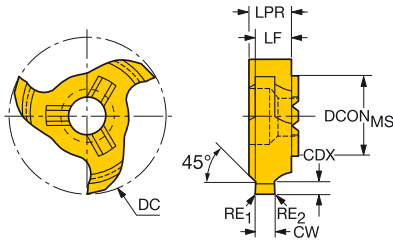
N11

CoroMill® 327 solid carbide head for grooving



For full radius grooves

| | | | | | | | P | M | K | N | S | Dimensions, mm | | | | | |
|------|-----------------|-----------------|-------------------|-----|------|--------------------|------|------|------|------|------|--------------------|-------|------|--------|--------|-------|
| CW | RE ₁ | RE ₂ | CZC _{MS} | CDX | ZEFP | Ordering code | 1025 | 1025 | 1025 | 1025 | 1025 | DCON _{MS} | DC | LF | CWTOLL | CWTOLU | RPMX |
| 2.20 | 1.10 | 1.10 | 6.0 | 2.5 | 3 | 327R06-12 22011-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 11.70 | 3.50 | 0.000 | 0.030 | 50000 |
| 2.20 | 1.10 | 1.10 | 9.0 | 3.5 | 3 | 327R09-18 22011-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.030 | 50000 |
| 1.00 | 0.50 | 0.50 | 12.0 | 4.5 | 3 | 327R12-22 10005-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.75 | 0.000 | 0.030 | 50000 |
| 2.00 | 1.00 | 1.00 | 12.0 | 4.5 | 3 | 327R12-22 20010-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.75 | 0.000 | 0.030 | 50000 |
| 3.00 | 1.50 | 1.50 | 12.0 | 4.5 | 3 | 327R12-22 30015-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.75 | 0.000 | 0.030 | 50000 |
| 4.00 | 2.00 | 2.00 | 12.0 | 4.5 | 3 | 327R12-22 40020-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.75 | 0.000 | 0.030 | 50000 |

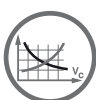


Circlip grooves with chamfer

| | | | | | | | P | M | K | N | S | Dimensions, mm | | | | | | |
|------|-----------------|-----------------|-------------------|-----|------|---------------------|------|------|------|------|------|--------------------|-------|------|------|--------|--------|-------|
| CW | RE ₁ | RE ₂ | CZC _{MS} | CDX | ZEFP | Ordering code | 1025 | 1025 | 1025 | 1025 | 1025 | DCON _{MS} | DC | LF | LPR | CWTOLL | CWTOLU | RPMX |
| 1.10 | 0.00 | 0.00 | 12.0 | 0.5 | 3 | 327R12-22 11045-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| 1.30 | 0.00 | 0.00 | 12.0 | 0.7 | 3 | 327R12-22 13045-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.20 | 5.80 | 0.090 | 0.110 | 50000 |
| 1.60 | 0.00 | 0.00 | 12.0 | 1.0 | 3 | 327R12-22 16045-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| 1.85 | 0.15 | 0.15 | 12.0 | 1.3 | 3 | 327R12-22 18545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.20 | 5.80 | 0.090 | 0.110 | 50000 |
| 2.15 | 0.15 | 0.15 | 12.0 | 1.5 | 3 | 327R12-22 21545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.85 | 0.090 | 0.110 | 50000 |
| 2.65 | 0.15 | 0.15 | 12.0 | 1.5 | 3 | 327R12-22 26545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| 3.15 | 0.20 | 0.20 | 12.0 | 1.8 | 3 | 327R12-22 31545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.80 | 0.090 | 0.110 | 50000 |
| 4.15 | 0.20 | 0.20 | 12.0 | 2.0 | 3 | 327R12-22 41545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.85 | 0.090 | 0.110 | 50000 |
| 1.30 | 0.00 | 0.00 | 12.0 | 0.8 | 3 | 327R12-221304508-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.20 | 5.80 | 0.090 | 0.110 | 50000 |
| 1.60 | 0.00 | 0.00 | 12.0 | 0.8 | 3 | 327R12-221604508-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| 2.65 | 0.15 | 0.15 | 12.0 | 1.8 | 3 | 327R12-222654518-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| 4.15 | 0.20 | 0.20 | 12.0 | 2.5 | 3 | 327R12-224154525-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.85 | 0.090 | 0.110 | 50000 |



L2



I154



I175



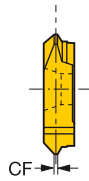
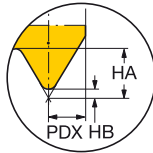
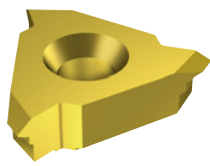
N23



N11

CoroMill® 328 insert for thread milling

For internal threads



Metric 60° Full form

| SSC | TP | NT | Ordering code | | | | | | Dimensions, mm | | | | |
|-----|------|----|------------------|---|---|---|---|---|----------------|-----|------|------|------|
| | | | | P | M | K | N | S | H | CF | HA | HB | PDX |
| 13 | 1.50 | 1 | 328R13-150 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.2 | 0.97 | 0.16 | 0.85 |
| | 2.00 | 1 | 328R13-200 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.3 | 1.30 | 0.22 | 1.05 |
| | 3.00 | 1 | 328R13-300 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.4 | 1.95 | 0.32 | 1.35 |
| | 3.50 | 1 | 328R13-350 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.4 | 2.27 | 0.38 | 1.55 |
| | 4.00 | 1 | 328R13-400 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.5 | 2.60 | 0.43 | 1.75 |
| | 4.50 | 1 | 328R13-450 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.6 | 2.92 | 0.49 | 1.95 |
| | 5.00 | 1 | 328R13-500 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.6 | 3.25 | 0.54 | 2.05 |
| | 5.50 | 1 | 328R13-550 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.7 | 3.57 | 0.60 | 2.30 |
| | 6.00 | 1 | 328R13-600 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.8 | 3.90 | 0.65 | 2.45 |

UN 60° Full form

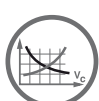
| SSC | TPI | NT | Ordering code | | | | | | Dimensions, mm | | | | |
|-----|------|----|-----------------|---|---|---|---|---|----------------|-----|------|------|------|
| | | | | P | M | K | N | S | H | CF | HA | HB | PDX |
| 13 | 16.0 | 1 | 328R13-16 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.2 | 1.02 | 0.16 | 0.80 |
| | 12.0 | 1 | 328R13-12 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.3 | 1.38 | 0.23 | 1.00 |
| | 8.0 | 1 | 328R13-08 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.4 | 2.06 | 0.34 | 1.40 |
| | 4.0 | 1 | 328R13-04 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.8 | 4.12 | 0.68 | 2.55 |

V-profile 60°

| SSC | TPN | TPX | TPIN | TPIX | NT | Ordering code | | | | | | Dimensions, mm | | | |
|-----|-----|-----|------|------|----|------------------|---|---|---|---|---|----------------|------|------|------|
| | | | | | | | P | M | K | N | S | H | CF | HA | HB |
| 13 | 1.5 | 3.5 | 7.0 | 16.0 | 1 | 328R13-150 VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 0.2 | 2.31 | 0.13 | 1.95 |
| | 4.0 | 6.0 | 4.0 | 6.0 | 1 | 328R13-400 VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 0.5 | 4.06 | 0.41 | 2.60 |



I143



I154



I175



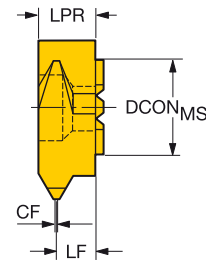
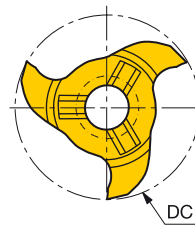
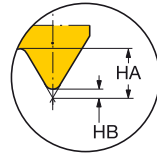
N23



N12

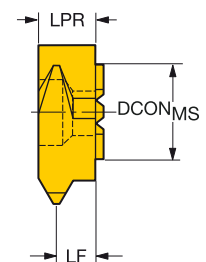
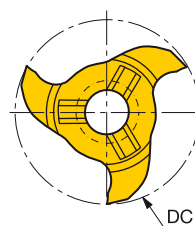
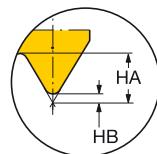
CoroMill® 327 solid carbide head for thread milling

For internal threads



V-profile 60° Non-topping

| TPN | TPX | TPIN | TPIX | DC | CZC _{MS} | ZEFP | Ordering code | Dimensions, mm | | | | | | | | | | |
|-----|-----|------|------|-------|-------------------|------|---------------------|----------------|---|---|---|---|--------------------|-----|------|------|-----|------|
| | | | | | | | | P | M | K | N | S | DCON _{MS} | CF | HA | HB | LF | LPR |
| 1.0 | 2.0 | 12.0 | 24.0 | 11.70 | 6.0 | 3 | 327R06-12 100VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 0.1 | 1.36 | 0.11 | 2.8 | 3.60 |
| 1.0 | 2.0 | 12.0 | 24.0 | 17.70 | 9.0 | 3 | 327R09-18 100VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.1 | 1.30 | 0.11 | 4.7 | 5.85 |
| 1.0 | 2.0 | 12.0 | 24.0 | 17.70 | 9.0 | 6 | 327R09-18 100VM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.1 | 1.30 | 0.11 | 5.0 | 5.85 |
| 1.0 | 2.0 | 12.0 | 24.0 | 21.70 | 12.0 | 3 | 327R12-22 100VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 0.1 | 1.30 | 0.11 | 4.6 | 5.80 |
| 1.0 | 2.0 | 12.0 | 24.0 | 21.70 | 12.0 | 6 | 327R12-22 100VM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 0.1 | 1.36 | 0.11 | 5.1 | 6.35 |
| 2.5 | 3.0 | 8.0 | 10.0 | 11.70 | 6.0 | 3 | 327R06-12 250VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 0.3 | 2.00 | 0.22 | 2.2 | 3.60 |
| 2.5 | 3.5 | 7.0 | 10.0 | 17.70 | 9.0 | 3 | 327R09-18 250VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.3 | 2.88 | 0.22 | 4.2 | 5.85 |
| 2.5 | 3.5 | 7.0 | 10.0 | 17.70 | 9.0 | 6 | 327R09-18 250VM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.3 | 2.88 | 0.22 | 4.3 | 5.85 |
| 2.5 | 4.5 | 5.0 | 10.0 | 21.70 | 12.0 | 3 | 327R12-22 250VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 0.3 | 2.92 | 0.22 | 3.7 | 5.60 |
| 2.5 | 4.5 | 5.0 | 10.0 | 21.70 | 12.0 | 6 | 327R12-22 250VM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 0.3 | 2.92 | 0.22 | 4.2 | 6.05 |



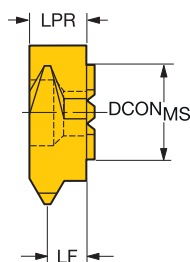
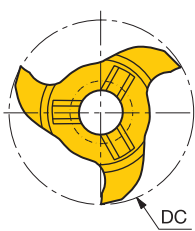
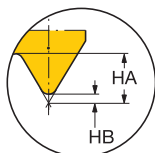
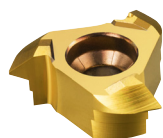
Metric 60° Full form

| TP | DC | CZC _{MS} | ZEFP | Ordering code | Dimensions, mm | | | | | | | | | |
|------|-------|-------------------|------|---------------------|----------------|---|---|---|---|--------------------|------|------|-----|------|
| | | | | | P | M | K | N | S | DCON _{MS} | HA | HB | LF | LPR |
| 1.50 | 17.70 | 9.0 | 3 | 327R09-18 150MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.97 | 0.16 | 4.8 | 5.85 |
| 1.50 | 17.70 | 9.0 | 6 | 327R09-18 150MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.97 | 0.16 | 5.0 | 5.85 |
| 2.00 | 17.70 | 9.0 | 3 | 327R09-18 200MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.30 | 0.22 | 4.6 | 5.85 |
| 2.00 | 17.70 | 9.0 | 6 | 327R09-18 200MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.30 | 0.22 | 4.8 | 5.85 |
| 3.00 | 17.70 | 9.0 | 3 | 327R09-18 300MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.95 | 0.32 | 4.3 | 5.85 |
| 3.00 | 17.70 | 9.0 | 6 | 327R09-18 300MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.95 | 0.32 | 4.6 | 5.85 |
| 3.50 | 17.70 | 9.0 | 3 | 327R09-18 350MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.27 | 0.38 | 4.0 | 5.85 |
| 3.50 | 17.70 | 9.0 | 6 | 327R09-18 350MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.27 | 0.38 | 4.0 | 5.85 |
| 1.50 | 21.70 | 12.0 | 3 | 327R12-22 150MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 0.97 | 0.16 | 4.8 | 5.80 |
| 1.75 | 21.70 | 12.0 | 3 | 327R12-22 175MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 1.14 | 0.19 | 4.7 | 5.80 |
| 2.00 | 21.70 | 12.0 | 3 | 327R12-22 200MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 1.30 | 0.22 | 4.6 | 5.80 |
| 3.00 | 21.70 | 12.0 | 3 | 327R12-22 300MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 1.95 | 0.32 | 4.3 | 5.80 |
| 3.50 | 21.70 | 12.0 | 3 | 327R12-22 350MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 2.27 | 0.38 | 4.0 | 5.80 |
| 4.00 | 21.70 | 12.0 | 3 | 327R12-22 400MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 2.60 | 0.43 | 3.9 | 5.80 |
| 4.50 | 21.70 | 12.0 | 3 | 327R12-22 450MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 2.92 | 0.49 | 3.7 | 5.70 |



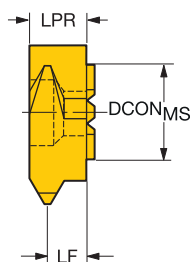
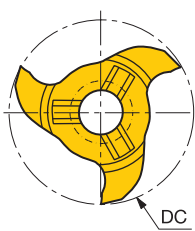
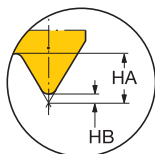
CoroMill® 327 solid carbide head for thread milling

For internal threads



UN 60° Full form

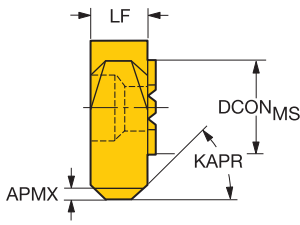
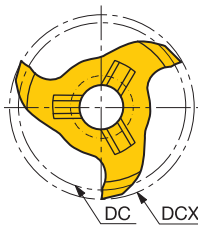
| TPI | DC | CZC _{MS} | APMX | ZEFP | Ordering code | P | M | K | N | S | Dimensions, mm | | | | |
|-----|-------|-------------------|------|------|--------------------|------|------|------|------|------|--------------------|------|------|-----|------|
| | | | | | | 1025 | 1025 | 1025 | 1025 | 1025 | DCON _{MS} | HA | HB | LF | LPR |
| 20 | 17.70 | 9.0 | 0.69 | 3 | 327R09-18 20UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.82 | 0.14 | 5.2 | 5.85 |
| 18 | 17.70 | 9.0 | 0.76 | 3 | 327R09-18 18UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.92 | 0.15 | 5.0 | 5.85 |
| 16 | 17.70 | 9.0 | 0.86 | 3 | 327R09-18 16UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.03 | 0.17 | 5.0 | 5.85 |
| 16 | 17.70 | 9.0 | 0.86 | 6 | 327R09-18 16UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.03 | 0.17 | 5.0 | 5.85 |
| 14 | 17.70 | 9.0 | 0.99 | 3 | 327R09-18 14UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.18 | 0.20 | 5.0 | 5.85 |
| 14 | 17.70 | 9.0 | 0.99 | 6 | 327R09-18 14UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.18 | 0.20 | 5.0 | 5.85 |
| 12 | 17.70 | 9.0 | 1.14 | 3 | 327R09-18 12UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.37 | 0.23 | 4.9 | 5.85 |
| 12 | 17.70 | 9.0 | 1.14 | 6 | 327R09-18 12UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.37 | 0.23 | 4.9 | 5.85 |
| 11 | 17.70 | 9.0 | 1.24 | 3 | 327R09-18 11UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.50 | 0.25 | 4.8 | 5.85 |
| 11 | 17.70 | 9.0 | 1.24 | 6 | 327R09-18 11UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.50 | 0.25 | 4.8 | 5.85 |
| 10 | 17.70 | 9.0 | 1.37 | 3 | 327R09-18 10UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.65 | 0.27 | 4.7 | 5.85 |
| 8 | 17.70 | 9.0 | 1.73 | 3 | 327R09-18 08UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.06 | 0.34 | 4.4 | 5.85 |
| 8 | 17.70 | 9.0 | 1.73 | 6 | 327R09-18 08UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.06 | 0.34 | 4.4 | 5.85 |



Whitworth 55° Full form

| TPI | DC | CZC _{MS} | ZEFP | Ordering code | P | M | K | N | S | Dimensions, mm | | | | |
|-----|-------|-------------------|------|-------------------|------|------|------|------|------|--------------------|------|------|-----|------|
| | | | | | 1025 | 1025 | 1025 | 1025 | 1025 | DCON _{MS} | HA | HB | LF | LPR |
| 19 | 11.70 | 6.0 | 3 | 327R06-12 19WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 1.07 | 0.21 | 2.5 | 3.60 |
| 19 | 17.70 | 9.0 | 3 | 327R09-18 19WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.07 | 0.21 | 4.9 | 5.85 |
| 14 | 11.70 | 6.0 | 3 | 327R06-12 14WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 1.45 | 0.29 | 2.3 | 3.60 |
| 14 | 17.70 | 9.0 | 3 | 327R09-18 14WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.45 | 0.29 | 4.6 | 5.85 |
| 11 | 11.70 | 6.0 | 3 | 327R06-12 11WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 1.85 | 0.37 | 2.0 | 3.60 |
| 11 | 17.70 | 9.0 | 3 | 327R09-18 11WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.85 | 0.37 | 4.4 | 5.85 |

CoroMill® 327 solid carbide head for chamfering



| KAPR | CZC _{MS} | APMX | ZEFP | Ordering code | P | M | K | Dimensions, mm | | | | |
|------|-------------------|------|------|--------------------|------|------|------|--------------------|-------|------|------|-------|
| | | | | | 1025 | 1025 | 1025 | DCON _{MS} | DC | DCX | LF | RPMX |
| 45° | 6.0 | 0.80 | 3 | 327R06-12 12045-CH | ☆ | ☆ | ☆ | 6.00 | 10.10 | 11.7 | 3.60 | 80000 |
| 45° | 12.0 | 1.70 | 3 | 327R12-22 20045-CH | ☆ | ☆ | ☆ | 12.00 | 18.30 | 21.7 | 5.85 | 80000 |



L2



I154



I175



N23



N11

CoroMill® 495

Versatile chamfer cutter

Application

- Chamfering of holes and along edges
- Typical operations are chamfers, back chamfers, preparation for welding and deburring

ISO application area:



Benefits and features

- Versatile tool for many different chamfer operations
- Flexible inserts capable to perform in several workpiece materials
- High machine utilization thanks to few tool changes
- Indexable inserts with four cutting edges
- Cutter bodies with high number of inserts in relation to body size



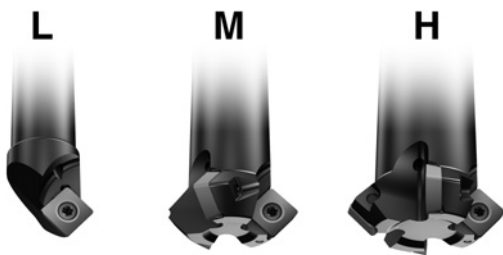
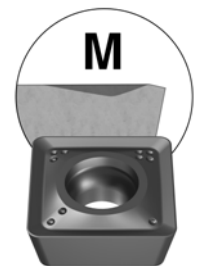
www.sandvik.coromant.com/coromill495

Couplings

- Coromant Capto®
- Cylindrical shank
- Coromant EH

Inserts

- Insert geometries and grades for all materials
- Four cutting edges



Coarse pitch

Close pitch

Extra close pitch



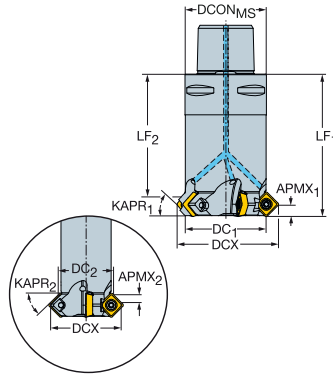
I152



I153

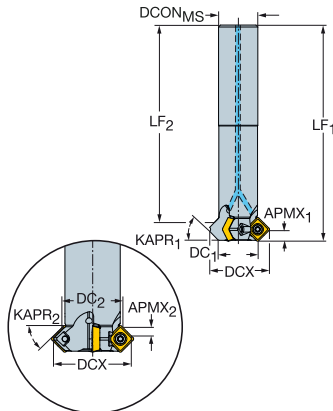
CoroMill® 495 chamfer milling cutter

Coromant Capto® - Internal coolant supply



| KAPR ₁ KAPR ₂ | | CZC _{MS} | APMX ₁ | APMX ₂ | CNSC | Ordering code | Dimensions, mm | | | | | | | | | | CICT | MIID | | | |
|-------------------------------------|-----|-------------------|-------------------|-------------------|------|---------------|----------------|-----------------|--------------------|-----------------|-----------------|------|------|-----------------|-----------------|-----|------|------|------|---|--------------|
| 45° | 45° | 09 | C4 | 5.4 | 5.4 | 3 | 5 | 495-040C4-4509H | DCON _{MS} | DC ₁ | DC ₂ | DCX | BD | LF ₁ | LF ₂ | BAR | NM | KG | RPMX | | |
| 45° | 45° | 09 | C5 | 5.4 | 5.4 | 3 | 6 | 495-050C5-4509H | 50.0 | 50.5 | 50.5 | 61.9 | 49.7 | 75.0 | 63.2 | 20 | 1.4 | 1.58 | 5300 | 5 | 495-09T3M-XL |
| 45° | 45° | 09 | C6 | 5.4 | 5.4 | 3 | 7 | 495-063C6-4509H | 63.0 | 63.5 | 63.5 | 74.9 | 62.7 | 80.0 | 68.2 | 20 | 1.4 | 2.43 | 4700 | 6 | 495-09T3M-XL |
| 45° | 45° | 09 | C6 | 5.4 | 5.4 | 3 | 7 | 495-063C6-4509H | 63.0 | 63.5 | 63.5 | 74.9 | 62.7 | 80.0 | 68.2 | 20 | 1.4 | 2.43 | 4700 | 7 | 495-09T3M-XL |

Cylindrical shank - Internal coolant supply



| KAPR ₁ KAPR ₂ | | CZC _{MS} | APMX ₁ | APMX ₂ | CNSC | Ordering code | Dimensions, mm | | | | | | | | | | CICT | MIID | | | | |
|-------------------------------------|-----|-------------------|-------------------|-------------------|------|---------------|------------------|------------------|--------------------|-----------------|-----------------|------|-------|-----------------|-----------------|------|------|------|-------|-------|--------------|--------------|
| 30° | 60° | 09 | 16 | 3.8 | 6.5 | 1 | 1 | 495-012A16-3009L | DCON _{MS} | DC ₁ | DC ₂ | DCX | BD | LF ₁ | LF ₂ | LU | BAR | NM | KG | RPMX | | |
| 45° | 45° | 09 | 16 | 5.4 | 5.4 | 1 | 1 | 495-012A16-4509L | 16.0 | 12.0 | 17.7 | 23.4 | 11.2 | 100.0 | 90.8 | 51.0 | 20 | 1.4 | 0.23 | 14400 | 1 | 495-09T3M-XL |
| 60° | 30° | 09 | 16 | 6.8 | 3.9 | 1 | 1 | 495-012A16-6009L | 16.0 | 12.0 | 13.5 | 20.1 | 13.5 | 100.0 | 90.3 | 49.0 | 20 | 1.4 | 0.20 | 14400 | 1 | 495-09T3M-XL |
| 75° | 09 | 16 | 7.7 | 7.7 | 1 | 1 | 495-012A16-7509L | 16.0 | 12.0 | 16.2 | 13.0 | 13.0 | 100.0 | 90.3 | 49.0 | 20 | 1.4 | 0.20 | 14400 | 1 | 495-09T3M-XL | |
| 45° | 45° | 09 | 20 | 5.4 | 5.4 | 1 | 3 | 495-020A20-4509M | 20.0 | 20.5 | 20.9 | 31.9 | 19.7 | 110.0 | 98.2 | 58.0 | 20 | 1.4 | 0.33 | 9500 | 3 | 495-09T3M-XL |
| 75° | 09 | 25 | 7.7 | 7.7 | 1 | 3 | 495-025A25-7509H | 25.0 | 25.5 | 29.7 | 25.2 | 25.2 | 100.0 | 90.3 | 49.0 | 20 | 1.4 | 0.50 | 8100 | 3 | 495-09T3M-XL | |
| 30° | 60° | 09 | 25 | 3.8 | 6.5 | 1 | 4 | 495-025A25-3009H | 25.0 | 25.5 | 31.8 | 39.5 | 30.7 | 120.0 | 108.7 | 59.0 | 20 | 1.4 | 0.54 | 8100 | 4 | 495-09T3M-XL |
| 45° | 45° | 09 | 25 | 5.4 | 5.4 | 1 | 4 | 495-025A25-4509H | 25.0 | 25.5 | 25.9 | 36.9 | 24.7 | 120.0 | 108.2 | 59.0 | 20 | 1.4 | 0.48 | 8100 | 4 | 495-09T3M-XL |
| 60° | 30° | 09 | 25 | 6.8 | 3.9 | 1 | 4 | 495-025A25-6009H | 25.0 | 25.5 | 19.9 | 33.6 | 18.7 | 120.0 | 108.4 | 59.0 | 20 | 1.4 | 0.42 | 8100 | 4 | 495-09T3M-XL |

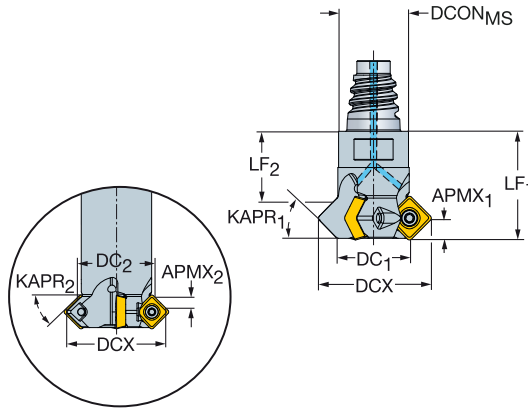
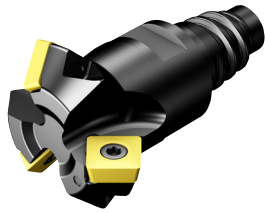
| |
|--------------|
| Spare parts |
| Insert screw |
| 5513 020-04 |

For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 495 chamfer milling cutter

Coromant EH - Internal coolant supply



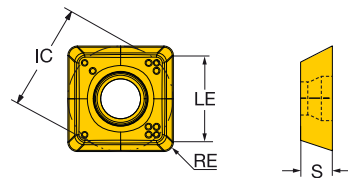
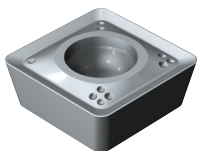
| KAPR ₁ | | KAPR ₂ | | CZC _{MS} | | APMX ₁ | | APMX ₂ | | CNCS | | Ordering code | Dimensions, mm | | | | | | | | | | CICT | MIID |
|-------------------|-----|-------------------|-----|-------------------|-----|-------------------|---|-------------------|--------------------|-----------------|-----------------|---------------|----------------|-----------------|-----------------|-----|-----|------|-------|---|--------------|--|------|------|
| 45° | 45° | 09 | E16 | 5.4 | 5.4 | 1 | 1 | 495-012EH16-4509L | DCON _{MS} | DC ₁ | DC ₂ | DCX | BD | LF ₁ | LF ₂ | BAR | NM | KG | RPMX | 1 | 495-09T3M-XL | | | |
| 45° | 45° | 09 | E20 | 5.4 | 5.4 | 1 | 3 | 495-020EH20-4509M | 15.5 | 12.0 | 17.7 | 23.4 | 11.2 | 30.0 | 20.8 | 20 | 1.4 | 0.09 | 14400 | 3 | 495-09T3M-XL | | | |
| 45° | 45° | 09 | E25 | 5.4 | 5.4 | 1 | 4 | 495-025EH25-4509H | 19.3 | 20.5 | 20.9 | 31.9 | 19.7 | 30.0 | 18.2 | 20 | 1.4 | 0.15 | 9500 | 4 | 495-09T3M-XL | | | |
| 45° | 45° | 09 | E25 | 5.4 | 5.4 | 1 | 4 | 495-025EH25-4509H | 24.2 | 25.5 | 25.5 | 36.9 | 24.7 | 35.0 | 23.2 | 20 | 1.4 | 0.18 | 8100 | | | | | |

| |
|--------------|
| Spare parts |
| Insert screw |
| 5513 020-04 |

For complete list of spare parts, see www.sandvik.coromant.com

CoroMill® 495 insert for milling

KRINS 90°



| | | RE | | Ordering code | P | M | N | S | H | Dimensions, mm | | |
|--------|----|------|--------------|---------------|------|------|------|------|------|----------------|-----|------|
| MM | 09 | 0.80 | 495-09T3M-MM | 1130 | 1040 | 1130 | 1130 | 1130 | 1130 | IC | LE | S |
| Medium | PM | 09 | 0.80 | 495-09T3M-PM | ★ | ☆ | ☆ | ☆ | ☆ | 9.0 | 7.4 | 3.51 |



L2



1154



N23



N9



N15



N3

Milling with large engagement

| ISO P | MC No. | CMC No. | Material | Specific cutting force k_{c1} N/mm ² | Hardness Brinell HB | mc | Cutting speed v_c , m/min | | |
|-----------|--------|---------|---|--|------------------------|------|---|----------------|-------------|
| | | | | | | | CT530 | GC1010 | GC1025 |
| | | | | | | | Max chip thickness, h_{ex} mm 0.1 – 0.15 – 0.2 | | |
| | | | Steel | | | | | | |
| | | | Unalloyed | | | | | | |
| P1.1.Z.AN | 01.1 | | C = 0.1–0.25% | 1500 | 125 | 0.25 | 430–390–350 | - | 340–310–255 |
| P1.2.Z.AN | 01.2 | | C = 0.25–0.55% | 1600 | 150 | 0.25 | 385–350–315 | - | 305–280–230 |
| P1.3.Z.AN | 01.3 | | C = 0.55–0.80% | 1700 | 170 | 0.25 | 365–330–300 | - | 290–260–215 |
| P1.3.Z.AN | 01.4 | | | 1800 | 210 | 0.25 | 315–290–260 | - | 250–230–185 |
| P1.3.Z.HT | 01.5 | | | 2000 | 300 | 0.25 | 235–210–195 | - | 185–170–140 |
| | | | Low alloyed (alloying elements ≤ 5%) | | | | | | |
| P2.1.Z.AN | 02.1 | | Non-hardened | 1700 | 175 | 0.25 | 300–275–245 | - | 280–255–210 |
| P2.5.Z.HT | 02.2 | | Hardened and tempered | 1900 | 300 | 0.25 | 195–180–160 | - | 155–140–115 |
| | | | High alloyed (alloying elements > 5%) | | | | | | |
| P3.0.Z.AN | 03.11 | | Annealed | 1950 | 200 | 0.25 | 230–205–185 | 180–165–135 | 180–165–135 |
| P3.1.Z.AN | 03.13 | | Hardened tool steel | 2150 | 200 | 0.25 | 190–170–155 | 150–135–110 | 150–135–110 |
| P3.0.Z.HT | 03.21 | | | 2900 | 300 | 0.25 | 165–150–135 | 130–120–100 | 130–120–100 |
| P3.0.Z.HT | 03.22 | | | 3100 | 380 | 0.25 | 105–95–85 | 80–75–60 | 80–75–60 |
| | | | Castings | | | | | | |
| P1.5.C.UT | 06.1 | | Unalloyed | 1400 | 150 | 0.25 | 305–280–250 | 245–220–180 | 245–220–180 |
| P2.6.C.UT | 06.2 | | Low alloyed (alloying elements ≤ 5%) | 1600 | 200 | 0.25 | 245–220–200 | 195–175–145 | 195–175–145 |
| P3.0.C.UT | 06.3 | | High alloyed (alloying elements > 5%) | 1950 | 200 | 0.25 | 180–160–145 | 140–130–105 | 140–130–105 |
| ISO M | MC No. | CMC No. | Material | Specific cutting force k_{c1} N/mm ² | Hardness Brinell HB | mc | Cutting speed v_c , m/min | | |
| | | | | | | | CT530 | M30B | GC1130 |
| | | | | | | | Max chip thickness, h_{ex} mm 0.1 – 0.15 – 0.2 | | |
| | | | | | | | Cutting speed v_c , m/min | | |
| | | | Stainless steel | | | | | | |
| | | | Ferritic/martensitic | | | | | | |
| P5.0.Z.AN | 05.11 | | Non-hardened | 1800 | 200 | 0.21 | 285–255–230 | 265–210–135 | 255–225–180 |
| P5.0.Z.PH | 05.12 | | PH-hardened | 2850 | 330 | 0.21 | 205–185–165 | 175–140–90 | 180–160–130 |
| P5.0.Z.HT | 05.13 | | Hardened | 2350 | 330 | 0.21 | 215–190–170 | 200–160–100 | 185–165–135 |
| | | | Austenitic | | | | | | |
| M1.0.Z.AQ | 05.21 | | Non-hardened | 1950 | 200 | 0.21 | 265–240–215 | - | 250–225–180 |
| M1.0.Z.PH | 05.22 | | PH-hardened | 2850 | 330 | 0.21 | 200–175–160 | - | 170–155–125 |
| M2.0.Z.AQ | 05.23 | | Super austenitic | 2250 | 200 | | - | - | - |
| | | | Austenitic-ferritic (Duplex) | | | | | | |
| M3.1.Z.AQ | 05.51 | | Non-weldable ≥ 0.05%C | 2000 | 230 | 0.21 | 260–235–210 | - | 205–185–145 |
| M3.2.Z.AQ | 05.52 | | Weldable < 0.05%C | 2450 | 260 | 0.21 | 230–205–185 | - | 175–155–125 |
| | | | Stainless steel – Cast | | | | | | |
| | | | Ferritic/martensitic | | | | | | |
| P5.0.C.UT | 15.11 | | Non-hardened | 1700 | 200 | 0.25 | 255–230–205 | 230–185–120 | 225–200–160 |
| P5.0.C.PH | 15.12 | | PH-hardened | 2450 | 330 | 0.25 | 180–160–145 | 150–120–80 | 155–140–115 |
| P5.0.C.HT | 15.13 | | Hardened | 2150 | 330 | 0.25 | 195–175–155 | 180–145–90 | 170–155–120 |
| M1.0.C.UT | 15.21 | | Non hardened | 1800 | 200 | 0.25 | 255–225–205 | - | 235–210–170 |
| M1.0C.PH | 15.22 | | PH-hardened | 2450 | 330 | 0.25 | 180–160–145 | - | 160–140–115 |
| M2.0.C.AQ | 15.23 | | Super austenitic | 2150 | 200 | | - | - | - |
| | | | Austenitic-ferritic (Duplex) | | | | | | |
| M3.1.C.AQ | 15.51 | | Non-weldable ≥ 0.05%C | 1800 | 230 | 0.25 | 245–220–195 | - | 195–175–140 |
| M3.2.C.AQ | 15.52 | | Weldable < 0.05%C | 2250 | 260 | 0.25 | 215–190–170 | - | 160–145–115 |
| ISO K | MC No. | CMC No. | Material | Specific cutting force k_{c1} N/mm ² | Hardness Brinell HB | mc | Cutting speed v_c , m/min | | |
| | | | | | | | CB50 | CC6190 | GC1010 |
| | | | | | | | Max chip thickness, h_{ex} mm 0.1 – 0.15 – 0.2 | | |
| | | | | | | | Cutting speed v_c , m/min | | |
| | | | Malleable cast iron | | | | | | |
| | | | Ferritic (short chipping) | 790 | 130 | 0.28 | - | 1300–1050–880 | 225–185–150 |
| K1.1.C.NS | 07.2 | | Pearlitic (long chipping) | 900 | 230 | 0.28 | - | 1100–890–730 | 185–155–125 |
| | | | Grey cast iron | | | | | | |
| K2.1.C.UT | 08.1 | | Low tensile strength | 890 | 180 | 0.28 | 910–780–670 | 1600–1300–1050 | 245–200–165 |
| K2.2.C.UT | 08.2 | | High tensile strength | 1100 | 245 | 0.28 | 850–720–620 | 1200–990–810 | 195–160–130 |
| | | | Nodular cast iron | | | | | | |
| K3.1.C.UT | 09.1 | | Ferritic | 900 | 160 | 0.28 | - | 1000–830–680 | 155–125–105 |
| K3.3.C.UT | 09.2 | | Pearlitic | 1350 | 250 | 0.28 | 495–420–360 | 840–690–570 | 145–120–95 |

**Conditions:**

Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

| GC1130 | GC4220 | GC4330 | GC4340 | GC2030 | GC2040 | GC3040 | | | | |
|---|---|---|---|--|--|---|---|---|----------------------------|----------------------------|
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.05-0.1-0.2 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.4 | 0.1-0.2-0.4 | 0.1-0.2-0.4 | | | | |
| Cutting speed v_c m/min | | | | | | | | | | |
| 375-340-280 335-305-250 320-290-235 275-250-205 205-185-155 | 490-405-330 440-360-295 415-340-280 365-300-245 270-220-180 | 400-330-270 360-295-245 340-280-230 295-245-200 220-180-150 | 340-280-230 305-250-205 290-235-195 250-205-170 185-155-125 | 295-240-165 265-215-145 250-205-135 220-180-120 160-130-90 | 295-240-165 265-215-145 250-205-135 220-180-120 160-130-90 | 390-320-260 350-285-235 330-270-220 290-235-195 215-175-145 | | | | |
| 265-240-195 170-155-130 | 345-285-230 225-185-150 | 280-230-190 185-150-125 | 240-195-160 155-130-105 | 205-170-115 135-110-75 | 205-170-115 135-110-75 | 275-225-185 180-145-120 | | | | |
| 180-165-135 150-135-110 130-120-100 80-75-60 | 300-245-200 215-180-145 190-155-125 120-95-80 | 195-160-130 160-130-110 140-115-95 85-70-60 | 165-135-110 135-110-90 120-100-80 75-60-50 | 155-130-85 125-105-70 110-90-60 70-55-38 | 155-130-85 125-105-70 110-90-60 70-55-38 | 205-170-140 170-140-115 150-125-100 95-75-65 | | | | |
| 245-220-180 195-175-145 140-130-105 | 350-290-235 280-230-190 205-170-140 | 260-215-175 205-170-140 150-125-100 | 220-180-150 175-145-120 130-105-85 | 210-170-115 170-140-95 120-100-70 | 210-170-115 170-140-95 120-100-70 | 280-230-190 220-180-150 160-135-110 | | | | |
| GC1040 | S30T | S40T | GC2030 | GC2040 | GC4330 | GC4340 | GC1010 | GC1025 | | |
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.05-0.15-0.25 | 0.05-0.15-0.25 | 0.1-0.2-0.3 | 0.05-0.15-0.25 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.4 | 0.1-0.2-0.3 | 0.05-0.1-0.2 | | |
| Cutting speed v_c m/min | | | | | | | | | | |
| 185-140-105 130-100-70 135-100-75 | 255-190-140 180-135-100 185-140-105 | 250-200-160 170-135-110 180-145-115 | 240-190-155 170-135-110 175-140-115 | 240-190-155 165-130-105 175-140-110 | 275-220-175 190-150-120 200-160-125 | 210-170-110 140-110-70 160-125-80 | 285-255-230 205-185-165 215-190-170 | 255-225-180 180-160-130 185-165-135 | | |
| 180-135-100 125-95-70 125-90-70 | 250-185-140 170-130-95 170-125-95 | 210-165-135 165-130-105 145-115-95 | 235-190-150 165-130-105 - | 200-160-130 160-125-100 - | - - - | 185-150-95 135-105-70 - | 265-240-215 200-175-160 170-125-95 | 250-225-180 170-155-125 - | | |
| 150-115-85 125-95-70 | 205-155-115 175-130-95 | 175-140-110 140-115-90 | 195-155-125 165-130-105 | 170-135-105 135-110-85 | - - | 170-135-85 135-110-70 | 260-240-215 230-205-185 | 205-185-145 170-155-125 | | |
| 165-125-90 115-85-65 125-90-70 | 225-165-125 155-115-85 170-125-95 | 220-175-140 150-120-95 165-135-105 | 215-170-135 150-120-95 160-130-105 | 210-170-135 145-115-90 160-130-100 | 245-195-155 165-130-105 180-145-115 | 185-150-95 120-100-65 145-115-75 | 255-230-205 180-160-145 195-175-155 | 225-200-160 155-140-115 170-155-120 | | |
| 175-130-95 115-85-65 110-85-60 | 235-175-130 160-115-85 155-115-85 | 200-160-130 150-120-95 130-105-85 | 225-180-145 150-120-95 - | 190-155-125 145-115-90 - | - - - | 180-140-90 125-100-65 - | 255-225-205 180-160-145 - | 235-210-170 160-140-115 - | | |
| 145-105-80 115-85-65 | 195-15-110 160-120-90 | 165-130-105 135-105-85 | 185-150-120 150-120-95 | 160-125-100 130-100-80 | - - | 160-125-80 125-100-65 | 245-220-195 215-190-170 | 195-175-140 160-145-115 | | |
| GC3220 | GC3330 | GC3040 | K20W | GC4330 | GC4340 | GC1020 | H13A | K20D | K20M | K15W |
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.1-0.2-0.3 | 0.1-0.2-0.4 | 0.1-0.2-0.4 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.4 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.3 |
| Cutting speed v_c m/min | | | | | | | | | | |
| 265-220-180 220-180-150 | 260-215-145 215-175-120 | 240-195-135 200-165-110 | 225-185-150 185-150-125 | 215-175-145 175-145-120 | 195-160-130 160-130-110 | 205-170-140 170-140-115 | 120-105-75 100-85-65 | 265-220-180 220-180-150 | 255-210-170 210-170-140 | - - |
| 290-240-195 235-190-155 | 285-235-155 225-185-125 | 260-215-145 210-170-115 | 245-200-165 195-160-130 | 230-190-155 185-155-125 | 215-175-145 170-140-115 | 225-185-150 180-145-120 | 130-110-85 105-90-65 | 290-240-195 235-190-155 | 275-225-185 220-180-150 | 245-200-165 195-160-130 |
| 180-150-125 170-140-115 | 280-230-155 225-185-125 | 165-135-90 150-125-85 | 155-125-105 140-115-95 | 145-120-100 135-110-90 | 135-110-90 125-100-85 | 140-115-95 130-105-90 | 80-70-50 75-65-50 | 180-150-125 170-140-115 | 175-140-115 160-130-110 | - - |

Milling with large engagement

| ISO N | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | CD10 | | | H10 | | | CT530 | | | |
|---------------------------------|--------|---------|--|---------------------------------|------------------|------|---------------------------------|-------------|--------------|------------------|--|--|------------------|--|--|--|
| | | | | | | | Max chip thickness, h_{ex} mm | | | | | | | | | |
| | | | | | | | 0.1 - 0.15 - 0.2 | | | 0.1 - 0.15 - 0.2 | | | 0.1 - 0.15 - 0.2 | | | |
| Cutting speed v_c , m/min | | | | | | | | | | | | | | | | |
| Aluminium alloys | | | | | | | | | | | | | | | | |
| N1.2.Z.UT | 30.11 | | Wrought or wrought and coldworked, non-aging | 400 | 60 | | 1900-1750-1600 | 940-870-810 | 1050-960-890 | | | | | | | |
| N1.2.Z.AG | 30.12 | | Wrought or wrought and aged | 650 | 100 | | 1700-1550-1450 | 850-780-730 | 930-860-800 | | | | | | | |
| Aluminium alloys | | | | | | | | | | | | | | | | |
| N1.3.C.UT | 30.21 | | Cast, non-aging | 600 | 75 | 0.25 | 1900-1750-1600 | 940-870-810 | 1050-960-890 | | | | | | | |
| N1.3.C.AG | 30.22 | | Cast or cast and aged | 700 | 90 | 0.25 | 1700-1550-1450 | 850-790-730 | 930-860-800 | | | | | | | |
| Aluminium alloys | | | | | | | | | | | | | | | | |
| N1.1.Z.UT | 30.3 | | Al >99% | 350 | 30 | | 1900-1750-1600 | 950-880-810 | 1050-960-890 | | | | | | | |
| Aluminium alloys | | | | | | | | | | | | | | | | |
| N1.4.C.NS | 30.41 | | Cast, 13-15% Si | 700 | 130 | | 760-700-650 | 380-350-325 | 415-385-355 | | | | | | | |
| | 30.42 | | Cast, 16-22% Si | 700 | 130 | | 570-530-485 | 285-265-245 | 310-290-270 | | | | | | | |
| Copper and copper alloys | | | | | | | | | | | | | | | | |
| N3.3.U.UT | 33.1 | | Free cutting alloys, $\geq 1\%$ Pb | 550 | 110 | 0.25 | 940-870-810 | 470-435-405 | 520-480-445 | | | | | | | |
| N3.2.C.UT | 33.2 | | Brass, leaded bronzes, $\leq 1\%$ Pb | 550 | 90 | | 940-870-810 | 470-435-405 | 520-480-445 | | | | | | | |
| N3.1.U.UT | 33.3 | | Bronze and non-leaded copper incl. electrolytic copper | 1350 | 100 | 0.25 | 660-610-570 | 330-305-285 | 365-335-310 | | | | | | | |

| ISO S | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | GC1025 | | | GC1130 | | | H13A | | | |
|-------------------------------------|--------|---------|---|---------------------------------|------------------|------|---------------------------------|-------------|-------------|------------------|--|--|------------------|--|--|--|
| | | | | | | | Max chip thickness, h_{ex} mm | | | | | | | | | |
| | | | | | | | 0.05 - 0.15 - 0.2 | | | 0.1 - 0.15 - 0.2 | | | 0.1 - 0.15 - 0.2 | | | |
| Cutting speed v_c , m/min | | | | | | | | | | | | | | | | |
| Heat resistant super alloys | | | | | | | | | | | | | | | | |
| Iron base | | | | | | | | | | | | | | | | |
| S1.0.U.AN | 20.11 | | Annealed or solution treated | 2400 | 200 | 0.25 | 60-55-50 | 60-55-50 | 60-55-50 | | | | | | | |
| | 20.12 | | Aged or solution treated and aged | 2500 | 280 | 0.25 | 45-40-37 | 45-40-37 | 45-40-38 | | | | | | | |
| Nickel base | | | | | | | | | | | | | | | | |
| S2.0.Z.AN | 20.21 | | Annealed or solution treated | 2650 | 250 | 0.25 | 60-55-50 | 60-55-50 | 55-55-50 | | | | | | | |
| | 20.22 | | Aged or solution treated and aged | 2900 | 350 | 0.25 | 36-33-30 | 36-33-30 | 35-33-30 | | | | | | | |
| S2.0.C.NS | 20.24 | | Cast or cast and aged | 3000 | 320 | 0.25 | 45-40-36 | 45-40-36 | 45-40-38 | | | | | | | |
| Cobalt alloys | | | | | | | | | | | | | | | | |
| S3.0.Z.AN | 20.31 | | Annealed or solution treated | 2700 | 200 | 0.25 | 25-22-20 | 25-22-20 | 23-21-18 | | | | | | | |
| S3.0.Z.AG | 20.32 | | Solution treated and aged | 3000 | 300 | 0.25 | 18-16-14 | 18-16-14 | 17-15-13 | | | | | | | |
| S3.0.C.NS | 20.33 | | Cast or cast and aged | 3100 | 320 | 0.25 | 16-14-13 | 16-14-13 | 16-14-13 | | | | | | | |
| Titanium alloys¹⁾ | | | | | | | | | | | | | | | | |
| S4.1.Z.UT | 23.1 | | Commercial pure (99,5% Ti) | 1300 | Rm ²⁾ | 0.23 | 125-115-105 | 125-115-105 | 125-115-110 | | | | | | | |
| S4.2.Z.AN | 23.21 | | α , near α and $\alpha + \beta$ alloys, annealed | 1400 | 950 | 0.23 | 55-50-45 | 55-50-45 | 50-45-45 | | | | | | | |
| S4.3.Z.AG | 23.22 | | $\alpha + \beta$ alloys in aged cond., β alloys, annealed or aged | 1400 | 1050 | 0.23 | 45-40-36 | 45-40-36 | 38-36-33 | | | | | | | |

| ISO H | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | CB50 | | | CT530 | | | GC4220 | | | |
|-----------------------------|--------|---------|-----------------------|---------------------------------|------------------|------|---------------------------------|-------------|-----------|-------------------|--|--|-------------------|--|--|--|
| | | | | | | | Max chip thickness, h_{ex} mm | | | | | | | | | |
| | | | | | | | 0.07 - 0.12 - 0.2 | | | 0.07 - 0.12 - 0.2 | | | 0.1 - 0.15 - 0.25 | | | |
| Cutting speed v_c , m/min | | | | | | | | | | | | | | | | |
| Extra hard steel | | | | | | | | | | | | | | | | |
| H1.3.Z.HA | 04.1 | | Hardened and tempered | 4200 | 59 HRC | 0.25 | 160-140-115 | 80-75-55 | 55-45-36 | | | | | | | |
| Chilled cast iron | | | | | | | | | | | | | | | | |
| H2.0.C.UT | 10.1 | | Cast or cast and aged | 2250 | 400 | 0.28 | 310-270-215 | 155-140-110 | 100-90-70 | | | | | | | |

- 1) 45-60° entering angle. Positive cutting geometry and coolant should be used.
 2) Rm = ultimate tensile strength measured in MPa.

**Conditions:**

Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

| GC1130 | H10F | H13A | GC1025 | | | | | |
|---|-------------------|------------------|-------------------|-------------------|--------------|--|--|--|
| Max chip thickness, h_{ex} mm | | | | | | | | |
| 0.1 - 0.15 - 0.2 | 0.1 - 0.15 - 0.2 | 0.1 - 0.15 - 0.2 | 0.1-0.15-0.2 | | | | | |
| Cutting speed v_c m/min | | | | | | | | |
| 990-910-850 | 940-870-810 | 750-700-650 | 990-910-850 | | | | | |
| 890-820-760 | 850-780-730 | 680-630-580 | 890-820-760 | | | | | |
| 990-910-850 | 940-870-810 | 750-700-650 | 990-910-850 | | | | | |
| 990-920-850 | 850-790-730 | 680-630-580 | 990-920-850 | | | | | |
| 990-920-850 | 950-880-810 | 760-700-650 | 990-920-850 | | | | | |
| 395-370-340 | 380-350-325 | 300-280-260 | 395-370-340 | | | | | |
| 300-275-255 | 285-265-245 | 225-210-195 | 300-275-255 | | | | | |
| 495-460-425 | 470-435-405 | 375-350-325 | 495-460-425 | | | | | |
| 495-460-425 | 470-435-405 | 375-350-325 | 495-460-425 | | | | | |
| 345-320-295 | 330-305-285 | 265-245-225 | 345-320-295 | | | | | |
| H10F S30T S40T GC2030 GC2040 GC1010 | | | | | | | | |
| Max chip thickness, h_{ex} mm | | | | | | | | |
| 0.1 - 0.15 - 0.2 | 0.1 - 0.15 - 0.2 | 0.1 - 0.15 - 0.2 | 0.05 - 0.15 - 0.2 | 0.1 - 0.15 - 0.25 | 0.1-0.15-0.2 | | | |
| Cutting speed v_c m/min | | | | | | | | |
| 55-50-45 | - | - | 55-50-45 | 60-55-45 | - | | | |
| 40-37-35 | - | - | 40-38-34 | 45-39-32 | - | | | |
| 50-50-45 | - | - | 55-50-45 | 55-50-40 | - | | | |
| 32-30-27 | - | - | 34-31-28 | 35-31-26 | - | | | |
| 40-37-34 | - | - | 40-37-34 | 40-38-31 | - | | | |
| 22-19-17 | - | - | 23-21-18 | 23-21-17 | - | | | |
| 15-14-12 | - | - | 17-15-13 | 17-15-12 | - | | | |
| 14-13-12 | - | - | 15-14-12 | 15-14-11 | - | | | |
| 115-105-100 | 150-135-125 | 125-115-110 | 120-105-95 | 120-110-100 | 150-135-125 | | | |
| 45-40-38 | 65-60-55 | 45-40-39 | 50-45-39 | 45-39-36 | 65-60-55 | | | |
| 34-31-29 | 50-50-45 | 38-36-33 | 40-37-34 | 37-33-30 | 55-50-45 | | | |
| GC3040 GC1010 GC1130 GC1025 | | | | | | | | |
| Max chip thickness, h_{ex} mm | | | | | | | | |
| 0.1 - 0.2 - 0.25 | 0.07 - 0.12 - 0.2 | 0.07-0.12-0.2 | 0.07-0.12-0.2 | | | | | |
| Cutting speed v_c m/min | | | | | | | | |
| 45-33-29 | 110-95-80 | 40-36-29 | 40-36-29 | | | | | |
| 85-65-55 | 215-185-150 | 75-70-55 | 75-70-55 | | | | | |

Milling with small engagement

| ISO P | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | CT530 | GC1010 | GC3040 |
|--|--------|---------|------------------------------------|---------------------------------|------------------|------|---------------------------------|------------------|--------------|
| | | | | | | | Max chip thickness, h_{ex} mm | | |
| | | | | | | | 0.1 - 0.15 - 0.2 | 0.05 - 0.1 - 0.2 | 0.1-0.15-0.3 |
| Cutting speed v_c , m/min | | | | | | | | | |
| Steel | | | | | | | | | |
| Unalloyed | | | | | | | | | |
| P1.1.Z.AN | 01.1 | | C = 0.1-0.25% | 1500 | 125 | 0.25 | 500-490-475 | - | 455-445-415 |
| P1.2.Z.AN | 01.2 | | C = 0.25-0.55% | 1600 | 150 | 0.25 | 450-440-430 | - | 410-400-375 |
| P1.3.Z.AN | 01.3 | | C = 0.55-0.80% | 1700 | 170 | 0.25 | 425-415-405 | - | 385-375-350 |
| P1.3.Z.AN | 01.4 | | | 1800 | 210 | 0.25 | 370-360-355 | - | 335-330-305 |
| P1.3.Z.HT | 01.5 | | | 2000 | 300 | 0.25 | 275-265-260 | - | 250-245-225 |
| Low-alloy (alloying elements ≤5%) | | | | | | | | | |
| P2.1.Z.AN | 02.1 | | Non-hardened | 1700 | 175 | 0.25 | 350-345-335 | - | 320-310-290 |
| P2.5.Z.HT | 02.2 | | Hardened and tempered | 1900 | 300 | 0.25 | 230-225-220 | - | 205-205-190 |
| High-alloy (alloying elements >5%) | | | | | | | | | |
| P3.0.Z.AN | 03.11 | | Annealed | 1950 | 200 | 0.25 | 265-260-255 | 195-190-185 | 240-235-220 |
| P3.1.Z.AN | 03.13 | | Hardened tool steel | 2150 | 200 | 0.25 | 220-215-210 | 160-160-150 | 200-195-185 |
| P3.0.Z.HT | 03.21 | | | 2900 | 300 | 0.25 | 190-190-185 | 140-140-135 | 175-170-160 |
| P3.0.Z.HT | 03.22 | | | 3100 | 380 | 0.25 | 120-120-115 | 90-85-85 | 110-105-100 |
| Castings | | | | | | | | | |
| P1.5.C.UT | 06.1 | | Unalloyed | 1400 | 150 | 0.25 | 355-350-340 | 265-255-245 | 325-315-295 |
| P2.6.C.UT | 06.2 | | Low-alloy (alloying elements ≤5%) | 1600 | 200 | 0.25 | 285-280-275 | 210-205-195 | 260-255-235 |
| P3.0.C.UT | 06.3 | | High-alloy (alloying elements >5%) | 1950 | 200 | 0.25 | 210-205-200 | 155-150-145 | 190-185-175 |
| ISO M | | | | | | | | | |
| ISO M | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | CT530 | GC1130 | GC1025 |
| | | | | | | | Max chip thickness, h_{ex} mm | | |
| | | | | | | | 0.1 - 0.15 - 0.2 | 0.05 - 0.1 - 0.2 | 0.05-0.1-0.2 |
| Cutting speed v_c , m/min | | | | | | | | | |
| Stainless steel | | | | | | | | | |
| Ferritic/martensitic | | | | | | | | | |
| P5.0.Z.AN | 05.11 | | Non-hardened | 1800 | 200 | 0.21 | 340-335-325 | 275-270-255 | 275-270-255 |
| P5.0.Z.PH | 05.12 | | PH-hardened | 2850 | 330 | 0.21 | 245-240-235 | 195-190-180 | 195-190-180 |
| P5.0.Z.HT | 05.13 | | Hardened | 2350 | 330 | 0.21 | 255-250-240 | 200-195-190 | 200-195-190 |
| Austenitic | | | | | | | | | |
| M1.0.Z.AQ | 05.21 | | Non-hardened | 1950 | 200 | 0.21 | 320-310-300 | 270-265-255 | 270-265-255 |
| M1.0.Z.PH | 05.22 | | PH-hardened | 2850 | 330 | 0.21 | 235-230-225 | 190-185-175 | 190-185-175 |
| M2.0.Z.AQ | 05.23 | | Super austenitic | 2250 | 200 | | - | - | - |
| Austenitic-ferritic (Duplex) | | | | | | | | | |
| M3.1.Z.AQ | 05.51 | | Non-weldable ≥ 0.05%C | 2000 | 230 | 0.21 | 310-300-295 | 225-220-210 | 225-220-210 |
| M3.2.Z.AQ | 05.52 | | Weldable < 0.05%C | 2450 | 260 | 0.21 | 275-270-260 | 190-185-175 | 190-185-175 |
| Stainless steel - Cast | | | | | | | | | |
| Ferritic/martensitic | | | | | | | | | |
| P5.0.C.UT | 15.11 | | Non-hardened | 1700 | 200 | 0.25 | 305-295-290 | 245-240-230 | 245-240-230 |
| P5.0C.PH | 15.12 | | PH-hardened | 2450 | 330 | 0.25 | 215-210-205 | 170-170-160 | 170-170-160 |
| P5.0.C.HT | 15.13 | | Hardened | 2150 | 330 | 0.25 | 235-225-220 | 185-180-175 | 185-180-175 |
| Austenitic | | | | | | | | | |
| M1.0.C.UT | 15.21 | | Austenitic | 1800 | 200 | 0.25 | 300-295-285 | 260-250-240 | 260-250-240 |
| M1.0C.PH | 15.22 | | PH-hardened | 2450 | 330 | 0.25 | 215-210-205 | 170-170-160 | 170-170-160 |
| M2.0.C.AQ | 15.23 | | Super austenitic | 2150 | 200 | | - | - | - |
| Austenitic-ferritic (Duplex) | | | | | | | | | |
| M3.1.C.AQ | 15.51 | | Non-weldable ≥ 0.05%C | 1800 | 230 | 0.25 | 295-285-280 | 215-205-195 | 215-205-195 |
| M3.2.C.AQ | 15.52 | | Weldable < 0.05%C | 2250 | 260 | 0.25 | 255-250-245 | 175-170-165 | 175-170-165 |
| ISO K | | | | | | | | | |
| ISO K | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | CB50 | CC6190 | K20D |
| | | | | | | | Max chip thickness, h_{ex} mm | | |
| | | | | | | | 0.1 - 0.15 - 0.2 | 0.1 - 0.2 - 0.3 | 0.1-0.2-0.3 |
| Cutting speed v_c , m/min | | | | | | | | | |
| Malleable cast iron | | | | | | | | | |
| K1.1.C.NS | 07.1 | | Ferritic (short chipping) | 790 | 130 | 0.28 | - | 1500-1450-1400 | 305-290-280 |
| | 07.2 | | Pearlitic (long chipping) | 900 | 230 | 0.28 | - | 1250-1200-1150 | 250-240-230 |
| Grey cast iron | | | | | | | | | |
| K2.1.C.UT | 08.1 | | Low tensile strength | 890 | 180 | 0.28 | 1150-1100-1100 | 1850-1750-1700 | 285-270-260 |
| K2.2.C.UT | 08.2 | | High tensile strength | 1100 | 245 | 0.28 | 1100-1050-1000 | 1400-1350-1300 | 225-215-210 |
| Nodular cast iron | | | | | | | | | |
| K3.1.C.UT | 09.1 | | Ferritic | 900 | 160 | 0.28 | - | 1200-1150-1100 | 210-205-200 |
| K3.3.C.UT | 09.2 | | Pearlitic | 1350 | 250 | 0.28 | 630-610-590 | 980-930-890 | 195-195-185 |

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

**Conditions:**

Side milling, cutter dia. 25 mm.
Working engagement 10 mm.

| GC1025 | GC1130 | GC4220 | GC4330 | GC4340 | GC2030 | GC2040 | | | | |
|---|---|---|---|---|---|---|---|---|----------------------------|----------------------------|
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.05-0.1-0.2 | 0.05-0.1-0.2 | 0.1-0.15-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.05-0.15-0.25 | 0.1-0.2-0.3 | | | | |
| Cutting speed v_c, m/min | | | | | | | | | | |
| 365-360-345 330-325-310 310-305-290 270-265-255 200-195-190 | 405-395-380 365-355-340 345-335-320 300-295-280 220-220-210 | 570-560-520 510-500-470 485-475-445 425-415-390 310-305-285 | 465-445-425 420-400-385 395-380-360 345-330-315 255-245-235 | 395-380-360 355-340-325 335-320-310 295-280-270 220-210-200 | 340-335-320 305-300-290 290-280-270 255-250-240 185-185-175 | 340-325-315 305-295-280 290-275-265 255-245-235 185-180-170 | | | | |
| 300-295-285 170-165-160 | 285-280-265 185-180-175 | 400-390-365 260-255-240 | 325-315-300 215-205-195 | 280-265-255 180-175-165 | 240-235-225 155-155-145 | 240-230-220 155-150-145 | | | | |
| 195-190-185 160-160-150 140-140-135 90-85-85 | 195-190-185 160-160-150 140-140-135 90-85-85 | 350-340-320 250-245-230 220-215-200 135-135-125 | 225-215-205 185-180-170 165-155-150 100-95-95 | 190-185-175 160-150-145 140-135-125 85-85-80 | 180-175-170 150-145-140 130-125-120 80-80-75 | 180-175-165 150-140-135 130-125-120 80-75-75 | | | | |
| 265-255-245 210-205-195 155-150-145 | 265-255-245 210-205-195 155-150-145 | 410-400-375 325-320-295 240-235-220 | 305-290-280 240-230-220 175-170-160 | 255-245-235 205-195-190 150-145-140 | 240-235-225 195-190-185 145-140-135 | 240-230-220 195-185-180 145-135-130 | | | | |
| GC1040 | | | | | | | | | | |
| S30T | | | | | | | | | | |
| S40T | | | | | | | | | | |
| GC2030 | | | | | | | | | | |
| GC2040 | | | | | | | | | | |
| GC4330 | | | | | | | | | | |
| GC4340 | | | | | | | | | | |
| M30B | | | | | | | | | | |
| GC1010 | | | | | | | | | | |
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.05-0.15-0.25 | | | | | | | | | | |
| 0.05-0.15-0.25 | | | | | | | | | | |
| 0.1-0.2-0.25 | | | | | | | | | | |
| 0.05-0.15-0.25 | | | | | | | | | | |
| 0.1-0.2-0.25 | | | | | | | | | | |
| 0.1-0.2-0.25 | | | | | | | | | | |
| 0.1-0.2-0.25 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.2-0.4 | | | | | | | | | | |
| 0.05-0.1-0.2 | | | | | | | | | | |
| Cutting speed v_c, m/min | | | | | | | | | | |
| 210-195-185 145-140-130 155-145-135 | 285-265-250 200-185-175 210-195-180 | 295-280-275 205-195-275 215-205-200 | 260-250-235 185-175-170 195-185-175 | 285-270-265 195-185-180 205-195-190 | 325-310-305 225-215-210 235-225-220 | 250-240-225 165-160-150 190-180-170 | 275-270-255 195-190-180 200-195-190 | 340-335-325 245-240-235 255-250-240 | | |
| 205-190-175 140-135-125 140-130-120 | 280-260-245 190-180-170 190-180-170 | 250-235-230 195-185-180 175-165-160 | 255-245-230 180-170-160 - | 240-225-220 190-180-175 - | - - - | 220-210-200 160-150-145 - | - - - | 320-310-300 235-230-225 190-180-170 | | |
| 170-160-150 140-130-125 | 230-215-200 195-180-170 | 205-195-190 165-160-155 | 215-205-195 180-170-160 | 200-190-185 160-155-150 | - - | 200-190-180 160-155-145 | - - | 310-300-295 275-270-260 | | |
| 185-175-165 130-120-110 185-175-170 | 250-235-220 175-165-155 190-180-165 | 2-250-235 180-170-165 200-190-185 | 235-225-210 160-155-145 175-165-160 | 250-240-235 170-165-160 190-180-175 | 290-275-270 195-185-185 215-205-200 | 225-210-200 145-140-130 175-165-155 | 245-240-230 170-170-160 185-180-175 | 305-295-290 215-210-205 235-225-220 | | |
| 195-180-170 130-120-110 125-120-110 | 265-250-235 175-165-155 175-160-150 | 240-225-220 180-170-165 155-145-145 | 245-230-220 160-155-145 - | 230-215-210 170-165-160 - | - - - | 210-200-190 145-140-130 - | - - - | 300-295-285 215-210-205 - | | |
| 160-150-140 130-125-115 | 220-205-190 180-170-160 | 195-185-180 160-150-145 | 205-195-185 165-160-150 | 190-180-175 150-145-140 | - - | 190-180-170 150-140-135 | - - | 295-285-280 255-250-245 | | |
| GC3220 | | | | | | | | | | |
| GC3330 | | | | | | | | | | |
| GC3040 | | | | | | | | | | |
| K20W | | | | | | | | | | |
| GC4330 | | | | | | | | | | |
| GC4340 | | | | | | | | | | |
| GC1020 | | | | | | | | | | |
| H13A | | | | | | | | | | |
| GC1010 | | | | | | | | | | |
| K20M | | | | | | | | | | |
| K15W | | | | | | | | | | |
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.1-0.15-0.25 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.15-0.25 | | | | | | | | | | |
| 0.1-0.15-0.25 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| 0.1-0.2-0.3 | | | | | | | | | | |
| Cutting speed v_c, m/min | | | | | | | | | | |
| 310-305-290 255-250-240 | 305-290-280 250-240-230 | 280-270-255 230-220-210 | 260-250-240 215-205-195 | 250-245-235 205-200-190 | 225-220-210 185-185-175 | 240-230-220 195-190-180 | 135-130-125 110-110-105 | 250-245-235 205-200-190 | 295-290-275 245-240-225 | - - |
| 340-330-315 270-265-255 | 330-315-300 265-255-240 | 305-290-280 245-235-225 | 285-270-260 225-215-210 | 270-265-255 215-210-205 | 250-240-230 200-195-185 | 260-250-240 205-200-190 | 145-140-140 120-115-110 | 270-265-255 215-210-205 | 320-315-300 260-250-240 | 285-270-260 225-215-210 |
| 210-205-200 195-195-185 | 330-315-300 265-255-240 | 190-185-175 175-170-160 | 180-170-165 165-160-150 | 170-165-160 155-155-145 | 155-150-145 145-140-135 | 160-155-150 150-145-140 | 95-90-85 85-85-80 | 170-165-160 155-155-145 | 200-195-190 185-185-175 | - - |

Milling with small engagement

| ISO N | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | CD10 | CT530 | H10 |
|-----------|--------|---------|---|---------------------------------|------------------------|------|---------------------------------|------------------|----------------|
| | | | | | | | Max chip thickness, h_{ex} mm | | |
| | | | | | | | 0.1 - 0.15 - 0.2 | 0.1 - 0.15 - 0.2 | 0.1-0.15-0.2 |
| | | | | 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 | | 2100-2100-2050 | 1150-1150-1100 | 1050-1050-1000 |
| N1.2.Z.AG | 30.12 | | Wrought or wrought and aged | 650 | 100 | | 1900-1850-1850 | 1050-1050-1000 | 950-940-920 |
| N1.3.C.UT | 30.21 | | Aluminium alloys Cast, non-aging | 600 | 75 | 0.25 | 2100-2100-2050 | 1150-1150-1000 | 1050-1050-1000 |
| N1.3.C.AG | 30.22 | | Cast or cast and aged | 700 | 90 | 0.25 | 1900-1900-1850 | 1050-1050-1100 | 950-940-920 |
| N1.1.Z.UT | 30.3 | | Aluminium alloys Al >99% | 350 | 30 | | 2150-2100-2050 | 1150-1150-1150 | 1050-1050-1050 |
| N1.4.C.NS | 30.41 | 30.42 | Aluminium alloys Cast, 13-15% Si | 700 | 130 | | 850-840-820 | 470-460-450 | 425-420-410 |
| | | | Cast, 16-22% Si | 700 | 130 | | 640-630-620 | 350-345-340 | 320-315-310 |
| N3.3.U.UT | 33.1 | | Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb | 550 | 110 | 0.25 | 1050-1050-1050 | 580-570-560 | 530-520-510 |
| N3.2.C.UT | 33.2 | | Brass, leaded bronzes, $\leq 1\%$ Pb | 550 | 90 | | 1050-1050-1000 | 580-570-560 | 530-520-510 |
| N3.1.U.UT | 33.3 | | Bronze and non-leaded copper incl. electrolytic copper | 1350 | 100 | 0.25 | 740-730-720 | 410-400-395 | 370-365-360 |
| ISO S | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | GC1025 | GC1130 | GC1010 |
| | | | | N/mm ² | HB | | Cutting speed v_c , m/min | | |
| | | | Heat resistant super alloys Iron base | | | | Max chip thickness, h_{ex} mm | | |
| S1.0.U.AN | 20.11 | | Annealed or solution treated | 2400 | 200 | 0.25 | 70-70-70 | 70-70-70 | - |
| S1.0.U.AG | 20.12 | | Aged or solution treated and aged | 2500 | 280 | 0.25 | 55-50-50 | 55-50-50 | - |
| | | | Nickel base | | | | Max chip thickness, h_{ex} mm | | |
| S2.0.Z.AN | 20.21 | | Annealed or solution treated | 2650 | 250 | 0.25 | 70-65-65 | 70-65-65 | - |
| S2.0.Z.AG | 20.22 | | Aged or solution treated and aged | 2900 | 350 | 0.25 | 45-40-40 | 45-40-40 | - |
| S2.0.C.NS | 20.24 | | Cast or cast and aged | 3000 | 320 | 0.25 | 55-50-50 | 55-50-50 | - |
| | | | Cobalt alloys | | | | Max chip thickness, h_{ex} mm | | |
| S3.0.Z.AN | 20.31 | | Annealed or solution treated | 2700 | 200 | 0.25 | 30-29-28 | 30-29-28 | - |
| S3.0.Z.AG | 20.32 | | Solution treated and aged | 3000 | 300 | 0.25 | 21-20-20 | 21-20-20 | - |
| S3.0.C.NS | 20.33 | | Cast or cast and aged | 3100 | 320 | 0.25 | 20-19-18 | 20-19-18 | - |
| | | | Titanium alloys¹⁾ | | Rm¹⁾ | | Max chip thickness, h_{ex} mm | | |
| S4.1.Z.UT | 23.1 | | Commercial pure (99,5% Ti) | 1300 | 400 | 0.23 | 150-145-140 | 150-145-140 | 170-165-160 |
| S4.2.Z.AN | 23.21 | | α , near α and $\alpha + \beta$ alloys, annealed | 1400 | 950 | 0.23 | 65-65-65 | 65-65-65 | 75-75-70 |
| S4.3.Z.AG | 23.22 | | $\alpha + \beta$ alloys in aged cond., β alloys, annealed or aged | 1400 | 1050 | 0.23 | 55-50-50 | 55-50-50 | 65-60-66 |
| ISO H | MC No. | CMC No. | Material | Specific cutting force k_{c1} | Hardness Brinell | mc | CB50 | CT530 | GC1025 |
| | | | | N/mm ² | HB | | Cutting speed v_c , m/min | | |
| | | | Extra hard steel | | | | Max chip thickness, h_{ex} mm | | |
| H1.3.Z.HA | 04.1 | | Hardened and tempered | 4200 | 59 HRC | 0.25 | 190-180-175 | 95-90-85 | 45-45-45 |
| | | | Chilled cast iron | | | | Max chip thickness, h_{ex} mm | | |
| H2.0.C.UT | 10.1 | | Cast or cast and aged | 2250 | 400 | 0.28 | 355-345-330 | 180-175-165 | 90-85-85 |

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.

**Conditions:**

Side milling, cutter dia. 25 mm.
Working engagement 10 mm.

| GC1025 | GC1130 | H10F | H13A | | | | | | | |
|---|----------------|----------------|---------------|---------------|----------------|--|--|--|--|--|
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.1-0.15-0.2 | 0.1-0.15-0.2 | 0.1-0.15-0.2 | 0.1-0.15-0.2 | | | | | | | |
| Cutting speed v_c m/min | | | | | | | | | | |
| 1100-1100-1050 | 1100-1100-1050 | 1050-1050-1000 | 850-830-820 | | | | | | | |
| 1000-980-970 | 1000-980-970 | 950-940-920 | 760-750-740 | | | | | | | |
| 1100-1100-1050 | 1100-1100-1050 | 1050-1050-1000 | 850-830-820 | | | | | | | |
| 110-1100-1100 | 1100-1100-1100 | 950-940-920 | 760-750-740 | | | | | | | |
| 1100-1100-1100 | 1100-1100-1100 | 1050-1050-1050 | 850-840-825 | | | | | | | |
| 445-440-430 | 445-440-430 | 425-420-410 | 340-335-330 | | | | | | | |
| 335-330-325 | 335-330-325 | 320-315-310 | 255-250-245 | | | | | | | |
| 560-550-540 | 560-550-540 | 530-520-510 | 425-415-410 | | | | | | | |
| 560-550-540 | 560-550-540 | 530-520-510 | 425-415-410 | | | | | | | |
| 390-380-375 | 390-380-375 | 370-365-360 | 295-290-285 | | | | | | | |
| H13A H10F S30T S40T GC2030 GC2040 | | | | | | | | | | |
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.1-0.15-0.2 | 0.1-0.2-0.3 | 0.1-0.15-0.2 | 0.1-0.15-0.2 | 0.05-0.15-0.2 | 0.05-0.15-0.25 | | | | | |
| Cutting speed v_c m/min | | | | | | | | | | |
| 65-65-65 | 60-60-60 | - | - | 65-65-65 | 70-65-65 | | | | | |
| 50-50-50 | 45-45-40 | - | - | 50-50-45 | 50-50-45 | | | | | |
| 65-65-60 | 60-55-55 | - | - | 65-60-60 | 65-65-60 | | | | | |
| 40-39-38 | 36-35-33 | - | - | 40-38-38 | 40-39-38 | | | | | |
| 50-50-50 | 45-45-40 | - | - | 50-45-45 | 50-50-45 | | | | | |
| 28-27-26 | 26-24-23 | - | - | 28-27-26 | 28-27-26 | | | | | |
| 20-19-19 | 18-17-16 | - | - | 20-19-19 | 20-19-19 | | | | | |
| 19-19-18 | 17-16-16 | - | - | 19-18-17 | 19-18-17 | | | | | |
| 140-140-135 | 130-125-120 | 170-165-160 | 145-145-140 | 140-135-130 | 145-140-135 | | | | | |
| 55-55-55 | 50-50-45 | 75-75-70 | 55-50-50 | 55-55-55 | 50-50-50 | | | | | |
| 45-40-40 | 38-37-36 | 65-60-66 | 45-45-45 | 50-45-45 | 45-40-40 | | | | | |
| GC4220 GC3040 GC1010 GC1130 | | | | | | | | | | |
| Max chip thickness, h_{ex} mm | | | | | | | | | | |
| 0.1-0.12-0.25 | 0.1-0.2-0.25 | 0.07-0.12-0.2 | 0.07-0.12-0.2 | | | | | | | |
| Cutting speed v_c m/min | | | | | | | | | | |
| 65-65-60 | 55-50-50 | 130-125-120 | 45-45-45 | | | | | | | |
| 125-125-115 | 100-95-95 | 250-240-230 | 90-85-85 | | | | | | | |

Face milling tools



CoroMill® 345

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 345L-1305M-PM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) |
| 345R-1305E-KL | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) |
| 345R-1305E-KM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) |
| 345R-1305E-PL | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) |
| 345R-1305M-KH | 0.35 | (0.3-0.49) | 0.25 | (0.21-0.35) |
| 345R-1305M-KL | 0.16 | (0.07-0.23) | 0.11 | (0.05-0.16) |
| 345R-1305M-KM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) |
| 345R-1305M-PH | 0.45 | (0.35-0.55) | 0.32 | (0.25-0.39) |
| 345R-1305M-PL | 0.17 | (0.07-0.21) | 0.12 | (0.05-0.15) |
| 345R-1305M-PM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) |
| 345R-13T5E-ML | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) |
| 345R-13T5E-MM | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) |
| 345R-13T5M-MM | 0.25 | (0.16-0.34) | 0.18 | (0.11-0.24) |

CoroMill® 245

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R245-12T3E | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) |
| R245-12T3E-AL | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| R245-12T3E-KL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| R245-12T3E-ML | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| R245-12T3E-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| R245-12T3K-MM | 0.23 | (0.1-0.28) | 0.16 | (0.07-0.2) |
| R245-12T3M-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| R245-12T3M-KL | 0.17 | (0.08-0.21) | 0.12 | (0.06-0.15) |
| R245-12T3M-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| R245-12T3M-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| R245-12T3M-PL | 0.17 | (0.08-0.21) | 0.12 | (0.06-0.15) |
| R245-12T3M-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| R245-18T6M-KM | 0.28 | (0.16-0.49) | 0.2 | (0.11-0.35) |
| R245-18T6M-MM | 0.28 | (0.16-0.49) | 0.2 | (0.11-0.35) |
| R245-18T6M-PM | 0.28 | (0.16-0.49) | 0.2 | (0.11-0.35) |

CoroMill® 419

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|-----------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 419N-140530E-SM | 0.61 | (0.4-1.2) | 0.2 | (0.13-0.39) |
| 419N-140530M-KH | 0.98 | (0.49-2) | 0.32 | (0.16-0.65) |
| 419R-1405E-MM | 0.71 | (0.34-1.2) | 0.23 | (0.11-0.39) |
| 419R-1405M-PH | 0.98 | (0.46-2) | 0.32 | (0.15-0.65) |
| 419R-1405M-PM | 0.8 | (0.4-1.78) | 0.26 | (0.13-0.58) |

CoroMill® 210

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|-----------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R210-090412M-KM | 0.98 | (0.4-1.5) | 0.17 | (0.07-0.26) |
| R210-090412M-MM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |
| R210-090412M-PM | 0.98 | (0.4-1.5) | 0.17 | (0.07-0.26) |
| R210-090414E-KM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |
| R210-090414E-MM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |
| R210-090414E-PM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |
| R210-140512M-KM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |
| R210-140512M-MM | 2.02 | (0.4-2.99) | 0.35 | (0.07-0.52) |
| R210-140512M-PM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |
| R210-140514E-KM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |
| R210-140514E-MM | 2.02 | (0.4-2.99) | 0.35 | (0.07-0.52) |
| R210-140514E-PM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) |

Face milling tools

CoroMill® 415



| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 415N-050206M-M30 | 0.39 | (0.3-0.5) | 0.1 | (0.08-0.13) |
| 415N-070310M-M30 | 0.46 | (0.35-0.55) | 0.12 | (0.09-0.14) |
| 415N-070320E-M30 | 0.46 | (0.35-0.55) | 0.12 | (0.09-0.14) |
| 415N-070320M-M30 | 0.46 | (0.35-0.55) | 0.12 | (0.09-0.14) |
| 415N-050212E-M30 | 0.39 | (0.35-0.55) | 0.1 | (0.08-0.13) |
| 415N-050212M-M30 | 0.39 | (0.35-0.55) | 0.1 | (0.08-0.13) |

CoroMill® 425

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 425N-1707E-KLW12 | 0.19 | (0.02-0.28) | 0.08 | (0.01-0.12) |

CoroMill® 745

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|----------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 745L-2109E-M50 | 0.25 | (0.18-0.42) | 0.17 | (0.12-0.28) |
| * | 0.61 | (0.44-1.02) | 0.17 | (0.12-0.28) |
| 745R-2109E-H50 | 0.3 | (0.21-0.45) | 0.2 | (0.11-0.3) |
| * | 0.73 | (0.51-1.09) | 0.2 | (0.14-0.30) |
| 745R-2109E-M30 | 0.21 | (0.15-0.3) | 0.14 | (0.4-0.2) |
| * | 0.51 | (0.36-0.73) | 0.14 | (0.10-0.20) |
| 745R-2109E-M31 | 0.21 | (0.15-0.3) | 0.14 | (0.1-0.2) |
| 745R-2109E-M50 | 0.25 | (0.18-0.42) | 0.17 | (0.12-0.28) |
| * | 0.61 | (0.44-0.90) | 0.17 | (0.12-0.28) |

* High feed cutter

Shoulder milling tools

CoroMill® 490

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|-----------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 490L-140408M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) |
| 490R-08T304E-ML | 0.13 | (0.08-0.18) | 0.13 | (0.08-0.18) |
| 490R-08T304M-KL | 0.12 | (0.05-0.15) | 0.12 | (0.05-0.15) |
| 490R-08T304M-PL | 0.08 | (0.05-0.12) | 0.08 | (0.05-0.12) |
| 490R-08T308E-ML | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) |
| 490R-08T308E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) |
| 490R-08T308M-KH | 0.24 | (0.15-0.3) | 0.24 | (0.15-0.3) |
| 490R-08T308M-KL | 0.12 | (0.05-0.15) | 0.12 | (0.05-0.15) |
| 490R-08T308M-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| 490R-08T308M-MM | 0.16 | (0.1-0.2) | 0.16 | (0.1-0.2) |
| 490R-08T308M-PH | 0.2 | (0.15-0.25) | 0.2 | (0.15-0.25) |
| 490R-08T308M-PL | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) |
| 490R-08T308M-PM | 0.15 | (0.1-0.2) | 0.15 | (0.1-0.2) |
| 490R-08T312E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) |
| 490R-08T312M-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| 490R-08T312M-PM | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) |
| 490R-08T316E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) |
| 490R-08T316M-KH | 0.24 | (0.15-0.3) | 0.24 | (0.15-0.3) |
| 490R-08T316M-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| 490R-08T316M-PH | 0.21 | (0.15-0.25) | 0.21 | (0.15-0.25) |
| 490R-08T316M-PM | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) |
| 490R-140408E | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| 490R-140408E-ML | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) |
| 490R-140408E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) |
| 490R-140408M-MM | 0.16 | (0.12-0.2) | 0.16 | (0.12-0.2) |
| 490R-140408M-PH | 0.28 | (0.2-0.35) | 0.28 | (0.2-0.35) |
| 490R-140408M-PL | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) |
| 490R-140408M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) |
| 490R-140412E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) |
| 490R-140412M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) |
| 490R-140416E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) |
| 490R-140416M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) |
| 490R-140420E | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| 490R-140420E-MM | 0.16 | (0.12-0.2) | 0.17 | (0.12-0.22) |
| 490R-140420M-MM | 0.16 | (0.12-0.2) | 0.16 | (0.12-0.2) |
| 490R-140420M-PH | 0.28 | (0.2-0.35) | 0.28 | (0.2-0.35) |
| 490R-140420M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) |

Shoulder milling tools



CoroMill® 390

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 390R-070202E-ML | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) |
| 390R-070202E-NL | 0.1 | (0.02-0.2) | 0.1 | (0.02-0.2) |
| 390R-070202E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) |
| 390R-070202M-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070202M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070204E-KL | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) |
| 390R-070204E-ML | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) |
| 390R-070204E-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070204E-NL | 0.05 | (0.02-0.07) | 0.1 | (0.02-0.2) |
| 390R-070204E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) |
| 390R-070204M-KM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070204M-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070204M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070208E-KL | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) |
| 390R-070208E-ML | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) |
| 390R-070208E-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070208E-NL | 0.05 | (0.02-0.07) | 0.1 | (0.02-0.2) |
| 390R-070208E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) |
| 390R-070208M-KM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070208M-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070208M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070212E-ML | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) |
| 390R-070212E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) |
| 390R-070212M-MM | 0.1 | (0.02-0.2) | 0.07 | (0.03-0.1) |
| 390R-070212M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) |
| 390R-070216E-ML | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) |
| 390R-070216E-PL | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) |
| 390R-070216M-KM | 0.05 | (0.02-0.07) | 0.07 | (0.03-0.1) |
| 390R-070216M-MM | 0.1 | (0.02-0.2) | 0.07 | (0.03-0.1) |
| 390R-070216M-PM | 0.12 | (0.08-0.2) | 0.07 | (0.03-0.1) |
| R390-11T302E-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.18) |
| R390-11T302E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T302E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T304E-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-11T304M-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| R390-11T304M-PM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| R390-11T308E-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-11T308E-ML | 0.08 | (0.04-0.15) | 0.08 | (0.04-0.15) |
| R390-11T308E-NL | 0.18 | (0.06-0.35) | 0.15 | (0.05-0.25) |
| R390-11T308E-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-11T308E-PLW | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T308M-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-11T308M-KM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T308M-MM | 0.13 | (0.08-0.2) | 0.13 | (0.08-0.2) |
| R390-11T308M-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-11T308M-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T310M-KH | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T310M-MH | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T310M-PH | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T312E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-11T312E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T312E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T316E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) |
| R390-11T316E-ML | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T316E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T316E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T316M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) |
| R390-11T316M-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T320E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-11T320E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T320E-NL | 0.18 | (0.06-0.4) | 0.18 | (0.06-0.35) |
| R390-11T320E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T324E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-11T324E-ML | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T324E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T324E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T331E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) |
| R390-11T331E-ML | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T331E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T331E-NL | 0.18 | (0.06-0.4) | 0.18 | (0.06-0.4) |
| R390-11T331E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T331M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) |

Shoulder milling tools



CoroMill® 390

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|--------------------|--------------------------------|--------------|--|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R390-11T331M-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-11T304E-P4-NL | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| R390-170404E-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.18) |
| R390-170404E-MM | 0.15 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170404E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170404M-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| R390-170404M-PM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| R390-170408E-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-170408E-ML | 0.08 | (0.04-0.15) | 0.08 | (0.04-0.15) |
| R390-170408E-NL | 0.17 | (0.1-0.2) | 0.15 | (0.08-0.25) |
| R390-170408E-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-170408M-KH | 0.2 | (0.15-0.35) | 0.2 | (0.15-0.35) |
| R390-170408M-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-170408M-KM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) |
| R390-170408M-MM | 0.15 | (0.08-0.2) | 0.15 | (0.08-0.2) |
| R390-170408M-PH | 0.2 | (0.15-0.35) | 0.2 | (0.15-0.35) |
| R390-170408M-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) |
| R390-170408M-PM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) |
| R390-170412E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-170412E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170412E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170416E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) |
| R390-170416E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170416E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170416M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) |
| R390-170416M-PH | 0.2 | (0.15-0.35) | 0.2 | (0.15-0.35) |
| R390-170416M-PM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) |
| R390-170420E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-170420E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170420E-NL | 0.2 | (0.12-0.32) | 0.2 | (0.1-0.3) |
| R390-170420E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170424E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-170424E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170424E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170431E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) |
| R390-170431E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170431E-NL | 0.2 | (0.12-0.32) | 0.2 | (0.12-0.32) |
| R390-170431E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170431M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) |
| R390-170431M-PM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) |
| R390-170440E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-170440E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170440E-NL | 0.2 | (0.12-0.4) | 0.2 | (0.12-0.32) |
| R390-170440E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170448E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-170448E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170448E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170450E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-170450E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170450E-NL | 0.2 | (0.12-0.4) | 0.2 | (0.12-0.4) |
| R390-170450E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170460E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) |
| R390-170460E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170460E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170464E-KM | 0.08 | (0.04-0.15) | 0.1 | (0.08-0.18) |
| R390-170464E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170464E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) |
| R390-170408E-P6-NL | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| R390-180608H-KL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) |
| R390-180608H-ML | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) |
| R390-180608H-PL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) |
| R390-180608M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180608M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) |
| R390-180608M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180612H-KL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) |
| R390-180612H-ML | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) |
| R390-180612H-PL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) |
| R390-180612M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180612M-KMR | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180612M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) |
| R390-180612M-MMR | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) |
| R390-180612M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |

Shoulder milling tools



CoroMill® 390

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R390-180612M-PMR | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180616H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180616H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180616M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180616M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) |
| R390-180616M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180620H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180620H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180620M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180620M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) |
| R390-180620M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180624H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180624H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180631H-KL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) |
| R390-180631H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180631H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180631M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180631M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) |
| R390-180631M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) |
| R390-180640H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180640H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180650H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180650H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) |
| R390-180660H-ML | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) |
| R390-180660H-PL | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) |
| R390-180664H-ML | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) |
| R390-180664H-PL | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) |

CoroMill® 690

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 690-100508M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-100510M-P-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-100512M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-100516M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-100520M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-100531M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140608M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140610M-P-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140612M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140616M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140620M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140624M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140631M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140650M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140660M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |
| 690-140664M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) |

CoroMill® Century

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R590-110504H-NL | 0.15 | (0.05-0.3) | 0.2 | (0.1-0.4) |
| R590-110508H-KL | 0.12 | (0.07-0.2) | 0.08 | (0.05-0.15) |
| R590-110508H-PL | 0.12 | (0.01-0.15) | 0.08 | (0.05-0.15) |
| R590-110508H-PR2-KM | 0.2 | (0.1-0.4) | 0.2 | (0.1-0.3) |
| R590-1105H-PC2-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) |
| R590-1105H-PC5-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) |
| R590-1105H-PR2-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) |
| R590-1105H-PR5-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) |
| R590-1105H-PS2-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) |
| R590-1105H-PS5-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) |
| L590-1105H-ZC2-KL | 0.08 | (0.05-0.15) | 0.2 | (0.1-0.3) |
| R590-1105H-ZC2-KL | 0.2 | (0.1-0.3) | 0.2 | (0.1-0.3) |

Disc milling tools



CoroMill® 331

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| L331.1A-115030E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| L331.1A-115040E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| L331.1A-115048E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| L331.1A-115063E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| L331.1A-115015E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| L331.1A-115023E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| L331.1A-115030E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| L331.1A-043515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-043523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-054515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-054523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-054530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-084515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-084523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-084530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-115015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-115023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-115030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-115048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-115063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-145015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-145023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-145030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-145048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| L331.1A-145063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-115030E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| R331.1A-115040E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| R331.1A-115048E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| R331.1A-115063E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) |
| R331.1A-115015E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| R331.1A-115023E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| R331.1A-115030E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| R331.1A-043515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-043523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-054515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-054523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-054530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-084515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-084523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-084530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-115015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-115023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-115030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-115048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-115063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-145015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-145023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-145030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-145048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| R331.1A-145063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-043505E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) |
| N331.1A-043505E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) |
| N331.1A-043505E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| N331.1A-054508E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) |
| N331.1A-054508E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) |
| N331.1A-054508E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| N331.1A-084508E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) |
| N331.1A-084508E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) |
| N331.1A-084508E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| N331.1A-115008E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) |
| N331.1A-115008E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) |
| N331.1A-115008E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| N331.1A-145008E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) |
| N331.1A-145008E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) |
| N331.1A-145008E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) |
| N331.1A-043505H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-054508H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-084508H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-115008H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-145008H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-084508H-WM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-115008H-WM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-145008H-WM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|--------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| N331.1A-043505H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-054508H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-084508H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-115008H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-145008H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-043505H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-054508H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-084508H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-115008H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-145008H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-043505H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) |
| N331.1A-054508H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) |
| N331.1A-084508H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) |
| N331.1A-115008H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) |
| N331.1A-145008H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) |
| N331.1A-043505H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-054508H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-084508H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-115008H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-145008H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-054508H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-084508H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-115008H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-145008H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-043505E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-054508E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-084508E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-115008E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-145008E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) |
| N331.1A-054508E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-084508E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-115008E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-145008E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-043505M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-054508M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-084508M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-115008M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1A-145008M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) |
| N331.1D-136508E-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) |
| N331.1D-136508M-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) |
| N331.1D-136512M-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) |
| N331.1D-136520E-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) |
| N331.1D-136520M-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) |

DC/AR ratio = 12% (same for all 90 degree concepts)

Profile milling tools

CoroMill® 300

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{bx} mm | |
|---------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R300-0517E-PM | 0.08 | (0.05-0.12) | 0.08 | (0.05-0.12) |
| R300-0720E-MM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) |
| R300-0720E-PM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) |
| R300-0724E-MM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) |
| R300-0724E-PM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) |
| R300-0828E-KL | 0.13 | (0.05-0.2) | 0.11 | (0.05-0.15) |
| R300-0828E-KM | 0.15 | (0.07-0.25) | 0.13 | (0.05-0.2) |
| R300-0828E-MM | 0.13 | (0.07-0.2) | 0.13 | (0.05-0.2) |
| R300-0828E-PL | 0.11 | (0.05-0.15) | 0.11 | (0.05-0.15) |
| R300-0828E-PM | 0.13 | (0.05-0.2) | 0.13 | (0.05-0.2) |
| R300-0828M-KH | 0.15 | (0.07-0.25) | 0.15 | (0.07-0.25) |
| R300-0828M-MH | 0.13 | (0.05-0.2) | 0.15 | (0.07-0.25) |
| R300-0828M-MM | 0.13 | (0.07-0.2) | 0.13 | (0.07-0.2) |
| R300-0828M-PH | 0.15 | (0.07-0.25) | 0.15 | (0.07-0.25) |
| R300-0828M-PM | 0.13 | (0.07-0.2) | 0.13 | (0.07-0.2) |
| R300-0932E-MM | 0.15 | (0.07-0.23) | 0.13 | (0.04-0.2) |
| R300-0932E-PM | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) |
| R300-0932M-PH | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) |
| R300-0932M-PM | 0.15 | (0.07-0.23) | 0.13 | (0.06-0.2) |
| R300-1032E-KL | 0.21 | (0.05-0.29) | 0.13 | (0.04-0.15) |
| R300-1032E-MM | 0.17 | (0.07-0.29) | 0.18 | (0.04-0.25) |
| R300-1032E-PL | 0.15 | (0.05-0.17) | 0.13 | (0.04-0.15) |
| R300-1032E-PM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) |
| R300-1032M-KH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1032M-MH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1032M-MM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) |
| R300-1032M-PH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1032M-PM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) |
| R300-1240E-KM | 0.23 | (0.07-0.35) | 0.18 | (0.04-0.25) |
| R300-1240E-ML | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) |
| R300-1240E-MM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) |
| R300-1240E-PL | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) |
| R300-1240E-PM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) |
| R300-1240M-KH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1240M-MH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1240M-MM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) |
| R300-1240M-PH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1240M-PM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) |
| R300-1340E-ML | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) |
| R300-1340E-MM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) |
| R300-1340E-PL | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) |
| R300-1340E-PM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) |
| R300-1340M-KH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1340M-MH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1340M-MM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) |

Profile milling tools



CoroMill® 300

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R300-1340M-PH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) |
| R300-1340M-PM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) |
| R300-1648E-KM | 0.29 | (0.07-0.46) | 0.2 | (0.04-0.3) |
| R300-1648E-ML | 0.17 | (0.05-0.23) | 0.15 | (0.04-0.2) |
| R300-1648E-MM | 0.21 | (0.07-0.29) | 0.2 | (0.04-0.3) |
| R300-1648E-PL | 0.17 | (0.05-0.23) | 0.15 | (0.04-0.2) |
| R300-1648E-PM | 0.23 | (0.05-0.35) | 0.2 | (0.04-0.3) |
| R300-1648M-KH | 0.29 | (0.07-0.46) | 0.25 | (0.06-0.4) |
| R300-1648M-MH | 0.29 | (0.07-0.46) | 0.25 | (0.06-0.4) |
| R300-1648M-MM | 0.21 | (0.07-0.29) | 0.18 | (0.06-0.25) |
| R300-1648M-PH | 0.29 | (0.07-0.46) | 0.25 | (0.06-0.4) |
| R300-1648M-PM | 0.21 | (0.07-0.29) | 0.18 | (0.06-0.25) |
| R300-2060E-ML | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) |
| R300-2060E-MM | 0.35 | (0.06-0.57) | 0.25 | (0.04-0.4) |
| R300-2060E-PL | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) |
| R300-2060E-PM | 0.35 | (0.06-0.57) | 0.25 | (0.04-0.4) |
| R300-2060M-KH | 0.49 | (0.07-0.78) | 0.35 | (0.05-0.55) |
| R300-2060M-MH | 0.49 | (0.07-0.78) | 0.35 | (0.05-0.55) |
| R300-2060M-MM | 0.28 | (0.07-0.42) | 0.2 | (0.05-0.3) |
| R300-2060M-PH | 0.49 | (0.07-0.78) | 0.35 | (0.05-0.55) |
| R300-2060M-PM | 0.28 | (0.07-0.42) | 0.2 | (0.05-0.3) |
| R300-2570E-ML | 0.31 | (0.06-0.4) | 0.22 | (0.04-0.28) |
| R300-2570E-PL | 0.31 | (0.06-0.4) | 0.22 | (0.04-0.28) |
| R300-2570M-KH | 0.57 | (0.07-0.85) | 0.4 | (0.05-0.6) |
| R300-2570M-MM | 0.31 | (0.07-0.47) | 0.22 | (0.05-0.33) |
| R300-2570M-PH | 0.57 | (0.07-0.85) | 0.4 | (0.05-0.6) |
| R300-2570M-PM | 0.31 | (0.07-0.47) | 0.22 | (0.05-0.33) |

CoroMill® 600

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 600-1045E-ML | 0.2 | (0.05-0.35) | 0.2 | (0.05-0.35) |
| 600-1045M-ML | 0.2 | (0.05-0.35) | 0.2 | (0.05-0.35) |
| 600-1252E-ML | 0.25 | (0.05-0.35) | 0.25 | (0.05-0.35) |
| 600-1252M-ML | 0.25 | (0.05-0.35) | 0.25 | (0.05-0.35) |
| 600R-1045M-MM | 0.35 | (0.15-0.55) | 0.35 | (0.15-0.55) |
| 600R-1252M-MM | 0.35 | (0.15-0.55) | 0.35 | (0.15-0.55) |

CoroMill® 216

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| APMT160408-M | 0.35 | (0.14-0.7) | 0.25 | (0.1-0.5) |
| R216-1002E-M | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) |
| R216-1202E-M | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) |
| R216-1202M-M | 0.14 | (0.08-0.21) | 0.1 | (0.04-0.15) |
| R216-1603E-M | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) |
| R216-1603M-M | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| R216-20T3E-M | 0.21 | (0.06-0.25) | 0.15 | (0.04-0.18) |
| R216-20T3M-M | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| R216-2504E-M | 0.21 | (0.06-0.25) | 0.15 | (0.04-0.18) |
| R216-2504M-M | 0.17 | (0.08-0.21) | 0.12 | (0.06-0.15) |
| R216-3006E-M | 0.24 | (0.06-0.28) | 0.17 | (0.04-0.2) |
| R216-3006M-M | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) |
| R216-3206E-M | 0.24 | (0.06-0.28) | 0.17 | (0.04-0.2) |
| R216-3206M-M | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) |
| R216-4007E-M | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) |
| R216-4007M-M | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) |
| R216-5007E-M | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) |
| R216-5007M-M | 0.35 | (0.1-0.7) | 0.25 | (0.07-0.5) |

Profile milling tools



CoroMill® 200

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| RCHT09T300-ML | 0.15 | (0.08-0.2) | 0.15 | (0.08-0.2) |
| RCHT09T300-PL | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| RCHT10T3M0-KL | 0.17 | (0.1-0.2) | 0.1 | (0.08-0.15) |
| RCHT10T3M0-ML | 0.15 | (0.08-0.2) | 0.15 | (0.08-0.2) |
| RCHT10T3M0-PL | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) |
| RCHT1204M0 | 0.21 | (0.1-0.42) | 0.1 | (0.08-0.15) |
| RCHT1204M0-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) |
| RCHT1204M0-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| RCHT130400-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) |
| RCHT130400-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) |
| RCHT130400-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| RCHT1606M0-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) |
| RCHT1606M0-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) |
| RCHT1606M0-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| RCHT190600-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) |
| RCHT190600-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| RCHT2006M0-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) |
| RCHT2006M0-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) |
| RCHT2006M0-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) |
| RCHT1204M0-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) |
| RCKT09T300-KH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) |
| RCKT09T300-MM | 0.2 | (0.1-0.3) | 0.2 | (0.1-0.3) |
| RCKT09T300-PH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) |
| RCKT09T300-PM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| RCKT10T3M0-KH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) |
| RCKT10T3M0-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| RCKT10T3M0-MM | 0.2 | (0.1-0.3) | 0.2 | (0.1-0.3) |
| RCKT10T3M0-PH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) |
| RCKT10T3M0-PM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| RCKT10T3M0-WM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) |
| RCKT1204M0-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT1204M0-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT1204M0-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) |
| RCKT1204M0-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT1204M0-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT1204M0-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT1204M0 | 0.35 | (0.1-0.42) | 0.15 | (0.07-0.3) |
| RCKT130400-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT130400-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT130400-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) |
| RCKT130400-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT130400-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT130400-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT1606M0-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT1606M0-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT1606M0-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) |
| RCKT1606M0-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT1606M0-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT1606M0-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT1606M0 | 0.35 | (0.1-0.42) | 0.15 | (0.07-0.3) |
| RCKT190600-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT190600-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT190600-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) |
| RCKT190600-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT190600-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT190600-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT2006M0-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT2006M0-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT2006M0-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) |
| RCKT2006M0-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) |
| RCKT2006M0-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |
| RCKT2006M0-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) |

Groove milling tools



CoroMill® 327

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 327R12-22 11045-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 13045-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 16045-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 18545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 21545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 26545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 31545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 41545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-221304508-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-221604508-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-222654518-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-224154525-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R06-10 10000-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R06-10 15002-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R06-10 20002-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R06-10 25002-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R09-18 15002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 20002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 25002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 30002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-22 15002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 20002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 25002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 30002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 40002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R14-28 15000-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R14-28 20002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R14-28 25002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R14-28 30002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R14-28 35002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R14-28 40002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R09-18 15001-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 20002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 25002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 30002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-28 15001-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-28 20002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-28 25002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-28 30002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-28 40002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R14-35 15001-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R14-35 20002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R14-35 25002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R14-35 30002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R06-12 22011-RM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R09-18 22011-RM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-22 10005-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 20010-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 30015-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 40020-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |

CoroMill® 328

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|-------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 328R13-13000-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-16000-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-18502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-18545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-21502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-21545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-26502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-26545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-2654515-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-31502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-31545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-41502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-41545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-4154520-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-51502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-51545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |

Groove milling tools



CoroMill® QD

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|--------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| QD-NE-0200-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NF-0239-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NF-0250-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NG-0300-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NG-0318-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NH-0400-015E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NJ-0476-020E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NJ-0500-020E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NK-0600-025E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NK-0635-025E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) |
| QD-NE-0200-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NF-0239-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NF-0250-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NG-0300-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NG-0318-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NH-0400-025E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NJ-0476-030E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NJ-0500-030E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NK-0600-035E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NK-0635-035E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NE-0200-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NF-0239-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NF-0250-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NG-0300-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NG-0318-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NH-0400-025E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NJ-0476-030E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NJ-0500-030E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NK-0600-035E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NK-0635-035E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NE-0200-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NF-0239-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NF-0250-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NG-0300-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NG-0318-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NH-0400-025E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NJ-0476-030E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NJ-0500-030E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NK-0600-035E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NK-0635-035E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) |
| QD-NE-0200-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NF-0239-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NF-0250-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NG-0300-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NG-0318-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NH-0400-025E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NJ-0476-030E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NJ-0500-030E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NK-0600-035E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NK-0635-035E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) |
| QD-NE-0200-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NF-0239-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NF-0250-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NG-0300-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NH-0400-025E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NG-0318-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NJ-0476-030E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NJ-0500-030E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NK-0600-035E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |
| QD-NK-0635-035E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) |

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|--------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| QD-NE-0200-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NF-0239-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NF-0250-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NG-0300-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NG-0318-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NH-0400-040M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NJ-0476-045M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NJ-0500-045M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NK-0600-050M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NK-0635-050M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) |
| QD-NE-0200-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NF-0239-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NF-0250-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NG-0300-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NG-0318-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NH-0400-025E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NJ-0476-030E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NJ-0500-030E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NK-0600-035E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NK-0635-035E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) |
| QD-NE-0200-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NF-0239-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NF-0250-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NG-0300-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NG-0318-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NH-0400-025E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NJ-0476-030E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NJ-0500-030E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NK-0600-035E-PM | 0.2 | (0.08-0.12) | 0.1 | (0.07-0.1) |
| QD-NK-0635-035E-PM | 0.2 | (0.08-0.12) | 0.1 | (0.07-0.1) |
| QD-NE-0200-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NF-0239-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NF-0250-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NG-0300-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NG-0318-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NH-0400-025M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NJ-0476-030M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NJ-0500-030M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) |
| QD-NK-0600-035M-PM | 0.12 | (0.08-0.12) | 0.1 | (0.07-0.1) |
| QD-NK-0635-035M-PM | 0.12 | (0.08-0.12) | 0.1 | (0.07-0.1) |
| QD-NE-0200-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NF-0239-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NF-0250-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NG-0300-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NG-0318-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NH-0400-040M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NJ-0476-045M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NJ-0500-045M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) |
| QD-NK-0600-050M-PH | 0.12 | (0.05-0.12) | 0.1 | (0.04-0.1) |
| QD-NK-0635-050M-PH | 0.12 | (0.05-0.12) | 0.1 | (0.04-0.1) |

Recommendation for diameter 63 mm cutters:

- PL is the 1st choice geometry in ISO P applications
- Use maximum 70% of the recommended h_{ex} value when using the PM geometry
- PH geometry is not recommended

Thread milling tools

CoroMill® 328



| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|-----------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 328R13-04UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-06UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-08UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-10UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-12UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-14UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-150MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-150VM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-16UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-200MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-300MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-350MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-400MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-400VM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-450MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-500MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-550MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |
| 328R13-600MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) |

CoroMill® 327

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------------|--------------------------------|--------------|---------------------------------|--------------|
| | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 327R06-12 100VM-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R09-18 100VM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-22 100VM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R06-12 250VM-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R09-18 250VM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-22 250VM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R06-12 19WH-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R09-18 19WH-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R06-12 14WH-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R09-18 14WH-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R06-12 11WH-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) |
| 327R09-18 11WH-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 24UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 20UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 18UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 16UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 14UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 12UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 11UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 10UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 08UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 150MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 200MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 300MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 350MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-22 150MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 175MM-TH | 0.07 | (0.04-0.1) | 0.06 | (0.04-0.1) |
| 327R12-22 200MM-TH | 0.07 | (0.04-0.1) | 0.06 | (0.04-0.1) |
| 327R12-22 300MM-TH | 0.07 | (0.04-0.1) | 0.06 | (0.04-0.1) |
| 327R12-22 350MM-TH | 0.07 | (0.04-0.1) | 0.06 | (0.04-0.1) |
| 327R12-22 400MM-TH | 0.07 | (0.04-0.1) | 0.06 | (0.04-0.1) |
| 327R12-22 450MM-TH | 0.07 | (0.04-0.1) | 0.06 | (0.04-0.1) |
| 327R09-18 100VM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-22 100VM-THM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R09-18 250VM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R12-22 250VM-THM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R09-18 24UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 20UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 18UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 16UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 14UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 12UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 11UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 10UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 08UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 150MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 200MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 300MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |
| 327R09-18 350MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) |

Chamfer milling tools



CoroMill® 495

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|---------------|--------------------------------|---------------|---------------------------------|---------------|
| | Starting value | (min. - max.) | Starting value | (min. - max.) |
| 495-09T3M-MM | 0.17 | (0.12-0.25) | 0.16 | (0.12-0.2) |
| 495-09T3M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) |

CoroMill® 327

| Ordering code | Feed per tooth, f_z mm/tooth | | Max chip thickness, h_{ex} mm | |
|--------------------|--------------------------------|---------------|---------------------------------|---------------|
| | Starting value | (min. - max.) | Starting value | (min. - max.) |
| 327R06-12 12045-CH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |
| 327R12-22 20045-CH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) |

Grades for milling

P Steel

Basic grades



GC1130 (HC) - P30 (P15-P40)

Hard, thin coated PVD-grade with Zertivo™ technology for various applications. Suitable from light roughing to finishing in average stability for wet and dry machining. Good choice for complex tool paths and sticky materials.

Where GC1130 is not available, please use GC1030.



GC4340 (HC) - P40 (P35-P50)

Tough CVD-coated grade (medium thick coating) suited for tough and demanding medium to rough milling applications for wet and dry machining.



GC4330 (HC) - P30 (P10-P40)

Medium hard CVD-coated grade (medium thick coating) designed for medium to rough milling applications in average cutting conditions for wet and dry machining.



GC4220 (HC) - P20 (P10-P25)

Hard CVD-coated (thick coating) grade suitable for high cutting speeds in medium to rough milling application with good stability for dry machining.

Complementary grades



GC1010 (HC) - P10 (P05-P15)

Very hard PVD-coated (thin coating) grade for finishing in very stable conditions and hardened materials for wet and dry machining.



CT530 (HT) - P15 (P10-P15)

Medium hard uncoated cermet grade for finishing applications at high cutting speeds for dry machining.



GC2030 (HC) - P30 (P20-P40)

Medium hard PVD-coated (thin coating) grade for sticky materials for wet and dry machining.



GC2040 (HC) - P45 (P30-P50)

Tough CVD-coated grade (medium thick coating) for roughing in tough and demanding applications for wet and dry machining and good for mixed material production.



GC3040 (HC) - P20 (P10-P40)

Medium hard CVD-coated (thick coating) grade which complements GC4330 in abrasive materials.



M30B (HC) - P35 (P30-P40)

Tough CVD-coated (thin coated) grade for turbine blade machining under tough and demanding conditions at high cutting speeds for wet and dry machining.



GC1025 (HC) - P30 (P15-P30)

Hard PVD-coated (thin coating) grade for light roughing to finishing in sticky materials for wet and dry machining.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

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

HC Hardmetals as above, but coated

Grades for milling

M Austenitic/ferritic/martensitic stainless steel

Basic grades



GC1040 (HC) - M30 (M15-M35)

Tough, thin-coated PVD grade for finishing to roughing in unstable to stable wet or dry conditions. Good choice for complex tool paths and sticky materials.



GC2040 (HC) - M40 (M25-M40)

Tough, medium-thick coated CVD grade designed for tough and demanding, medium to rough milling applications with poor stability in dry conditions. High feed rates, large diameters and radial engagements.



S30T (HC) - M25 (M15-M35)

Medium hard, thin-coated PVD grade to be used as a complement to GC1040 when stability is good and for demands on high cutting speed in wet and dry conditions.



GC2030 (HC) - M25 (M15-M30)

Medium-hard, thin coated PVD grade for light roughing to finishing. Complement to GC1040 in good stability, for high cutting speeds in dry conditions.

Complementary grades



M30B (HC) - M35 (M30-M40)

Tough, thin-coated CVD grade for turbine blade machining under toughness-demanding conditions at high cutting speeds. Can be used in both wet and dry conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

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

HC Hardmetals as above, but coated

Complementary grades



S40T (HC) - M40 (M30-M40)

Very tough, medium-thick-coated CVD grade designed for toughness-demanding medium to rough milling applications with poor stability. Can be used in both dry and wet conditions.



GC1130 (HC) - M15 (M10-M20)

Hard, thin-coated PVD grade with Zertivo™ technology for use as a complement to GC1040 with good stability and demands for high cutting speed. Can be used in both dry and wet conditions. Good choice for mixed ISO M/ISO P material production.

Where GC1130 does not exist, please use GC1030.



CT530 (HT) - M10 (M10-M15)

Medium hard uncoated cermet grade for finishing applications at high cutting speeds for dry machining.



GC1010 (HC) - M10 (M05-M10)

Very hard, thin-coated PVD grade for finishing in stable conditions for wet and dry machining.



GC4330 (HC) - M30 (M25-M35)

Medium hard, medium-thick-coated CVD grade for medium to rough milling of martensitic stainless steels at elevated cutting speeds in average and dry conditions.



GC4340 (HC) - M40 (M30-M40)

Tough, medium-thick-coated CVD grade for tough and demanding, medium to rough milling applications of martensitic stainless steels in dry conditions.

Grades for milling

Cast iron

Basic grades



GC3330 (HC) - K20 (K15-K35)

Hard CVD-coated grade with thick coating, designed for medium to rough milling of all cast irons in average to stable conditions, both dry and wet. First choice in grey cast iron and mixed ISO K applications.



GC1020 (HC) - K20 (K10-K25)

Hard PVD-coated grade with thin coating for light roughing to finishing of nodular cast iron in dry and wet conditions, and grey cast iron in wet and average to stable conditions. First choice for nodular cast iron and/or small diameter cutters.



GC3220 (HC) - K15 (K10-K25)

Hard CVD-coated grade with very thick coating, designed for high cutting speeds in medium to rough grey cast milling applications with good stability in dry conditions.



GC3040 (HC) - K30 (K20-K40)

Medium-hard CVD grade with thick coating for tough and demanding medium to rough milling applications of grey cast iron in dry conditions.



K20W (HC) - K20 (K15-K30)

Hard CVD-coated grade with thin coating for finishing to light rough milling of all cast irons in stable and wet conditions. Ideal for large diameter cutters.



K20D (HC) - K15 (K10-K25)

Hard CVD-coated grade with very thick coating designed for high cutting speed in medium to rough grey cast iron milling applications with good stability in dry conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HC Hardmetals as above, but coated

Ceramics:

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

Boron nitride:

BN Polycrystalline boron nitride¹⁾

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

Complementary grades



CB50 (BN) - K10 (K01-K20)

Hard CBN-tipped grade for light roughing to finishing of grey cast iron in stable, dry conditions. Use when dimensional stability and long tool life are critical.



CC6190 (CN) - K05 (K01-K15)

Hard silicon nitride ceramic grade for very high cutting speeds in light roughing to semi-finishing of grey cast iron in stable and dry conditions.



GC1010 (HC) - K05 (K01-K10)

Very hard PVD-coated grade with thin coating for finishing in very stable conditions. A harder complement to GC1020 in wet conditions.



H13A (HW) - K20 (K10-K25)

Hard uncoated carbide grade for rough to finish milling with sharp cutting edges, at low speeds and in average to stable, dry and wet conditions.



GC4340 (HC) - K40 (K30-K40)

Tough CVD-coated grade with medium-thick coating, for use as a tougher complement to GC3040 when stability is poor, in dry and wet conditions.



GC4330 (HC) - K30 (K20-K35)

Medium-hard CVD-coated grade with medium-thick coating, for toughness-demanding, medium to rough milling applications of nodular cast iron in dry and wet conditions.



K20M (HC) - K15 (K10-K25)

Hard CVD-coated grade with medium-thick coating, for medium to rough milling in various applications of all kinds of cast iron, mainly dry conditions.



K15W (HC) - K15 (K10-K25)

Hard CVD-coated grade with thin coating for finishing of cast iron and bi-metal components such as cast iron and aluminum in stable and wet conditions. Use as a complement to K20W when a sharp edge is needed.

Grades for milling

N
Non ferrous metals, plastics, wood

Basic grades


H13A (HW) - N15 (N10-N25)

Hard uncoated grade for roughing to semi-finishing with sharp edges in average to stable conditions. Excellent surface finish in wet and dry machining.


H10 (HW) - N10 (N05-N15)

Very hard uncoated grade, for light roughing to finishing with sharp cutting edges in stable conditions with high demands on the quality of the surface finish in wet and dry machining.


CD10 (DP) - N05 (N01-N10)

Polycrystalline diamond-tipped grade (PCD) with sharp edges for light roughing to finishing in stable conditions for wet or dry machining with a high demand on the quality of the surface finish and process stability. Good choice for abrasive materials.

Complementary grades


CT530 (HT) - N15 (N10-N20)

Medium-hard, uncoated cermet grade for finishing in rather stable conditions and elevated cutting speeds in wet and dry conditions.


GC1130 (HC) - N15 (N10-N25)

Hard, thin-coated PVD Zertivo™ grade for roughing to semi-finishing in average conditions with less demands on surface finish in wet and dry conditions.

*Where GC1130 does not exist, please use GC1030.


H10F (HW) - N15 (N10-N25)

Hard uncoated grade for light roughing to finishing with sharp edges in average conditions for good surface in wet and dry conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

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

HC Hardmetals as above, but coated

Diamond:

DP Polycrystalline diamond¹⁾

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

Grades for milling

S Heat resistant alloys Titanium alloys

Basic grades



S30T (HC) - S25 (S15-S30)

Medium-hard PVD-coated grade with thin coating, for finishing to light roughing applications in rather stable conditions. Excellent edge line durability and surface finish. Can be used in both wet and dry conditions.



S40T (HC) - S35 (S25-S45)

A very tough, medium-thick-coated CVD grade for roughing in toughness-demanding applications. Can be used in both wet and dry conditions.



GC1130 (HC) - S15 (S10-S25)

A hard PVD-coated Zertivo™ grade with thin coating, to be used as a complement to S30T for long time in cut. Can be used in both wet and dry conditions.

*Where GC1130 does not exist, please use GC1030.



GC1010 (HC) - S10 (S05-S10)

A very hard and thin-coated PVD grade for finishing in very stable, wet or dry conditions.

Complementary grades



GC1040 (HC) - S30 (S20-S35)

Tough thin-coated PVD grade, to be used as a tougher complement to S30T in slightly more unstable applications in both wet and dry conditions.



GC2030 (HC) - S20 (S15-S25)

Medium-hard, thin-coated PVD grade to be used as a complement to S30T for long time in cut. Can be used in both wet and dry conditions.



GC2040 (HC) - S30 (S25-S40)

Tough, medium thick coated CVD grade for roughing in toughness-demanding applications. Use as a complement to S40T for large diameters or large radial engagements in wet and dry conditions.



H10F (HW) - S25 (S20-S30)

Hard uncoated grade for light roughing to finishing in stable conditions with high demands on sharp edges and surface finish for both wet and dry conditions.



H13A (HW) - S20 (S15-S25)

Hard uncoated grade, for use as backup for H10F in more stable applications. Can be used in both wet and dry conditions.



GC1025 (HC) - S15 (S10-S20)

Hard, thin-coated PVD grade to be used as a complement to S30T for long time in cut and/or machining sticky materials. Can be used in both wet and dry conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HC Hardmetals as above, but coated

Grades for milling

H

Hardened steel

Basic grades



GC1010 (HC) - H10 (H05-H15)

Hard PVD grade with a thin coating for light roughing to finishing of hardened steel with 36 HRC or higher and should be used in stable conditions for both wet and dry machining.



GC4220 (HC) - H25 (H15-H30)

Hard CVD grade with a thick coating for light roughing to finishing at low feeds, moderate speeds and large radial engagements in the lower ISO H hardness range for both wet and dry machining.

Complementary grades



GC1130 (HC) - H10 (H10-H20)

Hard, thin coated PVD grade with Zertivo™ technology for light roughing to finishing at low feeds, moderate speeds and small radial engagements in the lower ISO H hardness range for both wet and dry machining.

*Where GC1130 does not exist, please use GC1030.



CT530 (HT) - H25(H10-H25)

Medium-hard uncoated cermet grade, for light finishing in stable and dry conditions.



CB50 (BN) - H05 (H01-H10)

Hard CBN-tipped grade for semi-finishing to finishing in very stable and dry conditions. Use when dimensional stability and long tool life are crucial.



GC3040 (HC) - H25 (H20-H30)

Medium-hard, thick coated CVD grade that can be used as a backup to GC4220 in unstable and dry conditions.



CC6190 (CN) - H10 (H05-H15)

Hard silicon nitride ceramic grade for light roughing to semi finishing of chilled cast iron at stable and dry conditions.

Letter symbols specifying the designation of hard cutting materials:

Hardmetals:

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

HC Hardmetals as above, but coated

Ceramics:

CN Nitride ceramics containing primarily silicon nitride (Si₃N₄)

Boron nitride:

BN Polycrystalline boron nitride¹⁾

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

Drilling

Exchangeable tip drills

CoroDrill® 870 J4

Indexable drills

CoroDrill® DS20 J26

CoroDrill® 880 J34

Trepanning tool J44

Coromant U insert for drilling J47

Which drilling solution suits your needs?

When drilling small to medium holes, there are different drilling solutions to choose from:

- Exchangeable tip drills
- Indexable insert drills
- Solid carbide drills

When selecting your drill type, there are many aspects to consider. Hole tolerance, drilling depth and diameter are of primary importance. Further, the work piece material, design of the component, batch sizes and machine type needs to be considered.

Generally speaking, symmetrical drills such as solid carbide or exchangeable tip will provide closer hole tolerances and operate at higher feed rates. Indexable insert drills are very cost efficient when hole tolerance is not of primary importance and since being run at lower feeds they impose lower amounts of axial forces into the work piece.

Select your strategy

Drilling is often carried out late in the manufacturing process, after previous operations have already enhanced the initial component's value. The drilling application, although seemingly simple, is a complex operation that can have significant consequences if the tool malfunctions or is run beyond its capacity. For this reason it is important to have a strategy on how to achieve your desired hole.

Drilling deep holes

- The process of drilling deeper holes requires longer tools that are more sensitive to deflection
- Chips have a longer distance to evacuate
- When drilling 6-7xD holes with CoroDrill DS20, a feed reduction at entry and exit is required. Entry feed should be 75% of recommended feed rate, exit feed should be 0.05 mm/rev.

Important factors to consider:






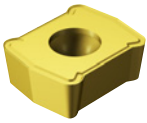






- If drilling holes deeper than 6xD with CoroDrill 870 use a piloting operation
- Ensure that coolant flow is sufficient to evacuate chips
- Adjust your cutting data to obtain satisfactory chips, a stable process and ultimately reaching the demands of your hole

Achieving a stable process

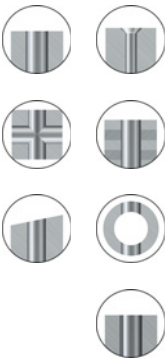
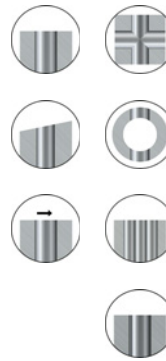
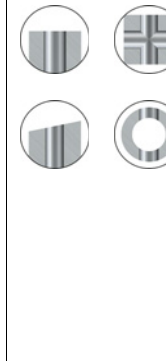
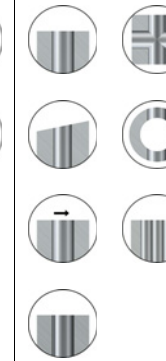

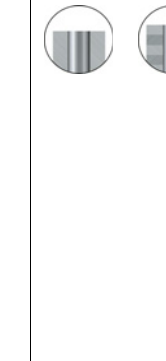
- Achieving a stable process is the ultimate goal when selecting your drilling strategy
- To achieve this multiple factors come into play (coolant, fixturing, machine capacity, etc.)
- Apart from the previously mentioned, a factor that has a large impact is cutting data

Adjust cutting data to optimize your process either to:

- Increase penetration rates (by increasing feed)
- Prolong tool life (by reducing speed)

| | | | | | | |
|----------------------|--|--|--|--|--|--|
| |  |  |  |  |  |  |
| Drill type | Exchangeable tip drill | Indexable insert drill | Indexable insert drill | Large diameter indexable insert drill | Trepanning tool | Coromant U insert for drilling |
| DC mm | 10.00-33.00 | 15.00-40.00 | 12.00-63.50 | 65.00-84.00 | 60.00-110.00 | |
| ISO application area |  |  |  |  |  |  |
| ULDR | 3-10 x DC | 4-7 x DC | 2-3 x DC | 3-4 x DC | 2.5 x DC | |
| TCHA | H9-H10 | IT13-IT14 | H12-H13 | IT13 | IT13 | |
| Coolant | Internal | Internal | Internal | Internal | External | |
| Page | J4 | J26 | J34 | J34 | J44 | J47 |

Application

| | | | | | |
|---|---|---|--|---|---|
|  |  |  |  |  |  |
|---|---|---|--|---|---|

CoroDrill® 870

Secure and predictable holemaking process

ISO application area:



Benefits and features

The interface between tip and drill is simple, accurate, and stable. Optimised drill flutes facilitate chip evacuation. The tip is changed while still in the holder saving you valuable cutting time. New cutting edge geometries and grades provide a safe cutting process with optimised chip control, high penetration rates, and a long, dependable tool life.



Application

- Reliable and secure process
- Easy handling and secure tip changing
- Optimised chip control and evacuation
- Long, predictable tool life and high productivity
- Low cost per hole and excellent hole quality

www.sandvik.coromant.com/corodril870

Drill bodies

- Drilling depths: up to 10 x drill diameter
- Couplings: Cylindrical shank with flat (ISO 9766)
- Hole tolerances: H9-H10

Drill tips

- New grades to provide increased tool life and predictable wear
- Easy handling and secure tip changing
- Tip changing possible while tool is in the machine to reduce downtime

Drill tip geometries

- PM optimized for ISO-P
- MM optimized for ISO-M
- KM optimized for ISO-K
- GP pilot tip for all materials

Gently press the tip down and toward the support surface while tightening the screw to the recommended torque shown on the drill body. Preferably use a torque screw driver to ensure the tip is securely seated. Untighten the screw approximately 1.5 revolutions to release the tip.



Tailor Made step and chamfer drills for producing step or chamfer holes in one operation are available.

Hole tolerance (not applicable for GP geometry)





H9 - H10

| Diameter range, mm | | 10.00-18.00 | 18.01-30.00 | 30.01-33.00 |
|--------------------|--------------------|----------------------|----------------------|----------------------|
| Hole tolerance, mm | 3xDC-8xDC 10xDC | 0/+0.043 0/+0.070 | 0/+0.052 0/+0.084 | 0/+0.062 0/+0.100 |



CoroDrill® 870

Geometry overview

| Geometry | Geometry information |
|----------|---|
| PM |  <p>-PM geometry is considered to be an all-round tip. Although primarily intended for low alloyed and carbon steels, it also shows good functionality and tool life in austenitic stainless steels as well as cast irons.</p> |
| MM |  <p>-MM geometry has the same micro and macro geometry as PM, but has a reinforced chisel edge improving tool life especially for Duplex stainless steels.</p> |
| KM |  <p>-KM shares the same micro geometry as the PM. The difference for KM is its corner chamfer allowing reduced exit breakouts in the work piece material.</p> |
| GP |  <p>-GP is intended for piloting applications. It is based upon the PM geometry but has a larger point angle and different tolerance class.</p> |

Grade overview

GC4334

- New thick PVD coating (AlTiN) with improved edge security provide resistance against built-up edge and chipping.
- A tough high Cr content fine-grain substrate for high reliability and chipping resistance.
- First choice in ISO-P

GC3334

- New multi-layer PVD coating (AlTiCrN) with improved wear resistance.
- A hard and fine-grained substrate, further increasing the wear resistance.
- First choice in ISO-K

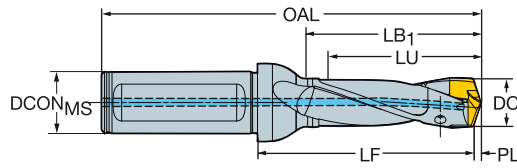
GC2334

- New thin multi-layer PVD coating (AlTiCrN) with improved resistance against flaking and chipping on secondary edge.
- A tough high Cr content fine-grain substrate for high reliability and chipping resistance.
- First choice in ISO-M

CoroDrill® 870 exchangeable tip drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



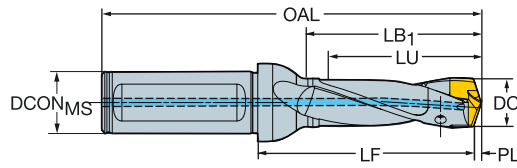
| | | | | | | | | Dimensions, mm | | | | | | | | | | |
|-------|-------|----|-------------------|------|---------------|--------------------|-------|----------------|-----------------|--------|------|----|------------------|------------------|----------------|--|--|--|
| DCN | DCX | LU | CZC _{MS} | TCHA | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | BAR | KG | RPM _X | MID _P | | | | |
| 10.00 | 10.49 | 6 | 33.09 | 16 | H9 | 870-1000-6L16-3 | 16.00 | 46.40 | 96.00 | 35.00 | 1.60 | 10 | 0.141 | 33000 | 870-1040-6-PM | | | |
| 10.00 | 10.49 | 6 | 54.07 | 16 | H9 | 870-1000-6L16-5 | 16.00 | 67.40 | 117.00 | 56.00 | 1.60 | 10 | 0.148 | 15000 | | | | |
| 10.00 | 10.49 | 6 | 85.54 | 16 | H9 | 870-1000-6L16-8 | 16.00 | 99.40 | 149.00 | 88.00 | 1.60 | 15 | 0.157 | 12000 | | | | |
| 10.00 | 10.49 | 6 | 106.52 | 16 | H10 | 870-1000-6L16-10 | 16.00 | 120.40 | 170.00 | 109.00 | 1.60 | 30 | 0.161 | 9000 | | | | |
| 10.50 | 10.99 | 7 | 34.67 | 16 | H9 | 870-1050-7L16-3 | 16.00 | 47.31 | 97.00 | 36.00 | 1.69 | 10 | 0.143 | 33000 | 870-1090-7-PM | | | |
| 10.50 | 10.99 | 7 | 56.65 | 16 | H9 | 870-1050-7L16-5 | 16.00 | 69.31 | 119.00 | 58.00 | 1.69 | 10 | 0.150 | 15000 | | | | |
| 10.50 | 10.99 | 7 | 89.62 | 16 | H9 | 870-1050-7L16-8 | 16.00 | 102.31 | 152.00 | 91.00 | 1.69 | 15 | 0.161 | 12000 | | | | |
| 10.50 | 10.99 | 7 | 111.60 | 16 | H10 | 870-1050-7L16-10 | 16.00 | 124.31 | 174.00 | 113.00 | 1.69 | 30 | 0.168 | 9000 | | | | |
| 11.00 | 11.49 | 8 | 36.23 | 16 | H9 | 870-1100-8L16-3 | 16.00 | 49.25 | 99.00 | 38.00 | 1.75 | 10 | 0.145 | 33000 | 870-1140-8-PM | | | |
| 11.00 | 11.49 | 8 | 59.21 | 16 | H9 | 870-1100-8L16-5 | 16.00 | 72.25 | 122.00 | 61.00 | 1.75 | 10 | 0.154 | 15000 | | | | |
| 11.00 | 11.49 | 8 | 93.68 | 16 | H9 | 870-1100-8L16-8 | 16.00 | 107.25 | 157.00 | 96.00 | 1.75 | 15 | 0.165 | 12000 | | | | |
| 11.00 | 11.49 | 8 | 116.66 | 16 | H10 | 870-1100-8L16-10 | 16.00 | 130.25 | 180.00 | 119.00 | 1.75 | 30 | 0.172 | 9000 | | | | |
| 11.50 | 11.99 | 9 | 37.82 | 16 | H9 | 870-1150-9L16-3 | 16.00 | 51.17 | 101.00 | 40.00 | 1.83 | 10 | 0.146 | 33000 | 870-1190-9-PM | | | |
| 11.50 | 11.99 | 9 | 61.80 | 16 | H9 | 870-1150-9L16-5 | 16.00 | 75.17 | 125.00 | 64.00 | 1.83 | 10 | 0.157 | 15000 | | | | |
| 11.50 | 11.99 | 9 | 97.77 | 16 | H9 | 870-1150-9L16-8 | 16.00 | 111.17 | 161.00 | 100.00 | 1.83 | 15 | 0.170 | 12000 | | | | |
| 11.50 | 11.99 | 9 | 121.75 | 16 | H10 | 870-1150-9L16-10 | 16.00 | 135.17 | 185.00 | 124.00 | 1.83 | 30 | 0.178 | 9000 | | | | |
| 12.00 | 12.49 | 10 | 39.38 | 16 | H9 | 870-1200-10L16-3 | 16.00 | 53.10 | 103.00 | 42.00 | 1.90 | 10 | 0.151 | 33000 | 870-1240-10-PM | | | |
| 12.00 | 12.49 | 10 | 64.36 | 16 | H9 | 870-1200-10L16-5 | 16.00 | 77.10 | 127.00 | 66.00 | 1.90 | 10 | 0.164 | 15000 | | | | |
| 12.00 | 12.49 | 10 | 101.83 | 16 | H9 | 870-1200-10L16-8 | 16.00 | 116.10 | 166.00 | 105.00 | 1.90 | 15 | 0.180 | 12000 | | | | |
| 12.00 | 12.49 | 10 | 126.81 | 16 | H10 | 870-1200-10L16-10 | 16.00 | 141.10 | 191.00 | 130.00 | 1.90 | 30 | 0.187 | 7000 | | | | |
| 12.50 | 12.99 | 11 | 40.97 | 16 | H9 | 870-1250-11L16-3 | 16.00 | 54.02 | 104.00 | 43.00 | 1.98 | 10 | 0.154 | 33000 | 870-1290-11-PM | | | |
| 12.50 | 12.99 | 11 | 66.95 | 16 | H9 | 870-1250-11L16-5 | 16.00 | 80.02 | 130.00 | 69.00 | 1.98 | 10 | 0.167 | 15000 | | | | |
| 12.50 | 12.99 | 11 | 105.92 | 16 | H9 | 870-1250-11L16-8 | 16.00 | 119.02 | 169.00 | 108.00 | 1.98 | 15 | 0.185 | 10000 | | | | |
| 12.50 | 12.99 | 11 | 131.90 | 16 | H10 | 870-1250-11L16-10 | 16.00 | 145.02 | 195.00 | 134.00 | 1.98 | 30 | 0.193 | 7000 | | | | |
| 13.00 | 13.49 | 12 | 42.54 | 16 | H9 | 870-1300-12L16-3 | 16.00 | 55.94 | 106.00 | 45.00 | 2.06 | 10 | 0.157 | 33000 | 870-1340-12-PM | | | |
| 13.00 | 13.49 | 12 | 69.52 | 16 | H9 | 870-1300-12L16-5 | 16.00 | 82.94 | 133.00 | 72.00 | 2.06 | 10 | 0.171 | 15000 | | | | |
| 13.00 | 13.49 | 12 | 109.99 | 16 | H9 | 870-1300-12L16-8 | 16.00 | 123.94 | 174.00 | 113.00 | 2.06 | 15 | 0.187 | 9500 | | | | |
| 13.00 | 13.49 | 12 | 136.97 | 16 | H10 | 870-1300-12L16-10 | 16.00 | 150.94 | 201.00 | 140.00 | 2.06 | 30 | 0.220 | 6500 | | | | |
| 13.50 | 13.99 | 13 | 44.13 | 16 | H9 | 870-1350-13L16-3 | 16.00 | 57.86 | 108.00 | 47.00 | 2.14 | 10 | 0.159 | 33000 | 870-1390-13-PM | | | |
| 13.50 | 13.99 | 13 | 72.11 | 16 | H9 | 870-1350-13L16-5 | 16.00 | 84.86 | 135.00 | 74.00 | 2.14 | 10 | 0.175 | 15000 | | | | |
| 13.50 | 13.99 | 13 | 114.08 | 16 | H9 | 870-1350-13L16-8 | 16.00 | 127.86 | 178.00 | 117.00 | 2.14 | 15 | 0.200 | 9500 | | | | |
| 13.50 | 13.99 | 13 | 142.06 | 16 | H10 | 870-1350-13L16-10 | 16.00 | 155.86 | 206.00 | 145.00 | 2.14 | 30 | 0.228 | 6500 | | | | |
| 14.00 | 14.99 | 14 | 47.27 | 20 | H9 | 870-1400-14L20-3 | 20.00 | 63.72 | 116.00 | 50.00 | 2.28 | 10 | 0.227 | 33000 | 870-1490-14-PM | | | |
| 14.00 | 14.99 | 14 | 77.25 | 20 | H9 | 870-1400-14L20-5 | 20.00 | 93.72 | 146.00 | 80.00 | 2.28 | 10 | 0.246 | 15000 | | | | |
| 14.00 | 14.99 | 14 | 122.22 | 20 | H9 | 870-1400-14L20-8 | 20.00 | 138.72 | 191.00 | 125.00 | 2.28 | 15 | 0.269 | 9500 | | | | |
| 14.00 | 14.99 | 14 | 152.20 | 20 | H10 | 870-1400-14L20-10 | 20.00 | 168.72 | 221.00 | 155.00 | 2.28 | 30 | 0.308 | 6500 | | | | |
| 15.00 | 15.99 | 15 | 50.42 | 20 | H9 | 870-1500-15L20-3 | 20.00 | 66.56 | 119.00 | 53.00 | 2.44 | 10 | 0.233 | 33000 | 870-1590-15-PM | | | |
| 15.00 | 15.99 | 15 | 82.40 | 20 | H9 | 870-1500-15L20-5 | 20.00 | 98.56 | 151.00 | 85.00 | 2.44 | 10 | 0.258 | 15000 | | | | |
| 15.00 | 15.99 | 15 | 130.37 | 20 | H9 | 870-1500-15L20-8 | 20.00 | 146.56 | 199.00 | 133.00 | 2.44 | 15 | 0.310 | 8000 | | | | |
| 15.00 | 15.99 | 15 | 162.35 | 20 | H10 | 870-1500-15L20-10 | 20.00 | 178.56 | 231.00 | 165.00 | 2.44 | 30 | 0.330 | 5000 | | | | |
| 16.00 | 16.99 | 16 | 53.56 | 20 | H9 | 870-1600-16L20-3 | 20.00 | 69.42 | 122.00 | 56.00 | 2.58 | 10 | 0.241 | 33000 | 870-1690-16-PM | | | |
| 16.00 | 16.99 | 16 | 87.54 | 20 | H9 | 870-1600-16L20-5 | 20.00 | 103.42 | 156.00 | 90.00 | 2.58 | 10 | 0.271 | 15000 | | | | |
| 16.00 | 16.99 | 16 | 138.51 | 20 | H9 | 870-1600-16L20-8 | 20.00 | 154.42 | 207.00 | 141.00 | 2.58 | 15 | 0.330 | 8000 | | | | |
| 16.00 | 16.99 | 16 | 172.49 | 20 | H10 | 870-1600-16L20-10 | 20.00 | 188.42 | 241.00 | 175.00 | 2.58 | 30 | 0.352 | 5000 | | | | |
| 17.00 | 17.99 | 17 | 56.71 | 20 | H9 | 870-1700-17L20-3 | 20.00 | 73.27 | 126.00 | 59.00 | 2.73 | 10 | 0.244 | 30000 | 870-1790-17-PM | | | |
| 17.00 | 17.99 | 17 | 92.69 | 20 | H9 | 870-1700-17L20-5 | 20.00 | 109.27 | 162.00 | 95.00 | 2.73 | 10 | 0.280 | 13500 | | | | |
| 17.00 | 17.99 | 17 | 146.66 | 20 | H9 | 870-1700-17L20-8 | 20.00 | 163.27 | 216.00 | 149.00 | 2.73 | 15 | 0.338 | 8000 | | | | |
| 17.00 | 17.99 | 17 | 182.64 | 20 | H10 | 870-1700-17L20-10 | 20.00 | 199.27 | 252.00 | 185.00 | 2.73 | 30 | 0.368 | 5000 | | | | |
| 18.00 | 18.99 | 18 | 59.86 | 20 | H9 | 870-1800-18L20-3 | 20.00 | 76.13 | 129.00 | 62.00 | 2.87 | 10 | 0.259 | 30000 | 870-1890-18-PM | | | |
| 18.00 | 18.99 | 18 | 97.84 | 20 | H9 | 870-1800-18L20-5 | 20.00 | 113.13 | 166.00 | 100.00 | 2.87 | 10 | 0.300 | 13500 | | | | |
| 18.00 | 18.99 | 18 | 154.81 | 20 | H9 | 870-1800-18L20-8 | 20.00 | 171.13 | 224.00 | 157.00 | 2.87 | 15 | 0.369 | 8000 | | | | |
| 18.00 | 18.99 | 18 | 192.79 | 20 | H10 | 870-1800-18L20-10 | 20.00 | 209.13 | 262.00 | 195.00 | 2.87 | 30 | 0.420 | 5000 | | | | |
| 19.00 | 19.99 | 19 | 63.01 | 25 | H9 | 870-1900-19L25-3 | 25.00 | 82.98 | 142.00 | 66.00 | 3.02 | 10 | 0.413 | 30000 | 870-1990-19-PM | | | |
| 19.00 | 19.99 | 19 | 102.99 | 25 | H9 | 870-1900-19L25-5 | 25.00 | 122.98 | 182.00 | 106.00 | 3.02 | 10 | 0.460 | 13500 | | | | |
| 19.00 | 19.99 | 19 | 162.96 | 25 | H9 | 870-1900-19L25-8 | 25.00 | 182.98 | 242.00 | 166.00 | 3.02 | 15 | 0.560 | 7000 | | | | |
| 19.00 | 19.99 | 19 | 202.94 | 25 | H10 | 870-1900-19L25-10 | 25.00 | 222.98 | 282.00 | 206.00 | 3.02 | 30 | 0.595 | 4500 | | | | |
| 20.00 | 20.99 | 20 | 66.16 | 25 | H9 | 870-2000-20L25-3 | 25.00 | 86.83 | 146.00 | 69.00 | 3.17 | 10 | 0.434 | 21500 | 870-2090-20-PM | | | |
| 20.00 | 20.99 | 20 | 108.14 | 25 | H9 | 870-2000-20L25-5 | 25.00 | 128.83 | 188.00 | 111.00 | 3.17 | 10 | 0.492 | 12000 | | | | |
| 20.00 | 20.99 | 20 | 171.11 | 25 | H9 | 870-2000-20L25-8 | 25.00 | 191.83 | 251.00 | 174.00 | 3.17 | 15 | 0.591 | 7000 | | | | |
| 20.00 | 20.99 | 20 | 213.09 | 25 | H10 | 870-2000-20L25-10 | 25.00 | 233.83 | 293.00 | 216.00 | 3.17 | 30 | 0.632 | 4500 | | | | |



CoroDrill® 870 exchangeable tip drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



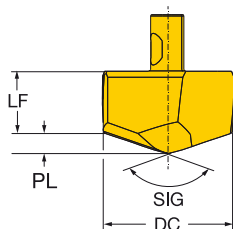
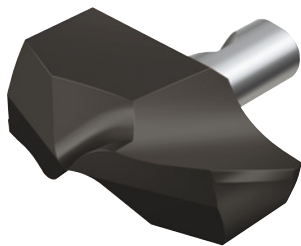
| | | | | | | | Dimensions, mm | | | | | | | | |
|-------|-------|----|-------------------|------|---------------|--------------------|----------------|--------|-----------------|--------|------|----|-------|------------------|----------------|
| DCN | DCX | LU | CZC _{MS} | TCHA | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | BAR | KG | RPMX | MID _p | |
| 21.00 | 21.99 | 21 | 69.30 | 25 | H9 | 870-2100-21L25-3 | 25.00 | 89.68 | 149.00 | 72.00 | 3.32 | 10 | 0.450 | 21500 | 870-2190-21-PM |
| 21.00 | 21.99 | 21 | 113.28 | 25 | H9 | 870-2100-21L25-5 | 25.00 | 133.68 | 193.00 | 116.00 | 3.32 | 10 | 0.508 | 12000 | |
| 21.00 | 21.99 | 21 | 179.25 | 25 | H9 | 870-2100-21L25-8 | 25.00 | 199.68 | 259.00 | 182.00 | 3.32 | 15 | 0.627 | 7000 | |
| 21.00 | 21.99 | 21 | 223.23 | 25 | H10 | 870-2100-21L25-10 | 25.00 | 243.68 | 303.00 | 226.00 | 3.32 | 30 | 0.679 | 4500 | |
| 22.00 | 22.99 | 22 | 72.45 | 25 | H9 | 870-2200-22L25-3 | 25.00 | 93.53 | 153.00 | 76.00 | 3.47 | 10 | 0.470 | 21500 | 870-2290-22-PM |
| 22.00 | 22.99 | 22 | 118.43 | 25 | H9 | 870-2200-22L25-5 | 25.00 | 139.53 | 199.00 | 122.00 | 3.47 | 10 | 0.575 | 12000 | |
| 22.00 | 22.99 | 22 | 187.40 | 25 | H9 | 870-2200-22L25-8 | 25.00 | 208.53 | 268.00 | 191.00 | 3.47 | 15 | 0.675 | 7000 | |
| 22.00 | 22.99 | 22 | 233.38 | 25 | H10 | 870-2200-22L25-10 | 25.00 | 253.53 | 313.00 | 236.00 | 3.47 | 30 | 0.724 | 4500 | |
| 23.00 | 23.99 | 23 | 75.59 | 25 | H9 | 870-2300-23L25-3 | 25.00 | 97.39 | 157.00 | 79.00 | 3.61 | 10 | 0.485 | 21500 | 870-2390-23-PM |
| 23.00 | 23.99 | 23 | 123.57 | 25 | H9 | 870-2300-23L25-5 | 25.00 | 145.39 | 205.00 | 127.00 | 3.61 | 10 | 0.600 | 21500 | |
| 23.00 | 23.99 | 23 | 195.54 | 25 | H9 | 870-2300-23L25-8 | 25.00 | 217.39 | 277.00 | 199.00 | 3.61 | 15 | 0.706 | 6000 | |
| 23.00 | 23.99 | 23 | 243.52 | 25 | H10 | 870-2300-23L25-10 | 25.00 | 265.39 | 325.00 | 247.00 | 3.61 | 30 | 0.776 | 4000 | |
| 24.00 | 24.99 | 24 | 78.75 | 32 | H9 | 870-2400-24L32-3 | 32.00 | 104.23 | 168.00 | 82.00 | 3.77 | 10 | 0.728 | 16000 | 870-2490-24-PM |
| 24.00 | 24.99 | 24 | 128.73 | 32 | H9 | 870-2400-24L32-5 | 32.00 | 155.23 | 219.00 | 132.00 | 3.77 | 10 | 0.898 | 10500 | |
| 24.00 | 24.99 | 24 | 203.70 | 32 | H9 | 870-2400-24L32-8 | 32.00 | 229.23 | 293.00 | 207.00 | 3.77 | 15 | 1.033 | 6000 | |
| 24.00 | 24.99 | 24 | 253.68 | 32 | H10 | 870-2400-24L32-10 | 32.00 | 275.23 | 339.00 | 257.00 | 3.77 | 30 | 1.073 | 4000 | |
| 25.00 | 25.99 | 25 | 81.90 | 32 | H9 | 870-2500-25L32-3 | 32.00 | 107.09 | 171.00 | 85.00 | 3.91 | 10 | 0.818 | 16000 | 870-2590-25-PM |
| 25.00 | 25.99 | 25 | 133.88 | 32 | H9 | 870-2500-25L32-5 | 32.00 | 159.09 | 223.00 | 137.00 | 3.91 | 10 | 0.930 | 10500 | |
| 25.00 | 25.99 | 25 | 211.85 | 32 | H9 | 870-2500-25L32-8 | 32.00 | 237.09 | 301.00 | 215.00 | 3.91 | 15 | 1.085 | 6000 | |
| 25.00 | 25.99 | 25 | 263.83 | 32 | H10 | 870-2500-25L32-10 | 32.00 | 289.09 | 353.00 | 267.00 | 3.91 | 30 | 1.121 | 4000 | |
| 26.00 | 26.99 | 26 | 85.05 | 32 | H9 | 870-2600-26L32-3 | 32.00 | 111.97 | 176.00 | 89.00 | 4.03 | 10 | 0.838 | 16000 | 870-2665-26-PM |
| 26.00 | 26.99 | 26 | 139.03 | 32 | H9 | 870-2600-26L32-5 | 32.00 | 165.97 | 230.00 | 143.00 | 4.03 | 10 | 0.956 | 10500 | |
| 26.00 | 26.99 | 26 | 220.00 | 32 | H9 | 870-2600-26L32-8 | 32.00 | 245.97 | 310.00 | 223.00 | 4.03 | 15 | 1.085 | 6000 | |
| 26.00 | 26.99 | 26 | 273.98 | 32 | H10 | 870-2600-26L32-10 | 32.00 | 299.97 | 364.00 | 277.00 | 4.03 | 10 | 1.269 | 3500 | |
| 27.00 | 27.99 | 27 | 88.21 | 32 | H9 | 870-2700-27L32-3 | 32.00 | 113.86 | 178.00 | 92.00 | 4.14 | 10 | 0.851 | 16000 | 870-2750-27-PM |
| 27.00 | 27.99 | 27 | 144.19 | 32 | H9 | 870-2700-27L32-5 | 32.00 | 170.86 | 235.00 | 148.00 | 4.14 | 10 | 0.997 | 10500 | |
| 27.00 | 27.99 | 27 | 228.16 | 32 | H9 | 870-2700-27L32-8 | 32.00 | 253.86 | 318.00 | 232.00 | 4.14 | 10 | 1.163 | 5000 | |
| 28.00 | 28.99 | 28 | 91.36 | 32 | H9 | 870-2800-28L32-3 | 32.00 | 116.68 | 181.00 | 95.00 | 4.32 | 10 | 0.906 | 16000 | 870-2858-28-PM |
| 28.00 | 28.99 | 28 | 149.34 | 32 | H9 | 870-2800-28L32-5 | 32.00 | 174.68 | 239.00 | 153.00 | 4.32 | 10 | 1.056 | 10500 | |
| 28.00 | 28.99 | 28 | 236.31 | 32 | H9 | 870-2800-28L32-8 | 32.00 | 261.68 | 326.00 | 240.00 | 4.32 | 10 | 1.249 | 5000 | |
| 29.00 | 29.99 | 29 | 94.50 | 32 | H9 | 870-2900-29L32-3 | 32.00 | 119.52 | 184.00 | 98.00 | 4.48 | 10 | 0.922 | 16000 | 870-2965-29-PM |
| 29.00 | 29.99 | 29 | 154.48 | 32 | H9 | 870-2900-29L32-5 | 32.00 | 180.52 | 245.00 | 158.00 | 4.48 | 10 | 1.098 | 10500 | |
| 29.00 | 29.99 | 29 | 244.45 | 32 | H9 | 870-2900-29L32-8 | 32.00 | 269.52 | 334.00 | 248.00 | 4.48 | 10 | 1.314 | 5000 | |
| 30.00 | 30.99 | 30 | 97.65 | 32 | H9 | 870-3000-30L32-3 | 32.00 | 123.40 | 188.00 | 102.00 | 4.60 | 10 | 0.961 | 16000 | 870-3050-30-PM |
| 30.00 | 30.99 | 30 | 159.63 | 32 | H9 | 870-3000-30L32-5 | 32.00 | 186.40 | 251.00 | 164.00 | 4.60 | 10 | 1.150 | 9500 | |
| 30.00 | 30.99 | 30 | 252.60 | 32 | H9 | 870-3000-30L32-8 | 32.00 | 277.40 | 342.00 | 256.00 | 4.60 | 10 | 1.415 | 4000 | |
| 31.00 | 33.00 | 31 | 104.09 | 32 | H9 | 870-3100-31L32-3 | 32.00 | 128.92 | 194.00 | 108.00 | 5.08 | 10 | 1.008 | 16000 | 870-3300-31-PM |
| 31.00 | 33.00 | 31 | 170.09 | 32 | H9 | 870-3100-31L32-5 | 32.00 | 194.92 | 260.00 | 174.00 | 5.08 | 10 | 1.233 | 9500 | |
| 31.00 | 33.00 | 31 | 269.09 | 32 | H9 | 870-3100-31L32-8 | 32.00 | 293.92 | 359.00 | 273.00 | 5.08 | 10 | 1.555 | 4000 | |

| Spare parts | | Spare parts | |
|-------------|--------------|-------------|--------------|
| | Insert screw | | Insert screw |
| 6 | 5513 031-15 | 19 | 5513 031-13 |
| 7 | 5513 031-15 | 20 | 5513 031-14 |
| 8 | 5513 031-15 | 21 | 5513 031-14 |
| 9 | 5513 031-15 | 22 | 5513 031-14 |
| 10 | 5513 031-12 | 23 | 5513 031-14 |
| 11 | 5513 031-12 | 24 | 5513 031-16 |
| 12 | 5513 031-12 | 25 | 5513 031-16 |
| 13 | 5513 031-12 | 26 | 5513 031-16 |
| 14 | 5513 031-12 | 27 | 5513 031-16 |
| 15 | 5513 031-12 | 28 | 5513 031-17 |
| 16 | 5513 031-13 | 29 | 5513 031-17 |
| 17 | 5513 031-13 | 30 | 5513 031-17 |
| 18 | 5513 031-13 | 31 | 5513 031-17 |

For complete list of spare parts, see www.sandvik.coromant.com



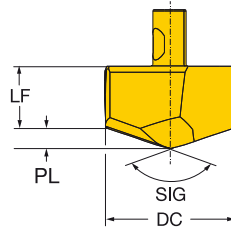
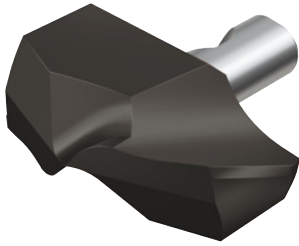
CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | Dimensions, mm | | | |
|-------|-----------------|----------|---|---|---|---|----------------|-----|------|------|
| | | P | M | K | N | S | LF | PL | SIG | TCHA |
| 10.00 | 6 870-1000-6-PM | ★ | | | | | 4.7 | 1.5 | 142° | H9 |
| 10.00 | 870-1000-6-MM | | ★ | | | | 4.7 | 1.5 | 142° | H9 |
| 10.00 | 870-1000-6-KM | ☆ | | ★ | | | 4.4 | 1.8 | 142° | H9 |
| 10.00 | 870-1000-6-GP | ★ | ★ | | ★ | ☆ | 4.6 | 1.1 | 152° | F9 |
| 10.10 | 870-1010-6-PM | ★ | | | | | 4.7 | 1.6 | 142° | H9 |
| 10.10 | 870-1010-6-MM | | ★ | | | | 4.7 | 1.6 | 142° | H9 |
| 10.10 | 870-1010-6-KM | ☆ | | ★ | | | 4.4 | 1.8 | 142° | H9 |
| 10.10 | 870-1010-6-GP | ★ | ★ | ★ | ☆ | ☆ | 4.6 | 1.1 | 152° | F9 |
| 10.20 | 870-1020-6-PM | ★ | | | | | 4.6 | 1.6 | 142° | H9 |
| 10.20 | 870-1020-6-MM | | ★ | | | | 4.6 | 1.6 | 142° | H9 |
| 10.20 | 870-1020-6-KM | ☆ | | ★ | | | 4.3 | 1.9 | 142° | H9 |
| 10.20 | 870-1020-6-GP | ★ | ★ | ★ | ☆ | ☆ | 4.6 | 1.1 | 152° | F9 |
| 10.30 | 870-1030-6-PM | ★ | | | | | 4.6 | 1.6 | 142° | H9 |
| 10.30 | 870-1030-6-MM | | ★ | | | | 4.6 | 1.6 | 142° | H9 |
| 10.30 | 870-1030-6-KM | ☆ | | ★ | | | 4.3 | 1.9 | 142° | H9 |
| 10.30 | 870-1030-6-GP | ★ | ★ | ★ | ☆ | ☆ | 4.6 | 1.1 | 152° | F9 |
| 10.40 | 870-1040-6-PM | ★ | | | | | 4.6 | 1.6 | 142° | H9 |
| 10.40 | 870-1040-6-MM | | ★ | | | | 4.6 | 1.6 | 142° | H9 |
| 10.40 | 870-1040-6-KM | ☆ | | ★ | | | 4.3 | 1.9 | 142° | H9 |
| 10.40 | 870-1040-6-GP | ★ | ★ | ★ | ☆ | ☆ | 4.6 | 1.1 | 152° | F9 |
| 10.50 | 7 870-1050-7-PM | ★ | | | | | 4.6 | 1.6 | 142° | H9 |
| 10.50 | 870-1050-7-MM | | ★ | | | | 4.6 | 1.6 | 142° | H9 |
| 10.50 | 870-1050-7-KM | ☆ | | ★ | | | 4.3 | 1.9 | 142° | H9 |
| 10.50 | 870-1050-7-GP | ★ | ★ | ★ | ☆ | ☆ | 4.6 | 1.2 | 152° | F9 |
| 10.60 | 870-1060-7-PM | ★ | | | | | 4.6 | 1.6 | 142° | H9 |
| 10.60 | 870-1060-7-MM | | ★ | | | | 4.6 | 1.6 | 142° | H9 |
| 10.60 | 870-1060-7-KM | ☆ | | ★ | | | 4.3 | 1.9 | 142° | H9 |
| 10.60 | 870-1060-7-GP | ★ | ★ | ★ | ☆ | ☆ | 4.6 | 1.2 | 152° | F9 |
| 10.70 | 870-1070-7-PM | ★ | | | | | 4.6 | 1.7 | 142° | H9 |
| 10.70 | 870-1070-7-MM | | ★ | | | | 4.6 | 1.7 | 142° | H9 |
| 10.70 | 870-1070-7-KM | ☆ | | ★ | | | 4.3 | 1.9 | 142° | H9 |
| 10.70 | 870-1070-7-GP | ★ | ★ | ★ | ☆ | ☆ | 4.5 | 1.2 | 152° | F9 |
| 10.80 | 870-1080-7-PM | ★ | | | | | 4.5 | 1.7 | 142° | H9 |
| 10.80 | 870-1080-7-MM | | ★ | | | | 4.5 | 1.7 | 142° | H9 |
| 10.80 | 870-1080-7-KM | ☆ | | ★ | | | 4.3 | 2.0 | 142° | H9 |
| 10.80 | 870-1080-7-GP | ★ | ★ | ★ | ☆ | ☆ | 4.5 | 1.2 | 152° | F9 |
| 10.90 | 870-1090-7-PM | ★ | | | | | 4.5 | 1.7 | 142° | H9 |
| 10.90 | 870-1090-7-MM | | ★ | | | | 4.5 | 1.7 | 142° | H9 |
| 10.90 | 870-1090-7-KM | ☆ | | ★ | | | 4.2 | 2.0 | 142° | H9 |
| 10.90 | 870-1090-7-GP | ★ | ★ | ★ | ☆ | ☆ | 4.5 | 1.2 | 152° | F9 |



CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA |
|------|---------------|----------------|---|---|---|---|-----|-----|------|-----|------|
| | | P | M | K | N | S | | | | | |
| 8 | 870-1100-8-PM | ★ | | | | | 5.2 | 1.7 | 142° | H9 | |
| 8 | 870-1100-8-MM | | ★ | | | | 5.2 | 1.7 | 142° | H9 | |
| 8 | 870-1100-8-KM | ☆ | | ★ | | | 4.9 | 2.0 | 142° | H9 | |
| 8 | 870-1100-8-GP | ★ | ★ | | | | 5.2 | 1.2 | 152° | F9 | |
| 11.0 | 870-1110-8-PM | ★ | | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.0 | 870-1110-8-MM | | ★ | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.0 | 870-1110-8-KM | ☆ | | ★ | | | 4.9 | 2.0 | 142° | H9 | |
| 11.0 | 870-1110-8-GP | ★ | ★ | | | | 5.2 | 1.2 | 152° | F9 | |
| 11.1 | 870-1111-8-PM | ★ | | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.1 | 870-1111-8-MM | | ★ | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.1 | 870-1111-8-KM | ☆ | | ★ | | | 4.9 | 2.0 | 142° | H9 | |
| 11.1 | 870-1111-8-GP | ★ | ★ | | | | 5.2 | 1.2 | 152° | F9 | |
| 11.2 | 870-1120-8-PM | ★ | | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.2 | 870-1120-8-MM | | ★ | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.2 | 870-1120-8-KM | ☆ | | ★ | | | 4.9 | 2.0 | 142° | H9 | |
| 11.2 | 870-1120-8-GP | ★ | ★ | | | | 5.2 | 1.2 | 152° | F9 | |
| 11.3 | 870-1130-8-PM | ★ | | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.3 | 870-1130-8-MM | | ★ | | | | 5.2 | 1.7 | 142° | H9 | |
| 11.3 | 870-1130-8-KM | ☆ | | ★ | | | 4.9 | 2.0 | 142° | H9 | |
| 11.3 | 870-1130-8-GP | ★ | ★ | | | | 5.2 | 1.2 | 152° | F9 | |
| 11.4 | 870-1140-8-PM | ★ | | | | | 5.2 | 1.8 | 142° | H9 | |
| 11.4 | 870-1140-8-MM | | ★ | | | | 5.2 | 1.8 | 142° | H9 | |
| 11.4 | 870-1140-8-KM | ☆ | | ★ | | | 4.9 | 2.0 | 142° | H9 | |
| 11.4 | 870-1140-8-GP | ★ | ★ | | | | 5.2 | 1.2 | 152° | F9 | |
| 9 | 870-1150-9-PM | ★ | | | | | 5.1 | 1.8 | 142° | H9 | |
| 9 | 870-1150-9-MM | | ★ | | | | 5.1 | 1.8 | 142° | H9 | |
| 9 | 870-1150-9-KM | ☆ | | ★ | | | 4.8 | 2.1 | 142° | H9 | |
| 9 | 870-1150-9-GP | ★ | ★ | | | | 5.2 | 1.2 | 152° | F9 | |
| 11.6 | 870-1160-9-PM | ★ | | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.6 | 870-1160-9-MM | | ★ | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.6 | 870-1160-9-KM | ☆ | | ★ | | | 4.8 | 2.1 | 142° | H9 | |
| 11.6 | 870-1160-9-GP | ★ | ★ | | | | 5.2 | 1.3 | 152° | F9 | |
| 11.7 | 870-1170-9-PM | ★ | | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.7 | 870-1170-9-MM | | ★ | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.7 | 870-1170-9-KM | ☆ | | ★ | | | 4.8 | 2.2 | 142° | H9 | |
| 11.7 | 870-1170-9-GP | ★ | ★ | | | | 5.1 | 1.3 | 152° | F9 | |
| 11.8 | 870-1180-9-PM | ★ | | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.8 | 870-1180-9-MM | | ★ | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.8 | 870-1180-9-KM | ☆ | | ★ | | | 4.7 | 2.2 | 142° | H9 | |
| 11.8 | 870-1180-9-GP | ★ | ★ | | | | 5.1 | 1.3 | 152° | F9 | |
| 11.9 | 870-1190-9-PM | ★ | | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.9 | 870-1190-9-MM | | ★ | | | | 5.1 | 1.8 | 142° | H9 | |
| 11.9 | 870-1190-9-KM | ☆ | | ★ | | | 4.7 | 2.2 | 142° | H9 | |
| 11.9 | 870-1190-9-GP | ★ | ★ | | | | 5.1 | 1.3 | 152° | F9 | |



J6



J50



J5



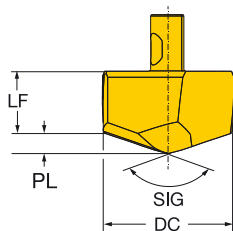
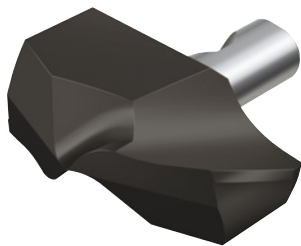
N23



N6



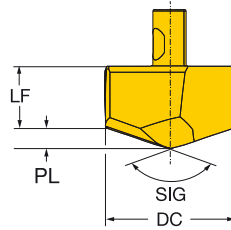
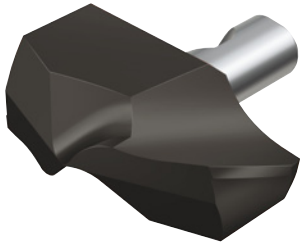
CoroDrill® 870 drill tip



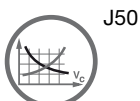
| DC | Ordering code | Material | | | | | Dimensions, mm | | | |
|-------|-------------------|----------|---|---|---|---|----------------|-----|------|------|
| | | P | M | K | N | S | LF | PL | SIG | TCHA |
| 12.00 | 10 870-1200-10-PM | ★ | | | | | 5.7 | 1.8 | 142° | H9 |
| 12.00 | 870-1200-10-MM | | ★ | | | | 5.7 | 1.8 | 142° | H9 |
| 12.00 | 870-1200-10-KM | ☆ | | ★ | | | 5.3 | 2.2 | 142° | H9 |
| 12.00 | 870-1200-10-GP | ★ | ★ | | ★ | ☆ | 5.7 | 1.3 | 152° | F9 |
| 12.10 | 870-1210-10-PM | ★ | | | | | 5.7 | 1.9 | 142° | H9 |
| 12.10 | 870-1210-10-MM | | ★ | | | | 5.7 | 1.9 | 142° | H9 |
| 12.10 | 870-1210-10-KM | ☆ | | ★ | | | 5.3 | 2.2 | 142° | H9 |
| 12.10 | 870-1210-10-GP | ★ | ★ | ★ | ★ | ☆ | 5.7 | 1.3 | 152° | F9 |
| 12.20 | 870-1220-10-PM | ★ | | | | | 5.6 | 1.9 | 142° | H9 |
| 12.20 | 870-1220-10-MM | | ★ | | | | 5.6 | 1.9 | 142° | H9 |
| 12.20 | 870-1220-10-KM | ☆ | | ★ | | | 5.3 | 2.2 | 142° | H9 |
| 12.20 | 870-1220-10-GP | ★ | ★ | ★ | ★ | ☆ | 5.7 | 1.3 | 152° | F9 |
| 12.30 | 870-1230-10-PM | ★ | | | | | 5.6 | 1.9 | 142° | H9 |
| 12.30 | 870-1230-10-MM | | ★ | | | | 5.6 | 1.9 | 142° | H9 |
| 12.30 | 870-1230-10-KM | ☆ | | ★ | | | 5.3 | 2.2 | 142° | H9 |
| 12.30 | 870-1230-10-GP | ★ | ★ | ★ | ★ | ☆ | 5.7 | 1.3 | 152° | F9 |
| 12.40 | 870-1240-10-PM | ★ | | | | | 5.6 | 1.9 | 142° | H9 |
| 12.40 | 870-1240-10-MM | | ★ | | | | 5.6 | 1.9 | 142° | H9 |
| 12.40 | 870-1240-10-KM | ☆ | | ★ | | | 5.3 | 2.3 | 142° | H9 |
| 12.40 | 870-1240-10-GP | ★ | ★ | ★ | ★ | ☆ | 5.7 | 1.3 | 152° | F9 |
| 12.50 | 11 870-1250-11-PM | ★ | | | | | 5.6 | 1.9 | 142° | H9 |
| 12.50 | 870-1250-11-MM | | ★ | | | | 5.6 | 1.9 | 142° | H9 |
| 12.50 | 870-1250-11-KM | ☆ | | ★ | | | 5.2 | 2.3 | 142° | H9 |
| 12.50 | 870-1250-11-GP | ★ | ★ | ★ | ★ | ☆ | 5.7 | 1.3 | 152° | F9 |
| 12.60 | 870-1260-11-PM | ★ | | | | | 5.6 | 1.9 | 142° | H9 |
| 12.60 | 870-1260-11-MM | | ★ | | | | 5.6 | 1.9 | 142° | H9 |
| 12.60 | 870-1260-11-KM | ☆ | | ★ | | | 5.2 | 2.3 | 142° | H9 |
| 12.60 | 870-1260-11-GP | ★ | ★ | ★ | ★ | ☆ | 5.6 | 1.4 | 152° | F9 |
| 12.70 | 870-1270-11-PM | ★ | | | | | 5.6 | 2.0 | 142° | H9 |
| 12.70 | 870-1270-11-MM | | ★ | | | | 5.6 | 2.0 | 142° | H9 |
| 12.70 | 870-1270-11-KM | ☆ | | ★ | | | 5.2 | 2.3 | 142° | H9 |
| 12.70 | 870-1270-11-GP | ★ | ★ | ★ | ★ | ☆ | 5.6 | 1.4 | 152° | F9 |
| 12.80 | 870-1280-11-PM | ★ | | | | | 5.5 | 2.0 | 142° | H9 |
| 12.80 | 870-1280-11-MM | | ★ | | | | 5.5 | 2.0 | 142° | H9 |
| 12.80 | 870-1280-11-KM | ☆ | | ★ | | | 5.2 | 2.3 | 142° | H9 |
| 12.80 | 870-1280-11-GP | ★ | ★ | ★ | ★ | ☆ | 5.6 | 1.4 | 152° | F9 |
| 12.90 | 870-1290-11-PM | ★ | | | | | 5.5 | 2.0 | 142° | H9 |
| 12.90 | 870-1290-11-MM | | ★ | | | | 5.5 | 2.0 | 142° | H9 |
| 12.90 | 870-1290-11-KM | ☆ | | ★ | | | 5.2 | 2.3 | 142° | H9 |
| 12.90 | 870-1290-11-GP | ★ | ★ | ★ | ★ | ☆ | 5.6 | 1.4 | 152° | F9 |



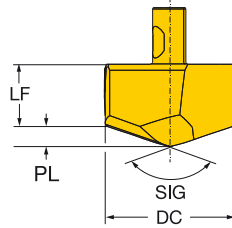
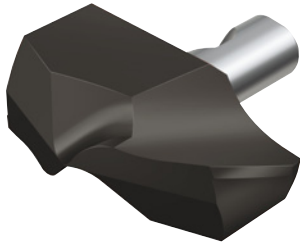
CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | | Dimensions, mm | | | |
|-------|-------------------|----------|------|------|------|------|------|----------------|------|------|--|
| | | P | M | K | N | S | LF | PL | SIG | TCHA | |
| | | 3334 | 4334 | 2334 | 3334 | 4334 | 2334 | 4334 | | | |
| 13.00 | 12 870-1300-12-PM | ★ | ☆ | ☆ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.00 | 870-1300-12-PL | ☆ | ★ | ★ | ☆ | ☆ | 5.4 | 2.6 | 142° | H9 | |
| 13.00 | 870-1300-12-MM | ☆ | ★ | ★ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.00 | 870-1300-12-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.6 | 2.4 | 142° | H9 | |
| 13.00 | 870-1300-12-GP | ★ | ★ | ★ | ☆ | ☆ | 6.1 | 1.4 | 152° | F9 | |
| 13.10 | 870-1310-12-PM | ★ | ☆ | ☆ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.10 | 870-1310-12-MM | ★ | ★ | ★ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.10 | 870-1310-12-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.6 | 2.4 | 142° | H9 | |
| 13.10 | 870-1310-12-GP | ★ | ★ | ★ | ☆ | ☆ | 6.1 | 1.4 | 152° | F9 | |
| 13.20 | 870-1320-12-PM | ★ | ☆ | ☆ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.20 | 870-1320-12-MM | ★ | ★ | ★ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.20 | 870-1320-12-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.6 | 2.5 | 142° | H9 | |
| 13.20 | 870-1320-12-GP | ★ | ★ | ★ | ☆ | ☆ | 6.1 | 1.4 | 152° | F9 | |
| 13.30 | 870-1330-12-PM | ★ | ☆ | ☆ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.30 | 870-1330-12-MM | ★ | ★ | ★ | ☆ | ☆ | 6.0 | 2.0 | 142° | H9 | |
| 13.30 | 870-1330-12-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.5 | 2.5 | 142° | H9 | |
| 13.30 | 870-1330-12-GP | ★ | ★ | ★ | ☆ | ☆ | 6.1 | 1.4 | 152° | F9 | |
| 13.40 | 870-1340-12-PM | ★ | ☆ | ☆ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.40 | 870-1340-12-MM | ★ | ★ | ★ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.40 | 870-1340-12-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.5 | 2.5 | 142° | H9 | |
| 13.40 | 870-1340-12-GP | ★ | ★ | ★ | ☆ | ☆ | 6.1 | 1.4 | 152° | F9 | |
| 13.50 | 13 870-1350-13-PM | ★ | ☆ | ☆ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.50 | 870-1350-13-MM | ★ | ★ | ★ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.50 | 870-1350-13-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.5 | 2.5 | 142° | H9 | |
| 13.50 | 870-1350-13-GP | ★ | ★ | ★ | ☆ | ☆ | 6.1 | 1.5 | 152° | F9 | |
| 13.60 | 870-1360-13-PM | ★ | ☆ | ☆ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.60 | 870-1360-13-MM | ★ | ★ | ★ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.60 | 870-1360-13-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.5 | 2.5 | 142° | H9 | |
| 13.60 | 870-1360-13-GP | ★ | ★ | ★ | ☆ | ☆ | 6.0 | 1.5 | 152° | F9 | |
| 13.70 | 870-1370-13-PM | ★ | ☆ | ☆ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.70 | 870-1370-13-MM | ★ | ★ | ★ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.70 | 870-1370-13-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.5 | 2.5 | 142° | H9 | |
| 13.70 | 870-1370-13-GP | ★ | ★ | ★ | ☆ | ☆ | 6.0 | 1.5 | 152° | F9 | |
| 13.80 | 870-1380-13-PM | ★ | ☆ | ☆ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.80 | 870-1380-13-MM | ★ | ★ | ★ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.80 | 870-1380-13-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.5 | 2.6 | 142° | H9 | |
| 13.80 | 870-1380-13-GP | ★ | ★ | ★ | ☆ | ☆ | 6.0 | 1.5 | 152° | F9 | |
| 13.90 | 870-1390-13-PM | ★ | ☆ | ☆ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.90 | 870-1390-13-MM | ★ | ★ | ★ | ☆ | ☆ | 5.9 | 2.1 | 142° | H9 | |
| 13.90 | 870-1390-13-KM | ☆ | ☆ | ★ | ☆ | ☆ | 5.4 | 2.6 | 142° | H9 | |
| 13.90 | 870-1390-13-GP | ★ | ★ | ★ | ☆ | ☆ | 6.0 | 1.5 | 152° | F9 | |



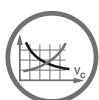
CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA |
|-------|----------------|----------------|---|---|---|---|--|-----|-----|------|------|
| | | P | M | K | N | S | | | | | |
| 14.00 | 870-1400-14-PM | ★ | | | | | | 6.6 | 2.1 | 142° | H9 |
| 14.00 | 870-1400-14-MM | | ★ | | | | | 6.6 | 2.1 | 142° | H9 |
| 14.00 | 870-1400-14-KM | ☆ | | ★ | | | | 6.1 | 2.6 | 142° | H9 |
| 14.00 | 870-1400-14-GP | ★ | ★ | | ★ | ☆ | | 6.7 | 1.5 | 152° | F9 |
| 14.10 | 870-1410-14-PM | ★ | | | | | | 6.6 | 2.2 | 142° | H9 |
| 14.10 | 870-1410-14-MM | | ★ | | | | | 6.6 | 2.2 | 142° | H9 |
| 14.10 | 870-1410-14-KM | ☆ | | ★ | | | | 6.1 | 2.6 | 142° | H9 |
| 14.10 | 870-1410-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.7 | 1.5 | 152° | F9 |
| 14.20 | 870-1420-14-PM | ★ | | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.20 | 870-1420-14-MM | | ★ | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.20 | 870-1420-14-KM | ☆ | | ★ | | | | 6.1 | 2.6 | 142° | H9 |
| 14.20 | 870-1420-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.7 | 1.5 | 152° | F9 |
| 14.29 | 870-1429-14-PM | ★ | | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.29 | 870-1429-14-MM | | ★ | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.29 | 870-1429-14-KM | ☆ | | ★ | | | | 6.1 | 2.6 | 142° | H9 |
| 14.29 | 870-1429-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.7 | 1.5 | 152° | F9 |
| 14.30 | 870-1430-14-PM | ★ | | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.30 | 870-1430-14-MM | | ★ | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.30 | 870-1430-14-KM | ☆ | | ★ | | | | 6.1 | 2.6 | 142° | H9 |
| 14.30 | 870-1430-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.7 | 1.5 | 152° | F9 |
| 14.40 | 870-1440-14-PM | ★ | | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.40 | 870-1440-14-MM | | ★ | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.40 | 870-1440-14-KM | ☆ | | ★ | | | | 6.1 | 2.6 | 142° | H9 |
| 14.40 | 870-1440-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.7 | 1.5 | 152° | F9 |
| 14.50 | 870-1450-14-PM | ★ | | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.50 | 870-1450-14-MM | | ★ | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.50 | 870-1450-14-KM | ☆ | | ★ | | | | 6.1 | 2.6 | 142° | H9 |
| 14.50 | 870-1450-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.7 | 1.6 | 152° | F9 |
| 14.60 | 870-1460-14-PM | ★ | | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.60 | 870-1460-14-MM | | ★ | | | | | 6.5 | 2.2 | 142° | H9 |
| 14.60 | 870-1460-14-KM | ☆ | | ★ | | | | 6.0 | 2.7 | 142° | H9 |
| 14.60 | 870-1460-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.6 | 1.6 | 152° | F9 |
| 14.70 | 870-1470-14-PM | ★ | | | | | | 6.5 | 2.3 | 142° | H9 |
| 14.70 | 870-1470-14-MM | | ★ | | | | | 6.5 | 2.3 | 142° | H9 |
| 14.70 | 870-1470-14-KM | ☆ | | ★ | | | | 6.0 | 2.7 | 142° | H9 |
| 14.70 | 870-1470-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.6 | 1.6 | 152° | F9 |
| 14.80 | 870-1480-14-PM | ★ | | | | | | 6.4 | 2.3 | 142° | H9 |
| 14.80 | 870-1480-14-MM | | ★ | | | | | 6.4 | 2.3 | 142° | H9 |
| 14.80 | 870-1480-14-KM | ☆ | | ★ | | | | 6.0 | 2.7 | 142° | H9 |
| 14.80 | 870-1480-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.6 | 1.6 | 152° | F9 |
| 14.90 | 870-1490-14-PM | ★ | | | | | | 6.4 | 2.3 | 142° | H9 |
| 14.90 | 870-1490-14-MM | | ★ | | | | | 6.4 | 2.3 | 142° | H9 |
| 14.90 | 870-1490-14-KM | ☆ | | ★ | | | | 6.0 | 2.7 | 142° | H9 |
| 14.90 | 870-1490-14-GP | ★ | ★ | ★ | ☆ | ☆ | | 6.6 | 1.6 | 152° | F9 |



J6



J50



J5

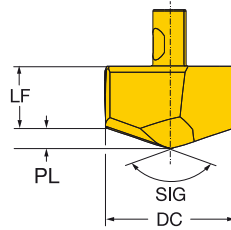
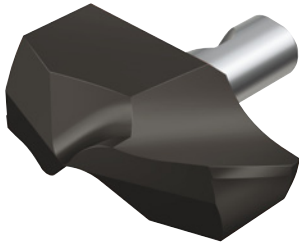


N23



N6

CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | | Dimensions, mm | | | | | |
|-------|----------------|----------|------|------|------|------|------|----------------|------|-----|------|-----|------|
| | | P | | M | | K | | N | S | LF | PL | SIG | TCHA |
| | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | 2334 | 4334 | | | | |
| 15.00 | 870-1500-15-PM | ★ | | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.00 | 870-1500-15-MM | | ★ | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.00 | 870-1500-15-KM | ☆ | | ★ | | | | | 6.5 | 2.8 | 142° | H9 | |
| 15.00 | 870-1500-15-GP | ★ | ★ | | | | | | 7.2 | 1.6 | 152° | F9 | |
| 15.10 | 870-1510-15-PM | ★ | | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.10 | 870-1510-15-MM | | ★ | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.10 | 870-1510-15-KM | ☆ | | ★ | | | | | 6.5 | 2.8 | 142° | H9 | |
| 15.10 | 870-1510-15-GP | ★ | ★ | | | | | | 7.2 | 1.6 | 152° | F9 | |
| 15.20 | 870-1520-15-PM | ★ | | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.20 | 870-1520-15-MM | | ★ | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.20 | 870-1520-15-KM | ☆ | | ★ | | | | | 6.5 | 2.8 | 142° | H9 | |
| 15.20 | 870-1520-15-GP | ★ | ★ | | | | | | 7.2 | 1.6 | 152° | F9 | |
| 15.30 | 870-1530-15-PM | ★ | | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.30 | 870-1530-15-MM | | ★ | | | | | | 7.0 | 2.3 | 142° | H9 | |
| 15.30 | 870-1530-15-KM | ☆ | | ★ | | | | | 6.5 | 2.8 | 142° | H9 | |
| 15.30 | 870-1530-15-GP | ★ | ★ | | | | | | 7.2 | 1.6 | 152° | F9 | |
| 15.40 | 870-1540-15-PM | ★ | | | | | | | 7.0 | 2.4 | 142° | H9 | |
| 15.40 | 870-1540-15-MM | | ★ | | | | | | 7.0 | 2.4 | 142° | H9 | |
| 15.40 | 870-1540-15-KM | ☆ | | ★ | | | | | 6.5 | 2.9 | 142° | H9 | |
| 15.40 | 870-1540-15-GP | ★ | ★ | | | | | | 7.2 | 1.6 | 152° | F9 | |
| 15.50 | 870-1550-15-PM | ★ | | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.50 | 870-1550-15-MM | | ★ | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.50 | 870-1550-15-KM | ☆ | | ★ | | | | | 6.4 | 2.9 | 142° | H9 | |
| 15.50 | 870-1550-15-GP | ★ | ★ | | | | | | 7.2 | 1.7 | 152° | F9 | |
| 15.60 | 870-1560-15-PM | ★ | | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.60 | 870-1560-15-MM | | ★ | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.60 | 870-1560-15-KM | ☆ | | ★ | | | | | 6.4 | 2.9 | 142° | H9 | |
| 15.60 | 870-1560-15-GP | ★ | ★ | | | | | | 7.1 | 1.7 | 152° | F9 | |
| 15.70 | 870-1570-15-PM | ★ | | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.70 | 870-1570-15-MM | | ★ | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.70 | 870-1570-15-KM | ☆ | | ★ | | | | | 6.4 | 2.9 | 142° | H9 | |
| 15.70 | 870-1570-15-GP | ★ | ★ | | | | | | 7.1 | 1.7 | 152° | F9 | |
| 15.80 | 870-1580-15-PM | ★ | | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.80 | 870-1580-15-MM | | ★ | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.80 | 870-1580-15-KM | ☆ | | ★ | | | | | 6.4 | 2.9 | 142° | H9 | |
| 15.80 | 870-1580-15-GP | ★ | ★ | | | | | | 7.1 | 1.7 | 152° | F9 | |
| 15.88 | 870-1588-15-PM | ★ | | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.88 | 870-1588-15-PL | ☆ | | ★ | | | | | 6.0 | 3.3 | 142° | H9 | |
| 15.88 | 870-1588-15-MM | | ★ | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.88 | 870-1588-15-KM | ☆ | | ★ | | | | | 6.4 | 2.9 | 142° | H9 | |
| 15.88 | 870-1588-15-GP | ★ | ★ | | | | | | 7.1 | 1.7 | 152° | F9 | |
| 15.90 | 870-1590-15-PM | ★ | | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.90 | 870-1590-15-MM | | ★ | | | | | | 6.9 | 2.4 | 142° | H9 | |
| 15.90 | 870-1590-15-KM | ☆ | | ★ | | | | | 6.4 | 2.9 | 142° | H9 | |
| 15.90 | 870-1590-15-GP | ★ | ★ | | | | | | 7.1 | 1.7 | 152° | F9 | |



J6



J50



J5



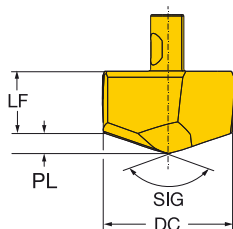
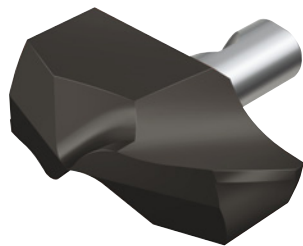
N23



N6



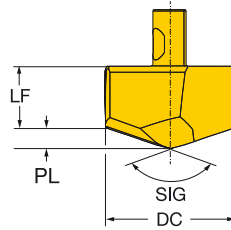
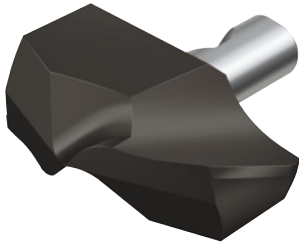
CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | LF | PL | SIG | TCHA |
|-------|----------------|----------------|---|---|---|---|-----|-----|------|------|
| | | P | M | K | N | S | | | | |
| 16.00 | 870-1600-16-PM | ★ | | | | | 7.6 | 2.4 | 142° | H9 |
| 16.00 | 870-1600-16-MM | | ★ | | | | 7.6 | 2.4 | 142° | H9 |
| 16.00 | 870-1600-16-KM | ☆ | | ★ | | | 7.0 | 3.0 | 142° | H9 |
| 16.00 | 870-1600-16-GP | ★ | ★ | | ☆ | | 7.8 | 1.7 | 152° | F9 |
| 16.10 | 870-1610-16-PM | ★ | | | ☆ | | 7.6 | 2.4 | 142° | H9 |
| 16.10 | 870-1610-16-MM | | ★ | | | ☆ | 7.6 | 2.4 | 142° | H9 |
| 16.10 | 870-1610-16-KM | ☆ | | ★ | | | 7.0 | 3.0 | 142° | H9 |
| 16.10 | 870-1610-16-GP | ★ | ★ | ★ | ☆ | | 7.8 | 1.7 | 152° | F9 |
| 16.13 | 870-1613-16-PM | ★ | | | ☆ | | 7.6 | 2.5 | 142° | H9 |
| 16.13 | 870-1613-16-PL | ☆ | ★ | | | | 6.7 | 3.3 | 142° | H9 |
| 16.13 | 870-1613-16-MM | | ★ | | | ☆ | 7.6 | 2.5 | 142° | H9 |
| 16.13 | 870-1613-16-KM | ☆ | | ★ | | | 7.0 | 3.0 | 142° | H9 |
| 16.13 | 870-1613-16-GP | ★ | ★ | ★ | ☆ | | 7.8 | 1.7 | 152° | F9 |
| 16.20 | 870-1620-16-PM | ★ | | | ☆ | | 7.5 | 2.5 | 142° | H9 |
| 16.20 | 870-1620-16-MM | | ★ | | | ☆ | 7.5 | 2.5 | 142° | H9 |
| 16.20 | 870-1620-16-KM | ☆ | | ★ | | | 7.0 | 3.0 | 142° | H9 |
| 16.20 | 870-1620-16-GP | ★ | ★ | ★ | ☆ | | 7.8 | 1.7 | 152° | F9 |
| 16.30 | 870-1630-16-PM | ★ | | | ☆ | | 7.5 | 2.5 | 142° | H9 |
| 16.30 | 870-1630-16-MM | | ★ | | | ☆ | 7.5 | 2.5 | 142° | H9 |
| 16.30 | 870-1630-16-KM | ☆ | | ★ | | | 7.0 | 3.1 | 142° | H9 |
| 16.30 | 870-1630-16-GP | ★ | ★ | ★ | ☆ | | 7.8 | 1.7 | 152° | F9 |
| 16.40 | 870-1640-16-PM | ★ | | | ☆ | | 7.5 | 2.5 | 142° | H9 |
| 16.40 | 870-1640-16-MM | | ★ | | | ☆ | 7.5 | 2.5 | 142° | H9 |
| 16.40 | 870-1640-16-KM | ☆ | | ★ | | | 6.9 | 3.1 | 142° | H9 |
| 16.40 | 870-1640-16-GP | ★ | ★ | ★ | ☆ | | 7.8 | 1.7 | 152° | F9 |
| 16.50 | 870-1650-16-PM | ★ | | | ☆ | | 7.5 | 2.5 | 142° | H9 |
| 16.50 | 870-1650-16-MM | | ★ | | | ☆ | 7.5 | 2.5 | 142° | H9 |
| 16.50 | 870-1650-16-KM | ☆ | | ★ | | | 6.9 | 3.1 | 142° | H9 |
| 16.50 | 870-1650-16-GP | ★ | ★ | ★ | ☆ | | 7.8 | 1.8 | 152° | F9 |
| 16.60 | 870-1660-16-PM | ★ | | | ☆ | | 7.5 | 2.5 | 142° | H9 |
| 16.60 | 870-1660-16-MM | | ★ | | | ☆ | 7.5 | 2.5 | 142° | H9 |
| 16.60 | 870-1660-16-KM | ☆ | | ★ | | | 6.9 | 3.1 | 142° | H9 |
| 16.60 | 870-1660-16-GP | ★ | ★ | ★ | ☆ | | 7.7 | 1.8 | 152° | F9 |
| 16.70 | 870-1670-16-PM | ★ | | | ☆ | | 7.5 | 2.5 | 142° | H9 |
| 16.70 | 870-1670-16-MM | | ★ | | | ☆ | 7.5 | 2.5 | 142° | H9 |
| 16.70 | 870-1670-16-KM | ☆ | | ★ | | | 6.9 | 3.1 | 142° | H9 |
| 16.70 | 870-1670-16-GP | ★ | ★ | ★ | ☆ | | 7.7 | 1.8 | 152° | F9 |
| 16.80 | 870-1680-16-PM | ★ | | | ☆ | | 7.4 | 2.6 | 142° | H9 |
| 16.80 | 870-1680-16-MM | | ★ | | | ☆ | 7.4 | 2.6 | 142° | H9 |
| 16.80 | 870-1680-16-KM | ☆ | | ★ | | | 6.9 | 3.1 | 142° | H9 |
| 16.80 | 870-1680-16-GP | ★ | ★ | ★ | ☆ | | 7.7 | 1.8 | 152° | F9 |
| 16.90 | 870-1690-16-PM | ★ | | | ☆ | | 7.4 | 2.6 | 142° | H9 |
| 16.90 | 870-1690-16-MM | | ★ | | | ☆ | 7.4 | 2.6 | 142° | H9 |
| 16.90 | 870-1690-16-KM | ☆ | | ★ | | | 6.9 | 3.2 | 142° | H9 |
| 16.90 | 870-1690-16-GP | ★ | ★ | ★ | ☆ | | 7.7 | 1.8 | 152° | F9 |



CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA |
|-------|----------------|----------------|------|------|------|------|------|-----|-----|------|------|
| | | P | | M | | K | | | | | |
| | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | | | | |
| 17.00 | 870-1700-17-PM | ★ | | | | | | 8.0 | 2.6 | 142° | H9 |
| 17.00 | 870-1700-17-MM | | ★ | | | | | 8.0 | 2.6 | 142° | H9 |
| 17.00 | 870-1700-17-KM | ☆ | | | ★ | | | 7.4 | 3.2 | 142° | H9 |
| 17.00 | 870-1700-17-GP | | ★ | ★ | | ★ | ☆ | 8.2 | 1.8 | 152° | F9 |
| 17.10 | 870-1710-17-PM | | ★ | | | | ☆ | 8.0 | 2.6 | 142° | H9 |
| 17.10 | 870-1710-17-MM | | ★ | | | | ☆ | 8.0 | 2.6 | 142° | H9 |
| 17.10 | 870-1710-17-KM | ☆ | | | ★ | | | 7.4 | 3.2 | 142° | H9 |
| 17.10 | 870-1710-17-GP | | ★ | ★ | | ★ | ☆ | 8.2 | 1.8 | 152° | F9 |
| 17.20 | 870-1720-17-PM | | ★ | | | | ☆ | 8.0 | 2.6 | 142° | H9 |
| 17.20 | 870-1720-17-MM | | ★ | | | | ☆ | 8.0 | 2.6 | 142° | H9 |
| 17.20 | 870-1720-17-KM | ☆ | | | ★ | | | 7.3 | 3.3 | 142° | H9 |
| 17.20 | 870-1720-17-GP | | ★ | ★ | | ★ | ☆ | 8.2 | 1.8 | 152° | F9 |
| 17.30 | 870-1730-17-PM | | ★ | | | | ☆ | 8.0 | 2.6 | 142° | H9 |
| 17.30 | 870-1730-17-MM | | ★ | | | | ☆ | 8.0 | 2.6 | 142° | H9 |
| 17.30 | 870-1730-17-KM | ☆ | | | ★ | | | 7.3 | 3.3 | 142° | H9 |
| 17.30 | 870-1730-17-GP | | ★ | ★ | | ★ | ☆ | 8.2 | 1.8 | 152° | F9 |
| 17.40 | 870-1740-17-PM | | ★ | | | | ☆ | 8.0 | 2.7 | 142° | H9 |
| 17.40 | 870-1740-17-MM | | ★ | | | | ☆ | 8.0 | 2.7 | 142° | H9 |
| 17.40 | 870-1740-17-KM | ☆ | | | ★ | | | 7.3 | 3.3 | 142° | H9 |
| 17.40 | 870-1740-17-GP | | ★ | ★ | | ★ | ☆ | 8.2 | 1.8 | 152° | F9 |
| 17.46 | 870-1746-17-PM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.46 | 870-1746-17-MM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.46 | 870-1746-17-KM | ☆ | | | ★ | | | 7.3 | 3.3 | 142° | H9 |
| 17.46 | 870-1746-17-GP | | ★ | ★ | | ★ | ☆ | 8.2 | 1.8 | 152° | F9 |
| 17.50 | 870-1750-17-PM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.50 | 870-1750-17-MM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.50 | 870-1750-17-KM | ☆ | | | ★ | | | 7.3 | 3.3 | 142° | H9 |
| 17.50 | 870-1750-17-GP | | ★ | ★ | | ★ | ☆ | 8.2 | 1.9 | 152° | F9 |
| 17.60 | 870-1760-17-PM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.60 | 870-1760-17-MM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.60 | 870-1760-17-KM | ☆ | | | ★ | | | 7.3 | 3.3 | 142° | H9 |
| 17.60 | 870-1760-17-GP | | ★ | ★ | | ★ | ☆ | 8.1 | 1.9 | 152° | F9 |
| 17.70 | 870-1770-17-PM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.70 | 870-1770-17-MM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.70 | 870-1770-17-KM | ☆ | | | ★ | | | 7.3 | 3.3 | 142° | H9 |
| 17.70 | 870-1770-17-GP | | ★ | ★ | | ★ | ☆ | 8.1 | 1.9 | 152° | F9 |
| 17.80 | 870-1780-17-PM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.80 | 870-1780-17-MM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.80 | 870-1780-17-KM | ☆ | | | ★ | | | 7.2 | 3.4 | 142° | H9 |
| 17.80 | 870-1780-17-GP | | ★ | ★ | | ★ | ☆ | 8.1 | 1.9 | 152° | F9 |
| 17.90 | 870-1790-17-PM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.90 | 870-1790-17-MM | | ★ | | | | ☆ | 7.9 | 2.7 | 142° | H9 |
| 17.90 | 870-1790-17-KM | ☆ | | | ★ | | | 7.2 | 3.4 | 142° | H9 |
| 17.90 | 870-1790-17-GP | | ★ | ★ | | ★ | ☆ | 8.1 | 1.9 | 152° | F9 |



J6



J50



J5



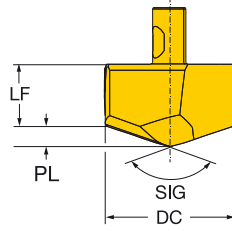
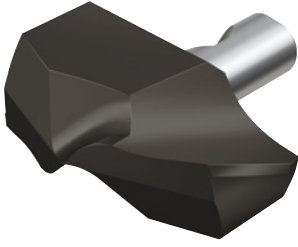
N23



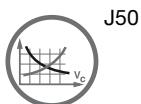
N6



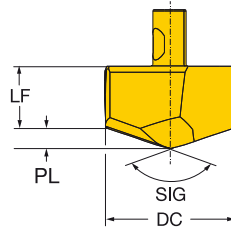
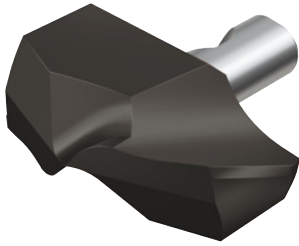
CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA |
|-------|----------------|----------------|---|---|---|---|--|-----|-----|------|------|
| | | P | M | K | N | S | | | | | |
| 18.00 | 870-1800-18-PM | ★ | | | | | | 8.6 | 2.7 | 142° | H9 |
| 18.00 | 870-1800-18-MM | | ★ | | | | | 8.6 | 2.7 | 142° | H9 |
| 18.00 | 870-1800-18-KM | ☆ | | ★ | | | | 7.9 | 3.4 | 142° | H9 |
| 18.00 | 870-1800-18-GP | ★ | ★ | | ★ | ☆ | | 8.8 | 1.9 | 152° | F9 |
| 18.10 | 870-1810-18-PM | ★ | | | | | | 8.6 | 2.7 | 142° | H9 |
| 18.10 | 870-1810-18-MM | | ★ | | | | | 8.6 | 2.7 | 142° | H9 |
| 18.10 | 870-1810-18-KM | ☆ | | ★ | | | | 7.9 | 3.4 | 142° | H9 |
| 18.10 | 870-1810-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.8 | 1.9 | 152° | F9 |
| 18.20 | 870-1820-18-PM | ★ | | | | | | 8.6 | 2.8 | 142° | H9 |
| 18.20 | 870-1820-18-MM | | ★ | | | | | 8.6 | 2.8 | 142° | H9 |
| 18.20 | 870-1820-18-KM | ☆ | | ★ | | | | 7.9 | 3.4 | 142° | H9 |
| 18.20 | 870-1820-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.8 | 1.9 | 152° | F9 |
| 18.30 | 870-1830-18-PM | ★ | | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.30 | 870-1830-18-MM | | ★ | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.30 | 870-1830-18-KM | ☆ | | ★ | | | | 7.9 | 3.4 | 142° | H9 |
| 18.30 | 870-1830-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.8 | 1.9 | 152° | F9 |
| 18.40 | 870-1840-18-PM | ★ | | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.40 | 870-1840-18-MM | | ★ | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.40 | 870-1840-18-KM | ☆ | | ★ | | | | 7.9 | 3.4 | 142° | H9 |
| 18.40 | 870-1840-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.8 | 1.9 | 152° | F9 |
| 18.50 | 870-1850-18-PM | ★ | | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.50 | 870-1850-18-MM | | ★ | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.50 | 870-1850-18-KM | ☆ | | ★ | | | | 7.9 | 3.5 | 142° | H9 |
| 18.50 | 870-1850-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.8 | 1.9 | 152° | F9 |
| 18.60 | 870-1860-18-PM | ★ | | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.60 | 870-1860-18-MM | | ★ | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.60 | 870-1860-18-KM | ☆ | | ★ | | | | 7.8 | 3.5 | 142° | H9 |
| 18.60 | 870-1860-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.8 | 2.0 | 152° | F9 |
| 18.70 | 870-1870-18-PM | ★ | | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.70 | 870-1870-18-MM | | ★ | | | | | 8.5 | 2.8 | 142° | H9 |
| 18.70 | 870-1870-18-KM | ☆ | | ★ | | | | 7.8 | 3.5 | 142° | H9 |
| 18.70 | 870-1870-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.7 | 2.0 | 152° | F9 |
| 18.80 | 870-1880-18-PM | ★ | | | | | | 8.5 | 2.9 | 142° | H9 |
| 18.80 | 870-1880-18-MM | | ★ | | | | | 8.5 | 2.9 | 142° | H9 |
| 18.80 | 870-1880-18-KM | ☆ | | ★ | | | | 7.8 | 3.5 | 142° | H9 |
| 18.80 | 870-1880-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.7 | 2.0 | 152° | F9 |
| 18.90 | 870-1890-18-PM | ★ | | | | | | 8.4 | 2.9 | 142° | H9 |
| 18.90 | 870-1890-18-MM | | ★ | | | | | 8.4 | 2.9 | 142° | H9 |
| 18.90 | 870-1890-18-KM | ☆ | | ★ | | | | 7.8 | 3.5 | 142° | H9 |
| 18.90 | 870-1890-18-GP | ★ | ★ | ★ | ☆ | ☆ | | 8.7 | 2.0 | 152° | F9 |



CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA |
|-------|----------------|----------------|------|------|------|------|------|-----|-----|------|------|
| | | P | | M | | K | | | | | |
| | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | | | | |
| 19.00 | 870-1900-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 9.0 | 2.9 | 142° | H9 |
| 19.00 | 870-1900-19-MM | | ★ | | | ☆ | | 9.0 | 2.9 | 142° | H9 |
| 19.00 | 870-1900-19-KM | ☆ | | ★ | | | | 8.3 | 3.6 | 142° | H9 |
| 19.00 | 870-1900-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.0 | 152° | F9 |
| 19.05 | 870-1905-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 9.0 | 2.9 | 142° | H9 |
| 19.05 | 870-1905-19-PL | ☆ | ★ | | | | | 8.0 | 3.8 | 142° | H9 |
| 19.05 | 870-1905-19-MM | | ★ | | | ☆ | | 9.0 | 2.9 | 142° | H9 |
| 19.05 | 870-1905-19-KM | ☆ | | ★ | | | | 8.3 | 3.6 | 142° | H9 |
| 19.05 | 870-1905-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.0 | 152° | F9 |
| 19.10 | 870-1910-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 9.0 | 2.9 | 142° | H9 |
| 19.10 | 870-1910-19-MM | | ★ | | | ☆ | | 9.0 | 2.9 | 142° | H9 |
| 19.10 | 870-1910-19-KM | ☆ | | ★ | | | | 8.3 | 3.6 | 142° | H9 |
| 19.10 | 870-1910-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.0 | 152° | F9 |
| 19.20 | 870-1920-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 9.0 | 2.9 | 142° | H9 |
| 19.20 | 870-1920-19-PL | ☆ | ★ | | | | | 8.0 | 3.9 | 142° | H9 |
| 19.20 | 870-1920-19-MM | | ★ | | | ☆ | | 9.0 | 2.9 | 142° | H9 |
| 19.20 | 870-1920-19-KM | ☆ | | ★ | | | | 8.3 | 3.6 | 142° | H9 |
| 19.20 | 870-1920-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.0 | 152° | F9 |
| 19.25 | 870-1925-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 9.0 | 2.9 | 142° | H9 |
| 19.25 | 870-1925-19-PL | ☆ | ★ | | | | | 8.0 | 3.9 | 142° | H9 |
| 19.25 | 870-1925-19-MM | | ★ | | | ☆ | | 9.0 | 2.9 | 142° | H9 |
| 19.25 | 870-1925-19-KM | ☆ | | ★ | | | | 8.3 | 3.6 | 142° | H9 |
| 19.25 | 870-1925-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.0 | 152° | F9 |
| 19.30 | 870-1930-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 9.0 | 2.9 | 142° | H9 |
| 19.30 | 870-1930-19-PL | ☆ | ★ | | | | | 8.0 | 4.0 | 142° | H9 |
| 19.30 | 870-1930-19-MM | | ★ | | | ☆ | | 9.0 | 2.9 | 142° | H9 |
| 19.30 | 870-1930-19-KM | ☆ | | ★ | | | | 8.3 | 3.6 | 142° | H9 |
| 19.30 | 870-1930-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.0 | 152° | F9 |
| 19.40 | 870-1940-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 9.0 | 2.9 | 142° | H9 |
| 19.40 | 870-1940-19-MM | | ★ | | | ☆ | | 9.0 | 2.9 | 142° | H9 |
| 19.40 | 870-1940-19-KM | ☆ | | ★ | | | | 8.2 | 3.7 | 142° | H9 |
| 19.40 | 870-1940-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.0 | 152° | F9 |
| 19.50 | 870-1950-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 8.9 | 3.0 | 142° | H9 |
| 19.50 | 870-1950-19-MM | | ★ | | | ☆ | | 8.9 | 3.0 | 142° | H9 |
| 19.50 | 870-1950-19-KM | ☆ | | ★ | | | | 8.2 | 3.7 | 142° | H9 |
| 19.50 | 870-1950-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.2 | 2.1 | 152° | F9 |
| 19.60 | 870-1960-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 8.9 | 3.0 | 142° | H9 |
| 19.60 | 870-1960-19-MM | | ★ | | | ☆ | | 8.9 | 3.0 | 142° | H9 |
| 19.60 | 870-1960-19-KM | ☆ | | ★ | | | | 8.2 | 3.7 | 142° | H9 |
| 19.60 | 870-1960-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.1 | 2.1 | 152° | F9 |
| 19.70 | 870-1970-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 8.9 | 3.0 | 142° | H9 |
| 19.70 | 870-1970-19-MM | | ★ | | | ☆ | | 8.9 | 3.0 | 142° | H9 |
| 19.70 | 870-1970-19-KM | ☆ | | ★ | | | | 8.2 | 3.7 | 142° | H9 |
| 19.70 | 870-1970-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.1 | 2.1 | 152° | F9 |
| 19.80 | 870-1980-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 8.9 | 3.0 | 142° | H9 |
| 19.80 | 870-1980-19-MM | | ★ | | | ☆ | | 8.9 | 3.0 | 142° | H9 |
| 19.80 | 870-1980-19-KM | ☆ | | ★ | | | | 8.2 | 3.7 | 142° | H9 |
| 19.80 | 870-1980-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.1 | 2.1 | 152° | F9 |
| 19.90 | 870-1990-19-PM | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 8.9 | 3.0 | 142° | H9 |
| 19.90 | 870-1990-19-MM | | ★ | | | ☆ | | 8.9 | 3.0 | 142° | H9 |
| 19.90 | 870-1990-19-KM | ☆ | | ★ | | | | 8.2 | 3.7 | 142° | H9 |
| 19.90 | 870-1990-19-GP | ★ | ★ | ★ | ☆ | ☆ | ☆ | 9.1 | 2.1 | 152° | F9 |



J6



J50



J5



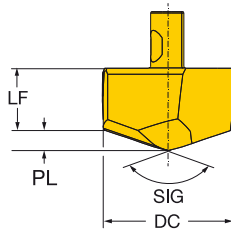
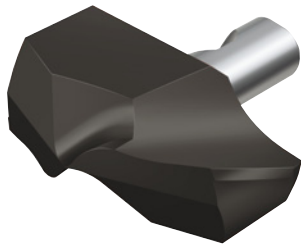
N23



N6



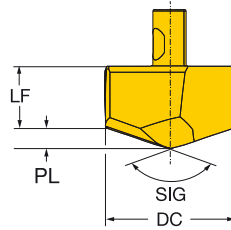
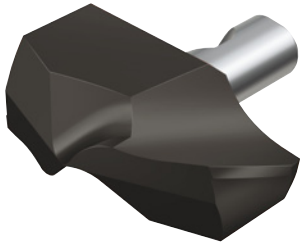
CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | Dimensions, mm | | | |
|-------|----------------|----------|---|---|---|---|----------------|-----|------|------|
| | | P | M | K | N | S | LF | PL | SIG | TCHA |
| 20.00 | 870-2000-20-PM | ★ | | | | | 9.5 | 3.0 | 142° | H9 |
| 20.00 | 870-2000-20-MM | | ★ | | | | 9.5 | 3.0 | 142° | H9 |
| 20.00 | 870-2000-20-KM | ☆ | | ★ | | | 8.7 | 3.8 | 142° | H9 |
| 20.00 | 870-2000-20-GP | ★ | ★ | | ★ | ☆ | 9.7 | 2.1 | 152° | F9 |
| 20.10 | 870-2010-20-PM | ★ | | | ☆ | ☆ | 9.5 | 3.0 | 142° | H9 |
| 20.10 | 870-2010-20-MM | | ★ | | | ☆ | 9.5 | 3.0 | 142° | H9 |
| 20.10 | 870-2010-20-KM | ☆ | | ★ | | | 8.7 | 3.8 | 142° | H9 |
| 20.10 | 870-2010-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.7 | 2.1 | 152° | F9 |
| 20.20 | 870-2020-20-PM | ★ | | | ☆ | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.20 | 870-2020-20-MM | | ★ | | | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.20 | 870-2020-20-KM | ☆ | | ★ | | | 8.7 | 3.9 | 142° | H9 |
| 20.20 | 870-2020-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.7 | 2.1 | 152° | F9 |
| 20.30 | 870-2030-20-PM | ★ | | | ☆ | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.30 | 870-2030-20-MM | | ★ | | | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.30 | 870-2030-20-KM | ☆ | | ★ | | | 8.6 | 3.9 | 142° | H9 |
| 20.30 | 870-2030-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.7 | 2.1 | 152° | F9 |
| 20.40 | 870-2040-20-PM | ★ | | | ☆ | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.40 | 870-2040-20-MM | | ★ | | | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.40 | 870-2040-20-KM | ☆ | | ★ | | | 8.6 | 3.9 | 142° | H9 |
| 20.40 | 870-2040-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.7 | 2.1 | 152° | F9 |
| 20.50 | 870-2050-20-PM | ★ | | | ☆ | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.50 | 870-2050-20-MM | | ★ | | | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.50 | 870-2050-20-KM | ☆ | | ★ | | | 8.6 | 3.9 | 142° | H9 |
| 20.50 | 870-2050-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.7 | 2.2 | 152° | F9 |
| 20.60 | 870-2060-20-PM | ★ | | | ☆ | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.60 | 870-2060-20-MM | | ★ | | | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.60 | 870-2060-20-KM | ☆ | | ★ | | | 8.6 | 3.9 | 142° | H9 |
| 20.60 | 870-2060-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.7 | 2.2 | 152° | F9 |
| 20.64 | 870-2064-20-PM | ★ | | | ☆ | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.64 | 870-2064-20-MM | | ★ | | | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.64 | 870-2064-20-KM | ☆ | | ★ | | | 8.6 | 3.9 | 142° | H9 |
| 20.64 | 870-2064-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.6 | 2.2 | 152° | F9 |
| 20.70 | 870-2070-20-PM | ★ | | | ☆ | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.70 | 870-2070-20-MM | | ★ | | | ☆ | 9.4 | 3.1 | 142° | H9 |
| 20.70 | 870-2070-20-KM | ☆ | | ★ | | | 8.6 | 3.9 | 142° | H9 |
| 20.70 | 870-2070-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.6 | 2.2 | 152° | F9 |
| 20.80 | 870-2080-20-PM | ★ | | | ☆ | ☆ | 9.3 | 3.2 | 142° | H9 |
| 20.80 | 870-2080-20-MM | | ★ | | | ☆ | 9.3 | 3.2 | 142° | H9 |
| 20.80 | 870-2080-20-KM | ☆ | | ★ | | | 8.6 | 4.0 | 142° | H9 |
| 20.80 | 870-2080-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.6 | 2.2 | 152° | F9 |
| 20.90 | 870-2090-20-PM | ★ | | | ☆ | ☆ | 9.3 | 3.2 | 142° | H9 |
| 20.90 | 870-2090-20-MM | | ★ | | | ☆ | 9.3 | 3.2 | 142° | H9 |
| 20.90 | 870-2090-20-KM | ☆ | | ★ | | | 8.5 | 4.0 | 142° | H9 |
| 20.90 | 870-2090-20-GP | ★ | ★ | ★ | ☆ | ☆ | 9.6 | 2.2 | 152° | F9 |



CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | Dimensions, mm | | | |
|-------|----------------|----------|---|---|---|---|----------------|-----|------|------|
| | | P | M | K | N | S | LF | PL | SIG | TCHA |
| 21.00 | 870-2100-21-PM | ★ | | | | | 10.0 | 3.2 | 142° | H9 |
| 21.00 | 870-2100-21-MM | | ★ | | | | 10.0 | 3.2 | 142° | H9 |
| 21.00 | 870-2100-21-KM | ☆ | | ★ | | | 9.2 | 4.0 | 142° | H9 |
| 21.00 | 870-2100-21-GP | ★ | ★ | | | | 10.3 | 2.2 | 152° | F9 |
| 21.10 | 870-2110-21-PM | ★ | | | | | 10.0 | 3.2 | 142° | H9 |
| 21.10 | 870-2110-21-MM | | ★ | | | | 10.0 | 3.2 | 142° | H9 |
| 21.10 | 870-2110-21-KM | ☆ | | ★ | | | 9.2 | 4.0 | 142° | H9 |
| 21.10 | 870-2110-21-GP | ★ | ★ | ★ | | | 10.3 | 2.2 | 152° | F9 |
| 21.20 | 870-2120-21-PM | ★ | | | | | 10.0 | 3.2 | 142° | H9 |
| 21.20 | 870-2120-21-MM | | ★ | | | | 10.0 | 3.2 | 142° | H9 |
| 21.20 | 870-2120-21-KM | ☆ | | ★ | | | 9.2 | 4.0 | 142° | H9 |
| 21.20 | 870-2120-21-GP | ★ | ★ | ★ | | | 10.3 | 2.2 | 152° | F9 |
| 21.30 | 870-2130-21-PM | ★ | | | | | 10.0 | 3.2 | 142° | H9 |
| 21.30 | 870-2130-21-MM | | ★ | | | | 10.0 | 3.2 | 142° | H9 |
| 21.30 | 870-2130-21-KM | ☆ | | ★ | | | 9.2 | 4.0 | 142° | H9 |
| 21.30 | 870-2130-21-GP | ★ | ★ | ★ | | | 10.3 | 2.2 | 152° | F9 |
| 21.40 | 870-2140-21-PM | ★ | | | | | 10.0 | 3.2 | 142° | H9 |
| 21.40 | 870-2140-21-MM | | ★ | | | | 10.0 | 3.2 | 142° | H9 |
| 21.40 | 870-2140-21-KM | ☆ | | ★ | | | 9.2 | 4.0 | 142° | H9 |
| 21.40 | 870-2140-21-GP | ★ | ★ | ★ | | | 10.3 | 2.2 | 152° | F9 |
| 21.50 | 870-2150-21-PM | ★ | | | | | 10.0 | 3.3 | 142° | H9 |
| 21.50 | 870-2150-21-MM | | ★ | | | | 10.0 | 3.3 | 142° | H9 |
| 21.50 | 870-2150-21-KM | ☆ | | ★ | | | 9.2 | 4.0 | 142° | H9 |
| 21.50 | 870-2150-21-GP | ★ | ★ | ★ | | | 10.3 | 2.2 | 152° | F9 |
| 21.60 | 870-2160-21-PM | ★ | | | | | 9.9 | 3.3 | 142° | H9 |
| 21.60 | 870-2160-21-MM | | ★ | | | | 9.9 | 3.3 | 142° | H9 |
| 21.60 | 870-2160-21-KM | ☆ | | ★ | | | 9.1 | 4.1 | 142° | H9 |
| 21.60 | 870-2160-21-GP | ★ | ★ | ★ | | | 10.3 | 2.3 | 152° | F9 |
| 21.70 | 870-2170-21-PM | ★ | | | | | 9.9 | 3.3 | 142° | H9 |
| 21.70 | 870-2170-21-MM | | ★ | | | | 9.9 | 3.3 | 142° | H9 |
| 21.70 | 870-2170-21-KM | ☆ | | ★ | | | 9.1 | 4.1 | 142° | H9 |
| 21.70 | 870-2170-21-GP | ★ | ★ | ★ | | | 10.2 | 2.3 | 152° | F9 |
| 21.80 | 870-2180-21-PM | ★ | | | | | 9.9 | 3.3 | 142° | H9 |
| 21.80 | 870-2180-21-MM | | ★ | | | | 9.9 | 3.3 | 142° | H9 |
| 21.80 | 870-2180-21-KM | ☆ | | ★ | | | 9.1 | 4.1 | 142° | H9 |
| 21.80 | 870-2180-21-GP | ★ | ★ | ★ | | | 10.2 | 2.3 | 152° | F9 |
| 21.90 | 870-2190-21-PM | ★ | | | | | 9.9 | 3.3 | 142° | H9 |
| 21.90 | 870-2190-21-MM | | ★ | | | | 9.9 | 3.3 | 142° | H9 |
| 21.90 | 870-2190-21-KM | ☆ | | ★ | | | 9.1 | 4.1 | 142° | H9 |
| 21.90 | 870-2190-21-GP | ★ | ★ | ★ | | | 10.2 | 2.3 | 152° | F9 |



J6



J50



J5



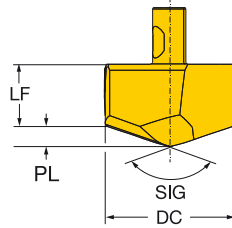
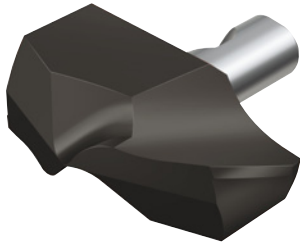
N23



N6



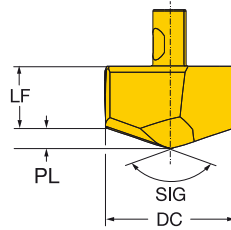
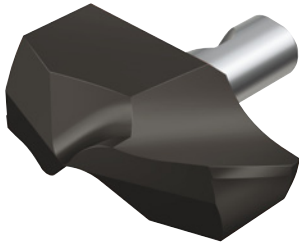
CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | Dimensions, mm | | | |
|-------|----------------|----------|---|---|---|---|----------------|-----|------|------|
| | | P | M | K | N | S | LF | PL | SIG | TCHA |
| 22.00 | 870-2200-22-PM | ★ | | | | | 10.5 | 3.3 | 142° | H9 |
| 22.00 | 870-2200-22-MM | | ★ | | | | 10.5 | 3.3 | 142° | H9 |
| 22.00 | 870-2200-22-KM | ☆ | | ★ | | | 9.6 | 4.2 | 142° | H9 |
| 22.00 | 870-2200-22-GP | ★ | ★ | | ★ | | 10.8 | 2.3 | 152° | F9 |
| 22.10 | 870-2210-22-PM | ★ | | | ★ | | 10.5 | 3.3 | 142° | H9 |
| 22.10 | 870-2210-22-MM | | ★ | | | ★ | 10.5 | 3.3 | 142° | H9 |
| 22.10 | 870-2210-22-KM | ☆ | | ★ | | | 9.6 | 4.2 | 142° | H9 |
| 22.10 | 870-2210-22-GP | ★ | ★ | ★ | ★ | | 10.8 | 2.3 | 152° | F9 |
| 22.20 | 870-2220-22-PM | ★ | | | ★ | | 10.5 | 3.4 | 142° | H9 |
| 22.20 | 870-2220-22-PL | ☆ | ★ | | | | 9.3 | 4.5 | 142° | H9 |
| 22.20 | 870-2220-22-MM | | ★ | | | ★ | 10.5 | 3.4 | 142° | H9 |
| 22.20 | 870-2220-22-KM | ☆ | | ★ | | | 9.6 | 4.2 | 142° | H9 |
| 22.20 | 870-2220-22-GP | ★ | ★ | ★ | ★ | | 10.8 | 2.3 | 152° | F9 |
| 22.23 | 870-2223-22-PM | ★ | | | ★ | | 10.5 | 3.4 | 142° | H9 |
| 22.23 | 870-2223-22-MM | | ★ | | | ★ | 10.5 | 3.4 | 142° | H9 |
| 22.23 | 870-2223-22-KM | ☆ | | ★ | | | 9.6 | 4.2 | 142° | H9 |
| 22.23 | 870-2223-22-GP | ★ | ★ | ★ | ★ | | 10.8 | 2.3 | 152° | F9 |
| 22.30 | 870-2230-22-PM | ★ | | | ★ | | 10.4 | 3.4 | 142° | H9 |
| 22.30 | 870-2230-22-MM | | ★ | | | ★ | 10.4 | 3.4 | 142° | H9 |
| 22.30 | 870-2230-22-KM | ☆ | | ★ | | | 9.6 | 4.2 | 142° | H9 |
| 22.30 | 870-2230-22-GP | ★ | ★ | ★ | ★ | | 10.8 | 2.3 | 152° | F9 |
| 22.40 | 870-2240-22-PM | ★ | | | ★ | | 10.4 | 3.4 | 142° | H9 |
| 22.40 | 870-2240-22-MM | | ★ | | | ★ | 10.4 | 3.4 | 142° | H9 |
| 22.40 | 870-2240-22-KM | ☆ | | ★ | | | 9.6 | 4.2 | 142° | H9 |
| 22.40 | 870-2240-22-GP | ★ | ★ | ★ | ★ | | 10.8 | 2.3 | 152° | F9 |
| 22.50 | 870-2250-22-PM | ★ | | | ★ | | 10.4 | 3.4 | 142° | H9 |
| 22.50 | 870-2250-22-MM | | ★ | | | ★ | 10.4 | 3.4 | 142° | H9 |
| 22.50 | 870-2250-22-KM | ☆ | | ★ | | | 9.5 | 4.3 | 142° | H9 |
| 22.50 | 870-2250-22-GP | ★ | ★ | ★ | ★ | | 10.8 | 2.4 | 152° | F9 |
| 22.60 | 870-2260-22-PM | ★ | | | ★ | | 10.4 | 3.4 | 142° | H9 |
| 22.60 | 870-2260-22-MM | | ★ | | | ★ | 10.4 | 3.4 | 142° | H9 |
| 22.60 | 870-2260-22-KM | ☆ | | ★ | | | 9.5 | 4.3 | 142° | H9 |
| 22.60 | 870-2260-22-GP | ★ | ★ | ★ | ★ | | 10.7 | 2.4 | 152° | F9 |
| 22.70 | 870-2270-22-PM | ★ | | | ★ | | 10.4 | 3.4 | 142° | H9 |
| 22.70 | 870-2270-22-MM | | ★ | | | ★ | 10.4 | 3.4 | 142° | H9 |
| 22.70 | 870-2270-22-KM | ☆ | | ★ | | | 9.5 | 4.3 | 142° | H9 |
| 22.70 | 870-2270-22-GP | ★ | ★ | ★ | ★ | | 10.7 | 2.4 | 152° | F9 |
| 22.80 | 870-2280-22-PM | ★ | | | ★ | | 10.4 | 3.5 | 142° | H9 |
| 22.80 | 870-2280-22-MM | | ★ | | | ★ | 10.4 | 3.5 | 142° | H9 |
| 22.80 | 870-2280-22-KM | ☆ | | ★ | | | 9.5 | 4.3 | 142° | H9 |
| 22.80 | 870-2280-22-GP | ★ | ★ | ★ | ★ | | 10.7 | 2.4 | 152° | F9 |
| 22.90 | 870-2290-22-PM | ★ | | | ★ | | 10.3 | 3.5 | 142° | H9 |
| 22.90 | 870-2290-22-MM | | ★ | | | ★ | 10.3 | 3.5 | 142° | H9 |
| 22.90 | 870-2290-22-KM | ☆ | | ★ | | | 9.5 | 4.3 | 142° | H9 |
| 22.90 | 870-2290-22-GP | ★ | ★ | ★ | ★ | | 10.7 | 2.4 | 152° | F9 |



CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA |
|-------|-------------------|----------------|------|------|------|------|------|------|-----|------|------|
| | | P | | M | | K | | | | | |
| | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | | | | |
| 23.00 | 23 870-2300-23-PM | ★ | | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.00 | 870-2300-23-MM | | ★ | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.00 | 870-2300-23-KM | ☆ | | ★ | | | | 10.1 | 4.4 | 142° | H9 |
| 23.00 | 870-2300-23-GP | ★ | | ★ | | | | 11.4 | 2.4 | 152° | F9 |
| 23.10 | 870-2310-23-PM | ★ | | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.10 | 870-2310-23-MM | | ★ | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.10 | 870-2310-23-KM | ☆ | | ★ | | | | 10.1 | 4.4 | 142° | H9 |
| 23.10 | 870-2310-23-GP | ★ | | ★ | | | | 11.4 | 2.4 | 152° | F9 |
| 23.20 | 870-2320-23-PM | ★ | | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.20 | 870-2320-23-MM | | ★ | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.20 | 870-2320-23-KM | ☆ | | ★ | | | | 10.1 | 4.4 | 142° | H9 |
| 23.20 | 870-2320-23-GP | ★ | | ★ | | | | 11.4 | 2.4 | 152° | F9 |
| 23.30 | 870-2330-23-PM | ★ | | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.30 | 870-2330-23-MM | | ★ | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.30 | 870-2330-23-KM | ☆ | | ★ | | | | 10.1 | 4.5 | 142° | H9 |
| 23.30 | 870-2330-23-GP | ★ | | ★ | | | | 11.4 | 2.4 | 152° | F9 |
| 23.40 | 870-2340-23-PM | ★ | | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.40 | 870-2340-23-MM | | ★ | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.40 | 870-2340-23-KM | ☆ | | ★ | | | | 10.0 | 4.5 | 142° | H9 |
| 23.40 | 870-2340-23-GP | ★ | | ★ | | | | 11.4 | 2.4 | 152° | F9 |
| 23.50 | 870-2350-23-PM | ★ | | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.50 | 870-2350-23-MM | | ★ | | | | | 11.0 | 3.5 | 142° | H9 |
| 23.50 | 870-2350-23-KM | ☆ | | ★ | | | | 10.0 | 4.5 | 142° | H9 |
| 23.50 | 870-2350-23-GP | ★ | | ★ | | | | 11.4 | 2.4 | 152° | F9 |
| 23.60 | 870-2360-23-PM | ★ | | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.60 | 870-2360-23-MM | | ★ | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.60 | 870-2360-23-KM | ☆ | | ★ | | | | 10.0 | 4.5 | 142° | H9 |
| 23.60 | 870-2360-23-GP | ★ | | ★ | | | | 11.4 | 2.4 | 152° | F9 |
| 23.70 | 870-2370-23-PM | ★ | | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.70 | 870-2370-23-MM | | ★ | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.70 | 870-2370-23-KM | ☆ | | ★ | | | | 10.0 | 4.5 | 142° | H9 |
| 23.70 | 870-2370-23-GP | ★ | | ★ | | | | 11.4 | 2.5 | 152° | F9 |
| 23.80 | 870-2380-23-PM | ★ | | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.80 | 870-2380-23-PL | ☆ | | ★ | | | | 9.7 | 4.8 | 142° | H9 |
| 23.80 | 870-2380-23-MM | | ★ | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.80 | 870-2380-23-KM | ☆ | | ★ | | | | 10.0 | 4.5 | 142° | H9 |
| 23.80 | 870-2380-23-GP | ★ | | ★ | | | | 11.3 | 2.5 | 152° | F9 |
| 23.81 | 870-2381-23-PM | ★ | | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.81 | 870-2381-23-MM | | ★ | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.81 | 870-2381-23-KM | ☆ | | ★ | | | | 10.0 | 4.5 | 142° | H9 |
| 23.81 | 870-2381-23-GP | ★ | | ★ | | | | 11.3 | 2.5 | 152° | F9 |
| 23.90 | 870-2390-23-PM | ★ | | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.90 | 870-2390-23-MM | | ★ | | | | | 10.9 | 3.6 | 142° | H9 |
| 23.90 | 870-2390-23-KM | ☆ | | ★ | | | | 10.0 | 4.6 | 142° | H9 |
| 23.90 | 870-2390-23-GP | ★ | | ★ | | | | 11.3 | 2.5 | 152° | F9 |



J6



J50



J5



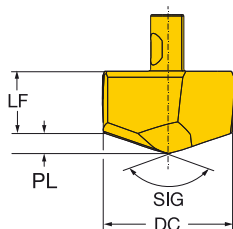
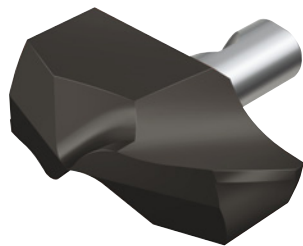
N23



N6



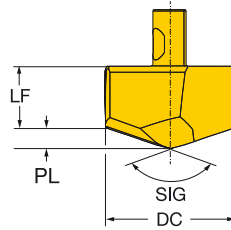
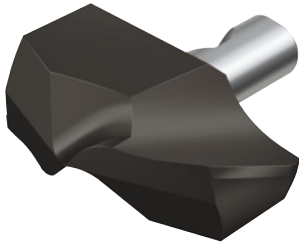
CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | Dimensions, mm | | | |
|-------|----------------|----------|---|---|---|---|----------------|-----|------|------|
| | | P | M | K | N | S | LF | PL | SIG | TCHA |
| 24.00 | 870-2400-24-PM | ★ | | | | | 11.4 | 3.6 | 142° | H9 |
| 24.00 | 870-2400-24-MM | | ★ | | | | 11.4 | 3.6 | 142° | H9 |
| 24.00 | 870-2400-24-KM | ☆ | | ★ | | | 10.4 | 4.6 | 142° | H9 |
| 24.00 | 870-2400-24-GP | ★ | ★ | | ★ | ☆ | 11.8 | 2.5 | 152° | F9 |
| 24.10 | 870-2410-24-PM | ★ | | | ☆ | ☆ | 11.4 | 3.6 | 142° | H9 |
| 24.10 | 870-2410-24-MM | | ★ | | | ☆ | 11.4 | 3.6 | 142° | H9 |
| 24.10 | 870-2410-24-KM | ☆ | | ★ | | | 10.4 | 4.7 | 142° | H9 |
| 24.10 | 870-2410-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.8 | 2.5 | 152° | F9 |
| 24.20 | 870-2420-24-PM | ★ | | | ☆ | ☆ | 11.4 | 3.7 | 142° | H9 |
| 24.20 | 870-2420-24-MM | | ★ | | | ☆ | 11.4 | 3.7 | 142° | H9 |
| 24.20 | 870-2420-24-KM | ☆ | | ★ | | | 10.3 | 4.7 | 142° | H9 |
| 24.20 | 870-2420-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.8 | 2.5 | 152° | F9 |
| 24.30 | 870-2430-24-PM | ★ | | | ☆ | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.30 | 870-2430-24-MM | | ★ | | | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.30 | 870-2430-24-KM | ☆ | | ★ | | | 10.3 | 4.7 | 142° | H9 |
| 24.30 | 870-2430-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.8 | 2.5 | 152° | F9 |
| 24.40 | 870-2440-24-PM | ★ | | | ☆ | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.40 | 870-2440-24-MM | | ★ | | | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.40 | 870-2440-24-KM | ☆ | | ★ | | | 10.3 | 4.7 | 142° | H9 |
| 24.40 | 870-2440-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.8 | 2.6 | 152° | F9 |
| 24.50 | 870-2450-24-PM | ★ | | | ☆ | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.50 | 870-2450-24-MM | | ★ | | | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.50 | 870-2450-24-KM | ☆ | | ★ | | | 10.3 | 4.7 | 142° | H9 |
| 24.50 | 870-2450-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.7 | 2.6 | 152° | F9 |
| 24.60 | 870-2460-24-PM | ★ | | | ☆ | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.60 | 870-2460-24-MM | | ★ | | | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.60 | 870-2460-24-KM | ☆ | | ★ | | | 10.3 | 4.7 | 142° | H9 |
| 24.60 | 870-2460-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.7 | 2.6 | 152° | F9 |
| 24.70 | 870-2470-24-PM | ★ | | | ☆ | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.70 | 870-2470-24-MM | | ★ | | | ☆ | 11.3 | 3.7 | 142° | H9 |
| 24.70 | 870-2470-24-KM | ☆ | | ★ | | | 10.3 | 4.8 | 142° | H9 |
| 24.70 | 870-2470-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.7 | 2.6 | 152° | F9 |
| 24.80 | 870-2480-24-PM | ★ | | | ☆ | ☆ | 11.3 | 3.8 | 142° | H9 |
| 24.80 | 870-2480-24-MM | | ★ | | | ☆ | 11.3 | 3.8 | 142° | H9 |
| 24.80 | 870-2480-24-KM | ☆ | | ★ | | | 10.2 | 4.8 | 142° | H9 |
| 24.80 | 870-2480-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.7 | 2.6 | 152° | F9 |
| 24.90 | 870-2490-24-PM | ★ | | | ☆ | ☆ | 11.2 | 3.8 | 142° | H9 |
| 24.90 | 870-2490-24-MM | | ★ | | | ☆ | 11.2 | 3.8 | 142° | H9 |
| 24.90 | 870-2490-24-KM | ☆ | | ★ | | | 10.2 | 4.8 | 142° | H9 |
| 24.90 | 870-2490-24-GP | ★ | ★ | ★ | ☆ | ☆ | 11.7 | 2.6 | 152° | F9 |



CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA | | | | |
|-------|-------------------|----------------|------|------|------|------|------|----|----|-----|------|------|------|------|------|
| | | P | | M | | K | | | | | | N | | S | |
| | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | | | | | 2334 | 4334 | 3334 | 4334 |
| 25.00 | 25 870-2500-25-PM | ★ | | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.00 | 870-2500-25-MM | | ★ | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.00 | 870-2500-25-KM | ☆ | | | ★ | | | | | | | 10.9 | 4.8 | 142° | H9 |
| 25.00 | 870-2500-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.3 | 2.6 | 152° | F9 |
| 25.10 | 870-2510-25-PM | ★ | | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.10 | 870-2510-25-MM | | ★ | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.10 | 870-2510-25-KM | ☆ | | | ★ | | | | | | | 10.9 | 4.8 | 142° | H9 |
| 25.10 | 870-2510-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.3 | 2.7 | 152° | F9 |
| 25.20 | 870-2520-25-PM | ★ | | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.20 | 870-2520-25-MM | | ★ | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.20 | 870-2520-25-KM | ☆ | | | ★ | | | | | | | 10.9 | 4.8 | 142° | H9 |
| 25.20 | 870-2520-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.2 | 2.7 | 152° | F9 |
| 25.30 | 870-2530-25-PM | ★ | | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.30 | 870-2530-25-MM | | ★ | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.30 | 870-2530-25-KM | ☆ | | | ★ | | | | | | | 10.9 | 4.8 | 142° | H9 |
| 25.30 | 870-2530-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.2 | 2.7 | 152° | F9 |
| 25.40 | 870-2540-25-PM | ★ | | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.40 | 870-2540-25-MM | | ★ | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.40 | 870-2540-25-KM | ☆ | | | ★ | | | | | | | 10.9 | 4.8 | 142° | H9 |
| 25.40 | 870-2540-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.2 | 2.7 | 152° | F9 |
| 25.50 | 870-2550-25-PM | ★ | | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.50 | 870-2550-25-MM | | ★ | | | | | | | | | 11.9 | 3.8 | 142° | H9 |
| 25.50 | 870-2550-25-KM | ☆ | | | ★ | | | | | | | 10.9 | 4.9 | 142° | H9 |
| 25.50 | 870-2550-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.2 | 2.7 | 152° | F9 |
| 25.60 | 870-2560-25-PM | ★ | | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.60 | 870-2560-25-MM | | ★ | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.60 | 870-2560-25-KM | ☆ | | | ★ | | | | | | | 10.8 | 4.9 | 142° | H9 |
| 25.60 | 870-2560-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.2 | 2.7 | 152° | F9 |
| 25.65 | 870-2565-25-PL | ☆ | | | ★ | | | | | | | 10.5 | 5.2 | 142° | H9 |
| 25.70 | 870-2570-25-PM | ★ | | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.70 | 870-2570-25-MM | | ★ | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.70 | 870-2570-25-KM | ☆ | | | ★ | | | | | | | 10.8 | 4.9 | 142° | H9 |
| 25.70 | 870-2570-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.2 | 2.7 | 152° | F9 |
| 25.80 | 870-2580-25-PM | ★ | | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.80 | 870-2580-25-MM | | ★ | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.80 | 870-2580-25-KM | ☆ | | | ★ | | | | | | | 10.8 | 4.9 | 142° | H9 |
| 25.80 | 870-2580-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.1 | 2.8 | 152° | F9 |
| 25.90 | 870-2590-25-PM | ★ | | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.90 | 870-2590-25-MM | | ★ | | | | | | | | | 11.8 | 3.9 | 142° | H9 |
| 25.90 | 870-2590-25-KM | ☆ | | | ★ | | | | | | | 10.8 | 4.9 | 142° | H9 |
| 25.90 | 870-2590-25-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.1 | 2.8 | 152° | F9 |
| 26.00 | 26 870-2600-26-PM | ★ | | | | | | | | | | 12.5 | 3.9 | 142° | H9 |
| 26.00 | 870-2600-26-MM | | ★ | | | | | | | | | 12.5 | 3.9 | 142° | H9 |
| 26.00 | 870-2600-26-KM | ☆ | | | ★ | | | | | | | 11.4 | 5.0 | 142° | H9 |
| 26.00 | 870-2600-26-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.9 | 2.7 | 152° | F9 |
| 26.50 | 870-2650-26-PM | ★ | | | | | | | | | | 12.4 | 4.0 | 142° | H9 |
| 26.50 | 870-2650-26-MM | | ★ | | | | | | | | | 12.4 | 4.0 | 142° | H9 |
| 26.50 | 870-2650-26-KM | ☆ | | | ★ | | | | | | | 11.3 | 5.1 | 142° | H9 |
| 26.50 | 870-2650-26-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.8 | 2.8 | 152° | F9 |
| 26.65 | 870-2665-26-PM | ★ | | | | | | | | | | 12.4 | 4.0 | 142° | H9 |
| 26.65 | 870-2665-26-MM | | ★ | | | | | | | | | 12.4 | 4.0 | 142° | H9 |
| 26.65 | 870-2665-26-KM | ☆ | | | ★ | | | | | | | 11.3 | 5.1 | 142° | H9 |
| 26.65 | 870-2665-26-GP | ★ | | ★ | | ★ | ☆ | ☆ | | | | 12.8 | 2.8 | 152° | F9 |



J6



J50



J5



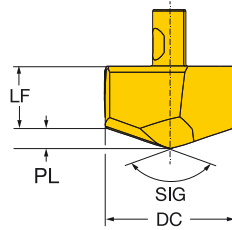
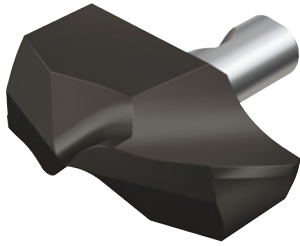
N23



N6



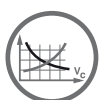
CoroDrill® 870 drill tip



| DC | Ordering code | Dimensions, mm | | | | | | LF | PL | SIG | TCHA | |
|-------|-------------------|----------------|------|------|------|------|------|------|------|-----|------|----|
| | | P | M | K | N | S | | | | | | |
| 27.00 | 27 870-2700-27-PM | 3334 | 4334 | 2334 | 3334 | 4334 | 2334 | 4334 | 13.0 | 4.1 | 142° | H9 |
| 27.00 | 870-2700-27-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.0 | 4.1 | 142° | H9 |
| 27.00 | 870-2700-27-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 11.8 | 5.2 | 142° | H9 |
| 27.00 | 870-2700-27-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 13.3 | 2.8 | 152° | F9 |
| 27.50 | 870-2750-27-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 12.9 | 4.1 | 142° | H9 |
| 27.50 | 870-2750-27-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 12.9 | 4.1 | 142° | H9 |
| 27.50 | 870-2750-27-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 11.7 | 5.3 | 142° | H9 |
| 27.50 | 870-2750-27-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 13.2 | 2.9 | 152° | F9 |
| 28.00 | 28 870-2800-28-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.4 | 4.2 | 142° | H9 |
| 28.00 | 870-2800-28-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.4 | 4.2 | 142° | H9 |
| 28.00 | 870-2800-28-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 12.2 | 5.4 | 142° | H9 |
| 28.00 | 870-2800-28-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 13.8 | 2.9 | 152° | F9 |
| 28.50 | 870-2850-28-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.3 | 4.3 | 142° | H9 |
| 28.50 | 870-2850-28-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.3 | 4.3 | 142° | H9 |
| 28.50 | 870-2850-28-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 12.1 | 5.5 | 142° | H9 |
| 28.50 | 870-2850-28-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 13.7 | 3.0 | 152° | F9 |
| 28.58 | 870-2858-28-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.3 | 4.3 | 142° | H9 |
| 28.58 | 870-2858-28-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.3 | 4.3 | 142° | H9 |
| 28.58 | 870-2858-28-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 12.1 | 5.5 | 142° | H9 |
| 28.58 | 870-2858-28-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 13.7 | 3.0 | 152° | F9 |
| 29.00 | 29 870-2900-29-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.9 | 4.4 | 142° | H9 |
| 29.00 | 870-2900-29-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.9 | 4.4 | 142° | H9 |
| 29.00 | 870-2900-29-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 12.7 | 5.6 | 142° | H9 |
| 29.00 | 870-2900-29-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 14.3 | 3.0 | 152° | F9 |
| 29.50 | 870-2950-29-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.9 | 4.5 | 142° | H9 |
| 29.50 | 870-2950-29-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.9 | 4.5 | 142° | H9 |
| 29.50 | 870-2950-29-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 12.6 | 5.7 | 142° | H9 |
| 29.50 | 870-2950-29-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 14.2 | 3.1 | 152° | F9 |
| 29.65 | 870-2965-29-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.8 | 4.5 | 142° | H9 |
| 29.65 | 870-2965-29-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.8 | 4.5 | 142° | H9 |
| 29.65 | 870-2965-29-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 12.6 | 5.7 | 142° | H9 |
| 29.65 | 870-2965-29-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 14.2 | 3.1 | 152° | F9 |
| 30.00 | 30 870-3000-30-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 14.4 | 4.5 | 142° | H9 |
| 30.00 | 870-3000-30-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 14.4 | 4.5 | 142° | H9 |
| 30.00 | 870-3000-30-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 13.1 | 5.8 | 142° | H9 |
| 30.00 | 870-3000-30-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 14.7 | 3.2 | 152° | F9 |
| 30.50 | 870-3050-30-PM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 14.3 | 4.6 | 142° | H9 |
| 30.50 | 870-3050-30-MM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 14.3 | 4.6 | 142° | H9 |
| 30.50 | 870-3050-30-KM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 13.0 | 5.9 | 142° | H9 |
| 30.50 | 870-3050-30-GP | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 14.6 | 3.2 | 152° | F9 |



J6



J50



J5

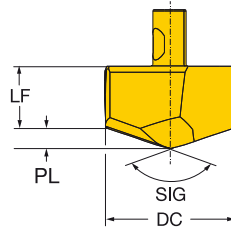
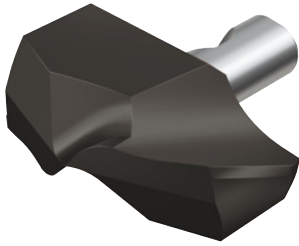


N23



N6

CoroDrill® 870 drill tip



| DC | Ordering code | Material | | | | | | Dimensions, mm | | | |
|-------|----------------|----------|---|---|---|---|------|----------------|------|------|--|
| | | P | M | K | N | S | LF | PL | SIG | TCHA | |
| 31.00 | 870-3100-31-PM | ★ | | | | | 14.8 | 4.8 | 142° | H9 | |
| 31.00 | 870-3100-31-MM | | ★ | | | | 14.8 | 4.8 | 142° | H9 | |
| 31.00 | 870-3100-31-KM | ☆ | | ★ | | | 13.4 | 6.1 | 142° | H9 | |
| 31.00 | 870-3100-31-GP | ★ | ★ | ★ | ☆ | ☆ | 15.1 | 3.3 | 152° | F9 | |
| 31.50 | 870-3150-31-PM | ★ | | | ☆ | ☆ | 14.7 | 4.8 | 142° | H9 | |
| 31.50 | 870-3150-31-MM | | ★ | | | ☆ | 14.7 | 4.8 | 142° | H9 | |
| 31.50 | 870-3150-31-KM | ☆ | | ★ | | | 13.3 | 6.2 | 142° | H9 | |
| 31.50 | 870-3150-31-GP | ★ | ★ | ★ | ☆ | ☆ | 15.0 | 3.4 | 152° | F9 | |
| 31.75 | 870-3175-31-PM | ★ | | | ☆ | ☆ | 14.6 | 4.9 | 142° | H9 | |
| 31.75 | 870-3175-31-MM | | ★ | | | ☆ | 14.6 | 4.9 | 142° | H9 | |
| 31.75 | 870-3175-31-KM | ☆ | | ★ | | | 13.3 | 6.2 | 142° | H9 | |
| 31.75 | 870-3175-31-GP | ★ | ★ | ★ | ☆ | ☆ | 15.0 | 3.4 | 152° | F9 | |
| 32.00 | 870-3200-31-PM | ★ | | | ☆ | ☆ | 14.6 | 4.9 | 142° | H9 | |
| 32.00 | 870-3200-31-MM | | ★ | | | ☆ | 14.6 | 4.9 | 142° | H9 | |
| 32.00 | 870-3200-31-KM | ☆ | | ★ | | | 13.2 | 6.3 | 142° | H9 | |
| 32.00 | 870-3200-31-GP | ★ | ★ | ★ | ☆ | ☆ | 15.0 | 3.4 | 152° | F9 | |
| 32.15 | 870-3215-31-PM | ★ | | | ☆ | ☆ | 14.6 | 5.0 | 142° | H9 | |
| 32.15 | 870-3215-31-MM | | ★ | | | ☆ | 14.6 | 5.0 | 142° | H9 | |
| 32.15 | 870-3215-31-KM | ☆ | | ★ | | | 13.2 | 6.3 | 142° | H9 | |
| 32.15 | 870-3215-31-GP | ★ | ★ | ★ | ☆ | ☆ | 14.9 | 3.5 | 152° | F9 | |
| 32.50 | 870-3250-31-PM | ★ | | | ☆ | ☆ | 14.5 | 5.0 | 142° | H9 | |
| 32.50 | 870-3250-31-MM | | ★ | | | ☆ | 14.5 | 5.0 | 142° | H9 | |
| 32.50 | 870-3250-31-KM | ☆ | | ★ | | | 13.1 | 6.4 | 142° | H9 | |
| 32.50 | 870-3250-31-GP | ★ | ★ | ★ | ☆ | ☆ | 14.9 | 3.5 | 152° | F9 | |
| 33.00 | 870-3300-31-PM | ★ | | | ☆ | ☆ | 14.4 | 5.1 | 142° | H9 | |
| 33.00 | 870-3300-31-MM | | ★ | | | ☆ | 14.4 | 5.1 | 142° | H9 | |
| 33.00 | 870-3300-31-KM | ☆ | | ★ | | | 13.0 | 6.5 | 142° | H9 | |
| 33.00 | 870-3300-31-GP | ★ | ★ | ★ | ☆ | ☆ | 14.8 | 3.6 | 152° | F9 | |



J6



J50



J5



N23



N6



CoroDrill® DS20

Indexable insert drills

ISO application area



Benefits and features

- Secure and reliable cutting process with high productivity
- Versatile drill with good chip formation in a broad cutting data range
- Optimized chip control and chip evacuation
- Light cutting and extremely low cutting forces
- Only indexable insert drills that can drill holes up to 7 x DC

Modular Drilling Interface

The MDI adaptors are available in Coromant Capto® and HSK and provide high precision, excellent centring capabilities and can reduce tool inventory. See page L2



www.sandvik.coromant.com/corodrills20

Drill bodies

- Cylindrical shank with flat according to ISO 9766
- Modular Drilling Interface (MDI)

Inserts

- Inserts with optimized geometries for all materials

| D_c min mm | D_c max mm | Achievable lower tolerance (TCHAL) | | | | Achievable upper tolerance (TCHAU) | | | |
|-----------------|-----------------|------------------------------------|-----|------|------|------------------------------------|------|-----|-----|
| | | 4xD | 5xD | 6xD | 7xD | 4xD | 5xD | 6xD | 7xD |
| 15.00 | 18.00 | 0 | 0 | -0.1 | -0.1 | 0.27 | 0.27 | 0.4 | 0.4 |
| 18.01 | 30.00 | 0 | 0 | -0.1 | -0.1 | 0.33 | 0.33 | 0.4 | 0.4 |
| 30.01 | 40.00 | 0 | 0 | -0.1 | -0.1 | 0.39 | 0.39 | 0.4 | 0.4 |



J28











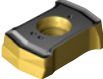
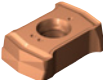


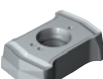


J33



N6

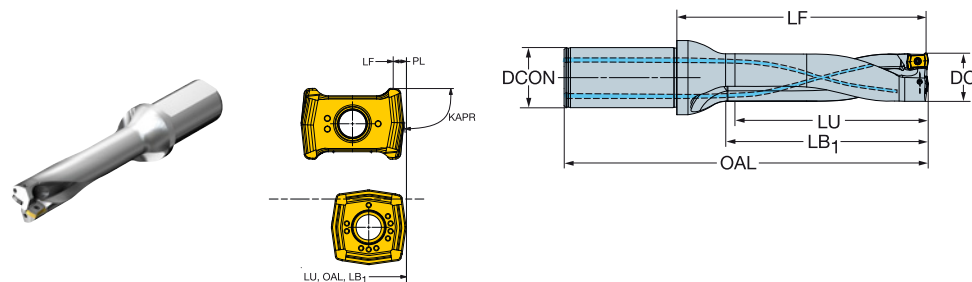
Insert overview

| Central insert | | Geometry information | |
|---|--|----------------------|--|
| L5 |  | P M N S H | <ul style="list-style-type: none"> - Long-chipping materials - Hardened steel - Low to medium feed - Light cutting |
| M7 |  | P K | <ul style="list-style-type: none"> - Short-chipping material - Low to high feed - Strong reinforced edge |
| Peripheral insert | | Geometry information | |
| M7W |  | P K H | <ul style="list-style-type: none"> - First choice in short chipping materials - Low to high feed - Strong reinforced edge |
| L5W |  | P M N S | <ul style="list-style-type: none"> - Long-chipping materials - Low to medium feed - Light cutting |
| H5W |  | P M | <ul style="list-style-type: none"> - Complementary for long-chipping materials - Low to medium feed - Negative T-land - High cutting forces |
| S5W |  | M N S | <ul style="list-style-type: none"> - Sharp and extremely light cutting - Low feed |
| L6W |  | P M K N S H | <ul style="list-style-type: none"> - All-round geometry for mixed production - First choice in Inconel and hardened steel - Low to medium feed - Light cutting |
| Central insert | | Grade information | |
|  | P K S H | GC1344 | <ul style="list-style-type: none"> - PVD-coated with Zertivo® technology - Excellent wear resistance and toughness |
|  | M S | GC1144 | <ul style="list-style-type: none"> - PVD-coated grade for all types of ISO M and titanium materials |
|  | N S | H13A | <ul style="list-style-type: none"> - Universal, tough and uncoated grade best for low to moderate cutting speeds - Complementary grade for ISO S |
| Peripheral insert | | Grade information | |
|  | P M K H | GC4334 | <ul style="list-style-type: none"> - Good to average conditions - CVD coating with Inveio® technology provides a high level of wear resistance |
|  | M S | GC2044 | <ul style="list-style-type: none"> - PVD-oxide coating for excellent wear resistance |
|  | P M K N S H | GC4344 | <ul style="list-style-type: none"> - PVD-coating with Zertivo® technology - Tough and demanding operations - Provides good edge-line properties and reliable tool life |
|  | P K | GC4324 | <ul style="list-style-type: none"> - MT-CVD coating with Inveio® technology - Productive choice in stable conditions |
|  | N S | H13A | <ul style="list-style-type: none"> - Universal, tough and uncoated grade best for low to moderate cutting speeds - Complementary grade for ISO S |

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



| DC | | | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, mm | | | | | | | RPMX | |
|-------|-----|-----|--------|-------------------|-------|-------|-------|------------------|--------------------|--------|--------|-----------------|------|------|-----|-------|-------|
| DC | 01C | 01P | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | RPMX |
| 15.00 | 01C | 01P | 60.00 | 20 | 1.00 | 0.00 | 0.27 | DS20-D1500L20-04 | 20.00 | 80.69 | 131.00 | 63.00 | 0.46 | 81° | 10 | 0.190 | 24000 |
| | | | 75.00 | 20 | 1.00 | 0.00 | 0.27 | DS20-D1500L20-05 | 20.00 | 95.69 | 146.00 | 78.00 | 0.46 | 81° | 10 | 0.200 | 15000 |
| | | | 90.00 | 20 | 1.00 | -0.10 | 0.40 | DS20-D1500L20-06 | 20.00 | 110.69 | 161.00 | 93.00 | 0.46 | 81° | 10 | 0.210 | 11000 |
| | | | 105.00 | 20 | 1.00 | -0.10 | 0.40 | DS20-D1500L20-07 | 20.00 | 125.69 | 176.00 | 108.00 | 0.46 | 81° | 10 | 0.219 | 8000 |
| 16.00 | 01C | 01P | 64.00 | 20 | 0.75 | 0.00 | 0.27 | DS20-D1600L20-04 | 20.00 | 84.69 | 135.00 | 67.00 | 0.46 | 81° | 10 | 0.220 | 22000 |
| | | | 80.00 | 20 | 0.75 | 0.00 | 0.27 | DS20-D1600L20-05 | 20.00 | 100.69 | 151.00 | 83.00 | 0.46 | 81° | 10 | 0.212 | 14000 |
| | | | 96.00 | 20 | 0.75 | -0.10 | 0.40 | DS20-D1600L20-06 | 20.00 | 116.69 | 167.00 | 99.00 | 0.46 | 81° | 10 | 0.224 | 10000 |
| | | | 112.00 | 20 | 0.75 | -0.10 | 0.40 | DS20-D1600L20-07 | 20.00 | 132.69 | 183.00 | 115.00 | 0.46 | 81° | 10 | 0.236 | 7000 |
| 17.00 | 01C | 01P | 68.00 | 20 | 0.50 | 0.00 | 0.27 | DS20-D1700L20-04 | 20.00 | 88.69 | 139.00 | 71.00 | 0.46 | 81° | 10 | 0.211 | 21000 |
| | | | 85.00 | 20 | 0.50 | 0.00 | 0.27 | DS20-D1700L20-05 | 20.00 | 105.69 | 156.00 | 88.00 | 0.46 | 81° | 10 | 0.226 | 13000 |
| | | | 102.00 | 20 | 0.50 | -0.10 | 0.40 | DS20-D1700L20-06 | 20.00 | 122.69 | 173.00 | 105.00 | 0.46 | 81° | 10 | 0.240 | 9000 |
| | | | 119.00 | 20 | 0.50 | -0.10 | 0.40 | DS20-D1700L20-07 | 20.00 | 139.69 | 190.00 | 122.00 | 0.46 | 81° | 10 | 0.255 | 7000 |
| 18.00 | 01C | 01P | 72.00 | 25 | 0.25 | 0.00 | 0.27 | DS20-D1800L25-04 | 25.00 | 96.69 | 153.00 | 75.00 | 0.46 | 81° | 10 | 0.348 | 20000 |
| | | | 90.00 | 25 | 0.25 | 0.00 | 0.27 | DS20-D1800L25-05 | 25.00 | 114.69 | 171.00 | 93.00 | 0.46 | 81° | 10 | 0.366 | 13000 |
| | | | 108.00 | 25 | 0.25 | -0.10 | 0.40 | DS20-D1800L25-06 | 25.00 | 132.69 | 189.00 | 111.00 | 0.46 | 81° | 10 | 0.383 | 9000 |
| | | | 126.00 | 25 | 0.25 | -0.10 | 0.40 | DS20-D1800L25-07 | 25.00 | 150.69 | 207.00 | 129.00 | 0.46 | 81° | 10 | 0.400 | 6000 |
| 19.00 | 02C | 02P | 76.00 | 25 | 1.06 | 0.00 | 0.33 | DS20-D1900L25-04 | 25.00 | 100.62 | 157.00 | 79.00 | 0.55 | 81° | 10 | 0.348 | 19000 |
| | | | 95.00 | 25 | 1.06 | 0.00 | 0.33 | DS20-D1900L25-05 | 25.00 | 119.62 | 176.00 | 98.00 | 0.55 | 81° | 10 | 0.367 | 12000 |
| | | | 114.00 | 25 | 1.06 | -0.10 | 0.40 | DS20-D1900L25-06 | 25.00 | 138.62 | 195.00 | 117.00 | 0.55 | 81° | 10 | 0.387 | 8000 |
| | | | 133.00 | 25 | 1.06 | -0.10 | 0.40 | DS20-D1900L25-07 | 25.00 | 157.62 | 214.00 | 136.00 | 0.55 | 81° | 10 | 0.405 | 6000 |
| 20.00 | 02C | 02P | 80.00 | 25 | 0.82 | 0.00 | 0.33 | DS20-D2000L25-04 | 25.00 | 104.62 | 161.00 | 83.00 | 0.55 | 81° | 10 | 0.364 | 18000 |
| | | | 100.00 | 25 | 0.82 | 0.00 | 0.33 | DS20-D2000L25-05 | 25.00 | 124.62 | 181.00 | 103.00 | 0.55 | 81° | 10 | 0.386 | 11000 |
| | | | 120.00 | 25 | 0.82 | -0.10 | 0.40 | DS20-D2000L25-06 | 25.00 | 144.62 | 201.00 | 123.00 | 0.55 | 81° | 10 | 0.409 | 8000 |
| | | | 140.00 | 25 | 0.82 | -0.10 | 0.40 | DS20-D2000L25-07 | 25.00 | 164.62 | 221.00 | 143.00 | 0.55 | 81° | 10 | 0.431 | 6000 |
| 21.00 | 02C | 02P | 84.00 | 25 | 0.58 | 0.00 | 0.33 | DS20-D2100L25-04 | 25.00 | 108.62 | 165.00 | 87.00 | 0.55 | 81° | 10 | 0.381 | 17000 |
| | | | 105.00 | 25 | 0.58 | 0.00 | 0.33 | DS20-D2100L25-05 | 25.00 | 129.62 | 186.00 | 108.00 | 0.55 | 81° | 10 | 0.407 | 11000 |
| | | | 126.00 | 25 | 0.58 | -0.10 | 0.40 | DS20-D2100L25-06 | 25.00 | 150.62 | 207.00 | 129.00 | 0.55 | 81° | 10 | 0.434 | 8000 |
| | | | 147.00 | 25 | 0.58 | -0.10 | 0.40 | DS20-D2100L25-07 | 25.00 | 171.62 | 228.00 | 150.00 | 0.55 | 81° | 10 | 0.460 | 5000 |
| 22.00 | 02C | 02P | 88.00 | 25 | 0.34 | 0.00 | 0.33 | DS20-D2200L25-04 | 25.00 | 112.62 | 169.00 | 91.00 | 0.55 | 81° | 10 | 0.401 | 16000 |
| | | | 110.00 | 25 | 0.34 | 0.00 | 0.33 | DS20-D2200L25-05 | 25.00 | 134.62 | 191.00 | 113.00 | 0.55 | 81° | 10 | 0.431 | 10000 |
| | | | 132.00 | 25 | 0.34 | -0.10 | 0.40 | DS20-D2200L25-06 | 25.00 | 156.62 | 213.00 | 135.00 | 0.55 | 81° | 10 | 0.463 | 7000 |
| | | | 154.00 | 25 | 0.34 | -0.10 | 0.40 | DS20-D2200L25-07 | 25.00 | 178.62 | 235.00 | 157.00 | 0.55 | 81° | 10 | 0.494 | 5000 |
| 23.00 | 03C | 03P | 92.00 | 25 | 1.30 | 0.00 | 0.33 | DS20-D2300L25-04 | 25.00 | 117.53 | 174.00 | 96.00 | 0.66 | 81° | 10 | 0.420 | 15000 |
| | | | 115.00 | 25 | 1.30 | 0.00 | 0.33 | DS20-D2300L25-05 | 25.00 | 140.53 | 197.00 | 119.00 | 0.66 | 81° | 10 | 0.452 | 10000 |
| | | | 138.00 | 25 | 1.30 | -0.10 | 0.40 | DS20-D2300L25-06 | 25.00 | 163.53 | 220.00 | 142.00 | 0.66 | 81° | 10 | 0.488 | 7000 |
| | | | 161.00 | 25 | 1.30 | -0.10 | 0.40 | DS20-D2300L25-07 | 25.00 | 186.53 | 243.00 | 165.00 | 0.66 | 81° | 10 | 0.524 | 5000 |
| 24.00 | 03C | 03P | 96.00 | 25 | 1.10 | 0.00 | 0.33 | DS20-D2400L25-04 | 25.00 | 121.53 | 178.00 | 100.00 | 0.66 | 81° | 10 | 0.439 | 15000 |
| | | | 120.00 | 25 | 1.10 | 0.00 | 0.33 | DS20-D2400L25-05 | 25.00 | 145.53 | 202.00 | 124.00 | 0.66 | 81° | 10 | 0.550 | 9000 |
| | | | 144.00 | 25 | 1.10 | -0.10 | 0.40 | DS20-D2400L25-06 | 25.00 | 169.53 | 226.00 | 148.00 | 0.66 | 81° | 10 | 0.520 | 6000 |
| | | | 168.00 | 25 | 1.10 | -0.10 | 0.40 | DS20-D2400L25-07 | 25.00 | 193.53 | 250.00 | 172.00 | 0.66 | 81° | 10 | 0.561 | 5000 |
| 25.00 | 03C | 03P | 100.00 | 25 | 0.90 | 0.00 | 0.33 | DS20-D2500L25-04 | 25.00 | 125.53 | 182.00 | 104.00 | 0.66 | 81° | 10 | 0.463 | 14000 |
| | | | 125.00 | 25 | 0.90 | 0.00 | 0.33 | DS20-D2500L25-05 | 25.00 | 150.53 | 207.00 | 129.00 | 0.66 | 81° | 10 | 0.510 | 9000 |
| | | | 150.00 | 25 | 0.90 | -0.10 | 0.40 | DS20-D2500L25-06 | 25.00 | 175.53 | 232.00 | 154.00 | 0.66 | 81° | 10 | 0.557 | 6000 |
| | | | 175.00 | 25 | 0.90 | -0.10 | 0.40 | DS20-D2500L25-07 | 25.00 | 200.53 | 257.00 | 179.00 | 0.66 | 81° | 10 | 0.603 | 4000 |

| Spare parts | |
|-------------|--------------|
| DC | Insert screw |
| 15.00-18.00 | 5513 020-27 |
| 18.01-22.00 | 5513 020-88 |
| 22.01-27.00 | 5513 020-58 |
| 27.01-33.00 | 5513 020-57 |
| 33.01-40.00 | 416.1-833 |
| 40.01-65.00 | 416.1-834 |

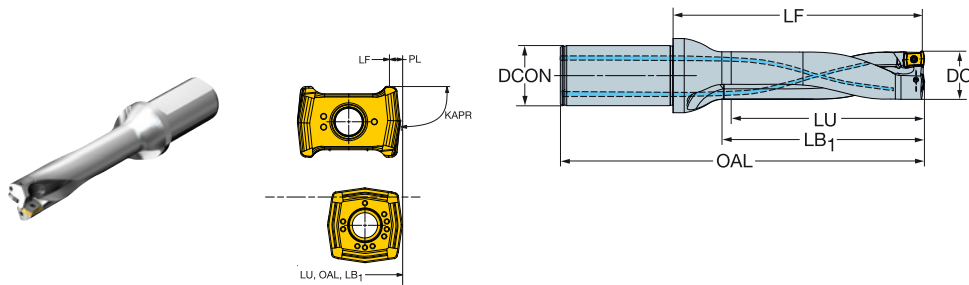
For complete list of spare parts, see www.sandvik.coromant.com



CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



| DC | | LU | CZC _{MIS} | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, mm | | | | | | | RPMX | | |
|-------|-----|-----|--------------------|-------|-------|-------|---------------|---------------------|-------|--------|-----------------|--------|------|-----|------|-------|-------|
| DC | 03C | 03P | 04C | 04P | 05C | 05P | | DCON _{MIS} | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | | |
| 26.00 | 03C | 03P | 104.00 | 32 | 0.70 | 0.00 | 0.33 | DS20-D2600L32-04 | 32.00 | 133.53 | 194.00 | 108.00 | 0.66 | 81° | 10 | 0.600 | 14000 |
| | | | 130.00 | 32 | 0.70 | 0.00 | 0.33 | DS20-D2600L32-05 | 32.00 | 159.53 | 220.00 | 134.00 | 0.66 | 81° | 10 | 0.758 | 9000 |
| | | | 156.00 | 32 | 0.70 | -0.10 | 0.40 | DS20-D2600L32-06 | 32.00 | 185.53 | 246.00 | 160.00 | 0.66 | 81° | 10 | 0.812 | 6000 |
| | | | 182.00 | 32 | 0.70 | -0.10 | 0.40 | DS20-D2600L32-07 | 32.00 | 211.53 | 272.00 | 186.00 | 0.66 | 81° | 10 | 0.865 | 4000 |
| 27.00 | 03C | 03P | 108.00 | 32 | 0.50 | 0.00 | 0.33 | DS20-D2700L32-04 | 32.00 | 136.53 | 197.00 | 112.00 | 0.66 | 81° | 10 | 0.734 | 13000 |
| | | | 135.00 | 32 | 0.50 | 0.00 | 0.33 | DS20-D2700L32-05 | 32.00 | 163.53 | 224.00 | 139.00 | 0.66 | 81° | 10 | 0.794 | 8000 |
| | | | 162.00 | 32 | 0.50 | -0.10 | 0.40 | DS20-D2700L32-06 | 32.00 | 190.53 | 251.00 | 166.00 | 0.66 | 81° | 10 | 0.854 | 6000 |
| | | | 189.00 | 32 | 0.50 | -0.10 | 0.40 | DS20-D2700L32-07 | 32.00 | 217.53 | 278.00 | 193.00 | 0.66 | 81° | 10 | 0.912 | 4000 |
| 28.00 | 04C | 04P | 112.00 | 32 | 2.12 | 0.00 | 0.33 | DS20-D2800L32-04 | 32.00 | 140.16 | 201.00 | 116.00 | 0.83 | 81° | 10 | 0.743 | 13000 |
| | | | 140.00 | 32 | 2.12 | 0.00 | 0.33 | DS20-D2800L32-05 | 32.00 | 168.16 | 229.00 | 144.00 | 0.83 | 81° | 10 | 0.809 | 8000 |
| | | | 168.00 | 32 | 2.12 | -0.10 | 0.40 | DS20-D2800L32-06 | 32.00 | 196.16 | 257.00 | 172.00 | 0.83 | 81° | 10 | 0.874 | 6000 |
| | | | 196.00 | 32 | 2.12 | -0.10 | 0.40 | DS20-D2800L32-07 | 32.00 | 224.16 | 285.00 | 200.00 | 0.83 | 81° | 10 | 0.939 | 4000 |
| 29.00 | 04C | 04P | 116.00 | 32 | 1.84 | 0.00 | 0.33 | DS20-D2900L32-04 | 32.00 | 144.16 | 205.00 | 120.00 | 0.83 | 81° | 10 | 0.773 | 12000 |
| | | | 145.00 | 32 | 1.84 | 0.00 | 0.33 | DS20-D2900L32-05 | 32.00 | 173.16 | 234.00 | 149.00 | 0.83 | 81° | 10 | 0.846 | 8000 |
| | | | 174.00 | 32 | 1.84 | -0.10 | 0.40 | DS20-D2900L32-06 | 32.00 | 202.16 | 263.00 | 178.00 | 0.83 | 81° | 10 | 0.918 | 5000 |
| | | | 203.00 | 32 | 1.84 | -0.10 | 0.40 | DS20-D2900L32-07 | 32.00 | 231.16 | 292.00 | 207.00 | 0.83 | 81° | 10 | 0.991 | 4000 |
| 30.00 | 04C | 04P | 120.00 | 32 | 1.56 | 0.00 | 0.33 | DS20-D3000L32-04 | 32.00 | 148.16 | 209.00 | 124.00 | 0.83 | 81° | 10 | 0.805 | 12000 |
| | | | 150.00 | 32 | 1.56 | 0.00 | 0.33 | DS20-D3000L32-05 | 32.00 | 178.16 | 239.00 | 154.00 | 0.83 | 81° | 10 | 0.885 | 8000 |
| | | | 180.00 | 32 | 1.56 | -0.10 | 0.40 | DS20-D3000L32-06 | 32.00 | 208.16 | 269.00 | 184.00 | 0.83 | 81° | 10 | 0.966 | 5000 |
| | | | 210.00 | 32 | 1.56 | -0.10 | 0.40 | DS20-D3000L32-07 | 32.00 | 238.16 | 299.00 | 214.00 | 0.83 | 81° | 10 | 1.046 | 4000 |
| 31.00 | 04C | 04P | 124.00 | 40 | 1.28 | 0.00 | 0.35 | DS20-D3100L40-04 | 40.00 | 158.16 | 229.00 | 128.00 | 0.83 | 81° | 10 | 1.250 | 12000 |
| | | | 155.00 | 40 | 1.28 | 0.00 | 0.35 | DS20-D3100L40-05 | 40.00 | 189.16 | 260.00 | 159.00 | 0.83 | 81° | 10 | 1.339 | 7000 |
| | | | 186.00 | 40 | 1.28 | -0.10 | 0.40 | DS20-D3100L40-06 | 40.00 | 220.16 | 291.00 | 190.00 | 0.83 | 81° | 10 | 1.428 | 5000 |
| | | | 217.00 | 40 | 1.28 | -0.10 | 0.40 | DS20-D3100L40-07 | 40.00 | 251.16 | 322.00 | 221.00 | 0.83 | 81° | 10 | 1.516 | 4000 |
| 32.00 | 04C | 04P | 128.00 | 40 | 1.00 | 0.00 | 0.35 | DS20-D3200L40-04 | 40.00 | 162.16 | 233.00 | 132.00 | 0.83 | 81° | 10 | 1.286 | 11000 |
| | | | 160.00 | 40 | 1.00 | 0.00 | 0.35 | DS20-D3200L40-05 | 40.00 | 194.16 | 265.00 | 164.00 | 0.83 | 81° | 10 | 1.384 | 7000 |
| | | | 192.00 | 40 | 1.00 | -0.10 | 0.40 | DS20-D3200L40-06 | 40.00 | 226.16 | 297.00 | 196.00 | 0.83 | 81° | 10 | 1.481 | 5000 |
| | | | 224.00 | 40 | 1.00 | -0.10 | 0.40 | DS20-D3200L40-07 | 40.00 | 258.16 | 329.00 | 228.00 | 0.83 | 81° | 10 | 1.579 | 3000 |
| 33.00 | 04C | 04P | 132.00 | 40 | 0.72 | 0.00 | 0.35 | DS20-D3300L40-04 | 40.00 | 165.16 | 236.00 | 136.00 | 0.83 | 81° | 10 | 1.313 | 11000 |
| | | | 165.00 | 40 | 0.72 | 0.00 | 0.35 | DS20-D3300L40-05 | 40.00 | 198.16 | 269.00 | 169.00 | 0.83 | 81° | 10 | 1.420 | 7000 |
| | | | 198.00 | 40 | 0.72 | -0.10 | 0.40 | DS20-D3300L40-06 | 40.00 | 231.16 | 302.00 | 202.00 | 0.83 | 81° | 10 | 1.527 | 5000 |
| | | | 231.00 | 40 | 0.72 | -0.10 | 0.40 | DS20-D3300L40-07 | 40.00 | 264.16 | 335.00 | 235.00 | 0.83 | 81° | 10 | 1.634 | 3000 |
| 34.00 | 05C | 05P | 136.00 | 40 | 2.16 | 0.00 | 0.35 | DS20-D3400L40-04 | 40.00 | 169.28 | 240.00 | 140.00 | 1.00 | 81° | 10 | 1.354 | 11000 |
| | | | 170.00 | 40 | 2.16 | 0.00 | 0.35 | DS20-D3400L40-05 | 40.00 | 203.28 | 274.00 | 174.00 | 1.00 | 81° | 10 | 1.471 | 7000 |
| | | | 204.00 | 40 | 2.16 | -0.10 | 0.40 | DS20-D3400L40-06 | 40.00 | 237.28 | 308.00 | 208.00 | 1.00 | 81° | 10 | 1.531 | 4000 |
| | | | 238.00 | 40 | 2.16 | -0.10 | 0.40 | DS20-D3400L40-07 | 40.00 | 271.28 | 342.00 | 242.00 | 1.00 | 81° | 10 | 1.705 | 3000 |
| 35.00 | 05C | 05P | 140.00 | 40 | 1.92 | 0.00 | 0.35 | DS20-D3500L40-04 | 40.00 | 173.28 | 244.00 | 144.00 | 1.00 | 81° | 10 | 1.398 | 10000 |
| | | | 175.00 | 40 | 1.92 | 0.00 | 0.35 | DS20-D3500L40-05 | 40.00 | 208.28 | 279.00 | 179.00 | 1.00 | 81° | 10 | 1.525 | 6000 |
| | | | 210.00 | 40 | 1.92 | -0.10 | 0.40 | DS20-D3500L40-06 | 40.00 | 243.28 | 314.00 | 214.00 | 1.00 | 81° | 10 | 1.653 | 4000 |
| | | | 245.00 | 40 | 1.92 | -0.10 | 0.40 | DS20-D3500L40-07 | 40.00 | 278.28 | 349.00 | 249.00 | 1.00 | 81° | 10 | 1.781 | 3000 |
| 36.00 | 05C | 05P | 144.00 | 40 | 1.68 | 0.00 | 0.35 | DS20-D3600L40-04 | 40.00 | 177.28 | 248.00 | 148.00 | 1.00 | 81° | 10 | 1.443 | 10000 |
| | | | 180.00 | 40 | 1.68 | 0.00 | 0.35 | DS20-D3600L40-05 | 40.00 | 213.28 | 284.00 | 184.00 | 1.00 | 81° | 10 | 1.582 | 6000 |
| | | | 216.00 | 40 | 1.68 | -0.10 | 0.40 | DS20-D3600L40-06 | 40.00 | 249.28 | 320.00 | 220.00 | 1.00 | 81° | 10 | 1.721 | 4000 |
| | | | 252.00 | 40 | 1.68 | -0.10 | 0.40 | DS20-D3600L40-07 | 40.00 | 285.28 | 356.00 | 256.00 | 1.00 | 81° | 10 | 1.860 | 3000 |

| Spare parts | |
|-------------|--------------|
| DC | Insert screw |
| 15.00-18.00 | 5513 020-27 |
| 18.01-22.00 | 5513 020-88 |
| 22.01-27.00 | 5513 020-58 |
| 27.01-33.00 | 5513 020-57 |
| 33.01-40.00 | 416.1-833 |
| 40.01-65.00 | 416.1-834 |

For complete list of spare parts, see www.sandvik.coromant.com



J33



N23

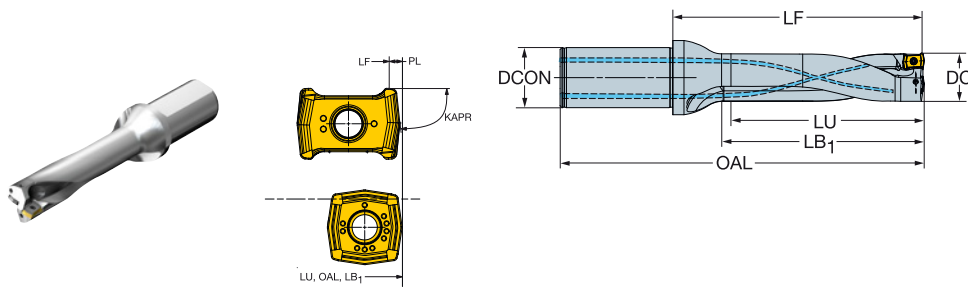


N15

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



| | | | | | | | Dimensions, mm | | | | | | | | | | |
|-------|-----|-----|--------|-------------------|-------|-------|----------------|------------------|--------------------|--------|--------|-----------------|------|------|-----|-------|-------|
| DC | | | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | RPMX |
| 37.00 | 05C | 05P | 148.00 | 40 | 1.44 | 0.00 | 0.35 | DS20-D3700L40-04 | 40.00 | 181.28 | 252.00 | 152.00 | 1.00 | 81° | 10 | 1.492 | 10000 |
| | | | 185.00 | 40 | 1.44 | 0.00 | 0.35 | DS20-D3700L40-05 | 40.00 | 218.28 | 289.00 | 189.00 | 1.00 | 81° | 10 | 1.643 | 6000 |
| | | | 222.00 | 40 | 1.44 | -0.10 | 0.40 | DS20-D3700L40-06 | 40.00 | 255.28 | 326.00 | 226.00 | 1.00 | 81° | 10 | 1.794 | 4000 |
| | | | 259.00 | 40 | 1.44 | -0.10 | 0.40 | DS20-D3700L40-07 | 40.00 | 292.28 | 363.00 | 263.00 | 1.00 | 81° | 10 | 1.945 | 3000 |
| 38.00 | 05C | 05P | 152.00 | 40 | 1.20 | 0.00 | 0.35 | DS20-D3800L40-04 | 40.00 | 185.28 | 256.00 | 156.00 | 1.00 | 81° | 10 | 1.543 | 9000 |
| | | | 190.00 | 40 | 1.20 | 0.00 | 0.35 | DS20-D3800L40-05 | 40.00 | 223.28 | 294.00 | 194.00 | 1.00 | 81° | 10 | 1.707 | 6000 |
| | | | 228.00 | 40 | 1.20 | -0.10 | 0.40 | DS20-D3800L40-06 | 40.00 | 261.28 | 332.00 | 232.00 | 1.00 | 81° | 10 | 1.870 | 4000 |
| | | | 266.00 | 40 | 1.20 | -0.10 | 0.40 | DS20-D3800L40-07 | 40.00 | 299.28 | 370.00 | 270.00 | 1.00 | 81° | 10 | 2.390 | 3000 |
| 39.00 | 05C | 05P | 156.00 | 40 | 0.96 | 0.00 | 0.35 | DS20-D3900L40-04 | 40.00 | 189.28 | 260.00 | 160.00 | 1.00 | 81° | 10 | 1.597 | 9000 |
| | | | 195.00 | 40 | 0.96 | 0.00 | 0.35 | DS20-D3900L40-05 | 40.00 | 228.28 | 299.00 | 199.00 | 1.00 | 81° | 10 | 1.774 | 6000 |
| | | | 234.00 | 40 | 0.96 | -0.10 | 0.40 | DS20-D3900L40-06 | 40.00 | 267.28 | 338.00 | 238.00 | 1.00 | 81° | 10 | 1.950 | 4000 |
| | | | 273.00 | 40 | 0.96 | -0.10 | 0.40 | DS20-D3900L40-07 | 40.00 | 306.28 | 377.00 | 277.00 | 1.00 | 81° | 10 | 2.127 | 3000 |
| 40.00 | 05C | 05P | 160.00 | 40 | 0.72 | 0.00 | 0.35 | DS20-D4000L40-04 | 40.00 | 193.28 | 264.00 | 164.00 | 1.00 | 81° | 10 | 1.654 | 9000 |
| | | | 200.00 | 40 | 0.72 | 0.00 | 0.35 | DS20-D4000L40-05 | 40.00 | 233.28 | 304.00 | 204.00 | 1.00 | 81° | 10 | 1.844 | 6000 |
| | | | 240.00 | 40 | 0.72 | -0.10 | 0.40 | DS20-D4000L40-06 | 40.00 | 273.28 | 344.00 | 244.00 | 1.00 | 81° | 10 | 2.035 | 4000 |
| | | | 280.00 | 40 | 0.72 | -0.10 | 0.40 | DS20-D4000L40-07 | 40.00 | 313.28 | 384.00 | 284.00 | 1.00 | 81° | 10 | 2.226 | 3000 |

| | Spare parts |
|-------------|--------------|
| DC | Insert screw |
| 15.00-18.00 | 5513 020-27 |
| 18.01-22.00 | 5513 020-88 |
| 22.01-27.00 | 5513 020-58 |
| 27.01-33.00 | 5513 020-57 |
| 33.01-40.00 | 416.1-833 |
| 40.01-65.00 | 416.1-834 |

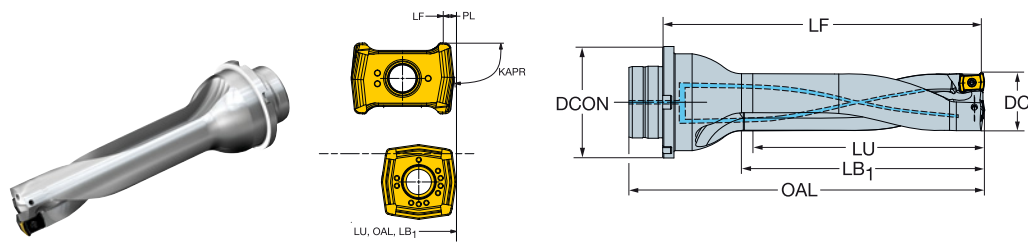
For complete list of spare parts, see www.sandvik.coromant.com



CoroDrill® DS20 indexable insert drill

Modular drill interface

Internal coolant supply



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-----|-----|--------|-------------------|-------|-------|-------|-------------------|--|--------------------|--------|--------|-----------------|------|------|-----|-------|-------|--|
| DC | | | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | RPMX | |
| 15.00 | 01C | 01P | 60.00 | MDI-20 | 1.00 | 0.00 | 0.27 | DS20-D1500DM20-04 | | 20.00 | 88.69 | 104.00 | 63.00 | 0.46 | 81° | 10 | 0.191 | 24000 | |
| | | | 105.00 | MDI-20 | 1.00 | -0.10 | 0.40 | DS20-D1500DM20-07 | | 20.00 | 133.69 | 149.00 | 108.00 | 0.46 | 81° | 10 | 0.204 | 8000 | |
| 16.00 | 01C | 01P | 64.00 | MDI-20 | 0.75 | 0.00 | 0.27 | DS20-D1600DM20-04 | | 20.00 | 92.69 | 108.00 | 67.00 | 0.46 | 81° | 10 | 0.199 | 22000 | |
| | | | 112.00 | MDI-20 | 0.75 | -0.10 | 0.40 | DS20-D1600DM20-07 | | 20.00 | 140.69 | 156.00 | 115.00 | 0.46 | 81° | 10 | 0.219 | 7000 | |
| 17.00 | 01C | 01P | 68.00 | MDI-20 | 0.50 | 0.00 | 0.27 | DS20-D1700DM20-04 | | 20.00 | 96.69 | 112.00 | 71.00 | 0.46 | 81° | 10 | 0.211 | 21000 | |
| | | | 119.00 | MDI-20 | 0.50 | -0.10 | 0.40 | DS20-D1700DM20-07 | | 20.00 | 147.69 | 163.00 | 122.00 | 0.46 | 81° | 10 | 0.236 | 7000 | |
| 18.00 | 01C | 01P | 72.00 | MDI-25 | 0.25 | 0.00 | 0.27 | DS20-D1800DM25-04 | | 25.00 | 104.69 | 120.00 | 75.00 | 0.46 | 81° | 10 | 0.317 | 20000 | |
| | | | 126.00 | MDI-25 | 0.25 | -0.10 | 0.40 | DS20-D1800DM25-07 | | 25.00 | 158.69 | 174.00 | 129.00 | 0.46 | 81° | 10 | 0.353 | 6000 | |
| 19.00 | 02C | 02P | 76.00 | MDI-25 | 1.06 | 0.00 | 0.33 | DS20-D1900DM25-04 | | 25.00 | 108.62 | 124.00 | 79.00 | 0.55 | 81° | 10 | 0.313 | 19000 | |
| | | | 133.00 | MDI-25 | 1.06 | -0.10 | 0.40 | DS20-D1900DM25-07 | | 25.00 | 165.62 | 181.00 | 136.00 | 0.55 | 81° | 10 | 0.389 | 6000 | |
| 20.00 | 02C | 02P | 80.00 | MDI-25 | 0.82 | 0.00 | 0.33 | DS20-D2000DM25-04 | | 25.00 | 112.62 | 128.00 | 83.00 | 0.55 | 81° | 10 | 0.340 | 18000 | |
| | | | 140.00 | MDI-25 | 0.82 | -0.10 | 0.40 | DS20-D2000DM25-07 | | 25.00 | 172.62 | 188.00 | 143.00 | 0.55 | 81° | 10 | 0.400 | 6000 | |
| 21.00 | 02C | 02P | 84.00 | MDI-25 | 0.58 | 0.00 | 0.33 | DS20-D2100DM25-04 | | 25.00 | 116.62 | 132.00 | 87.00 | 0.55 | 81° | 10 | 0.342 | 17000 | |
| | | | 147.00 | MDI-25 | 0.58 | -0.10 | 0.40 | DS20-D2100DM25-07 | | 25.00 | 179.62 | 195.00 | 150.00 | 0.55 | 81° | 10 | 0.425 | 5000 | |
| 22.00 | 02C | 02P | 88.00 | MDI-25 | 0.34 | 0.00 | 0.33 | DS20-D2200DM25-04 | | 25.00 | 120.62 | 136.00 | 91.00 | 0.55 | 81° | 10 | 0.381 | 16000 | |
| | | | 154.00 | MDI-25 | 0.34 | -0.10 | 0.40 | DS20-D2200DM25-07 | | 25.00 | 186.62 | 202.00 | 157.00 | 0.55 | 81° | 10 | 0.500 | 5000 | |
| 23.00 | 03C | 03P | 92.00 | MDI-25 | 1.30 | 0.00 | 0.33 | DS20-D2300DM25-04 | | 25.00 | 125.53 | 141.00 | 96.00 | 0.66 | 81° | 10 | 0.379 | 15000 | |
| | | | 161.00 | MDI-25 | 1.30 | -0.10 | 0.40 | DS20-D2300DM25-07 | | 25.00 | 194.53 | 210.00 | 165.00 | 0.66 | 81° | 10 | 0.488 | 5000 | |
| 24.00 | 03C | 03P | 96.00 | MDI-25 | 1.10 | 0.00 | 0.33 | DS20-D2400DM25-04 | | 25.00 | 129.53 | 145.00 | 100.00 | 0.66 | 81° | 10 | 0.400 | 15000 | |
| | | | 168.00 | MDI-25 | 1.10 | -0.10 | 0.40 | DS20-D2400DM25-07 | | 25.00 | 201.53 | 217.00 | 172.00 | 0.66 | 81° | 10 | 0.600 | 5000 | |
| 25.00 | 03C | 03P | 100.00 | MDI-25 | 0.90 | 0.00 | 0.33 | DS20-D2500DM25-04 | | 25.00 | 133.53 | 149.00 | 104.00 | 0.66 | 81° | 10 | 0.446 | 14000 | |
| | | | 175.00 | MDI-25 | 0.90 | -0.10 | 0.40 | DS20-D2500DM25-07 | | 25.00 | 208.53 | 224.00 | 179.00 | 0.66 | 81° | 10 | 0.600 | 4000 | |
| 26.00 | 03C | 03P | 104.00 | MDI-32 | 0.70 | 0.00 | 0.33 | DS20-D2600DM32-04 | | 32.00 | 142.53 | 158.00 | 108.00 | 0.66 | 81° | 10 | 0.700 | 14000 | |
| | | | 182.00 | MDI-32 | 0.70 | -0.10 | 0.40 | DS20-D2600DM32-07 | | 32.00 | 220.53 | 236.00 | 186.00 | 0.66 | 81° | 10 | 0.808 | 4000 | |
| 27.00 | 03C | 03P | 108.00 | MDI-32 | 0.50 | 0.00 | 0.33 | DS20-D2700DM32-04 | | 32.00 | 146.53 | 162.00 | 112.00 | 0.66 | 81° | 10 | 0.700 | 13000 | |
| | | | 189.00 | MDI-32 | 0.50 | -0.10 | 0.40 | DS20-D2700DM32-07 | | 32.00 | 227.53 | 243.00 | 193.00 | 0.66 | 81° | 10 | 0.853 | 4000 | |
| 28.00 | 04C | 04P | 112.00 | MDI-32 | 2.12 | 0.00 | 0.33 | DS20-D2800DM32-04 | | 32.00 | 150.16 | 166.00 | 116.00 | 0.83 | 81° | 10 | 0.705 | 13000 | |
| | | | 196.00 | MDI-32 | 2.12 | -0.10 | 0.40 | DS20-D2800DM32-07 | | 32.00 | 234.16 | 250.00 | 200.00 | 0.83 | 81° | 10 | 0.901 | 4000 | |
| 29.00 | 04C | 04P | 116.00 | MDI-32 | 1.84 | 0.00 | 0.33 | DS20-D2900DM32-04 | | 32.00 | 154.16 | 170.00 | 120.00 | 0.83 | 81° | 10 | 0.734 | 12000 | |
| | | | 203.00 | MDI-32 | 1.84 | -0.10 | 0.40 | DS20-D2900DM32-07 | | 32.00 | 241.16 | 257.00 | 207.00 | 0.83 | 81° | 10 | 0.952 | 4000 | |
| 30.00 | 04C | 04P | 120.00 | MDI-32 | 1.56 | 0.00 | 0.33 | DS20-D3000DM32-04 | | 32.00 | 158.16 | 174.00 | 124.00 | 0.83 | 81° | 10 | 0.766 | 12000 | |
| | | | 210.00 | MDI-32 | 1.56 | -0.10 | 0.40 | DS20-D3000DM32-07 | | 32.00 | 248.16 | 264.00 | 214.00 | 0.83 | 81° | 10 | 1.008 | 4000 | |
| 31.00 | 04C | 04P | 124.00 | MDI-32 | 1.28 | 0.00 | 0.35 | DS20-D3100DM32-04 | | 32.00 | 164.16 | 180.00 | 128.00 | 0.83 | 81° | 10 | 0.818 | 12000 | |
| | | | 217.00 | MDI-32 | 1.28 | -0.10 | 0.40 | DS20-D3100DM32-07 | | 32.00 | 256.16 | 272.00 | 221.00 | 0.83 | 81° | 10 | 1.075 | 4000 | |
| 32.00 | 04C | 04P | 128.00 | MDI-40 | 1.00 | 0.00 | 0.35 | DS20-D3200DM40-04 | | 40.00 | 175.16 | 191.00 | 132.00 | 0.83 | 81° | 10 | 1.260 | 11000 | |
| | | | 224.00 | MDI-40 | 1.00 | -0.10 | 0.40 | DS20-D3200DM40-07 | | 40.00 | 271.16 | 287.00 | 228.00 | 0.83 | 81° | 10 | 1.553 | 3000 | |
| 33.00 | 04C | 04P | 132.00 | MDI-40 | 0.72 | 0.00 | 0.35 | DS20-D3300DM40-04 | | 40.00 | 179.16 | 195.00 | 136.00 | 0.83 | 81° | 10 | 1.299 | 11000 | |
| | | | 231.00 | MDI-40 | 0.72 | -0.10 | 0.40 | DS20-D3300DM40-07 | | 40.00 | 278.16 | 294.00 | 235.00 | 0.83 | 81° | 10 | 1.620 | 3000 | |

| Spare parts | |
|-------------|--------------|
| DC | Insert screw |
| 15.00-18.00 | 5513 020-27 |
| 18.01-22.00 | 5513 020-88 |
| 22.01-27.00 | 5513 020-58 |
| 27.01-33.00 | 5513 020-57 |
| 33.01-40.00 | 416.1-833 |
| 40.01-59.00 | 416.1-834 |

For complete list of spare parts, see www.sandvik.coromant.com



J33



N23

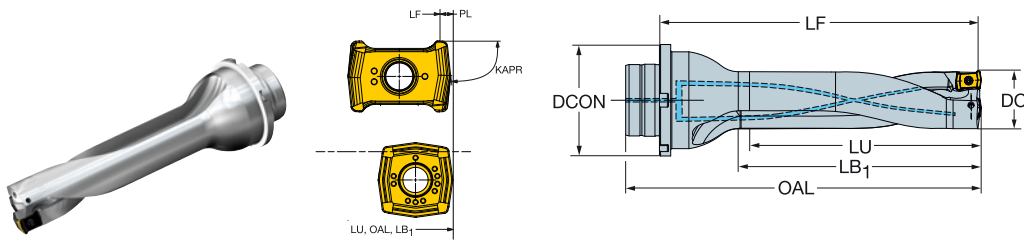


N15



CoroDrill® DS20 indexable insert drill

Modular drill interface
Internal coolant supply



| DC | | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, mm | | | | | | | BAR | KG | RPMX |
|-------|-----|-----|-------------------|--------|-------|-------|---------------|--------------------|-------|--------|-----------------|--------|------|-----|-----|-------|-------|
| DC | PL | LU | | | | | | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | | | | |
| 34.00 | 05P | 05P | 136.00 | MDI-40 | 2.16 | 0.00 | 0.35 | DS20-D3400DM40-04 | 40.00 | 183.28 | 199.00 | 140.00 | 1.00 | 81° | 10 | 1.340 | 11000 |
| | | | 238.00 | MDI-40 | 2.16 | -0.10 | 0.40 | DS20-D3400DM40-07 | 40.00 | 285.28 | 301.00 | 242.00 | 1.00 | 81° | 10 | 1.691 | 3000 |
| 35.00 | 05C | 05C | 140.00 | MDI-40 | 1.92 | 0.00 | 0.35 | DS20-D3500DM40-04 | 40.00 | 187.28 | 203.00 | 144.00 | 1.00 | 81° | 10 | 1.383 | 10000 |
| | | | 245.00 | MDI-40 | 1.92 | -0.10 | 0.40 | DS20-D3500DM40-07 | 40.00 | 292.28 | 308.00 | 249.00 | 1.00 | 81° | 10 | 1.766 | 3000 |
| 36.00 | 05C | 05C | 144.00 | MDI-40 | 1.68 | 0.00 | 0.35 | DS20-D3600DM40-04 | 40.00 | 191.28 | 207.00 | 148.00 | 1.00 | 81° | 10 | 1.429 | 10000 |
| | | | 252.00 | MDI-40 | 1.68 | -0.10 | 0.40 | DS20-D3600DM40-07 | 40.00 | 299.28 | 315.00 | 256.00 | 1.00 | 81° | 10 | 1.846 | 3000 |
| 37.00 | 05P | 05P | 148.00 | MDI-40 | 1.44 | 0.00 | 0.35 | DS20-D3700DM40-04 | 40.00 | 195.28 | 211.00 | 152.00 | 1.00 | 81° | 10 | 1.477 | 10000 |
| | | | 259.00 | MDI-40 | 1.44 | -0.10 | 0.40 | DS20-D3700DM40-07 | 40.00 | 306.28 | 322.00 | 263.00 | 1.00 | 81° | 10 | 1.930 | 3000 |
| 38.00 | 05P | 05P | 152.00 | MDI-40 | 1.20 | 0.00 | 0.35 | DS20-D3800DM40-04 | 40.00 | 199.28 | 215.00 | 156.00 | 1.00 | 81° | 10 | 1.529 | 9000 |
| | | | 266.00 | MDI-40 | 1.20 | -0.10 | 0.40 | DS20-D3800DM40-07 | 40.00 | 313.28 | 329.00 | 270.00 | 1.00 | 81° | 10 | 2.019 | 3000 |
| 39.00 | 05C | 05C | 156.00 | MDI-40 | 0.96 | 0.00 | 0.35 | DS20-D3900DM40-04 | 40.00 | 203.28 | 219.00 | 160.00 | 1.00 | 81° | 10 | 1.582 | 9000 |
| | | | 273.00 | MDI-40 | 0.96 | -0.10 | 0.40 | DS20-D3900DM40-07 | 40.00 | 320.28 | 336.00 | 277.00 | 1.00 | 81° | 10 | 2.113 | 3000 |
| 40.00 | 05C | 05P | 160.00 | MDI-40 | 0.72 | 0.00 | 0.35 | DS20-D4000DM40-04 | 40.00 | 206.28 | 222.00 | 164.00 | 1.00 | 81° | 10 | 1.624 | 9000 |
| | | | 280.00 | MDI-40 | 0.72 | -0.10 | 0.40 | DS20-D4000DM40-07 | 40.00 | 326.28 | 342.00 | 284.00 | 1.00 | 81° | 10 | 2.196 | 3000 |

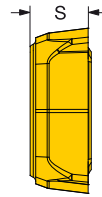
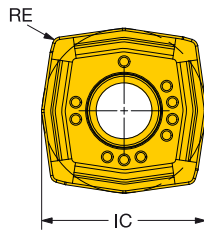
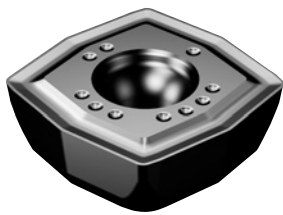
| Spare parts | |
|-------------|--------------|
| DC | Insert screw |
| 15.00-18.00 | 5513 020-27 |
| 18.01-22.00 | 5513 020-88 |
| 22.01-27.00 | 5513 020-58 |
| 27.01-33.00 | 5513 020-57 |
| 33.01-40.00 | 416.1-833 |
| 40.01-59.00 | 416.1-834 |

For complete list of spare parts, see www.sandvik.coromant.com



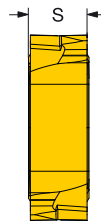
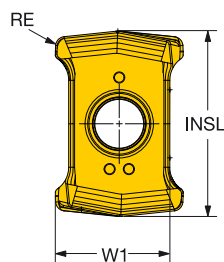
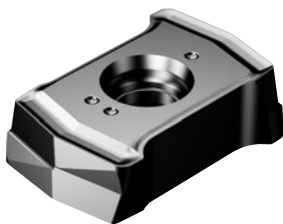
CoroDrill® DS20 insert for drilling

Central insert



| INSUC | Ordering code | P | M | K | N | S | H | Dimensions, mm | | | |
|-------|---------------|----------------|------|------|------|------|------|----------------|------|------|------|
| | | 1344 | 1144 | 1344 | HT3A | 1344 | HT3A | 1344 | S | RE | IC |
| 01C | C | DS20-0104-C-L5 | ★ | ★ | ★ | ☆ | ★ | ★ | 2.30 | 0.35 | 6.0 |
| 01C | C | DS20-0104-C-M7 | ★ | ★ | ★ | ☆ | ★ | ★ | 2.30 | 0.35 | 6.0 |
| 02C | C | DS20-0205-C-L5 | ★ | ★ | ★ | ☆ | ★ | ★ | 2.60 | 0.35 | 7.3 |
| 02C | C | DS20-0205-C-M7 | ★ | ★ | ★ | ☆ | ★ | ★ | 2.60 | 0.35 | 7.3 |
| 03C | C | DS20-0306-C-L5 | ★ | ★ | ★ | ☆ | ★ | ★ | 3.00 | 0.35 | 8.9 |
| 03C | C | DS20-0306-C-M7 | ★ | ★ | ★ | ☆ | ★ | ★ | 3.00 | 0.35 | 8.9 |
| 04C | C | DS20-0407-C-L5 | ★ | ★ | ★ | ☆ | ★ | ★ | 3.20 | 0.35 | 11.1 |
| 04C | C | DS20-0407-C-M7 | ★ | ★ | ★ | ☆ | ★ | ★ | 3.20 | 0.35 | 11.1 |
| 05C | C | DS20-0508-C-L5 | ★ | ★ | ★ | ☆ | ★ | ★ | 3.50 | 0.35 | 13.4 |
| 05C | C | DS20-0508-C-M7 | ★ | ★ | ★ | ☆ | ★ | ★ | 3.50 | 0.35 | 13.4 |

Peripheral insert



| INSUC | Ordering code | P | M | K | N | S | H | Dimensions, mm | | | | | | | | |
|-------|---------------|-----------------|------|------|------|------|------|----------------|------|------|------|------|------|------|------|------|
| | | 4324 | 4334 | 4334 | 2044 | 4334 | 4344 | HT3A | 2044 | 4344 | HT3A | 4334 | 4344 | S | RE | W1 |
| 01P | P | DS20-0104-P-H5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.73 | 0.40 | 5.0 |
| 01P | P | DS20-0104-P-L5W | ☆ | ★ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.73 | 0.40 | 5.0 |
| 01P | P | DS20-0104-P-L6W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | 2.73 | 0.40 | 5.0 |
| 01P | P | DS20-0104-P-M7W | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | 2.73 | 0.40 | 5.0 |
| 01P | P | DS20-0104-P-S5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.73 | 0.40 | 5.0 |
| 02P | P | DS20-0205-P-H5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.10 | 0.50 | 6.1 |
| 02P | P | DS20-0205-P-L5W | ☆ | ★ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.10 | 0.50 | 6.1 |
| 02P | P | DS20-0205-P-L6W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ★ | 3.10 | 0.50 | 6.1 |
| 02P | P | DS20-0205-P-M7W | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.10 | 0.50 | 6.1 |
| 02P | P | DS20-0205-P-S5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.10 | 0.50 | 6.1 |
| 03P | P | DS20-0306-P-H5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.53 | 0.60 | 7.3 |
| 03P | P | DS20-0306-P-L5W | ☆ | ★ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.53 | 0.60 | 7.3 |
| 03P | P | DS20-0306-P-L6W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ★ | 3.53 | 0.60 | 7.3 |
| 03P | P | DS20-0306-P-M7W | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.53 | 0.60 | 7.3 |
| 03P | P | DS20-0306-P-S5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.53 | 0.60 | 7.3 |
| 04P | P | DS20-0407-P-H5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.25 | 0.70 | 9.2 |
| 04P | P | DS20-0407-P-L5W | ☆ | ★ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.25 | 0.70 | 9.2 |
| 04P | P | DS20-0407-P-L6W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ★ | 4.25 | 0.70 | 9.2 |
| 04P | P | DS20-0407-P-M7W | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.25 | 0.70 | 9.2 |
| 04P | P | DS20-0407-P-S5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | 4.25 | 0.70 | 9.2 |
| 05P | P | DS20-0508-P-H5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.75 | 0.80 | 11.2 |
| 05P | P | DS20-0508-P-L5W | ☆ | ★ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.75 | 0.80 | 11.2 |
| 05P | P | DS20-0508-P-L6W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ★ | 4.75 | 0.80 | 11.2 |
| 05P | P | DS20-0508-P-M7W | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.75 | 0.80 | 11.2 |
| 05P | P | DS20-0508-P-S5W | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.75 | 0.80 | 11.2 |



J28



J54



N23

CoroDrill® 880

Indexable insert drills

J ISO application area



Benefits and features for hole diameters 12.00–63.50 mm

- Up to 100% higher productivity
- Close hole tolerance and improved surface finish
- Four true cutting edges with Wiper technology
- Strong drill body with central and peripheral inserts features unique Step Technology™ for a perfect cutting force balance
- Excellent chip evacuation



Benefits and features for hole diameters 65.00–84.00 mm

- Secure and reliable drilling due to a robust drill body with a rigid cartridge interface
- Excellent chip control and evacuation
- Excellent flexibility – one drill body covers five diameter dimensions due to replaceable fixed cartridge system
- User-friendly economical solution with exchangeable cartridges and indexable inserts



www.sandvik.coromant.com/corodril880

M Drill bodies

- Couplings:
- Coromant Capto®
 - Cylindrical shank
 - VL coupling

Inserts

- Inserts with optimized geometries for all materials

2 – 3 x DC

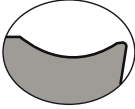

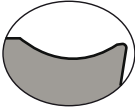
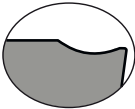
| | | | |
|--------------------|-------------|-------------|-------------|
| Diameter range, mm | 12.00-43.99 | 44.00-52.99 | 53.00-63.50 |
| Hole tolerance, mm | 0/+0.25 | 0/+0.28 | 0/+0.30 |

N



CoroDrill® 880

Geometry overview

| Geometry | Geometry information |
|----------|---|
| LM |  <ul style="list-style-type: none"> - First choice in low carbon steel - A versatile geometry with an all-around chip breaker - Operates best at low to medium feeds - Provides low cutting forces |
| GR |  <ul style="list-style-type: none"> - First choice in alloyed steel and cast irons - Operates best at medium to high feeds |
| MS |  <ul style="list-style-type: none"> - First choice in stainless and non-ferrous materials - Sharp edge allowing low cutting forces |
| GM |  <ul style="list-style-type: none"> - Low cutting forces - Low to medium feed |

Grade overview

4334

- First choice in normal conditions in ISO P and K
- Complementary choice in stable ISO M applications

4324

- Wear-resistant choice for ISO P and K

4344

- Secure grade that works in all types of materials

2044

- First choice in ISO M
- Complementary choice in ISO S

N124

- Diamond-coating
- First choice in ISO N

H13A

- Uncoated grade

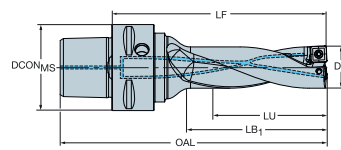
CoroDrill® 880 indexable insert drill

Coromant Capto®

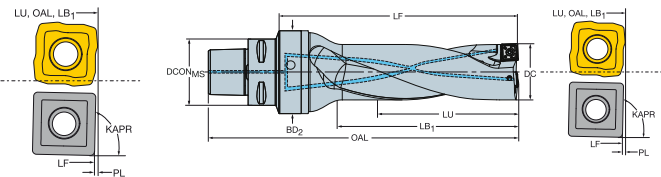


DSGN

1



2



| DC | CZC _{MS} | ADJLX | TCHAL | TCHAU | DSGN | Dimensions, mm | | | | | | | | | | | | |
|-------|-------------------|-------|-------|-------|------|----------------|------|-----|-----------------|-----------------|--------|--------|-------|------|------|----|-------|-------|
| | | | | | | DC | LU | OAL | LB ₁ | BD ₂ | PL | KAPR | BAR | KG | RPMX | | | |
| 12.00 | 01C | 01P | 36.00 | C4 | 0.25 | 0.00 | 0.25 | 1 | 880-D1200C4-03 | 40.00 | 70.61 | 95.00 | 39.00 | 0.38 | 79° | 10 | 0.343 | 33000 |
| 12.50 | 01C | 01P | 38.00 | C4 | 0.25 | 0.00 | 0.25 | 1 | 880-D1250C4-03 | 40.00 | 72.61 | 97.00 | 40.00 | 0.38 | 79° | 10 | 0.320 | 33000 |
| 12.70 | 01C | 01P | 38.00 | C4 | 0.25 | 0.00 | 0.25 | 1 | 880-D1270C4-03 | 40.00 | 73.61 | 98.00 | 41.00 | 0.38 | 79° | 10 | 0.352 | 33000 |
| | | | 38.00 | C5 | 0.25 | 0.00 | 0.25 | 1 | 880-D1270C5-03 | 50.00 | 73.61 | 104.00 | 41.00 | 0.38 | 79° | 10 | 0.570 | 33000 |
| | | | 38.00 | C6 | 0.25 | 0.00 | 0.25 | 1 | 880-D1270C6-03 | 63.00 | 75.61 | 114.00 | 41.00 | 0.38 | 79° | 10 | 0.900 | 33000 |
| 13.00 | 01C | 01P | 39.00 | C4 | 0.25 | 0.00 | 0.25 | 1 | 880-D1300C4-03 | 40.00 | 74.61 | 99.00 | 42.00 | 0.38 | 79° | 10 | 0.345 | 33000 |
| | | | 39.00 | C5 | 0.25 | 0.00 | 0.25 | 1 | 880-D1300C5-03 | 50.00 | 74.61 | 105.00 | 42.00 | 0.38 | 79° | 10 | 0.570 | 33000 |
| 13.50 | 01C | 01P | 41.00 | C4 | 0.25 | 0.00 | 0.25 | 1 | 880-D1350C4-03 | 40.00 | 76.61 | 101.00 | 44.00 | 0.38 | 79° | 10 | 0.355 | 33000 |
| | | | 41.00 | C6 | 0.25 | 0.00 | 0.25 | 1 | 880-D1350C6-03 | 63.00 | 78.61 | 117.00 | 44.00 | 0.38 | 79° | 10 | 0.900 | 33000 |
| 14.00 | 02C | 02P | 42.00 | C4 | 0.50 | 0.00 | 0.25 | 1 | 880-D1400C4-03 | 40.00 | 77.67 | 102.00 | 45.00 | 0.32 | 88° | 10 | 0.351 | 33000 |
| | | | 42.00 | C5 | 0.50 | 0.00 | 0.25 | 1 | 880-D1400C5-03 | 50.00 | 77.67 | 108.00 | 45.00 | 0.32 | 88° | 10 | 0.572 | 33000 |
| | | | 42.00 | C6 | 0.50 | 0.00 | 0.25 | 1 | 880-D1400C6-03 | 63.00 | 79.67 | 118.00 | 45.00 | 0.32 | 88° | 10 | 0.900 | 33000 |
| 14.50 | 02C | 02P | 44.00 | C4 | 0.45 | 0.00 | 0.25 | 1 | 880-D1450C4-03 | 40.00 | 79.67 | 104.00 | 46.00 | 0.32 | 88° | 10 | 0.356 | 33000 |
| 15.00 | 02C | 02P | 45.00 | C4 | 0.40 | 0.00 | 0.25 | 1 | 880-D1500C4-03 | 40.00 | 81.67 | 106.00 | 48.00 | 0.32 | 88° | 10 | 0.358 | 33000 |
| | | | 45.00 | C5 | 0.40 | 0.00 | 0.25 | 1 | 880-D1500C5-03 | 50.00 | 81.67 | 112.00 | 48.00 | 0.32 | 88° | 10 | 0.579 | 33000 |
| | | | 45.00 | C6 | 0.40 | 0.00 | 0.25 | 1 | 880-D1500C6-03 | 63.00 | 83.67 | 122.00 | 48.00 | 0.32 | 88° | 10 | 0.900 | 33000 |
| 15.50 | 02C | 02P | 47.00 | C4 | 0.30 | 0.00 | 0.25 | 1 | 880-D1550C4-03 | 40.00 | 83.66 | 108.00 | 50.00 | 0.33 | 88° | 10 | 0.363 | 33000 |
| | | | 47.00 | C5 | 0.30 | 0.00 | 0.25 | 1 | 880-D1550C5-03 | 50.00 | 83.66 | 114.00 | 50.00 | 0.33 | 88° | 10 | 0.584 | 33000 |
| | | | 47.00 | C6 | 0.30 | 0.00 | 0.25 | 1 | 880-D1550C6-03 | 63.00 | 85.66 | 124.00 | 50.00 | 0.33 | 88° | 10 | 0.900 | 33000 |
| 16.00 | 02C | 02P | 48.00 | C4 | 0.30 | 0.00 | 0.25 | 1 | 880-D1600C4-03 | 40.00 | 85.66 | 110.00 | 51.00 | 0.33 | 88° | 10 | 0.369 | 33000 |
| | | | 48.00 | C5 | 0.30 | 0.00 | 0.25 | 1 | 880-D1600C5-03 | 50.00 | 85.66 | 116.00 | 51.00 | 0.33 | 88° | 10 | 0.590 | 33000 |
| | | | 48.00 | C6 | 0.30 | 0.00 | 0.25 | 1 | 880-D1600C6-03 | 63.00 | 87.66 | 126.00 | 51.00 | 0.33 | 88° | 10 | 0.909 | 33000 |
| 16.50 | 03C | 03P | 50.00 | C4 | 0.60 | 0.00 | 0.25 | 1 | 880-D1650C4-03 | 40.00 | 87.63 | 112.00 | 53.00 | 0.36 | 88° | 10 | 0.377 | 30000 |
| | | | 50.00 | C5 | 0.60 | 0.00 | 0.25 | 1 | 880-D1650C5-03 | 50.00 | 87.63 | 118.00 | 53.00 | 0.36 | 88° | 10 | 0.596 | 30000 |
| 17.00 | 03C | 03P | 51.00 | C4 | 0.60 | 0.00 | 0.25 | 1 | 880-D1700C4-03 | 40.00 | 88.63 | 113.00 | 54.00 | 0.36 | 88° | 10 | 0.379 | 30000 |
| | | | 51.00 | C5 | 0.60 | 0.00 | 0.25 | 1 | 880-D1700C5-03 | 50.00 | 88.63 | 119.00 | 54.00 | 0.36 | 88° | 10 | 0.601 | 30000 |
| | | | 51.00 | C6 | 0.60 | 0.00 | 0.25 | 1 | 880-D1700C6-03 | 63.00 | 90.63 | 129.00 | 54.00 | 0.36 | 88° | 10 | 0.919 | 30000 |
| 17.50 | 03C | 03P | 53.00 | C4 | 0.50 | 0.00 | 0.25 | 1 | 880-D1750C4-03 | 40.00 | 91.62 | 116.00 | 56.00 | 0.37 | 88° | 10 | 0.411 | 30000 |
| | | | 53.00 | C5 | 0.50 | 0.00 | 0.25 | 1 | 880-D1750C5-03 | 50.00 | 91.62 | 122.00 | 56.00 | 0.37 | 88° | 10 | 0.638 | 30000 |
| | | | 53.00 | C6 | 0.50 | 0.00 | 0.25 | 1 | 880-D1750C6-03 | 63.00 | 93.62 | 132.00 | 56.00 | 0.37 | 88° | 10 | 0.976 | 30000 |
| 18.00 | 03C | 03P | 54.00 | C4 | 0.40 | 0.00 | 0.25 | 1 | 880-D1800C4-03 | 40.00 | 92.62 | 117.00 | 57.00 | 0.37 | 88° | 10 | 0.416 | 30000 |
| | | | 54.00 | C5 | 0.40 | 0.00 | 0.25 | 1 | 880-D1800C5-03 | 50.00 | 92.62 | 123.00 | 57.00 | 0.37 | 88° | 10 | 0.642 | 30000 |
| | | | 54.00 | C6 | 0.40 | 0.00 | 0.25 | 1 | 880-D1800C6-03 | 63.00 | 94.62 | 133.00 | 57.00 | 0.37 | 88° | 10 | 1.000 | 30000 |
| 18.50 | 03C | 03P | 56.00 | C4 | 0.40 | 0.00 | 0.25 | 1 | 880-D1850C4-03 | 40.00 | 94.62 | 119.00 | 59.00 | 0.37 | 88° | 10 | 0.419 | 30000 |
| | | | 56.00 | C5 | 0.40 | 0.00 | 0.25 | 1 | 880-D1850C5-03 | 50.00 | 94.62 | 125.00 | 59.00 | 0.37 | 88° | 10 | 0.646 | 30000 |
| 19.00 | 03C | 03P | 57.00 | C4 | 0.30 | 0.00 | 0.25 | 1 | 880-D1900C4-03 | 40.00 | 95.61 | 120.00 | 60.00 | 0.38 | 88° | 10 | 0.424 | 30000 |
| | | | 57.00 | C5 | 0.30 | 0.00 | 0.25 | 1 | 880-D1900C5-03 | 50.00 | 95.61 | 126.00 | 60.00 | 0.38 | 88° | 10 | 0.651 | 30000 |
| | | | 57.00 | C6 | 0.30 | 0.00 | 0.25 | 1 | 880-D1900C6-03 | 63.00 | 97.61 | 136.00 | 60.00 | 0.38 | 88° | 10 | 1.000 | 30000 |
| 19.50 | 03C | 03P | 59.00 | C4 | 0.30 | 0.00 | 0.25 | 1 | 880-D1950C4-03 | 40.00 | 98.61 | 123.00 | 62.00 | 0.38 | 88° | 10 | 0.436 | 30000 |
| | | | 59.00 | C5 | 0.30 | 0.00 | 0.25 | 1 | 880-D1950C5-03 | 50.00 | 98.61 | 129.00 | 62.00 | 0.38 | 88° | 10 | 0.658 | 30000 |
| 20.00 | 04C | 04P | 60.00 | C4 | 0.90 | 0.00 | 0.25 | 1 | 880-D2000C4-03 | 40.00 | 100.56 | 125.00 | 64.00 | 0.43 | 88° | 10 | 0.437 | 21500 |
| | | | 60.00 | C5 | 0.90 | 0.00 | 0.25 | 1 | 880-D2000C5-03 | 50.00 | 100.56 | 131.00 | 64.00 | 0.43 | 88° | 10 | 0.662 | 21500 |
| | | | 60.00 | C6 | 0.90 | 0.00 | 0.25 | 1 | 880-D2000C6-03 | 63.00 | 102.56 | 141.00 | 64.00 | 0.43 | 88° | 10 | 1.000 | 21500 |
| 21.00 | 04C | 04P | 63.00 | C4 | 0.80 | 0.00 | 0.25 | 1 | 880-D2100C4-03 | 40.00 | 103.56 | 128.00 | 66.00 | 0.43 | 88° | 10 | 0.400 | 21500 |
| | | | 63.00 | C5 | 0.80 | 0.00 | 0.25 | 1 | 880-D2100C5-03 | 50.00 | 103.56 | 134.00 | 66.00 | 0.43 | 88° | 10 | 0.673 | 21500 |
| | | | 63.00 | C6 | 0.80 | 0.00 | 0.25 | 1 | 880-D2100C6-03 | 63.00 | 105.56 | 144.00 | 66.00 | 0.43 | 88° | 10 | 1.012 | 21500 |
| 22.00 | 04C | 04P | 66.00 | C4 | 0.60 | 0.00 | 0.25 | 1 | 880-D2200C4-03 | 40.00 | 106.55 | 131.00 | 69.00 | 0.44 | 88° | 10 | 0.438 | 21500 |
| | | | 66.00 | C5 | 0.60 | 0.00 | 0.25 | 1 | 880-D2200C5-03 | 50.00 | 106.55 | 137.00 | 69.00 | 0.44 | 88° | 10 | 0.688 | 21500 |
| | | | 66.00 | C6 | 0.60 | 0.00 | 0.25 | 1 | 880-D2200C6-03 | 63.00 | 108.55 | 147.00 | 69.00 | 0.44 | 88° | 10 | 1.029 | 21500 |
| 23.00 | 04C | 04P | 69.00 | C4 | 0.50 | 0.00 | 0.25 | 1 | 880-D2300C4-03 | 40.00 | 110.54 | 135.00 | 72.00 | 0.45 | 88° | 10 | 0.480 | 21500 |
| | | | 69.00 | C5 | 0.50 | 0.00 | 0.25 | 1 | 880-D2300C5-03 | 50.00 | 110.54 | 141.00 | 72.00 | 0.45 | 88° | 10 | 0.711 | 21500 |
| | | | 69.00 | C6 | 0.50 | 0.00 | 0.25 | 1 | 880-D2300C6-03 | 63.00 | 112.54 | 151.00 | 72.00 | 0.45 | 88° | 10 | 1.048 | 21500 |
| 24.00 | 05C | 05P | 72.00 | C4 | 1.10 | 0.00 | 0.25 | 1 | 880-D2400C4-03 | 40.00 | 114.49 | 139.00 | 76.00 | 0.50 | 88° | 10 | 0.505 | 16000 |
| | | | 72.00 | C5 | 1.10 | 0.00 | 0.25 | 1 | 880-D2400C5-03 | 50.00 | 114.49 | 145.00 | 76.00 | 0.50 | 88° | 10 | 0.730 | 16000 |
| | | | 72.00 | C6 | 1.10 | 0.00 | 0.25 | 1 | 880-D2400C6-03 | 63.00 | 116.49 | 155.00 | 76.00 | 0.50 | 88° | 10 | 1.070 | 16000 |



J42



L2



J62



J35



N23



N6



N15

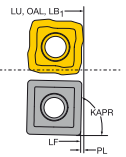
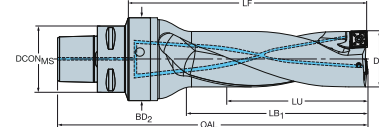
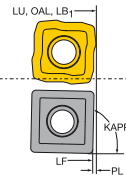
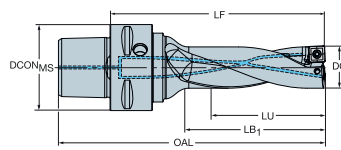
CoroDrill® 880 indexable insert drill

Coromant Capto®

DSGN

1

2



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-----|-----|--------|-------------------|-------|-------|-------|------|------------------|--------------------|--------|--------|-----------------|-----------------|------|------|-----|-------|-------|
| DC | 05C | 05P | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | DSGN | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | BD ₂ | PL | KAPR | BAR | KG | RPMX |
| 25.00 | 05C | 05P | 75.00 | C4 | 1.00 | 0.00 | 0.25 | 1 | 880-D2500C4-03 | 40.00 | 118.48 | 143.00 | 79.00 | | 0.51 | 88° | 10 | 0.526 | 16000 |
| | | | 75.00 | C5 | 1.00 | 0.00 | 0.25 | 1 | 880-D2500C5-03 | 50.00 | 118.48 | 149.00 | 79.00 | | 0.51 | 88° | 10 | 0.760 | 16000 |
| | | | 75.00 | C6 | 1.00 | 0.00 | 0.25 | 1 | 880-D2500C6-03 | 63.00 | 120.48 | 159.00 | 79.00 | | 0.51 | 88° | 10 | 1.099 | 16000 |
| 26.00 | 05C | 05P | 78.00 | C4 | 0.90 | 0.00 | 0.25 | 1 | 880-D2600C4-03 | 40.00 | 121.47 | 146.00 | 81.00 | | 0.52 | 88° | 10 | 0.596 | 16000 |
| | | | 78.00 | C5 | 0.90 | 0.00 | 0.25 | 1 | 880-D2600C5-03 | 50.00 | 121.47 | 152.00 | 81.00 | | 0.52 | 88° | 10 | 0.822 | 16000 |
| | | | 78.00 | C6 | 0.90 | 0.00 | 0.25 | 1 | 880-D2600C6-03 | 63.00 | 123.47 | 162.00 | 81.00 | | 0.52 | 88° | 10 | 1.165 | 16000 |
| 27.00 | 05C | 05P | 81.00 | C4 | 0.70 | 0.00 | 0.25 | 1 | 880-D2700C4-03 | 40.00 | 124.46 | 149.00 | 84.00 | | 0.53 | 88° | 10 | 0.623 | 16000 |
| | | | 81.00 | C5 | 0.70 | 0.00 | 0.25 | 1 | 880-D2700C5-03 | 50.00 | 124.46 | 155.00 | 84.00 | | 0.53 | 88° | 10 | 0.851 | 16000 |
| | | | 81.00 | C6 | 0.70 | 0.00 | 0.25 | 1 | 880-D2700C6-03 | 63.00 | 126.46 | 165.00 | 84.00 | | 0.53 | 88° | 10 | 1.188 | 16000 |
| 28.00 | 05C | 05P | 84.00 | C4 | 0.60 | 0.00 | 0.25 | 1 | 880-D2800C4-03 | 40.00 | 128.46 | 153.00 | 87.00 | | 0.53 | 88° | 10 | 0.665 | 16000 |
| | | | 84.00 | C5 | 0.60 | 0.00 | 0.25 | 1 | 880-D2800C5-03 | 50.00 | 128.46 | 159.00 | 87.00 | | 0.53 | 88° | 10 | 0.897 | 16000 |
| | | | 84.00 | C6 | 0.60 | 0.00 | 0.25 | 1 | 880-D2800C6-03 | 63.00 | 130.46 | 169.00 | 87.00 | | 0.53 | 88° | 10 | 1.229 | 16000 |
| 29.00 | 05C | 05P | 87.00 | C4 | 0.50 | 0.00 | 0.25 | 1 | 880-D2900C4-03 | 40.00 | 131.45 | 156.00 | 90.00 | | 0.54 | 88° | 10 | 0.696 | 16000 |
| | | | 87.00 | C5 | 0.50 | 0.00 | 0.25 | 1 | 880-D2900C5-03 | 50.00 | 131.45 | 162.00 | 90.00 | | 0.54 | 88° | 10 | 0.930 | 16000 |
| | | | 87.00 | C6 | 0.50 | 0.00 | 0.25 | 1 | 880-D2900C6-03 | 63.00 | 133.45 | 172.00 | 90.00 | | 0.54 | 88° | 10 | 1.264 | 16000 |
| 30.00 | 06C | 06P | 90.00 | C4 | 1.12 | 0.00 | 0.25 | 1 | 880-D3000C4-03 | 40.00 | 136.41 | 161.00 | 94.00 | | 0.58 | 88° | 10 | 0.679 | 16000 |
| | | | 90.00 | C5 | 1.12 | 0.00 | 0.25 | 1 | 880-D3000C5-03 | 50.00 | 136.41 | 167.00 | 94.00 | | 0.58 | 88° | 10 | 0.920 | 16000 |
| | | | 90.00 | C6 | 1.12 | 0.00 | 0.25 | 1 | 880-D3000C6-03 | 63.00 | 138.41 | 177.00 | 94.00 | | 0.58 | 88° | 10 | 1.220 | 16000 |
| 31.00 | 06C | 06P | 93.00 | C5 | 0.99 | 0.00 | 0.25 | 1 | 880-D3100C5-03 | 50.00 | 140.40 | 171.00 | 97.00 | | 0.59 | 88° | 10 | 0.998 | 16000 |
| | | | 93.00 | C6 | 0.99 | 0.00 | 0.25 | 1 | 880-D3100C6-03 | 63.00 | 142.40 | 181.00 | 97.00 | | 0.59 | 88° | 10 | 1.350 | 16000 |
| | | | 93.00 | C5 | 0.87 | 0.00 | 0.25 | 1 | 880-D3200C5-03 | 50.00 | 143.39 | 174.00 | 100.00 | | 0.60 | 88° | 10 | 1.020 | 16000 |
| 32.00 | 06C | 06P | 96.00 | C6 | 0.87 | 0.00 | 0.25 | 1 | 880-D3200C6-03 | 63.00 | 145.39 | 184.00 | 100.00 | | 0.60 | 88° | 10 | 1.360 | 16000 |
| | | | 99.00 | C5 | 0.75 | 0.00 | 0.25 | 1 | 880-D3300C5-03 | 50.00 | 147.38 | 178.00 | 103.00 | | 0.61 | 88° | 10 | 1.040 | 16000 |
| | | | 99.00 | C6 | 0.75 | 0.00 | 0.25 | 1 | 880-D3300C6-03 | 63.00 | 149.38 | 188.00 | 103.00 | | 0.61 | 88° | 10 | 1.429 | 16000 |
| 34.00 | 06C | 06P | 102.00 | C5 | 0.62 | 0.00 | 0.25 | 1 | 880-D3400C5-03 | 50.00 | 150.37 | 181.00 | 106.00 | | 0.62 | 88° | 10 | 1.060 | 16000 |
| | | | 102.00 | C6 | 0.62 | 0.00 | 0.25 | 1 | 880-D3400C6-03 | 63.00 | 152.37 | 191.00 | 106.00 | | 0.62 | 88° | 10 | 1.465 | 16000 |
| | | | 105.00 | C5 | 0.50 | 0.00 | 0.25 | 1 | 880-D3500C5-03 | 50.00 | 154.37 | 185.00 | 109.00 | | 0.62 | 88° | 10 | 1.160 | 16000 |
| 35.00 | 06C | 06P | 105.00 | C6 | 0.50 | 0.00 | 0.25 | 1 | 880-D3500C6-03 | 63.00 | 156.37 | 195.00 | 109.00 | | 0.62 | 88° | 10 | 1.519 | 16000 |
| | | | 108.00 | C5 | 1.38 | 0.00 | 0.25 | 1 | 880-D3600C5-03 | 50.00 | 158.32 | 189.00 | 112.00 | | 0.67 | 88° | 10 | 1.175 | 16000 |
| | | | 108.00 | C6 | 1.38 | 0.00 | 0.25 | 1 | 880-D3600C6-03 | 63.00 | 160.32 | 199.00 | 112.00 | | 0.67 | 88° | 10 | 1.516 | 16000 |
| 37.00 | 07C | 07P | 111.00 | C5 | 1.25 | 0.00 | 0.25 | 1 | 880-D3700C5-03 | 50.00 | 161.31 | 192.00 | 115.00 | | 0.68 | 88° | 10 | 1.213 | 16000 |
| | | | 111.00 | C6 | 1.25 | 0.00 | 0.25 | 1 | 880-D3700C6-03 | 63.00 | 163.31 | 202.00 | 115.00 | | 0.68 | 88° | 10 | 1.560 | 16000 |
| | | | 114.00 | C5 | 1.13 | 0.00 | 0.25 | 1 | 880-D3800C5-03 | 50.00 | 165.31 | 196.00 | 118.00 | | 0.68 | 88° | 10 | 1.240 | 16000 |
| 38.00 | 07C | 07P | 114.00 | C6 | 1.13 | 0.00 | 0.25 | 1 | 880-D3800C6-03 | 63.00 | 167.31 | 206.00 | 118.00 | | 0.68 | 88° | 10 | 1.630 | 16000 |
| | | | 117.00 | C5 | 1.00 | 0.00 | 0.25 | 1 | 880-D3900C5-03 | 50.00 | 168.30 | 199.00 | 121.00 | | 0.69 | 88° | 10 | 1.305 | 16000 |
| | | | 117.00 | C6 | 1.00 | 0.00 | 0.25 | 1 | 880-D3900C6-03 | 63.00 | 170.30 | 209.00 | 121.00 | | 0.69 | 88° | 10 | 1.643 | 16000 |
| 40.00 | 07C | 07P | 120.00 | C5 | 0.88 | 0.00 | 0.25 | 1 | 880-D4000C5-03 | 50.00 | 172.29 | 203.00 | 124.00 | | 0.70 | 88° | 10 | 1.370 | 16000 |
| | | | 120.00 | C6 | 0.88 | 0.00 | 0.25 | 1 | 880-D4000C6-03 | 63.00 | 174.29 | 213.00 | 124.00 | | 0.70 | 88° | 10 | 1.716 | 16000 |
| | | | 123.00 | C5 | 0.75 | 0.00 | 0.25 | 1 | 880-D4100C5-03 | 50.00 | 176.28 | 207.00 | 127.00 | | 0.71 | 88° | 10 | 1.448 | 16000 |
| 41.00 | 07C | 07P | 123.00 | C6 | 0.75 | 0.00 | 0.25 | 1 | 880-D4100C6-03 | 63.00 | 178.28 | 217.00 | 127.00 | | 0.71 | 88° | 10 | 1.800 | 16000 |
| | | | 126.00 | C5 | 0.63 | 0.00 | 0.25 | 2 | 880-D4200C5-03M1 | 50.00 | 199.27 | 230.00 | 130.00 | 62.50 | 0.72 | 88° | 10 | 2.110 | 16000 |
| | | | 126.00 | C6 | 0.63 | 0.00 | 0.25 | 1 | 880-D4200C6-03M1 | 63.00 | 199.27 | 238.00 | 130.00 | | 0.72 | 88° | 10 | 2.418 | 16000 |
| 43.00 | 07C | 07P | 129.00 | C5 | 0.50 | 0.00 | 0.25 | 2 | 880-D4300C5-03M1 | 50.00 | 203.30 | 234.00 | 133.00 | 62.50 | 0.69 | 88° | 10 | 2.139 | 16000 |
| | | | 129.00 | C6 | 0.50 | 0.00 | 0.25 | 1 | 880-D4300C6-03M1 | 63.00 | 203.30 | 242.00 | 133.00 | | 0.69 | 88° | 10 | 2.458 | 16000 |

| Spare parts | |
|-------------|-------------------|
| DC | Insert screw |
| 12.70-16.00 | 01-02 5513 020-87 |
| 16.50-19.50 | 03 5513 020-33 |
| 20.00-23.00 | 04 5513 020-58 |
| 24.00-29.00 | 05 5513 020-57 |
| 30.00-42.00 | 06-07 416.1-833 |

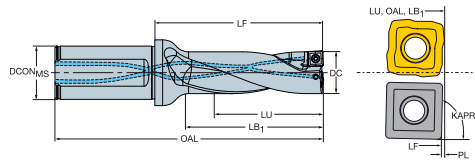
For complete list of spare parts, see www.sandvik.coromant.com



CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



Dimensions, mm

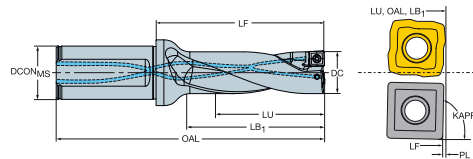
| DC | | | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | (BAR) | (KG) | RPMX |
|-------|-----|-----|-------|-------------------|-------|-------|-------|-----------------|--------------------|-------|--------|-----------------|------|------|-------|-------|-------|
| 12.00 | 01C | 01P | 24.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1200L20-02 | 20.00 | 38.61 | 89.00 | 27.00 | 0.38 | 79° | 10 | 0.189 | 33000 |
| | | | 36.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1200L20-03 | 20.00 | 50.61 | 101.00 | 39.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| 12.50 | 01C | 01P | 25.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1250L20-02 | 20.00 | 40.61 | 91.00 | 28.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| | | | 38.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1250L20-03 | 20.00 | 52.61 | 103.00 | 40.00 | 0.38 | 79° | 10 | 0.198 | 33000 |
| 12.70 | 01C | 01P | 25.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1270L20-02 | 20.00 | 40.61 | 91.00 | 28.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| | | | 38.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1270L20-03 | 20.00 | 53.61 | 104.00 | 41.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| 13.00 | 01C | 01P | 26.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1300L20-02 | 20.00 | 41.61 | 92.00 | 29.00 | 0.38 | 79° | 10 | 0.194 | 33000 |
| | | | 39.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1300L20-03 | 20.00 | 54.61 | 105.00 | 42.00 | 0.38 | 79° | 10 | 0.202 | 33000 |
| 13.50 | 01C | 01P | 27.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1350L20-02 | 20.00 | 42.61 | 93.00 | 30.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| | | | 41.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1350L20-03 | 20.00 | 55.61 | 106.00 | 43.00 | 0.38 | 79° | 10 | 0.204 | 33000 |
| 14.00 | 02C | 02P | 28.00 | 20 | 0.50 | 0.00 | 0.25 | 880-D1400L20-02 | 20.00 | 43.67 | 94.00 | 31.00 | 0.32 | 88° | 10 | 0.200 | 33000 |
| | | | 42.00 | 20 | 0.50 | 0.00 | 0.25 | 880-D1400L20-03 | 20.00 | 57.67 | 108.00 | 45.00 | 0.32 | 88° | 10 | 0.211 | 33000 |
| 14.50 | 02C | 02P | 29.00 | 20 | 0.45 | 0.00 | 0.25 | 880-D1450L20-02 | 20.00 | 45.67 | 96.00 | 32.00 | 0.32 | 88° | 10 | 0.210 | 33000 |
| | | | 44.00 | 20 | 0.45 | 0.00 | 0.25 | 880-D1450L20-03 | 20.00 | 59.67 | 110.00 | 46.00 | 0.32 | 88° | 10 | 0.217 | 33000 |
| 15.00 | 02C | 02P | 30.00 | 20 | 0.40 | 0.00 | 0.25 | 880-D1500L20-02 | 20.00 | 46.67 | 97.00 | 33.00 | 0.32 | 88° | 10 | 0.212 | 33000 |
| | | | 45.00 | 20 | 0.40 | 0.00 | 0.25 | 880-D1500L20-03 | 20.00 | 61.67 | 112.00 | 48.00 | 0.32 | 88° | 10 | 0.210 | 33000 |
| 15.50 | 02C | 02P | 31.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1550L20-02 | 20.00 | 48.66 | 99.00 | 35.00 | 0.33 | 88° | 10 | 0.208 | 33000 |
| | | | 47.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1550L20-03 | 20.00 | 63.66 | 114.00 | 50.00 | 0.33 | 88° | 10 | 0.225 | 33000 |
| 16.00 | 02C | 02P | 32.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1600L20-02 | 20.00 | 50.66 | 101.00 | 36.00 | 0.33 | 88° | 10 | 0.215 | 33000 |
| | | | 48.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1600L20-03 | 20.00 | 65.66 | 116.00 | 51.00 | 0.33 | 88° | 10 | 0.229 | 33000 |
| 16.50 | 03C | 03P | 33.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1650L20-02 | 20.00 | 51.63 | 102.00 | 37.00 | 0.36 | 88° | 10 | 0.224 | 33000 |
| | | | 50.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1650L20-03 | 20.00 | 67.63 | 118.00 | 53.00 | 0.36 | 88° | 10 | 0.235 | 30000 |
| 17.00 | 03C | 03P | 34.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1700L20-02 | 20.00 | 52.63 | 103.00 | 38.00 | 0.36 | 88° | 10 | 0.225 | 33000 |
| | | | 51.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1700L20-03 | 20.00 | 68.63 | 119.00 | 54.00 | 0.36 | 88° | 10 | 0.232 | 30000 |
| 17.50 | 03C | 03P | 35.00 | 25 | 0.50 | 0.00 | 0.25 | 880-D1750L25-02 | 25.00 | 54.62 | 111.00 | 39.00 | 0.37 | 88° | 10 | 0.347 | 33000 |
| | | | 53.00 | 25 | 0.50 | 0.00 | 0.25 | 880-D1750L25-03 | 25.00 | 71.62 | 128.00 | 56.00 | 0.37 | 88° | 10 | 0.362 | 30000 |
| 18.00 | 03C | 03P | 36.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1800L25-02 | 25.00 | 55.62 | 112.00 | 40.00 | 0.37 | 88° | 10 | 0.352 | 33000 |
| | | | 54.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1800L25-03 | 25.00 | 72.62 | 129.00 | 57.00 | 0.37 | 88° | 10 | 0.363 | 30000 |
| 18.50 | 03C | 03P | 37.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1850L25-02 | 25.00 | 56.62 | 113.00 | 41.00 | 0.37 | 88° | 10 | 0.354 | 33000 |
| | | | 56.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1850L25-03 | 25.00 | 74.62 | 131.00 | 59.00 | 0.37 | 88° | 10 | 0.369 | 30000 |
| 19.00 | 03C | 03P | 38.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1900L25-02 | 25.00 | 57.61 | 114.00 | 42.00 | 0.38 | 88° | 10 | 0.359 | 33000 |
| | | | 57.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1900L25-03 | 25.00 | 75.61 | 132.00 | 60.00 | 0.38 | 88° | 10 | 0.375 | 30000 |
| 19.50 | 03C | 03P | 39.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1950L25-02 | 25.00 | 59.61 | 116.00 | 43.00 | 0.38 | 88° | 10 | 0.371 | 33000 |
| | | | 59.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1950L25-03 | 25.00 | 78.61 | 135.00 | 62.00 | 0.38 | 88° | 10 | 0.387 | 30000 |
| 20.00 | 04C | 04P | 40.00 | 25 | 0.90 | 0.00 | 0.25 | 880-D2000L25-02 | 25.00 | 60.56 | 117.00 | 44.00 | 0.43 | 88° | 10 | 0.367 | 21500 |
| | | | 60.00 | 25 | 0.90 | 0.00 | 0.25 | 880-D2000L25-03 | 25.00 | 80.56 | 137.00 | 64.00 | 0.43 | 88° | 10 | 0.340 | 21500 |
| 20.50 | 04C | 04P | 62.00 | 25 | 0.80 | 0.00 | 0.25 | 880-D2050L25-03 | 25.00 | 81.56 | 138.00 | 65.00 | 0.43 | 88° | 10 | 0.392 | 21500 |
| 20.90 | 04C | 04P | 63.00 | 25 | 0.80 | 0.00 | 0.25 | 880-D2090L25-03 | 25.00 | 83.56 | 140.00 | 66.00 | 0.43 | 88° | 10 | 0.412 | 21500 |
| 21.00 | 04C | 04P | 42.00 | 25 | 0.80 | 0.00 | 0.25 | 880-D2100L25-02 | 25.00 | 63.56 | 120.00 | 46.00 | 0.43 | 88° | 10 | 0.382 | 21500 |
| | | | 63.00 | 25 | 0.80 | 0.00 | 0.25 | 880-D2100L25-03 | 25.00 | 83.56 | 140.00 | 66.00 | 0.43 | 88° | 10 | 0.396 | 21500 |
| 21.50 | 04C | 04P | 65.00 | 25 | 0.70 | 0.00 | 0.25 | 880-D2150L25-03 | 25.00 | 85.55 | 142.00 | 68.00 | 0.44 | 88° | 10 | 0.404 | 21500 |
| 22.00 | 04C | 04P | 44.00 | 25 | 0.60 | 0.00 | 0.25 | 880-D2200L25-02 | 25.00 | 65.55 | 122.00 | 48.00 | 0.44 | 88° | 10 | 0.367 | 21500 |
| | | | 66.00 | 25 | 0.60 | 0.00 | 0.25 | 880-D2200L25-03 | 25.00 | 86.55 | 143.00 | 69.00 | 0.44 | 88° | 10 | 0.423 | 21500 |
| 22.50 | 04C | 04P | 68.00 | 25 | 0.50 | 0.00 | 0.25 | 880-D2250L25-03 | 25.00 | 89.54 | 146.00 | 71.00 | 0.45 | 88° | 10 | 0.432 | 21500 |
| 23.00 | 04C | 04P | 46.00 | 25 | 0.50 | 0.00 | 0.25 | 880-D2300L25-02 | 25.00 | 68.54 | 125.00 | 50.00 | 0.45 | 88° | 10 | 0.403 | 21500 |
| | | | 69.00 | 25 | 0.50 | 0.00 | 0.25 | 880-D2300L25-03 | 25.00 | 90.54 | 147.00 | 72.00 | 0.45 | 88° | 10 | 0.448 | 21500 |
| 23.50 | 04C | 04P | 71.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D2350L25-03 | 25.00 | 92.54 | 149.00 | 74.00 | 0.45 | 88° | 10 | 0.443 | 21500 |
| 23.90 | 04C | 04P | 72.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D2390L25-03 | 25.00 | 94.53 | 151.00 | 76.00 | 0.46 | 88° | 10 | 0.465 | 21500 |
| 24.00 | 05C | 05P | 48.00 | 25 | 1.10 | 0.00 | 0.25 | 880-D2400L25-02 | 25.00 | 70.49 | 127.00 | 52.00 | 0.50 | 88° | 10 | 0.340 | 16000 |
| | | | 72.00 | 25 | 1.10 | 0.00 | 0.25 | 880-D2400L25-03 | 25.00 | 94.49 | 151.00 | 76.00 | 0.50 | 88° | 10 | 0.400 | 16000 |
| 24.50 | 05C | 05P | 74.00 | 25 | 1.00 | 0.00 | 0.25 | 880-D2450L25-03 | 25.00 | 96.49 | 153.00 | 77.00 | 0.50 | 88° | 10 | 0.480 | 16000 |
| 25.00 | 05C | 05P | 50.00 | 25 | 1.00 | 0.00 | 0.25 | 880-D2500L25-02 | 25.00 | 73.48 | 130.00 | 54.00 | 0.51 | 88° | 10 | 0.400 | 16000 |
| | | | 75.00 | 25 | 1.00 | 0.00 | 0.25 | 880-D2500L25-03 | 25.00 | 98.48 | 155.00 | 79.00 | 0.51 | 88° | 10 | 0.460 | 16000 |



CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



| | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-----|-----|--------|-------------------|-------|-------|-------|-----------------|--------------------|--------|--------|-----------------|------|------|-----|-------|-------|
| DC | | | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | RPMX |
| 25.50 | 05C | 05P | 77.00 | 25 | 0.90 | 0.00 | 0.25 | 880-D2550L25-03 | 25.00 | 99.48 | 156.00 | 80.00 | 0.51 | 88° | 10 | 0.501 | 16000 |
| 26.00 | 05C | 05P | 52.00 | 32 | 0.90 | 0.00 | 0.25 | 880-D2600L32-02 | 32.00 | 76.47 | 137.00 | 56.00 | 0.52 | 88° | 10 | 0.650 | 16000 |
| | | | 78.00 | 32 | 0.90 | 0.00 | 0.25 | 880-D2600L32-03 | 32.00 | 101.47 | 162.00 | 81.00 | 0.52 | 88° | 10 | 0.700 | 16000 |
| 26.40 | 05C | 05P | 79.00 | 32 | 0.80 | 0.00 | 0.25 | 880-D2640L32-03 | 32.00 | 103.47 | 164.00 | 83.00 | 0.52 | 88° | 10 | 0.707 | 16000 |
| 26.50 | 05C | 05P | 80.00 | 32 | 0.80 | 0.00 | 0.25 | 880-D2650L32-03 | 32.00 | 103.47 | 164.00 | 83.00 | 0.52 | 88° | 10 | 0.717 | 16000 |
| 27.00 | 05C | 05P | 54.00 | 32 | 0.70 | 0.00 | 0.25 | 880-D2700L32-02 | 32.00 | 78.46 | 139.00 | 58.00 | 0.53 | 88° | 10 | 0.669 | 16000 |
| | | | 81.00 | 32 | 0.70 | 0.00 | 0.25 | 880-D2700L32-03 | 32.00 | 104.46 | 165.00 | 84.00 | 0.53 | 88° | 10 | 0.724 | 16000 |
| 27.50 | 05C | 05P | 83.00 | 32 | 0.60 | 0.00 | 0.25 | 880-D2750L32-03 | 32.00 | 107.46 | 168.00 | 86.00 | 0.53 | 88° | 10 | 0.761 | 16000 |
| 28.00 | 05C | 05P | 56.00 | 32 | 0.60 | 0.00 | 0.25 | 880-D2800L32-02 | 32.00 | 81.46 | 142.00 | 60.00 | 0.53 | 88° | 10 | 0.693 | 16000 |
| | | | 84.00 | 32 | 0.60 | 0.00 | 0.25 | 880-D2800L32-03 | 32.00 | 108.46 | 169.00 | 87.00 | 0.53 | 88° | 10 | 0.755 | 16000 |
| 28.50 | 05C | 05P | 86.00 | 32 | 0.50 | 0.00 | 0.25 | 880-D2850L32-03 | 32.00 | 110.45 | 171.00 | 89.00 | 0.54 | 88° | 10 | 0.770 | 16000 |
| 29.00 | 05C | 05P | 58.00 | 32 | 0.50 | 0.00 | 0.25 | 880-D2900L32-02 | 32.00 | 83.45 | 144.00 | 62.00 | 0.54 | 88° | 10 | 0.710 | 16000 |
| | | | 87.00 | 32 | 0.50 | 0.00 | 0.25 | 880-D2900L32-03 | 32.00 | 111.45 | 172.00 | 90.00 | 0.54 | 88° | 10 | 0.784 | 16000 |
| 29.40 | 05C | 05P | 88.00 | 32 | 0.40 | 0.00 | 0.25 | 880-D2940L32-03 | 32.00 | 114.44 | 175.00 | 92.00 | 0.55 | 88° | 10 | 0.845 | 16000 |
| 29.50 | 05C | 05P | 89.00 | 32 | 0.40 | 0.00 | 0.25 | 880-D2950L32-03 | 32.00 | 114.44 | 175.00 | 92.00 | 0.55 | 88° | 10 | 0.809 | 16000 |
| 30.00 | 06C | 06P | 60.00 | 32 | 1.12 | 0.00 | 0.25 | 880-D3000L32-02 | 32.00 | 86.41 | 147.00 | 64.00 | 0.58 | 88° | 10 | 0.699 | 16000 |
| | | | 90.00 | 32 | 1.12 | 0.00 | 0.25 | 880-D3000L32-03 | 32.00 | 116.41 | 177.00 | 94.00 | 0.58 | 88° | 10 | 0.790 | 16000 |
| 30.50 | 06C | 06P | 92.00 | 32 | 1.05 | 0.00 | 0.25 | 880-D3050L32-03 | 32.00 | 117.40 | 178.00 | 95.00 | 0.59 | 88° | 10 | 0.800 | 16000 |
| 31.00 | 06C | 06P | 62.00 | 40 | 0.99 | 0.00 | 0.25 | 880-D3100L40-02 | 40.00 | 89.40 | 160.00 | 66.00 | 0.59 | 88° | 10 | 1.136 | 16000 |
| | | | 93.00 | 40 | 0.99 | 0.00 | 0.25 | 880-D3100L40-03 | 40.00 | 120.40 | 191.00 | 97.00 | 0.59 | 88° | 10 | 1.210 | 16000 |
| 31.50 | 06C | 06P | 95.00 | 40 | 0.93 | 0.00 | 0.25 | 880-D3150L40-03 | 40.00 | 121.39 | 192.00 | 98.00 | 0.60 | 88° | 10 | 1.230 | 16000 |
| 32.00 | 06C | 06P | 64.00 | 40 | 0.87 | 0.00 | 0.25 | 880-D3200L40-02 | 40.00 | 91.39 | 162.00 | 68.00 | 0.60 | 88° | 10 | 1.156 | 16000 |
| | | | 96.00 | 40 | 0.87 | 0.00 | 0.25 | 880-D3200L40-03 | 40.00 | 123.39 | 194.00 | 100.00 | 0.60 | 88° | 10 | 1.252 | 16000 |
| 32.50 | 06C | 06P | 98.00 | 40 | 0.81 | 0.00 | 0.25 | 880-D3250L40-03 | 40.00 | 125.39 | 196.00 | 101.00 | 0.60 | 88° | 10 | 1.278 | 16000 |
| 33.00 | 06C | 06P | 66.00 | 40 | 0.75 | 0.00 | 0.25 | 880-D3300L40-02 | 40.00 | 94.38 | 165.00 | 70.00 | 0.61 | 88° | 10 | 1.200 | 16000 |
| | | | 99.00 | 40 | 0.75 | 0.00 | 0.25 | 880-D3300L40-03 | 40.00 | 127.38 | 198.00 | 103.00 | 0.61 | 88° | 10 | 1.303 | 16000 |
| 33.50 | 06C | 06P | 101.00 | 40 | 0.68 | 0.00 | 0.25 | 880-D3350L40-03 | 40.00 | 129.38 | 200.00 | 105.00 | 0.61 | 88° | 10 | 1.317 | 16000 |
| 34.00 | 06C | 06P | 68.00 | 40 | 0.62 | 0.00 | 0.25 | 880-D3400L40-02 | 40.00 | 97.37 | 168.00 | 73.00 | 0.62 | 88° | 10 | 1.227 | 16000 |
| | | | 102.00 | 40 | 0.62 | 0.00 | 0.25 | 880-D3400L40-03 | 40.00 | 130.37 | 201.00 | 106.00 | 0.62 | 88° | 10 | 1.340 | 16000 |
| 34.50 | 06C | 06P | 104.00 | 40 | 0.56 | 0.00 | 0.25 | 880-D3450L40-03 | 40.00 | 133.37 | 204.00 | 108.00 | 0.62 | 88° | 10 | 1.380 | 16000 |
| 35.00 | 06C | 06P | 70.00 | 40 | 0.50 | 0.00 | 0.25 | 880-D3500L40-02 | 40.00 | 100.37 | 171.00 | 75.00 | 0.62 | 88° | 10 | 1.270 | 16000 |
| | | | 105.00 | 40 | 0.50 | 0.00 | 0.25 | 880-D3500L40-03 | 40.00 | 134.37 | 205.00 | 109.00 | 0.62 | 88° | 10 | 1.400 | 16000 |
| 35.50 | 06C | 06P | 107.00 | 40 | 0.44 | 0.00 | 0.25 | 880-D3550L40-03 | 40.00 | 136.36 | 207.00 | 111.00 | 0.63 | 88° | 10 | 1.415 | 16000 |
| 36.00 | 07C | 07P | 72.00 | 40 | 1.38 | 0.00 | 0.25 | 880-D3600L40-02 | 40.00 | 103.32 | 174.00 | 77.00 | 0.67 | 88° | 10 | 1.280 | 16000 |
| | | | 108.00 | 40 | 1.38 | 0.00 | 0.25 | 880-D3600L40-03 | 40.00 | 138.32 | 209.00 | 112.00 | 0.67 | 88° | 10 | 1.397 | 16000 |
| 37.00 | 07C | 07P | 74.00 | 40 | 1.25 | 0.00 | 0.25 | 880-D3700L40-02 | 40.00 | 104.31 | 175.00 | 78.00 | 0.68 | 88° | 10 | 1.300 | 16000 |
| | | | 111.00 | 40 | 1.25 | 0.00 | 0.25 | 880-D3700L40-03 | 40.00 | 141.31 | 212.00 | 115.00 | 0.68 | 88° | 10 | 1.446 | 16000 |
| 38.00 | 07C | 07P | 76.00 | 40 | 1.13 | 0.00 | 0.25 | 880-D3800L40-02 | 40.00 | 107.31 | 178.00 | 80.00 | 0.68 | 88° | 10 | 1.349 | 16000 |
| | | | 114.00 | 40 | 1.13 | 0.00 | 0.25 | 880-D3800L40-03 | 40.00 | 145.31 | 216.00 | 118.00 | 0.68 | 88° | 10 | 1.480 | 16000 |
| 39.00 | 07C | 07P | 78.00 | 40 | 1.00 | 0.00 | 0.25 | 880-D3900L40-02 | 40.00 | 109.30 | 180.00 | 82.00 | 0.69 | 88° | 10 | 1.366 | 16000 |
| | | | 117.00 | 40 | 1.00 | 0.00 | 0.25 | 880-D3900L40-03 | 40.00 | 148.30 | 219.00 | 121.00 | 0.69 | 88° | 10 | 1.535 | 16000 |
| 40.00 | 07C | 07P | 80.00 | 40 | 0.88 | 0.00 | 0.25 | 880-D4000L40-02 | 40.00 | 112.29 | 183.00 | 84.00 | 0.70 | 88° | 10 | 1.413 | 16000 |
| | | | 120.00 | 40 | 0.88 | 0.00 | 0.25 | 880-D4000L40-03 | 40.00 | 152.29 | 223.00 | 124.00 | 0.70 | 88° | 10 | 1.603 | 16000 |
| 41.00 | 07C | 07P | 82.00 | 40 | 0.75 | 0.00 | 0.25 | 880-D4100L40-02 | 40.00 | 116.28 | 187.00 | 87.00 | 0.71 | 88° | 10 | 1.480 | 16000 |
| | | | 123.00 | 40 | 0.75 | 0.00 | 0.25 | 880-D4100L40-03 | 40.00 | 156.28 | 227.00 | 127.00 | 0.71 | 88° | 10 | 1.690 | 16000 |
| 42.00 | 07C | 07P | 84.00 | 40 | 0.63 | 0.00 | 0.25 | 880-D4200L40-02 | 40.00 | 118.27 | 189.00 | 89.00 | 0.72 | 88° | 10 | 1.505 | 16000 |
| | | | 126.00 | 40 | 0.63 | 0.00 | 0.25 | 880-D4200L40-03 | 40.00 | 159.27 | 230.00 | 130.00 | 0.72 | 88° | 10 | 1.740 | 16000 |
| 43.00 | 07C | 07P | 86.00 | 40 | 0.50 | 0.00 | 0.25 | 880-D4300L40-02 | 40.00 | 121.26 | 192.00 | 91.00 | 0.73 | 88° | 10 | 1.510 | 16000 |
| | | | 129.00 | 40 | 0.50 | 0.00 | 0.25 | 880-D4300L40-03 | 40.00 | 163.26 | 234.00 | 133.00 | 0.73 | 88° | 10 | 1.730 | 16000 |
| 44.00 | 08C | 08P | 88.00 | 40 | 1.50 | 0.00 | 0.28 | 880-D4400L40-02 | 40.00 | 123.23 | 194.00 | 93.00 | 0.76 | 88° | 10 | 1.510 | 15000 |
| | | | 132.00 | 40 | 1.50 | 0.00 | 0.28 | 880-D4400L40-03 | 40.00 | 166.23 | 237.00 | 136.00 | 0.76 | 88° | 10 | 1.720 | 15000 |
| 45.00 | 08C | 08P | 90.00 | 40 | 1.40 | 0.00 | 0.28 | 880-D4500L40-02 | 40.00 | 126.22 | 197.00 | 95.00 | 0.77 | 88° | 10 | 1.560 | 15000 |
| | | | 135.00 | 40 | 1.40 | 0.00 | 0.28 | 880-D4500L40-03 | 40.00 | 171.22 | 242.00 | 140.00 | 0.77 | 88° | 10 | 1.800 | 15000 |



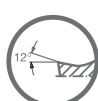
J42



L2



J62



J35



N23



N6



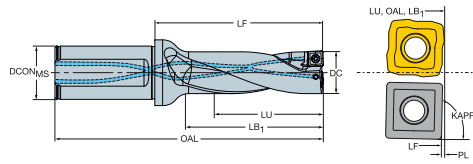
N15



CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



Dimensions, mm

| DC | | | LU | CZC _{MS} | ADJLX | TCHAL | TCHAU | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | RPMX |
|-------|-----|-----|--------|-------------------|-------|-------|-------|-----------------|--------------------|--------|--------|-----------------|------|------|-----|-------|-------|
| 46.00 | 08C | 08P | 92.00 | 40 | 1.30 | 0.00 | 0.28 | 880-D4600L40-02 | 40.00 | 129.22 | 200.00 | 97.00 | 0.78 | 88° | 10 | 1.610 | 15000 |
| | | | 138.00 | 40 | 1.30 | 0.00 | 0.28 | 880-D4600L40-03 | 40.00 | 175.22 | 246.00 | 143.00 | 0.78 | 88° | 10 | 1.881 | 15000 |
| 47.00 | 08C | 08P | 94.00 | 40 | 1.10 | 0.00 | 0.28 | 880-D4700L40-02 | 40.00 | 131.21 | 202.00 | 99.00 | 0.78 | 88° | 10 | 1.800 | 15000 |
| | | | 141.00 | 40 | 1.10 | 0.00 | 0.28 | 880-D4700L40-03 | 40.00 | 178.21 | 249.00 | 146.00 | 0.78 | 88° | 10 | 2.140 | 15000 |
| 48.00 | 08C | 08P | 96.00 | 40 | 1.00 | 0.00 | 0.28 | 880-D4800L40-02 | 40.00 | 134.20 | 205.00 | 101.00 | 0.79 | 88° | 10 | 1.925 | 15000 |
| | | | 144.00 | 40 | 1.00 | 0.00 | 0.28 | 880-D4800L40-03 | 40.00 | 182.20 | 253.00 | 149.00 | 0.79 | 88° | 10 | 2.235 | 15000 |
| 49.00 | 08C | 08P | 98.00 | 40 | 0.90 | 0.00 | 0.28 | 880-D4900L40-02 | 40.00 | 136.19 | 207.00 | 103.00 | 0.80 | 88° | 10 | 1.970 | 15000 |
| | | | 147.00 | 40 | 0.90 | 0.00 | 0.28 | 880-D4900L40-03 | 40.00 | 185.19 | 256.00 | 152.00 | 0.80 | 88° | 10 | 2.275 | 15000 |
| 50.00 | 08C | 08P | 100.00 | 40 | 0.80 | 0.00 | 0.28 | 880-D5000L40-02 | 40.00 | 139.18 | 210.00 | 105.00 | 0.81 | 88° | 10 | 2.031 | 15000 |
| | | | 150.00 | 40 | 0.80 | 0.00 | 0.28 | 880-D5000L40-03 | 40.00 | 189.18 | 260.00 | 155.00 | 0.81 | 88° | 10 | 2.430 | 15000 |
| 51.00 | 08C | 08P | 102.00 | 40 | 0.60 | 0.00 | 0.28 | 880-D5100L40-02 | 40.00 | 143.18 | 214.00 | 108.00 | 0.82 | 88° | 10 | 2.110 | 15000 |
| | | | 153.00 | 40 | 0.60 | 0.00 | 0.28 | 880-D5100L40-03 | 40.00 | 193.18 | 264.00 | 158.00 | 0.82 | 88° | 10 | 2.480 | 15000 |
| 52.00 | 08C | 08P | 104.00 | 40 | 0.50 | 0.00 | 0.28 | 880-D5200L40-02 | 40.00 | 145.17 | 216.00 | 110.00 | 0.82 | 88° | 10 | 2.180 | 15000 |
| | | | 156.00 | 40 | 0.50 | 0.00 | 0.28 | 880-D5200L40-03 | 40.00 | 196.17 | 267.00 | 161.00 | 0.82 | 88° | 10 | 2.595 | 15000 |
| 53.00 | 09C | 09P | 106.00 | 40 | 2.00 | 0.00 | 0.30 | 880-D5300L40-02 | 40.00 | 148.12 | 219.00 | 112.00 | 0.87 | 88° | 10 | 2.307 | 5000 |
| | | | 159.00 | 40 | 2.00 | 0.00 | 0.30 | 880-D5300L40-03 | 40.00 | 200.12 | 271.00 | 164.00 | 0.87 | 88° | 10 | 2.600 | 5000 |
| 54.00 | 09C | 09P | 108.00 | 40 | 1.90 | 0.00 | 0.30 | 880-D5400L40-02 | 40.00 | 150.11 | 221.00 | 114.00 | 0.88 | 88° | 10 | 2.380 | 5000 |
| | | | 162.00 | 40 | 1.90 | 0.00 | 0.30 | 880-D5400L40-03 | 40.00 | 203.11 | 274.00 | 167.00 | 0.88 | 88° | 10 | 2.714 | 5000 |
| 55.00 | 09C | 09P | 110.00 | 40 | 1.70 | 0.00 | 0.30 | 880-D5500L40-02 | 40.00 | 153.10 | 224.00 | 116.00 | 0.89 | 88° | 10 | 2.349 | 5000 |
| | | | 165.00 | 40 | 1.70 | 0.00 | 0.30 | 880-D5500L40-03 | 40.00 | 208.10 | 279.00 | 171.00 | 0.89 | 88° | 10 | 2.850 | 5000 |
| 56.00 | 09C | 09P | 112.00 | 40 | 1.60 | 0.00 | 0.30 | 880-D5600L40-02 | 40.00 | 156.10 | 227.00 | 118.00 | 0.89 | 88° | 10 | 2.451 | 5000 |
| | | | 168.00 | 40 | 1.60 | 0.00 | 0.30 | 880-D5600L40-03 | 40.00 | 212.10 | 283.00 | 174.00 | 0.89 | 88° | 10 | 2.977 | 5000 |
| 57.00 | 09C | 09P | 114.00 | 40 | 1.50 | 0.00 | 0.30 | 880-D5700L40-02 | 40.00 | 158.09 | 229.00 | 120.00 | 0.90 | 88° | 10 | 2.530 | 5000 |
| | | | 171.00 | 40 | 1.50 | 0.00 | 0.30 | 880-D5700L40-03 | 40.00 | 215.09 | 286.00 | 177.00 | 0.90 | 88° | 10 | 3.120 | 5000 |
| 58.00 | 09C | 09P | 116.00 | 40 | 1.40 | 0.00 | 0.30 | 880-D5800L40-02 | 40.00 | 161.08 | 232.00 | 122.00 | 0.91 | 88° | 10 | 2.650 | 5000 |
| | | | 174.00 | 40 | 1.40 | 0.00 | 0.30 | 880-D5800L40-03 | 40.00 | 219.08 | 290.00 | 180.00 | 0.91 | 88° | 10 | 3.593 | 5000 |
| 59.00 | 09C | 09P | 118.00 | 40 | 1.20 | 0.00 | 0.30 | 880-D5900L40-02 | 40.00 | 163.07 | 234.00 | 124.00 | 0.92 | 88° | 10 | 2.703 | 5000 |
| | | | 177.00 | 40 | 1.20 | 0.00 | 0.30 | 880-D5900L40-03 | 40.00 | 222.07 | 293.00 | 183.00 | 0.92 | 88° | 10 | 3.346 | 5000 |
| 60.00 | 09C | 09P | 120.00 | 40 | 1.10 | 0.00 | 0.30 | 880-D6000L40-02 | 40.00 | 166.06 | 237.00 | 126.00 | 0.93 | 88° | 10 | 2.820 | 5000 |
| | | | 180.00 | 40 | 1.10 | 0.00 | 0.30 | 880-D6000L40-03 | 40.00 | 226.06 | 297.00 | 186.00 | 0.93 | 88° | 10 | 3.570 | 5000 |
| 61.00 | 09C | 09P | 122.00 | 40 | 1.00 | 0.00 | 0.30 | 880-D6100L40-02 | 40.00 | 170.06 | 241.00 | 129.00 | 0.93 | 88° | 10 | 3.032 | 5000 |
| | | | 183.00 | 40 | 1.00 | 0.00 | 0.30 | 880-D6100L40-03 | 40.00 | 231.06 | 302.00 | 190.00 | 0.93 | 88° | 10 | 4.039 | 5000 |
| 62.00 | 09C | 09P | 124.00 | 40 | 0.80 | 0.00 | 0.30 | 880-D6200L40-02 | 40.00 | 172.05 | 243.00 | 131.00 | 0.94 | 88° | 10 | 3.020 | 5000 |
| | | | 186.00 | 40 | 0.80 | 0.00 | 0.30 | 880-D6200L40-03 | 40.00 | 234.05 | 305.00 | 193.00 | 0.94 | 88° | 10 | 4.115 | 5000 |
| 63.00 | 09C | 09P | 126.00 | 40 | 0.70 | 0.00 | 0.30 | 880-D6300L40-02 | 40.00 | 175.04 | 246.00 | 133.00 | 0.95 | 88° | 10 | 3.173 | 5000 |
| | | | 189.00 | 40 | 0.70 | 0.00 | 0.30 | 880-D6300L40-03 | 40.00 | 238.04 | 309.00 | 196.00 | 0.95 | 88° | 10 | 4.300 | 5000 |

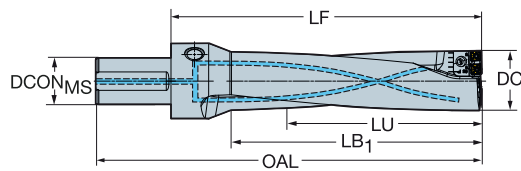
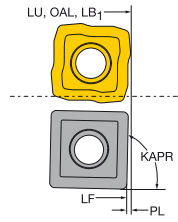
| Spare parts | | |
|-------------|--------------|-------------|
| DC | Insert screw | |
| 12.00-16.00 | 01-02 | 5513 020-87 |
| 16.50-19.50 | 03 | 5513 020-33 |
| 20.00-23.90 | 04 | 5513 020-58 |
| 24.00-28.50 | 05 | 5513 020-57 |
| 30.00-41.00 | 06-07 | 416.1-833 |
| 44.00-63.00 | 08-09 | 416.1-834 |

For complete list of spare parts, see www.sandvik.coromant.com



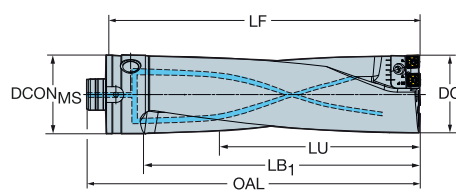
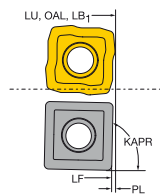
CoroDrill® 880 indexable insert drill

Internal coolant supply



Cylindrical shank with flat according to ISO 9766

| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|-------|---------|-----|-----|-----|--------|-------------------|-------|-------|-----------------|--------------------|--------|--------|-----------------|------|------|-----|--------|------|
| DC | C I I P | | | | LU | CZC _{MS} | TCHAL | TCHAU | Ordering code | DCON _{MS} | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | RPMX |
| 65.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0650L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 8.495 | 5000 |
| | | | | | 276.00 | 50 | -0.30 | 0.30 | 880-D0650L50-04 | 50.00 | 344.70 | 426.00 | 281.77 | 1.30 | 88° | 10 | 10.125 | 5000 |
| 66.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0660L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 8.470 | 5000 |
| | | | | | 276.00 | 50 | -0.30 | 0.30 | 880-D0660L50-04 | 50.00 | 344.70 | 426.00 | 281.77 | 1.30 | 88° | 10 | 7.900 | 5000 |
| 67.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0670L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 7.105 | 5000 |
| | | | | | 276.00 | 50 | -0.30 | 0.30 | 880-D0670L50-04 | 50.00 | 344.70 | 426.00 | 281.77 | 1.30 | 88° | 10 | 7.900 | 5000 |
| 68.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0680L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 8.460 | 5000 |
| | | | | | 276.00 | 50 | -0.30 | 0.30 | 880-D0680L50-04 | 50.00 | 344.70 | 426.00 | 281.77 | 1.30 | 88° | 10 | 7.900 | 5000 |
| 69.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0690L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 8.460 | 5000 |
| | | | | | 276.00 | 50 | -0.30 | 0.30 | 880-D0690L50-04 | 50.00 | 344.70 | 426.00 | 281.77 | 1.30 | 88° | 10 | 7.900 | 5000 |
| 70.00 | 06C | 06P | 06P | 06P | 222.00 | 50 | -0.30 | 0.30 | 880-D0700L50-03 | 50.00 | 300.60 | 382.00 | 249.63 | 1.40 | 88° | 10 | 9.485 | 5000 |
| | | | | | 296.00 | 50 | -0.30 | 0.30 | 880-D0700L50-04 | 50.00 | 374.60 | 456.00 | 323.63 | 1.40 | 88° | 10 | 10.980 | 5000 |
| 71.00 | 06C | 06P | 06P | 06P | 222.00 | 50 | -0.30 | 0.30 | 880-D0710L50-03 | 50.00 | 300.60 | 382.00 | 249.63 | 1.40 | 88° | 10 | 9.450 | 5000 |
| | | | | | 296.00 | 50 | -0.30 | 0.30 | 880-D0710L50-04 | 50.00 | 374.60 | 456.00 | 323.63 | 1.40 | 88° | 10 | 11.217 | 5000 |
| 72.00 | 06C | 06P | 06P | 06P | 222.00 | 50 | -0.30 | 0.30 | 880-D0720L50-03 | 50.00 | 300.60 | 382.00 | 249.63 | 1.40 | 88° | 10 | 9.515 | 5000 |
| | | | | | 296.00 | 50 | -0.30 | 0.30 | 880-D0720L50-04 | 50.00 | 374.60 | 456.00 | 323.63 | 1.40 | 88° | 10 | 11.320 | 5000 |
| 73.00 | 06C | 06P | 06P | 06P | 222.00 | 50 | -0.30 | 0.30 | 880-D0730L50-03 | 50.00 | 300.60 | 382.00 | 249.63 | 1.40 | 88° | 10 | 9.400 | 5000 |
| | | | | | 296.00 | 50 | -0.30 | 0.30 | 880-D0730L50-04 | 50.00 | 374.60 | 456.00 | 323.63 | 1.40 | 88° | 10 | 11.370 | 5000 |
| 74.00 | 06C | 06P | 07P | 07P | 222.00 | 50 | -0.30 | 0.30 | 880-D0740L50-03 | 50.00 | 300.60 | 382.00 | 249.63 | 1.40 | 88° | 10 | 9.350 | 5000 |
| | | | | | 296.00 | 50 | -0.30 | 0.30 | 880-D0740L50-04 | 50.00 | 374.60 | 456.00 | 323.63 | 1.40 | 88° | 10 | 11.275 | 5000 |
| 75.00 | 07C | 07P | 07P | 07P | 237.00 | 50 | -0.30 | 0.30 | 880-D0750L50-03 | 50.00 | 305.60 | 387.00 | 255.15 | 1.40 | 88° | 10 | 10.250 | 5000 |
| | | | | | 316.00 | 50 | -0.30 | 0.30 | 880-D0750L50-04 | 50.00 | 384.60 | 466.00 | 334.15 | 1.40 | 88° | 10 | 12.325 | 5000 |
| 76.00 | 07C | 07P | 07P | 07P | 237.00 | 50 | -0.30 | 0.30 | 880-D0760L50-03 | 50.00 | 305.60 | 387.00 | 255.15 | 1.40 | 88° | 10 | 10.700 | 5000 |
| | | | | | 316.00 | 50 | -0.30 | 0.30 | 880-D0760L50-04 | 50.00 | 384.60 | 466.00 | 334.15 | 1.40 | 88° | 10 | 12.250 | 5000 |
| 77.00 | 07C | 07P | 07P | 07P | 237.00 | 50 | -0.30 | 0.30 | 880-D0770L50-03 | 50.00 | 305.60 | 387.00 | 255.15 | 1.40 | 88° | 10 | 10.700 | 5000 |
| | | | | | 316.00 | 50 | -0.30 | 0.30 | 880-D0770L50-04 | 50.00 | 384.60 | 466.00 | 334.15 | 1.40 | 88° | 10 | 12.268 | 5000 |
| 78.00 | 07C | 07P | 07P | 07P | 237.00 | 50 | -0.30 | 0.30 | 880-D0780L50-03 | 50.00 | 305.60 | 387.00 | 255.15 | 1.40 | 88° | 10 | 10.700 | 5000 |
| | | | | | 316.00 | 50 | -0.30 | 0.30 | 880-D0780L50-04 | 50.00 | 384.60 | 466.00 | 334.15 | 1.40 | 88° | 10 | 12.385 | 5000 |
| 79.00 | 07C | 07P | 07P | 07P | 237.00 | 50 | -0.30 | 0.30 | 880-D0790L50-03 | 50.00 | 305.60 | 387.00 | 255.15 | 1.40 | 88° | 10 | 10.700 | 5000 |
| | | | | | 316.00 | 50 | -0.30 | 0.30 | 880-D0790L50-04 | 50.00 | 384.60 | 466.00 | 334.15 | 1.40 | 88° | 10 | 12.230 | 5000 |



VL coupling

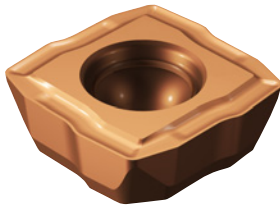
| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|-------|---------|-----|-----|-----|--------|-------------------|-------|-------|-----------------|----------------|--------|--------|-----------------|------|------|-----|--------|------|
| DC | C I I P | | | | LU | CZC _{MS} | TCHAL | TCHAU | Ordering code | DCON | LF | OAL | LB ₁ | PL | KAPR | BAR | KG | RPMX |
| 80.00 | 07C | 07P | 07P | 07P | 252.00 | 80 | -0.30 | 0.30 | 880-D0800V80-03 | 80.00 | 330.50 | 350.00 | 287.61 | 1.50 | 88° | 10 | 10.500 | 5000 |
| | | | | | 336.00 | 80 | -0.30 | 0.30 | 880-D0800V80-04 | 80.00 | 414.50 | 434.00 | 371.61 | 1.50 | 88° | 10 | 13.300 | 5000 |
| 81.00 | 07C | 07P | 07P | 07P | 252.00 | 80 | -0.30 | 0.30 | 880-D0810V80-03 | 80.00 | 330.50 | 350.00 | 287.61 | 1.50 | 88° | 10 | 12.700 | 5000 |
| | | | | | 336.00 | 80 | -0.30 | 0.30 | 880-D0810V80-04 | 80.00 | 414.50 | 434.00 | 371.61 | 1.50 | 88° | 10 | 13.125 | 5000 |
| 82.00 | 07C | 07P | 07P | 07P | 252.00 | 80 | -0.30 | 0.30 | 880-D0820V80-03 | 80.00 | 330.50 | 350.00 | 287.61 | 1.50 | 88° | 10 | 12.700 | 5000 |
| | | | | | 336.00 | 80 | -0.30 | 0.30 | 880-D0820V80-04 | 80.00 | 414.50 | 434.00 | 371.61 | 1.50 | 88° | 10 | 13.205 | 5000 |
| 83.00 | 07C | 07P | 07P | 07P | 252.00 | 80 | -0.30 | 0.30 | 880-D0830V80-03 | 80.00 | 330.50 | 350.00 | 287.61 | 1.50 | 88° | 10 | 12.700 | 5000 |
| | | | | | 336.00 | 80 | -0.30 | 0.30 | 880-D0830V80-04 | 80.00 | 414.50 | 434.00 | 371.61 | 1.50 | 88° | 10 | 15.100 | 5000 |
| 84.00 | 07C | 07P | 07P | 07P | 252.00 | 80 | -0.30 | 0.30 | 880-D0840V80-03 | 80.00 | 330.50 | 350.00 | 287.61 | 1.50 | 88° | 10 | 12.700 | 5000 |
| | | | | | 336.00 | 80 | -0.30 | 0.30 | 880-D0840V80-04 | 80.00 | 414.50 | 434.00 | 371.61 | 1.50 | 88° | 10 | 13.300 | 5000 |

Cartridges are included, inserts are sold separately

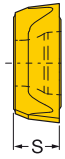
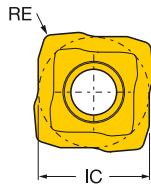


CoroDrill® 880 insert for drilling

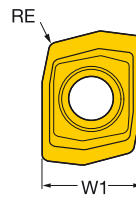
Central insert



880..C



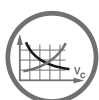
880-01..C



| INSUC | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | |
|-------------|---------------|----------------|--------------------|--------------------|------|------|------|------|------|------|------|---|----|------|------|------|------|
| | | P | | M | | K | | N | | S | | H | | | | | |
| | | 1044 | 1044 | 1144 | 1044 | H13A | N134 | 1044 | 1144 | H13A | 1044 | S | RE | IC | W1 | | |
| Medium feed | 01C | C | 880-01 02 03H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 2.20 | 0.30 | 4.8 |
| | 02C | C | 880-02 02 04H-C-GM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 2.40 | 0.40 | 4.9 |
| | | C | 880-02 02 04H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 2.40 | 0.40 | 4.9 |
| | 03C | C | 880-03 03 05H-C-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | 2.60 | 0.50 | 5.7 |
| | | C | 880-03 03 05H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 2.60 | 0.50 | 5.7 |
| | 04C | C | 880-04 03 05H-C-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | 2.80 | 0.50 | 6.8 |
| | | C | 880-04 03 05H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 2.80 | 0.50 | 6.8 |
| | 05C | C | 880-05 03 05H-C-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | 3.00 | 0.50 | 8.4 |
| | | C | 880-05 03 05H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 3.00 | 0.50 | 8.4 |
| | 06C | C | 880-06 04 06H-C-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | 3.50 | 0.60 | 10.2 |
| | | C | 880-06 04 06H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 3.50 | 0.60 | 10.2 |
| | 07C | C | 880-07 04 06H-C-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | 4.00 | 0.60 | 12.4 |
| | | C | 880-07 04 06H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 4.00 | 0.60 | 12.4 |
| | 08C | C | 880-08 05 08H-C-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | 4.50 | 0.80 | 14.9 |
| | | C | 880-08 05 08H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 4.50 | 0.80 | 14.9 |
| | 09C | C | 880-09 06 08H-C-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ★ | 5.50 | 0.80 | 17.9 |
| | | C | 880-09 06 08H-C-LM | ★ | ☆ | ★ | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ★ | 5.50 | 0.80 | 17.9 |
| | High feed | 01C | C | 880-01 02 03H-C-GR | ★ | | ★ | ☆ | | | ☆ | | | ★ | 2.20 | 0.30 | 4.8 |
| 02C | | C | 880-02 02 04H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 2.40 | 0.40 | 4.9 | |
| 03C | | C | 880-03 03 05H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 2.60 | 0.50 | 5.7 | |
| 04C | | C | 880-04 03 05H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 2.80 | 0.50 | 6.8 | |
| 05C | | C | 880-05 03 05H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 3.00 | 0.50 | 8.4 | |
| 06C | | C | 880-06 04 06H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 3.50 | 0.60 | 10.2 | |
| 07C | | C | 880-07 04 06H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 4.00 | 0.60 | 12.4 | |
| 08C | | C | 880-08 05 08H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 4.50 | 0.80 | 14.9 | |
| 09C | | C | 880-09 06 08H-C-GR | ★ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | 5.50 | 0.80 | 17.9 | |



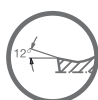
J36



J62



J35



J35



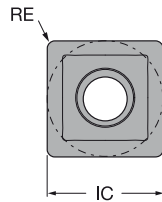
N23

CoroDrill® 880 insert for drilling

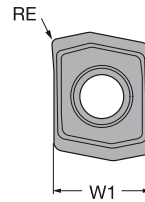
Peripheral insert



880..P



880-01..P



| INSUC | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | | |
|-------------|---------------|---------------------|---------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | | P | | M | | K | | N | | S | | H | | | | | | | | |
| | | 4324 | 4334 | 4344 | 2044 | 4334 | 4324 | 4334 | 4344 | 4344 | H13A | N124 | 2044 | 4344 | H13A | 4334 | | | | |
| S | RE | IC | W1 | | | | | | | | | | | | | | | | | |
| Medium feed | 01P | P | 880-01 02 W04H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.20 | 0.40 | 4.8 |
| | | P | 880-01 02 W04H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.20 | 0.40 | 4.8 |
| | 02P | P | 880-02 02 W04H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.40 | 0.40 | 5.1 |
| | | P | 880-02 02 W05H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.40 | 0.50 | 5.1 |
| | | P | 880-02 02 W05H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.40 | 0.50 | 5.1 |
| | 03P | P | 880-03 03 W05H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.60 | 0.50 | 6.0 |
| | | P | 880-03 03 W06H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.60 | 0.60 | 6.0 |
| | | P | 880-03 03 W06H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.60 | 0.60 | 6.0 |
| | 04P | P | 880-04 03 W05H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.80 | 0.50 | 7.4 |
| | | P | 880-04 03 W07H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.80 | 0.70 | 7.4 |
| | | P | 880-04 03 W07H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.80 | 0.70 | 7.4 |
| | 05P | P | 880-05 03 W05H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.00 | 0.50 | 8.9 |
| | | P | 880-05 03 W08H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.00 | 0.80 | 8.9 |
| | | P | 880-05 03 W08H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.00 | 0.80 | 8.9 |
| | 06P | P | 880-06 04 W06H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.50 | 0.60 | 10.7 |
| | | P | 880-06 04 W08H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.50 | 0.80 | 10.7 |
| | | P | 880-06 04 W08H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.50 | 0.80 | 10.7 |
| | 07P | P | 880-07 04 W06H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.00 | 0.60 | 12.7 |
| | P | 880-07 04 W10H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.00 | 1.00 | 12.7 | |
| | P | 880-07 04 W10H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.00 | 1.00 | 12.7 | |
| 08P | P | 880-08 05 W08H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.50 | 0.80 | 15.5 | |
| | P | 880-08 05 W10H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.50 | 1.00 | 15.5 | |
| | P | 880-08 05 W10H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.50 | 1.00 | 15.5 | |
| 09P | P | 880-09 06 W08H-P-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 5.50 | 0.80 | 18.6 | |
| | P | 880-09 06 W10H-P-LM | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 5.50 | 1.00 | 18.6 | |
| | P | 880-09 06 W10H-P-MS | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 5.50 | 1.00 | 18.6 | |
| High feed | 01P | P | 880-01 02 W04H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.20 | 0.40 | 4.8 |
| | 02P | P | 880-02 02 W05H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.40 | 0.50 | 5.1 |
| | | P | 880-02 02 W05H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.40 | 0.50 | 5.1 |
| | 03P | P | 880-03 03 W06H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.60 | 0.60 | 6.0 |
| | | P | 880-03 03 W06H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.60 | 0.60 | 6.0 |
| | 04P | P | 880-04 03 W07H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.80 | 0.70 | 7.4 |
| | | P | 880-04 03 W07H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.80 | 0.70 | 7.4 |
| | 05P | P | 880-05 03 W08H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.00 | 0.80 | 8.9 |
| | | P | 880-05 03 W08H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.00 | 0.80 | 8.9 |
| | 06P | P | 880-06 04 W10H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.50 | 1.00 | 10.7 |
| | | P | 880-06 04 W10H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.50 | 1.00 | 10.7 |
| | 07P | P | 880-07 04 W12H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.00 | 1.20 | 12.7 |
| | | P | 880-07 04 W12H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.00 | 1.20 | 12.7 |
| | 08P | P | 880-08 05 W12H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.50 | 1.20 | 15.5 |
| | | P | 880-08 05 W12H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.50 | 1.20 | 15.5 |
| | 09P | P | 880-09 06 W12H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 5.50 | 1.20 | 18.6 |
| | | P | 880-09 06 W12H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 5.50 | 1.20 | 18.6 |



J36



J62



J35



J35



N23

Trepanning tool

Proven concept for core drilling

Applications

- Trepanning
- Through-hole applications
- Stack drilling

ISO application area:



Benefits and features

- Excellent reliability in unstable applications and lathe applications
- Internal coolant supply
- Stack drilling cartridges available

Drill bodies

- VL coupling

Inserts

- Geometries and grades for most materials

Vertical setup

The core will fall down when drill breaks through, which does not normally cause a problem.

Horizontal setup

Long and heavy cores may require a core support to prevent the core from falling down and chipping the inner insert.



J45

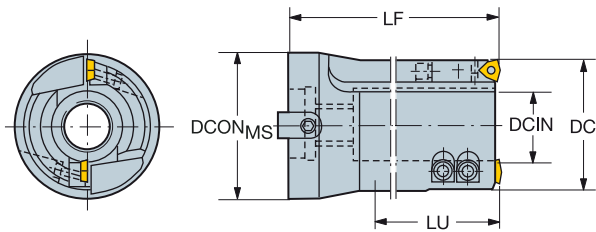


J46

Trepanning tool

VL coupling

Internal coolant supply



| | | | | | | | Dimensions, mm | | | | | |
|--------|-------|----|-------------------|-------|-------|---------------|--------------------|-------|--------|-----|----|--------|
| DC | DCIN | LU | CZC _{MS} | TCHAL | TCHAU | Ordering code | DCON _{MS} | LF | KAPR | BAR | KG | |
| 60.00 | 24.00 | 06 | 150.00 | 80 | -0.20 | 0.20 | R416.7-0600-25-01 | 80.00 | 195.00 | 85° | 20 | 3.160 |
| 65.00 | 29.00 | 06 | 165.00 | 80 | -0.20 | 0.20 | R416.7-0650-25-01 | 80.00 | 210.00 | 85° | 20 | 3.853 |
| 70.00 | 34.00 | 06 | 175.00 | 80 | -0.20 | 0.20 | R416.7-0700-25-01 | 80.00 | 220.00 | 85° | 20 | 4.080 |
| 75.00 | 39.00 | 06 | 190.00 | 80 | -0.20 | 0.20 | R416.7-0750-25-01 | 80.00 | 235.00 | 85° | 20 | 4.757 |
| 80.00 | 44.00 | 06 | 200.00 | 80 | -0.20 | 0.20 | R416.7-0800-25-01 | 80.00 | 245.00 | 85° | 20 | 5.524 |
| 85.00 | 49.00 | 06 | 215.00 | 80 | -0.20 | 0.20 | R416.7-0850-25-01 | 80.00 | 260.00 | 85° | 20 | 6.040 |
| 90.00 | 54.00 | 06 | 225.00 | 80 | -0.20 | 0.20 | R416.7-0900-25-01 | 80.00 | 270.00 | 85° | 20 | 6.700 |
| 95.00 | 59.00 | 06 | 240.00 | 80 | -0.20 | 0.20 | R416.7-0950-25-01 | 80.00 | 285.00 | 85° | 20 | 7.700 |
| 100.00 | 64.00 | 06 | 250.00 | 80 | -0.20 | 0.20 | R416.7-1000-25-01 | 80.00 | 295.00 | 85° | 20 | 8.634 |
| 110.00 | 74.00 | 06 | 275.00 | 80 | -0.20 | 0.20 | R416.7-1100-25-01 | 80.00 | 320.00 | 85° | 20 | 10.080 |

For mounting information see page M28

Spare parts

| Driving key | Screw | Screw |
|-------------|--------------|------------|
| 5631 010-03 | 3212 010-360 | 430.21-825 |

For complete list of spare parts, see www.sandvik.coromant.com

Accessories

Cartridge for trepanning tool

| Inner | Insert | Peripheral | Insert |
|-----------------|---------|-----------------|---------|
| L430.23-1117-06 | WCMX 06 | R430.26-1114-06 | WCMX 06 |

Cartridge for stack drilling with trepanning tool

| Inner | Insert | Peripheral | Insert |
|-------------------|---------|-------------------|---------|
| L430.23-1117-06SD | WCMX 06 | R430.26-1114-06SD | WCMX 06 |

Accessories, must be ordered separately



J46



L2

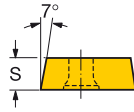
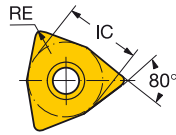
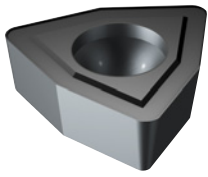


N23



N15

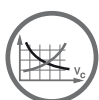
Trepanning inserts



| | | | | P | | | M | | | K | | | N | | S | | Dimensions, mm | | | | | |
|-------------|----|-------|--------------------|------|-----|------|------|------|-----|------|------|------|------|------|------|------|----------------|------|------|------|------|-----|
| | | INSUC | | 1020 | 235 | 3040 | 4235 | 1020 | 235 | 3040 | 4235 | 1020 | 1125 | 3040 | 4235 | 1020 | HT3A | 1020 | HT3A | S | RE | IC |
| Medium feed | 06 | P | WCMX 06 T3 08 R-51 | ☆ | ☆ | ★ | | ☆ | ☆ | ★ | | ☆ | | ★ | | ☆ | ★ | ☆ | ☆ | 3.97 | 0.80 | 9.5 |
| | | P | WCMX 06 T3 08 R-53 | ☆ | ☆ | ★ | | ☆ | ☆ | ★ | | ☆ | | ★ | | ☆ | ★ | ☆ | ☆ | 3.97 | 0.80 | 9.5 |
| | | P | WCMX 06 T3 08-56 | ☆ | ☆ | ★ | | ☆ | ☆ | ★ | | ☆ | | ★ | | ☆ | ★ | ☆ | ☆ | 3.97 | 0.80 | 9.5 |
| | | P | WCMX 06 T3 08-58 | ☆ | ☆ | ★ | | ☆ | ☆ | ★ | | ☆ | | ★ | | ☆ | ★ | ☆ | ☆ | 3.97 | 0.80 | 9.5 |
| | | P | WCMX 06 T3 08-GM | ☆ | ☆ | ★ | | ☆ | ☆ | ★ | | ☆ | | ★ | | ☆ | ★ | ☆ | ☆ | 3.97 | 0.80 | 9.5 |



J45

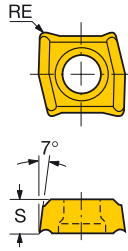
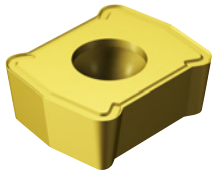


J67

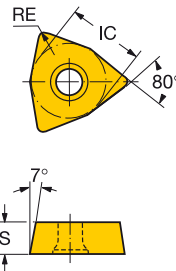
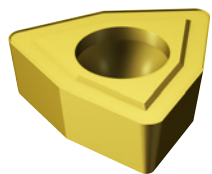


N23

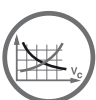
Coromant U insert for drilling



| Medium feed | INSUC | Ordering code | P | | | | | | | | | | | | M | | | K | | | N | | | S | | | H | | | Dimensions, mm | |
|-------------|-------|--------------------|------|------|-----|------|------|------|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|--|---|--|--|----------------|--|
| | | | 1020 | 1120 | 235 | 3040 | 1020 | 1120 | 235 | 3040 | 1020 | 1120 | 3040 | 1020 | 1120 | H13A | 1020 | 1120 | H13A | 1020 | 1120 | 3040 | S | RE | | | | | | | |
| | | | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | | | | | | |
| 02 | C | LCMX 02 02 04C-53 | ★ | | | | ★ | | | | | ★ | | | | | | | | | | | 2.38 | 0.40 | | | | | | | |
| | P | LCMX 02 02 04P-53 | | ☆ | | ★ | | | | | ★ | | | ★ | | | ★ | | | | | | 2.38 | 0.40 | | | | | | | |
| | C | LCMX 02 02 04TC-53 | ☆ | | | | | | | | ☆ | | | | | | | | | | ☆ | | | 2.38 | 0.40 | | | | | | |
| | P | LCMX 03 03 04-58 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.40 | | | | | | |
| | P | LCMX 03 03 04R-WM | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.45 | | | | | | |
| | P+C | LCMX 03 03 08-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |
| 03 | P+C | LCMX 03 03 08T-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |
| | P | LCMX 04 03 04-58 | | | ☆ | | | ☆ | | ☆ | | | | | | | | | | | | | | 3.18 | 0.40 | | | | | | |
| | P | LCMX 04 03 04R-WM | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.40 | | | | | | |
| | P+C | LCMX 04 03 08-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |
| | P+C | LCMX 04 03 08T-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |
| | P | LCMX 04 03 04-58 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.40 | | | | | | |
| 04 | P | LCMX 04 03 04R-WM | | | ☆ | | | ☆ | | ☆ | | | | | | | | | | | | | | 3.18 | 0.40 | | | | | | |
| | P+C | LCMX 04 03 08-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |
| | P+C | LCMX 04 03 08T-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |
| | P | LCMX 04 03 04-58 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.40 | | | | | | |
| | P | LCMX 04 03 04R-WM | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.40 | | | | | | |
| | P+C | LCMX 04 03 08-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |
| 05 | P+C | LCMX 04 03 08T-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ★ | | ★ | | ★ | | ☆ | | ★ | | | 3.18 | 0.80 | | | | | | |



| Medium feed | INSUC | Ordering code | P | | | | | | | | | | | | M | | | K | | | | N | | | S | | H | | Dimensions, mm | | |
|-------------|-------|--------------------|--------------------|------|-----|------|------|------|------|-----|------|------|------|------|-----|------|------|------|------|------|------|------|------|------|------|------|-----|---|----------------|--|--|
| | | | 1020 | 1125 | 235 | 3040 | 4235 | 1020 | 1125 | 235 | 3040 | 4235 | 1020 | 1125 | 235 | 3040 | 4235 | 1020 | H13A | 1020 | H13A | 1020 | 3040 | S | RE | IC | | | | | |
| | | | ☆ | ☆ | ★ | ☆ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | ☆ | ★ | | | |
| 05 | P | WCMX 05 03 04R-WM | ☆ | | | | | | | | | | | | | | | | | | | | | 3.18 | 0.40 | 7.9 | | | | | |
| | P | WCMX 05 03 08 R-51 | | | ☆ | | | | | | | | | | | | | | | | | | | 3.18 | 0.80 | 7.9 | | | | | |
| | P+C | WCMX 05 03 08 R-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | 3.18 | 0.80 | 7.9 | | | | | |
| | P+C | WCMX 05 03 08 T-53 | ☆ | | | | | | | | | | | | | | | | | | | | | 3.18 | 0.80 | 7.9 | | | | | |
| | P | WCMX 05 03 08-56 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.80 | 7.9 | | | | | |
| | P | WCMX 05 03 08-58 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.18 | 0.80 | 7.9 | | | | | |
| | C | WCMX 05 03 S R-54 | | | ☆ | | | | | | | | | ☆ | | | | | | | | | | 3.18 | 0.40 | 7.9 | | | | | |
| | 06 | P | WCMX 06 T3 04R-WM | ☆ | | | | | | | | | | | | | | | | | | | | | 3.97 | 0.40 | 9.5 | | | | |
| | | P | WCMX 06 T3 08 R-51 | | | ☆ | | | | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 | | | | |
| | | P+C | WCMX 06 T3 08 R-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | 3.97 | 0.80 | 9.5 | | | | |
| | | P+C | WCMX 06 T3 08 T-53 | ☆ | | | | | | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 | | | | |
| | | P | WCMX 06 T3 08-56 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 | | | | |
| P | | WCMX 06 T3 08-58 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 | | | | | |
| 08 | P+C | WCMX 06 T3 08-GM | | ☆ | | | ☆ | | | | ☆ | | | | ☆ | | | | | | | | | 3.97 | 0.80 | 9.5 | | | | | |
| | C | WCMX 06 T3 S R-56 | | | ☆ | | | | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 | | | | | |
| | P | WCMX 08 04 12 R-51 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | ☆ | | ☆ | | | 4.76 | 1.20 | 12.7 | | | | | |
| | P+C | WCMX 08 04 12 R-53 | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | | ☆ | | ★ | 4.76 | 1.20 | 12.7 | | | | | |
| | P+C | WCMX 08 04 12 T-53 | ☆ | | | | | | | | | | | | | | | | | | | | | 4.76 | 1.20 | 12.7 | | | | | |
| | P | WCMX 08 04 12-56 | | | ☆ | | | | ☆ | | ☆ | | | | | | | | | | | | | 4.76 | 1.20 | 12.7 | | | | | |
| 08 | P | WCMX 08 04 12-58 | | | ☆ | | | ☆ | | ☆ | | | | | | | | | | | | | | 4.76 | 1.20 | 12.7 | | | | | |
| | P+C | WCMX 08 04 12-GM | | ☆ | | | ☆ | | | | ☆ | | | | ☆ | | | | | | | | | 4.76 | 1.20 | 12.7 | | | | | |
| | C | WCMX 08 04 S R-56 | | | ☆ | | | | | | | | | | | | | | | | | | | 4.76 | 0.40 | 12.7 | | | | | |



J68



N23



CoroDrill® 880 large diameter drill

Insert to cartridge correlation

| Diameter range, mm | Central cartridge | | Peripheral cartridge | |
|--------------------|-------------------|-----|----------------------|-----|
| | Insert | Qty | Insert | Qty |
| 65-69 | 880-06...C | 1 | 880-06...P | 2 |
| | 880-06...P | 1 | | |
| 70-73 | 880-06...C | 1 | 880-06...P | 2 |
| | 880-06...P | 1 | | |
| 74 | 880-06...C | 1 | 880-07...P | 2 |
| | 880-06...P | 1 | | |
| 75-79 | 880-07...C | 1 | 880-07...P | 2 |
| | 880-07...P | 1 | | |
| 80-84 | 880-07...C | 1 | 880-07...P | 2 |
| | 880-07...P | 1 | | |

| DC Ordering code | | Included parts | | | |
|------------------|-----------------|--------------------|--------------------|-------------|-------------|
| | | Drill body | | Cartridge | |
| | | 3xD | 4xD | Central | Peripheral |
| 65 | 880-D0650xxx-xx | | | | |
| 66 | 880-D0660xxx-xx | 880-D065-069L50-3 | 880-D065-069L50-4 | 880-D0650-C | 880-D0650-P |
| 67 | 880-D0670xxx-xx | 880-D065-069LX50-3 | 880-D065-069LX50-4 | | 880-D0660-P |
| 68 | 880-D0680xxx-xx | 880-D065-069V80-3 | 880-D065-069V80-4 | | 880-D0670-P |
| 69 | 880-D0690xxx-xx | | | | 880-D0680-P |
| 70 | 880-D0700xxx-xx | | | | 880-D0690-P |
| 71 | 880-D0710xxx-xx | 880-D070-074L50-3 | 880-D070-074L50-4 | 880-D0700-C | 880-D0700-P |
| 72 | 880-D0720xxx-xx | 880-D070-074LX50-3 | 880-D070-074LX50-4 | | 880-D0710-P |
| 73 | 880-D0730xxx-xx | 880-D070-074V80-3 | 880-D070-074V80-4 | | 880-D0720-P |
| 74 | 880-D0740xxx-xx | | | | 880-D0730-P |
| 75 | 880-D0750xxx-xx | | | | 880-D0740-P |
| 76 | 880-D0760xxx-xx | 880-D075-079L50-3 | 880-D075-079L50-4 | 880-D0750-C | 880-D0750-P |
| 77 | 880-D0770xxx-xx | 880-D075-079LX50-3 | 880-D075-079LX50-4 | | 880-D0760-P |
| 78 | 880-D0780xxx-xx | 880-D075-079V80-3 | 880-D075-079V80-4 | | 880-D0770-P |
| 79 | 880-D0790xxx-xx | | | | 880-D0780-P |
| 80 | 880-D0800xxx-xx | | | | 880-D0790-P |
| 81 | 880-D0810xxx-xx | | | | 880-D0800-P |
| 82 | 880-D0820xxx-xx | 880-D080-084LX63-3 | 880-D080-084LX63-4 | 880-D0800-C | 880-D0810-P |
| 83 | 880-D0830xxx-xx | 880-D080-084V80-3 | 880-D080-084V80-4 | | 880-D0820-P |
| 84 | 880-D0840xxx-xx | | | | 880-D0830-P |
| | | | | | 880-D0840-P |

Selecting your cutting data

Chip formation and chip evacuation are critical issues in drilling and depend on the workpiece material, choice of drill/insert geometry, coolant pressure/volume and cutting data. Chip jamming can cause radial movement of the drill and consequently affect hole quality, drill life and reliability or drill/insert breakages.

Chip formation is acceptable when the chips can be evacuated from the drill without disturbance. The best way to identify this is to listen during drilling. A consistent sound means that chip evacuation is good, but an interrupted sound indicates chip jamming. Check the feed force or power monitor. If there are irregularities, chip jamming could be the reason. Look at the chips: if they are long and bent, instead of curled, chip jamming has occurred. Look at the hole: if chip jamming has occurred, an uneven surface will be visible

Effects of cutting speed – v_c

Cutting speed that is too high:

Rapid flank wear
Plastic deformation
Poor hole quality and bad hole tolerance

Cutting speed that is too low:

Built-up edge
Bad chip evacuation
Longer time in cut

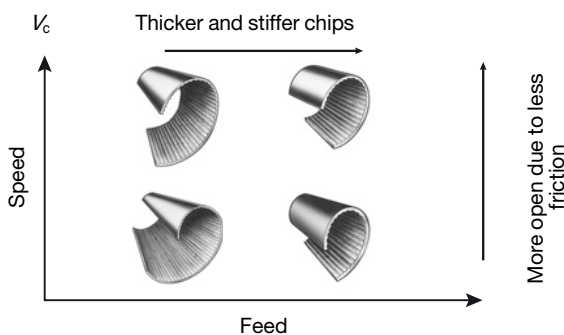
Effects of feed – f_n

High feed rate:

Harder chip breaking
Less time in cut
Less tool wear but increased risk for drill breakages
Reduced hole quality

Low feed rate:

Preferable for long-chipping materials
Quality improvement
Accelerated tool wear
Longer time in cut



Achieving good hole quality

Chip evacuation

Make sure chip evacuation is satisfactory. Chip jamming affects hole quality and reliability/tool life. Drill/insert geometry and cutting data are crucial.

Stability, tool set-up

Use the shortest possible drill. Use a rigid and accurate tool holder with minimum run-out. Make sure the machine spindle is in good condition and is well-aligned. Ensure that the component is fixed and stable. Establish correct feed rates for irregular, angular surfaces and cross holes.

Tool life

Check insert wear and establish a predetermined tool life program. The most effective way to supervise drilling is by using a feed force monitor.

Maintenance

Change the insert-clamping screw regularly. Clean the tip seat before changing the insert, and make sure to use a torque wrench. Don't exceed maximum wear before regrinding solid carbide drills.

Drilling deep holes with CoroDrill® DS20

If best possible hole quality is needed when drilling 6-7xD holes with CoroDrill DS20, it is important to utilize a reduced feed rate at the entry (first 1-2 mm) and exit (last 5 mm).

CoroDrill® 870

< 6 x DC

| ISO | MC No. | CMC No. | Material | Hardness Brinell (HB) | Cutting speed (V _c) m/min correlating with drill diameter | | | | | | |
|-----------|-----------|---|--|-----------------------|---|------|------|----------------|------|------|--|
| | | | | | 10.00-20.99 mm | | | 21.00-33.00 mm | | | |
| | | | | | Min. | Rec. | Max. | Min. | Rec. | Max. | |
| P | | | Unalloyed steel | | Grade 4334 | | | | | | |
| | P1.1.Z.AN | 01.1 | C=0.10-0.25% | 125 | 80 | 120 | 160 | 80 | 120 | 160 | |
| | P1.2.Z.AN | 01.2 | C=0.25-0.55% | 190 | 80 | 120 | 160 | 80 | 120 | 160 | |
| | P1.3.Z.AN | 01.3 | C=0.55-0.80% | 190 | 70 | 100 | 130 | 70 | 100 | 130 | |
| | P1.5.C.UT | 06.1 | Cast - untreated | 150 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | | | Low alloy steel | | Grade 4334 and 3334 | | | | | | |
| | P2.1.Z.AN | 02.1 | Annealed | 175 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | P2.2.Z.AN | 02.1 | Annealed | 240 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | P2.4.Z.AN | 02.1 | Annealed | 225 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | P2.5.Z.HT | 02.2 | Hardened and tempered | 330 | 70 | 100 | 130 | 50 | 75 | 100 | |
| P2.6.C.UT | 06.2 | Cast - untreated | 200 | 70 | 100 | 130 | 70 | 100 | 130 | | |
| | | High alloy steel | | | | | | | | | |
| P3.0.Z.AN | 03.11 | Annealed | 200 | 60 | 80 | 100 | 60 | 80 | 100 | | |
| P3.0.Z.HT | 03.21 | Hardened and tempered | 380 | 40 | 60 | 80 | 40 | 60 | 80 | | |
| M | | | Ferritic/martensitic stainless steel | | Grade 4334 and 2334 | | | | | | |
| | P5.0.Z.AN | 05.11 | Annealed | 200 | 30 | 40 | 50 | 30 | 40 | 50 | |
| | P5.0.Z.HT | 05.13 | Hardened and tempered | 330 | 70 | 90 | 110 | 60 | 75 | 90 | |
| | | | Austenitic stainless steel | | Grade 2334 and 4334 | | | | | | |
| | M1.0.Z.AQ | 05.21 | Annealed/quenched | 200 | 40 | 50 | 60 | 40 | 50 | 60 | |
| | M1.0.C.UT | 15.21 | Cast-untreated | 200 | 50 | 60 | 70 | 50 | 60 | 70 | |
| | M1.1.Z.AQ | 05.21 | Machinability improved | 200 | 60 | 75 | 90 | 60 | 75 | 90 | |
| | | | Super-austenitic (Ni≥20%) stainless steel | | | | | | | | |
| | M2.0.Z.AQ | 05.23 | Annealed/quenched | 200 | 20 | 40 | 60 | 20 | 40 | 60 | |
| | M2.0.C.AQ | 15.23 | Cast+annealed/quenched | 200 | 20 | 40 | 60 | 20 | 40 | 60 | |
| | | Duplex (austenitic/ferritic) stainless steel | | | | | | | | | |
| M3.1.Z.AQ | 05.51 | >60% ferrite (N<0.10%) | 230 | 40 | 55 | 70 | 40 | 55 | 70 | | |
| M3.2.Z.AQ | 05.52 | <60% ferrite (N≥0.10%) | 260 | 20 | 40 | 60 | 20 | 40 | 60 | | |
| K | | | Malleable cast iron | | Grade 3334 and 4334 | | | | | | |
| | K1.1.C.NS | 07.1 | Ferritic (short chipping) | 130 | 100 | 145 | 190 | 100 | 145 | 190 | |
| | K1.1.C.NS | 07.2 | Pearlitic (long chipping) | 200 | 90 | 125 | 160 | 90 | 125 | 160 | |
| | | | Grey cast iron | | | | | | | | |
| | K2.1.C.UT | 08.1 | Low tensile strength | 180 | 100 | 150 | 200 | 100 | 150 | 200 | |
| | K2.2.C.UT | 08.2 | High tensile strength | 245 | 90 | 130 | 170 | 90 | 130 | 170 | |
| | | Nodular cast iron | | | | | | | | | |
| K3.1.C.UT | 09.1 | Ferritic | 155 | 100 | 145 | 190 | 100 | 145 | 190 | | |
| K3.3.C.UT | 09.2 | Pearlitic | 265 | 90 | 125 | 160 | 90 | 125 | 160 | | |
| N | | | Aluminium based alloys | | Grade 4334 | | | | | | |
| | N1.2.Z.AG | 30.12 | AlSi alloys, Si ≤ 1% | 100 | 150 | 200 | 250 | 150 | 200 | 250 | |
| N1.3.C.AG | 30.22 | AlSi cast alloys, Si > 1% and < 13% | 80 | 150 | 200 | 250 | 150 | 200 | 250 | | |
| S | | | Heat resistant super alloys | | Grade 2334 and 4334 | | | | | | |
| | S2.0.Z.AG | 20.22 | Ni based | 350 | 18 | 20 | 30 | 18 | 20 | 30 | |
| S4.3.Z.AN | 23.21 | Titanium based | 330 | 25 | 40 | 60 | 25 | 40 | 60 | | |

CoroDrill® 870

< 6 x DC

| Feed (f_n) mm/r correlating with drill diameter | | | | | | | | | | | | | | | | | |
|---|------|------|----------------|------|------|----------------|------|------|----------------|------|------|----------------|------|------|----------------|------|------|
| 10.00-11.99 mm | | | 12.00-13.99 mm | | | 14.00-15.99 mm | | | 16.00-20.99 mm | | | 21.00-25.99 mm | | | 26.00-33.00 mm | | |
| Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. |
| Geometry -PM and -GP | | | | | | | | | | | | | | | | | |
| 0.12 | 0.18 | 0.28 | 0.14 | 0.20 | 0.35 | 0.16 | 0.25 | 0.41 | 0.20 | 0.32 | 0.45 | 0.20 | 0.34 | 0.45 | 0.20 | 0.34 | 0.45 |
| 0.12 | 0.18 | 0.28 | 0.14 | 0.20 | 0.35 | 0.16 | 0.25 | 0.41 | 0.20 | 0.32 | 0.45 | 0.20 | 0.34 | 0.45 | 0.20 | 0.34 | 0.45 |
| 0.12 | 0.18 | 0.28 | 0.14 | 0.20 | 0.35 | 0.16 | 0.25 | 0.41 | 0.20 | 0.32 | 0.45 | 0.20 | 0.34 | 0.45 | 0.20 | 0.34 | 0.45 |
| 0.12 | 0.18 | 0.28 | 0.14 | 0.20 | 0.35 | 0.16 | 0.25 | 0.41 | 0.20 | 0.32 | 0.45 | 0.20 | 0.34 | 0.45 | 0.20 | 0.34 | 0.45 |
| Geometry -PM, -KM and -GP | | | | | | | | | | | | | | | | | |
| 0.12 | 0.18 | 0.30 | 0.14 | 0.20 | 0.37 | 0.16 | 0.25 | 0.45 | 0.20 | 0.32 | 0.48 | 0.20 | 0.36 | 0.50 | 0.20 | 0.40 | 0.52 |
| 0.12 | 0.18 | 0.30 | 0.14 | 0.20 | 0.37 | 0.16 | 0.25 | 0.45 | 0.20 | 0.32 | 0.48 | 0.20 | 0.36 | 0.50 | 0.20 | 0.40 | 0.52 |
| 0.12 | 0.18 | 0.30 | 0.14 | 0.20 | 0.37 | 0.16 | 0.25 | 0.45 | 0.20 | 0.32 | 0.48 | 0.20 | 0.36 | 0.50 | 0.20 | 0.40 | 0.52 |
| 0.12 | 0.18 | 0.30 | 0.14 | 0.20 | 0.37 | 0.16 | 0.25 | 0.45 | 0.20 | 0.32 | 0.48 | 0.20 | 0.36 | 0.50 | 0.20 | 0.40 | 0.52 |
| 0.12 | 0.18 | 0.30 | 0.14 | 0.20 | 0.37 | 0.16 | 0.25 | 0.45 | 0.20 | 0.32 | 0.48 | 0.20 | 0.36 | 0.50 | 0.20 | 0.40 | 0.52 |
| 0.10 | 0.16 | 0.24 | 0.12 | 0.19 | 0.33 | 0.14 | 0.22 | 0.38 | 0.18 | 0.25 | 0.40 | 0.18 | 0.30 | 0.45 | 0.18 | 0.30 | 0.45 |
| 0.10 | 0.16 | 0.24 | 0.12 | 0.19 | 0.33 | 0.14 | 0.22 | 0.38 | 0.18 | 0.25 | 0.40 | 0.18 | 0.30 | 0.45 | 0.18 | 0.30 | 0.45 |
| Geometry -PM, -MM and -GP | | | | | | | | | | | | | | | | | |
| 0.12 | 0.14 | 0.19 | 0.14 | 0.16 | 0.22 | 0.14 | 0.18 | 0.24 | 0.18 | 0.24 | 0.30 | 0.22 | 0.28 | 0.34 | 0.22 | 0.28 | 0.34 |
| 0.10 | 0.12 | 0.16 | 0.10 | 0.12 | 0.16 | 0.12 | 0.14 | 0.18 | 0.14 | 0.18 | 0.22 | 0.16 | 0.22 | 0.26 | 0.16 | 0.22 | 0.26 |
| Geometry -MM, PM and -GP | | | | | | | | | | | | | | | | | |
| 0.10 | 0.12 | 0.14 | 0.10 | 0.12 | 0.14 | 0.12 | 0.14 | 0.16 | 0.12 | 0.16 | 0.2 | 0.14 | 0.18 | 0.22 | 0.14 | 0.18 | 0.22 |
| 0.10 | 0.12 | 0.14 | 0.10 | 0.12 | 0.14 | 0.12 | 0.14 | 0.16 | 0.12 | 0.16 | 0.2 | 0.14 | 0.18 | 0.22 | 0.14 | 0.18 | 0.22 |
| 0.10 | 0.12 | 0.16 | 0.10 | 0.12 | 0.16 | 0.12 | 0.14 | 0.18 | 0.14 | 0.16 | 0.22 | 0.14 | 0.18 | 0.24 | 0.14 | 0.18 | 0.24 |
| 0.10 | 0.12 | 0.14 | 0.10 | 0.12 | 0.16 | 0.10 | 0.12 | 0.16 | 0.10 | 0.14 | 0.16 | 0.12 | 0.14 | 0.18 | 0.12 | 0.14 | 0.18 |
| 0.10 | 0.12 | 0.14 | 0.10 | 0.12 | 0.16 | 0.10 | 0.12 | 0.16 | 0.10 | 0.14 | 0.16 | 0.12 | 0.14 | 0.18 | 0.12 | 0.14 | 0.18 |
| Geometry -MM and -GP | | | | | | | | | | | | | | | | | |
| 0.10 | 0.12 | 0.16 | 0.10 | 0.12 | 0.16 | 0.12 | 0.14 | 0.18 | 0.14 | 0.16 | 0.22 | 0.14 | 0.16 | 0.22 | 0.14 | 0.16 | 0.22 |
| 0.10 | 0.12 | 0.14 | 0.10 | 0.12 | 0.14 | 0.12 | 0.14 | 0.16 | 0.12 | 0.16 | 0.2 | 0.12 | 0.16 | 0.2 | 0.12 | 0.16 | 0.2 |
| Geometry -KM, PM and -GP | | | | | | | | | | | | | | | | | |
| 0.16 | 0.25 | 0.36 | 0.18 | 0.30 | 0.42 | 0.21 | 0.37 | 0.48 | 0.25 | 0.44 | 0.55 | 0.30 | 0.48 | 0.60 | 0.30 | 0.50 | 0.60 |
| 0.16 | 0.25 | 0.36 | 0.18 | 0.30 | 0.42 | 0.21 | 0.37 | 0.48 | 0.25 | 0.44 | 0.55 | 0.30 | 0.48 | 0.60 | 0.30 | 0.50 | 0.60 |
| 0.16 | 0.25 | 0.36 | 0.18 | 0.30 | 0.42 | 0.21 | 0.37 | 0.48 | 0.25 | 0.44 | 0.55 | 0.30 | 0.48 | 0.60 | 0.30 | 0.50 | 0.60 |
| 0.16 | 0.25 | 0.36 | 0.18 | 0.30 | 0.42 | 0.21 | 0.37 | 0.48 | 0.25 | 0.44 | 0.55 | 0.30 | 0.48 | 0.60 | 0.30 | 0.50 | 0.60 |
| 0.16 | 0.25 | 0.36 | 0.18 | 0.30 | 0.42 | 0.21 | 0.37 | 0.48 | 0.25 | 0.44 | 0.55 | 0.30 | 0.48 | 0.60 | 0.30 | 0.50 | 0.60 |
| Geometry -PM and -GP | | | | | | | | | | | | | | | | | |
| 0.20 | 0.25 | 0.30 | 0.22 | 0.32 | 0.40 | 0.26 | 0.34 | 0.42 | 0.30 | 0.36 | 0.44 | 0.32 | 0.38 | 0.50 | 0.32 | 0.38 | 0.50 |
| 0.20 | 0.25 | 0.30 | 0.22 | 0.32 | 0.40 | 0.26 | 0.34 | 0.42 | 0.30 | 0.36 | 0.44 | 0.32 | 0.38 | 0.50 | 0.32 | 0.38 | 0.50 |
| Geometry -MM, -PM and -GP | | | | | | | | | | | | | | | | | |
| 0.08 | 0.10 | 0.14 | 0.08 | 0.11 | 0.14 | 0.10 | 0.12 | 0.14 | 0.11 | 0.13 | 0.16 | 0.12 | 0.15 | 0.20 | 0.12 | 0.15 | 0.20 |
| 0.09 | 0.12 | 0.15 | 0.10 | 0.14 | 0.16 | 0.12 | 0.16 | 0.20 | 0.14 | 0.18 | 0.22 | 0.16 | 0.20 | 0.25 | 0.18 | 0.22 | 0.27 |

CoroDrill® 870

≥ 6 x DC

| ISO | MC No. | CMC No. | Material | Hardness Brinell (HB) | Cutting speed (V _c) m/min correlating with drill diameter | | | | | | |
|-----------|-----------|---|--|-----------------------|---|------|------|---------------|------|------|--|
| | | | | | 10.00-20.99mm | | | 21.00-33.00mm | | | |
| | | | | | Min. | Rec. | Max. | Min. | Rec. | Max. | |
| P | | | Unalloyed steel | | Grade 4334 | | | | | | |
| | P1.1.Z.AN | 01.1 | C=0.10-0.25% | 125 | 80 | 120 | 160 | 80 | 120 | 160 | |
| | P1.2.Z.AN | 01.2 | C=0.25-0.55% | 190 | 80 | 120 | 160 | 80 | 120 | 160 | |
| | P1.3.Z.AN | 01.3 | C=0.55-0.80% | 190 | 70 | 100 | 130 | 70 | 100 | 130 | |
| | P1.5.C.UT | 06.1 | Cast - untreated | 150 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | | | Low alloy steel | | Grade 4334 and 3334 | | | | | | |
| | P2.1.Z.AN | 02.1 | Annealed | 175 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | P2.2.Z.AN | 02.1 | Annealed | 240 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | P2.4.Z.AN | 02.1 | Annealed | 225 | 80 | 110 | 140 | 80 | 110 | 140 | |
| | P2.5.Z.HT | 02.2 | Hardened and tempered | 330 | 70 | 100 | 130 | 50 | 75 | 100 | |
| P2.6.C.UT | 06.2 | Cast - untreated | 200 | 70 | 100 | 130 | 70 | 100 | 130 | | |
| | | High alloy steel | | | | | | | | | |
| P3.0.Z.AN | 03.11 | Annealed | 200 | 60 | 80 | 100 | 60 | 80 | 100 | | |
| P3.0.Z.HT | 03.21 | Hardened and tempered | 380 | 40 | 60 | 80 | 40 | 60 | 80 | | |
| M | | | Ferritic/martensitic stainless steel | | Grade 4334 and 2334 | | | | | | |
| | P5.0.Z.AN | 05.11 | Annealed | 200 | 30 | 40 | 50 | 30 | 40 | 50 | |
| | P5.0.Z.HT | 05.13 | Hardened and tempered | 330 | 70 | 90 | 110 | 60 | 75 | 90 | |
| | | | Austenitic stainless steel | | Grade 2334 and 4334 | | | | | | |
| | M1.0.Z.AQ | 05.21 | Annealed/quenched | 200 | 40 | 50 | 60 | 40 | 50 | 60 | |
| | M1.0.C.UT | 15.21 | Cast-untreated | 200 | 50 | 60 | 70 | 50 | 60 | 70 | |
| | M1.1.Z.AQ | 05.21 | Machinability improved | 200 | 60 | 75 | 90 | 60 | 75 | 90 | |
| | | | Super-austenitic (Ni≥20%) stainless steel | | | | | | | | |
| | M2.0.Z.AQ | 05.23 | Annealed/quenched | 200 | 20 | 40 | 60 | 20 | 40 | 60 | |
| | M2.0.C.AQ | 15.23 | Cast+annealed/quenched | 200 | 20 | 40 | 60 | 20 | 40 | 60 | |
| | | Duplex (austenitic/ferritic) stainless steel | | Grade 2334 | | | | | | | |
| M3.1.Z.AQ | 05.51 | >60% ferrite (N<0.10%) | 230 | 40 | 55 | 70 | 40 | 55 | 70 | | |
| M3.2.Z.AQ | 05.52 | <60% ferrite (N≥0.10%) | 260 | 20 | 40 | 60 | 20 | 40 | 60 | | |
| K | | | Malleable cast iron | | Grade 3334 and 4334 | | | | | | |
| | K1.1.C.NS | 07.1 | Ferritic (short chipping) | 130 | 100 | 130 | 170 | 100 | 130 | 170 | |
| | K1.1.C.NS | 07.2 | Pearlitic (long chipping) | 200 | 90 | 115 | 145 | 90 | 115 | 145 | |
| | | | Grey cast iron | | | | | | | | |
| | K2.1.C.UT | 08.1 | Low tensile strength | 180 | 100 | 135 | 180 | 100 | 135 | 180 | |
| | K2.2.C.UT | 08.2 | High tensile strength | 245 | 90 | 120 | 155 | 90 | 120 | 155 | |
| | | Nodular cast iron | | | | | | | | | |
| K3.1.C.UT | 09.1 | Ferritic | 155 | 100 | 130 | 170 | 100 | 130 | 170 | | |
| K3.3.C.UT | 09.2 | Pearlitic | 265 | 90 | 115 | 145 | 90 | 115 | 145 | | |
| N | | | Aluminium based alloys | | Grade 4334 | | | | | | |
| | N1.2.Z.AG | 30.12 | AlSi alloys, Si ≤ 1% | 100 | 150 | 200 | 250 | 150 | 200 | 250 | |
| N1.3.C.AG | 30.22 | AlSi cast alloys, Si > 1% and < 13% | 80 | 150 | 200 | 250 | 150 | 200 | 250 | | |
| S | | | Heat resistant super alloys | | Grade 2334 and 4334 | | | | | | |
| | S2.0.Z.AG | 20.22 | Ni based | 350 | 18 | 20 | 30 | 18 | 20 | 30 | |
| S4.3.Z.AN | 23.21 | Titanium based | 330 | 25 | 40 | 60 | 25 | 40 | 60 | | |

CoroDrill® 870

≥ 6 x DC

| Feed (f_n) mm/r correlating with drill diameter | | | | | | | | | | | | | | | | | |
|---|------|------|----------------|------|------|----------------|------|------|----------------|------|------|----------------|------|------|----------------|------|------|
| 10.00-11.99 mm | | | 12.00-13.99 mm | | | 14.00-15.99 mm | | | 16.00-20.99 mm | | | 21.00-25.99 mm | | | 26.00-33.00 mm | | |
| Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. | Min. | Rec. | Max. |
| Geometry -PM | | | | | | | | | | | | | | | | | |
| 0.12 | 0.14 | 0.22 | 0.14 | 0.16 | 0.28 | 0.16 | 0.20 | 0.33 | 0.20 | 0.26 | 0.36 | 0.20 | 0.27 | 0.36 | 0.20 | 0.27 | 0.36 |
| 0.12 | 0.14 | 0.22 | 0.14 | 0.16 | 0.28 | 0.16 | 0.20 | 0.33 | 0.20 | 0.26 | 0.36 | 0.20 | 0.27 | 0.36 | 0.20 | 0.27 | 0.36 |
| 0.12 | 0.14 | 0.22 | 0.14 | 0.16 | 0.28 | 0.16 | 0.20 | 0.33 | 0.20 | 0.26 | 0.36 | 0.20 | 0.27 | 0.36 | 0.20 | 0.27 | 0.36 |
| 0.12 | 0.14 | 0.22 | 0.14 | 0.16 | 0.28 | 0.16 | 0.20 | 0.33 | 0.20 | 0.26 | 0.36 | 0.20 | 0.27 | 0.36 | 0.20 | 0.27 | 0.36 |
| Geometry -PM and -KM | | | | | | | | | | | | | | | | | |
| 0.12 | 0.14 | 0.24 | 0.14 | 0.16 | 0.30 | 0.16 | 0.20 | 0.36 | 0.20 | 0.26 | 0.38 | 0.20 | 0.29 | 0.40 | 0.20 | 0.32 | 0.42 |
| 0.12 | 0.14 | 0.24 | 0.14 | 0.16 | 0.30 | 0.16 | 0.20 | 0.36 | 0.20 | 0.26 | 0.38 | 0.20 | 0.29 | 0.40 | 0.20 | 0.32 | 0.42 |
| 0.12 | 0.14 | 0.24 | 0.14 | 0.16 | 0.30 | 0.16 | 0.20 | 0.36 | 0.20 | 0.26 | 0.38 | 0.20 | 0.29 | 0.40 | 0.20 | 0.32 | 0.42 |
| 0.12 | 0.13 | 0.21 | 0.14 | 0.15 | 0.26 | 0.16 | 0.18 | 0.32 | 0.20 | 0.22 | 0.34 | 0.20 | 0.25 | 0.35 | 0.20 | 0.28 | 0.36 |
| 0.12 | 0.14 | 0.24 | 0.14 | 0.16 | 0.30 | 0.16 | 0.20 | 0.36 | 0.20 | 0.26 | 0.38 | 0.20 | 0.29 | 0.40 | 0.20 | 0.32 | 0.42 |
| 0.10 | 0.13 | 0.19 | 0.12 | 0.15 | 0.26 | 0.14 | 0.18 | 0.30 | 0.18 | 0.20 | 0.32 | 0.18 | 0.24 | 0.36 | 0.18 | 0.24 | 0.36 |
| 0.10 | 0.11 | 0.17 | 0.12 | 0.13 | 0.23 | 0.14 | 0.15 | 0.27 | 0.18 | 0.19 | 0.28 | 0.18 | 0.21 | 0.32 | 0.18 | 0.21 | 0.32 |
| Geometry -PM and -MM | | | | | | | | | | | | | | | | | |
| 0.12 | 0.13 | 0.15 | 0.14 | 0.15 | 0.18 | 0.14 | 0.15 | 0.19 | 0.18 | 0.19 | 0.24 | 0.22 | 0.23 | 0.27 | 0.22 | 0.23 | 0.27 |
| 0.10 | 0.11 | 0.12 | 0.10 | 0.11 | 0.12 | 0.12 | 0.13 | 0.14 | 0.14 | 0.15 | 0.16 | 0.16 | 0.17 | 0.18 | 0.16 | 0.17 | 0.18 |
| Geometry -MM and -PM | | | | | | | | | | | | | | | | | |
| 0.10 | 0.11 | 0.12 | 0.10 | 0.11 | 0.12 | 0.12 | 0.13 | 0.14 | 0.12 | 0.13 | 0.16 | 0.14 | 0.15 | 0.18 | 0.14 | 0.15 | 0.18 |
| 0.10 | 0.11 | 0.12 | 0.10 | 0.11 | 0.12 | 0.12 | 0.13 | 0.14 | 0.12 | 0.13 | 0.16 | 0.14 | 0.15 | 0.18 | 0.14 | 0.15 | 0.18 |
| 0.10 | 0.11 | 0.13 | 0.10 | 0.11 | 0.13 | 0.12 | 0.13 | 0.14 | 0.14 | 0.15 | 0.18 | 0.14 | 0.15 | 0.19 | 0.14 | 0.15 | 0.19 |
| 0.10 | 0.11 | 0.12 | 0.10 | 0.11 | 0.13 | 0.10 | 0.11 | 0.13 | 0.10 | 0.11 | 0.13 | 0.12 | 0.13 | 0.14 | 0.12 | 0.13 | 0.14 |
| 0.10 | 0.11 | 0.12 | 0.10 | 0.11 | 0.13 | 0.10 | 0.11 | 0.13 | 0.10 | 0.11 | 0.13 | 0.12 | 0.13 | 0.14 | 0.12 | 0.13 | 0.14 |
| Geometry -MM | | | | | | | | | | | | | | | | | |
| 0.10 | 0.11 | 0.13 | 0.10 | 0.11 | 0.13 | 0.12 | 0.13 | 0.14 | 0.14 | 0.15 | 0.18 | 0.14 | 0.15 | 0.18 | 0.14 | 0.15 | 0.18 |
| 0.10 | 0.11 | 0.12 | 0.10 | 0.11 | 0.13 | 0.12 | 0.13 | 0.14 | 0.12 | 0.13 | 0.16 | 0.12 | 0.13 | 0.16 | 0.12 | 0.13 | 0.16 |
| Geometry -KM and -PM | | | | | | | | | | | | | | | | | |
| 0.16 | 0.20 | 0.29 | 0.18 | 0.24 | 0.34 | 0.21 | 0.30 | 0.38 | 0.25 | 0.35 | 0.44 | 0.30 | 0.38 | 0.48 | 0.30 | 0.40 | 0.48 |
| 0.16 | 0.20 | 0.29 | 0.18 | 0.24 | 0.34 | 0.21 | 0.30 | 0.38 | 0.25 | 0.35 | 0.44 | 0.30 | 0.38 | 0.48 | 0.30 | 0.40 | 0.48 |
| 0.16 | 0.20 | 0.29 | 0.18 | 0.24 | 0.34 | 0.21 | 0.30 | 0.38 | 0.25 | 0.35 | 0.44 | 0.30 | 0.38 | 0.48 | 0.30 | 0.40 | 0.48 |
| 0.16 | 0.20 | 0.29 | 0.18 | 0.24 | 0.34 | 0.21 | 0.30 | 0.38 | 0.25 | 0.35 | 0.44 | 0.30 | 0.38 | 0.48 | 0.30 | 0.40 | 0.48 |
| 0.16 | 0.20 | 0.29 | 0.18 | 0.24 | 0.34 | 0.21 | 0.30 | 0.38 | 0.25 | 0.35 | 0.44 | 0.30 | 0.38 | 0.48 | 0.30 | 0.40 | 0.48 |
| 0.16 | 0.20 | 0.29 | 0.18 | 0.24 | 0.34 | 0.21 | 0.30 | 0.38 | 0.25 | 0.35 | 0.44 | 0.30 | 0.38 | 0.48 | 0.30 | 0.40 | 0.48 |
| Geometry -PM | | | | | | | | | | | | | | | | | |
| 0.20 | 0.22 | 0.28 | 0.22 | 0.24 | 0.35 | 0.26 | 0.28 | 0.38 | 0.30 | 0.32 | 0.40 | 0.32 | 0.34 | 0.45 | 0.32 | 0.34 | 0.45 |
| 0.20 | 0.22 | 0.28 | 0.22 | 0.24 | 0.35 | 0.26 | 0.28 | 0.38 | 0.30 | 0.32 | 0.40 | 0.32 | 0.34 | 0.45 | 0.32 | 0.34 | 0.45 |
| Geometry -MM and -PM | | | | | | | | | | | | | | | | | |
| 0.08 | 0.10 | 0.14 | 0.08 | 0.11 | 0.14 | 0.10 | 0.12 | 0.14 | 0.11 | 0.13 | 0.16 | 0.12 | 0.15 | 0.20 | 0.12 | 0.15 | 0.20 |
| 0.09 | 0.11 | 0.14 | 0.10 | 0.12 | 0.15 | 0.12 | 0.14 | 0.18 | 0.14 | 0.16 | 0.20 | 0.16 | 0.18 | 0.22 | 0.18 | 0.20 | 0.25 |

CoroDrill® DS20

4 – 5 × DC

ENG

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 4xD | | | | | Drill length 5xD | | | | | |
|----------|--|---------------------------------|------|-------------|-------------------------------|------|-------------|-----------------|------------------|------------------|------------------|------------------|-----------------|------------------|------------------|------------------|------------------|--------------|---|
| | | | | | Min. | Rec. | Max. | | -S5W | -L5W | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W | |
| | | | | | | | | | | | | | | | | | | | Recommended start value at middle of feed range |
| | | | | | | | | | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev |
| P | P1.0.ZAN | Unalloyed steel C=0.05-0.10% | 110 | 4324 | 230 | 340 | 400 | 15.00-18.00 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | 0.04-0.1 | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | 0.04-0.09 | |
| | | | | 4334 | 210 | 285 | 325 | 18.01-22.00 | 0.04-0.09 | 0.04-0.09 | 0.04-0.09 | - | 0.04-0.11 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | 0.04-0.1 | |
| | | | | 4344 | 190 | 225 | 245 | 22.01-27.00 | 0.04-0.1 | 0.04-0.1 | 0.04-0.1 | - | 0.04-0.12 | 0.04-0.09 | 0.04-0.09 | 0.04-0.09 | - | 0.04-0.11 | |
| | | | | | | | | 27.01-33.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.13 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.12 | |
| | | | | | | | | 33.01-40.00 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.16 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.14 | |
| | | | | | | | | 40.01-52.00 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | 0.06-0.16 | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - | 0.06-0.14 | |
| | P1.1.ZAN | Unalloyed steel C=0.05-0.25% | 125 | 4324 | 230 | 320 | 370 | 15.00-18.00 | 0.04-0.1 | 0.04-0.1 | 0.04-0.1 | - | 0.04-0.1 | 0.04-0.09 | 0.04-0.09 | 0.04-0.09 | - | 0.04-0.09 | |
| | | | | 4334 | 200 | 270 | 305 | 18.01-22.00 | 0.04-0.11 | 0.04-0.11 | 0.04-0.11 | - | 0.04-0.11 | 0.04-0.1 | 0.04-0.1 | 0.04-0.1 | - | 0.04-0.1 | |
| | | | | 4344 | 170 | 210 | 235 | 22.01-27.00 | 0.04-0.12 | 0.04-0.12 | 0.04-0.12 | - | 0.04-0.12 | 0.04-0.11 | 0.04-0.11 | 0.04-0.11 | - | 0.04-0.11 | |
| | | | | | | | | 27.01-33.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.13 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.12 | |
| | | | | | | | | 33.01-40.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.16 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.14 | |
| | | | | | | | | 40.01-52.00 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | 0.06-0.16 | 0.06-0.13 | 0.06-0.13 | 0.06-0.13 | - | 0.06-0.14 | |
| | P1.2.ZAN | Unalloyed steel C=0.25-0.55% | 190 | 4324 | 190 | 265 | 305 | 15.00-18.00 | - | 0.05-0.12 | 0.06-0.14 | 0.06-0.16 | - | - | 0.05-0.1 | 0.06-0.12 | 0.06-0.14 | - | |
| | | | | 4334 | 155 | 215 | 250 | 18.01-22.00 | - | 0.05-0.14 | 0.06-0.16 | 0.06-0.18 | - | - | 0.05-0.12 | 0.06-0.14 | 0.06-0.15 | - | |
| | | | | 4344 | 120 | 165 | 190 | 22.01-27.00 | - | 0.05-0.18 | 0.06-0.2 | 0.06-0.22 | - | - | 0.05-0.15 | 0.06-0.17 | 0.06-0.19 | - | |
| | | | | | | | | 27.01-33.00 | - | 0.07-0.22 | 0.08-0.24 | 0.08-0.26 | - | - | 0.07-0.19 | 0.08-0.2 | 0.08-0.22 | - | |
| | | | | | | | 33.01-40.00 | - | 0.07-0.24 | 0.08-0.26 | 0.08-0.28 | - | - | 0.07-0.2 | 0.08-0.22 | 0.08-0.24 | - | | |
| | | | | | | | 40.01-52.00 | - | 0.09-0.24 | 0.1-0.26 | 0.1-0.28 | - | - | 0.09-0.2 | 0.1-0.22 | 0.1-0.24 | - | | |
| P1.3.ZAN | Unalloyed steel C=0.55-0.80% | 190 | 4324 | 170 | 250 | 290 | 15.00-18.00 | - | 0.05-0.12 | 0.06-0.14 | 0.06-0.16 | - | - | 0.05-0.1 | 0.06-0.12 | 0.06-0.14 | - | | |
| | | | 4334 | 140 | 205 | 240 | 18.01-22.00 | - | 0.05-0.14 | 0.06-0.16 | 0.06-0.18 | - | - | 0.05-0.12 | 0.06-0.14 | 0.06-0.15 | - | | |
| | | | 4344 | 105 | 155 | 185 | 22.01-27.00 | - | 0.05-0.18 | 0.06-0.2 | 0.06-0.22 | - | - | 0.05-0.15 | 0.06-0.17 | 0.06-0.19 | - | | |
| | | | | | | | 27.01-33.00 | - | 0.07-0.22 | 0.08-0.24 | 0.08-0.26 | - | - | 0.07-0.19 | 0.08-0.2 | 0.08-0.22 | - | | |
| | | | | | | | 33.01-40.00 | - | 0.07-0.24 | 0.08-0.26 | 0.08-0.28 | - | - | 0.07-0.2 | 0.08-0.22 | 0.08-0.24 | - | | |
| | | | | | | | 40.01-52.00 | - | 0.09-0.24 | 0.1-0.26 | 0.1-0.28 | - | - | 0.09-0.2 | 0.1-0.22 | 0.1-0.24 | - | | |
| P1.5.CUT | Unalloyed steel Cast - untreated | 150 | 4324 | 140 | 260 | 325 | 15.00-18.00 | - | 0.04-0.12 | 0.04-0.12 | 0.04-0.12 | - | - | 0.04-0.1 | 0.04-0.1 | 0.04-0.1 | - | | |
| | | | 4334 | 135 | 220 | 265 | 18.01-22.00 | - | 0.04-0.13 | 0.04-0.13 | 0.04-0.13 | - | - | 0.04-0.11 | 0.04-0.11 | 0.04-0.11 | - | | |
| | | | 4344 | 125 | 175 | 200 | 22.01-27.00 | - | 0.04-0.14 | 0.04-0.14 | 0.04-0.14 | - | - | 0.04-0.12 | 0.04-0.12 | 0.04-0.12 | - | | |
| | | | | | | | 27.01-33.00 | - | 0.05-0.15 | 0.05-0.15 | 0.05-0.15 | - | - | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | | |
| | | | | | | | 33.01-40.00 | - | 0.05-0.16 | 0.05-0.16 | 0.05-0.16 | - | - | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | | |
| | | | | | | | 40.01-52.00 | - | 0.06-0.16 | 0.06-0.16 | 0.06-0.16 | - | - | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | | |
| P2.1.ZAN | Low alloy steel Annealed | 175 | 4324 | 180 | 260 | 305 | 15.00-18.00 | - | - | 0.06-0.14 | 0.06-0.16 | - | - | - | 0.06-0.12 | 0.06-0.14 | - | | |
| | | | 4334 | 150 | 215 | 250 | 18.01-22.00 | - | - | 0.06-0.16 | 0.06-0.18 | - | - | - | 0.06-0.14 | 0.06-0.15 | - | | |
| | | | 4344 | 115 | 165 | 190 | 22.01-27.00 | - | - | 0.06-0.2 | 0.06-0.22 | - | - | - | 0.06-0.17 | 0.06-0.19 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | 0.08-0.26 | - | - | - | 0.08-0.2 | 0.08-0.22 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | 0.08-0.28 | - | - | - | 0.08-0.22 | 0.08-0.24 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | 0.1-0.28 | - | - | - | 0.1-0.22 | 0.1-0.24 | - | | |
| P2.2.ZAN | Low alloy steel Annealed | 240 | 4324 | 180 | 250 | 290 | 15.00-18.00 | - | - | 0.06-0.14 | 0.06-0.16 | - | - | - | 0.06-0.12 | 0.06-0.14 | - | | |
| | | | 4334 | 150 | 200 | 225 | 18.01-22.00 | - | - | 0.06-0.16 | 0.06-0.18 | - | - | - | 0.06-0.14 | 0.06-0.15 | - | | |
| | | | 4344 | 115 | 175 | 205 | 22.01-27.00 | - | - | 0.06-0.2 | 0.06-0.22 | - | - | - | 0.06-0.17 | 0.06-0.19 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | 0.08-0.26 | - | - | - | 0.08-0.2 | 0.08-0.22 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | 0.08-0.28 | - | - | - | 0.08-0.22 | 0.08-0.24 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | 0.1-0.28 | - | - | - | 0.1-0.22 | 0.1-0.24 | - | | |
| P2.5.ZHT | Low alloy steel Hardened and tempered | 330 | 4324 | 90 | 190 | 245 | 15.00-18.00 | - | - | 0.06-0.14 | 0.06-0.16 | - | - | - | 0.06-0.12 | 0.06-0.14 | - | | |
| | | | 4334 | 85 | 155 | 195 | 18.01-22.00 | - | - | 0.06-0.16 | 0.06-0.18 | - | - | - | 0.06-0.14 | 0.06-0.15 | - | | |
| | | | 4344 | 75 | 125 | 150 | 22.01-27.00 | - | - | 0.06-0.2 | 0.06-0.22 | - | - | - | 0.06-0.17 | 0.06-0.19 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | 0.08-0.26 | - | - | - | 0.08-0.2 | 0.08-0.22 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | 0.08-0.28 | - | - | - | 0.08-0.22 | 0.08-0.24 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | 0.1-0.28 | - | - | - | 0.1-0.22 | 0.1-0.24 | - | | |
| P2.6.CUT | Low alloy steel Cast - untreated | 200 | 4324 | 110 | 210 | 265 | 15.00-18.00 | - | - | 0.06-0.16 | 0.06-0.18 | - | - | - | 0.06-0.14 | 0.06-0.15 | - | | |
| | | | 4334 | 105 | 175 | 210 | 18.01-22.00 | - | - | 0.06-0.18 | 0.06-0.2 | - | - | - | 0.06-0.15 | 0.06-0.17 | - | | |
| | | | 4344 | 100 | 140 | 160 | 22.01-27.00 | - | - | 0.06-0.22 | 0.06-0.24 | - | - | - | 0.06-0.19 | 0.06-0.2 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.26 | 0.08-0.28 | - | - | - | 0.08-0.22 | 0.08-0.24 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.28 | 0.08-0.3 | - | - | - | 0.08-0.24 | 0.08-0.26 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.28 | 0.1-0.3 | - | - | - | 0.1-0.24 | 0.1-0.26 | - | | |
| P3.0.ZAN | High alloy steel Annealed | 200 | 4324 | 160 | 245 | 290 | 15.00-18.00 | - | - | 0.06-0.14 | 0.06-0.16 | - | - | - | 0.06-0.12 | 0.06-0.14 | - | | |
| | | | 4334 | 130 | 200 | 240 | 18.01-22.00 | - | - | 0.06-0.16 | 0.06-0.18 | - | - | - | 0.06-0.14 | 0.06-0.15 | - | | |
| | | | 4344 | 100 | 150 | 180 | 22.01-27.00 | - | - | 0.06-0.2 | 0.06-0.22 | - | - | - | 0.06-0.17 | 0.06-0.19 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | 0.08-0.26 | - | - | - | 0.08-0.2 | 0.08-0.22 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | 0.08-0.28 | - | - | - | 0.08-0.22 | 0.08-0.24 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | 0.1-0.28 | - | - | - | 0.1-0.22 | 0.1-0.24 | - | | |
| | | | | 52.01-65.00 | - | - | 0.1-0.26 | 0.1-0.28 | - | - | - | 0.1-0.22 | 0.1-0.24 | - | | | | | |

CoroDrill® DS20

4 – 5 × DC

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 4xD | | | | | Drill length 5xD | | | | | |
|------|-------------------------------------|--|---|-------------|-------------------------------|------------------|------------------|----------------|------------------|------------------|------------------|------------------|-----------|------------------|------------------|------------------|------------------|-----------|----------|
| | | | | | -S5W | -L5W | -L6W | | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W | | | | |
| P | P3.0.Z.HT | High alloy steel Hardened and tempered | 380 | 4324 | 80 | 165 | 210 | 15.00-18.00 | - | - | 0.06-0.14 | 0.06-0.16 | - | - | - | 0.06-0.12 | 0.06-0.14 | - | |
| | | | | 4334 | 75 | 140 | 175 | 18.01-22.00 | - | - | 0.06-0.16 | 0.06-0.18 | - | - | - | 0.06-0.14 | 0.06-0.15 | - | |
| | | | | 4344 | 70 | 110 | 130 | 22.01-27.00 | - | - | 0.06-0.2 | 0.06-0.22 | - | - | - | 0.06-0.17 | 0.06-0.19 | - | |
| | | | | | | | | 27.01-33.00 | - | - | 0.08-0.24 | 0.08-0.26 | - | - | - | 0.08-0.2 | 0.08-0.22 | - | |
| | | | | | | | | 33.01-40.00 | - | - | 0.08-0.26 | 0.08-0.28 | - | - | - | 0.08-0.22 | 0.08-0.24 | - | |
| | | | | | | | | 40.01-52.00 | - | - | 0.1-0.26 | 0.1-0.28 | - | - | - | 0.1-0.22 | 0.1-0.24 | - | |
| | | | | | 52.01-65.00 | - | - | 0.1-0.26 | 0.1-0.28 | - | - | - | 0.1-0.22 | 0.1-0.24 | - | | | | |
| | | P5.0.Z.AN | Ferritic/martensitic stainless steel Annealed | 200 | 4334 | 115 | 185 | 225 | 15.00-18.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 |
| | 4344 | | | | 115 | 155 | 175 | 18.01-22.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | |
| | 2044 | | | | 115 | 150 | 165 | 22.01-27.00 | 0.05-0.15 | 0.05-0.15 | 0.05-0.15 | - | 0.05-0.14 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | |
| | | | | | | | | 27.01-33.00 | 0.07-0.16 | 0.07-0.16 | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.13 | |
| | | | | | | | | 33.01-40.00 | 0.07-0.18 | 0.07-0.18 | 0.07-0.18 | - | 0.07-0.16 | 0.07-0.15 | 0.07-0.15 | 0.07-0.15 | - | 0.07-0.14 | |
| | | | | | | | | 40.01-52.00 | 0.09-0.18 | 0.09-0.18 | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | 0.09-0.15 | 0.09-0.15 | - | 0.09-0.14 | |
| | | | | | 52.01-65.00 | 0.09-0.18 | 0.09-0.18 | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | 0.09-0.15 | 0.09-0.15 | - | 0.09-0.14 | | | | |
| | | P5.0.Z.HT | Ferritic/martensitic stainless steel Hardened and tempered | 330 | 4334 | 75 | 135 | 170 | 15.00-18.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 |
| 4344 | 70 | | | | 115 | 140 | 18.01-22.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | | |
| 2044 | 70 | | | | 115 | 140 | 22.01-27.00 | 0.05-0.15 | 0.05-0.15 | 0.05-0.15 | - | 0.05-0.14 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | | |
| | | | | | | | 27.01-33.00 | 0.07-0.16 | 0.07-0.16 | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.13 | | |
| | | | | | | | 33.01-40.00 | 0.07-0.18 | 0.07-0.18 | 0.07-0.18 | - | 0.07-0.16 | 0.07-0.15 | 0.07-0.15 | 0.07-0.15 | - | 0.07-0.14 | | |
| | | | | | | | 40.01-52.00 | 0.09-0.18 | 0.09-0.18 | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | 0.09-0.15 | 0.09-0.15 | - | 0.09-0.14 | | |
| | | | | 52.01-65.00 | 0.09-0.18 | 0.09-0.18 | 0.09-0.18 | - | 0.09-0.16 | 0.09-0.15 | 0.09-0.15 | 0.09-0.15 | - | 0.09-0.14 | | | | | |
| M | M1.0.Z.AQ | Austenitic Stainless steel Annealed/quenched | 200 | 4334 | 115 | 185 | 225 | 15.00-18.00 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | |
| | | | | 4344 | 115 | 165 | 190 | 18.01-22.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | |
| | | | | 2044 | 115 | 155 | 180 | 22.01-27.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | |
| | | | | | | | | 27.01-33.00 | 0.07-0.15 | 0.07-0.15 | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.13 | |
| | | | | | | | | 33.01-40.00 | 0.07-0.16 | 0.07-0.16 | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.14 | |
| | | | | | | | | 40.01-52.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | |
| | | | | | 52.01-65.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | | | |
| | | M1.1.Z.AQ | Austenitic Stainless steel Machinability improved | 200 | 4334 | 115 | 195 | 240 | 15.00-18.00 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 |
| | 4344 | | | | 115 | 175 | 210 | 18.01-22.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | |
| | 2044 | | | | 115 | 170 | 200 | 22.01-27.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | |
| | | | | | | | | 27.01-33.00 | 0.07-0.15 | 0.07-0.15 | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.13 | |
| | | | | | | | | 33.01-40.00 | 0.07-0.16 | 0.07-0.16 | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.14 | |
| | | | | | | | | 40.01-52.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | |
| | | | | | 52.01-65.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | | | |
| | | M2.0.Z.AQ | Super Austenitic (>20% Ni) Stainless steel Annealed/quenched | 200 | 4334 | 80 | 125 | 150 | 15.00-18.00 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 |
| 4344 | 80 | | | | 110 | 125 | 18.01-22.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | | |
| 2044 | 80 | | | | 110 | 125 | 22.01-27.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | | |
| | | | | | | | 27.01-33.00 | 0.07-0.15 | 0.07-0.15 | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.13 | | |
| | | | | | | | 33.01-40.00 | 0.07-0.16 | 0.07-0.16 | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.14 | | |
| | | | | | | | 40.01-52.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | |
| | | | | 52.01-65.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | | | | |
| | M3.1.Z.AQ | Duplex stainless steel >60% ferrite (N<0.10%) | 230 | 4334 | 85 | 125 | 145 | 15.00-18.00 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | |
| 4344 | | | | 85 | 115 | 130 | 18.01-22.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | | |
| 2044 | | | | 85 | 110 | 125 | 22.01-27.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | | |
| | | | | | | | 27.01-33.00 | 0.07-0.15 | 0.07-0.15 | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.13 | | |
| | | | | | | | 33.01-40.00 | 0.07-0.16 | 0.07-0.16 | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.14 | | |
| | | | | | | | 40.01-52.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | |
| | | | | 52.01-65.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | | | | |
| | M3.2.Z.AQ | Duplex stainless steel <60% ferrite (N>0.10%) | 260 | 4334 | 75 | 105 | 120 | 15.00-18.00 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | |
| 4344 | | | | 75 | 100 | 115 | 18.01-22.00 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | 0.05-0.11 | | |
| 2044 | | | | 75 | 100 | 115 | 22.01-27.00 | 0.05-0.14 | 0.05-0.14 | 0.05-0.14 | - | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | 0.05-0.13 | - | 0.05-0.12 | | |
| | | | | | | | 27.01-33.00 | 0.07-0.15 | 0.07-0.15 | 0.07-0.15 | - | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.13 | | |
| | | | | | | | 33.01-40.00 | 0.07-0.16 | 0.07-0.16 | 0.07-0.16 | - | 0.07-0.15 | 0.07-0.14 | 0.07-0.14 | 0.07-0.14 | - | 0.07-0.14 | | |
| | | | | | | | 40.01-52.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | |
| | | | | 52.01-65.00 | 0.09-0.16 | 0.09-0.16 | 0.09-0.16 | - | 0.09-0.15 | 0.09-0.14 | 0.09-0.14 | 0.09-0.14 | - | 0.09-0.14 | | | | | |
| S | S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS | Heat resistant super alloys Ni based | 350 | 4334 | 20 | 40 | 50 | 15.00-18.00 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | - | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | | |
| | | | | 4344 | 20 | 40 | 50 | 18.01-22.00 | 0.04-0.09 | 0.04-0.09 | 0.04-0.09 | - | - | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | | |
| | | | | 2044 | 20 | 40 | 50 | 22.01-27.00 | 0.04-0.1 | 0.04-0.1 | 0.04-0.1 | - | - | 0.04-0.09 | 0.04-0.09 | 0.04-0.09 | - | | |
| | | | | | 27.01-33.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | - | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | | | | | |
| | | | | | 33.01-40.00 | 0.05-0.12 | 0.05-0.12 | 0.05-0.12 | - | - | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | | | | | |
| | | | | | 40.01-52.00 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - | | | | | |

CoroDrill® DS20

4 – 5 × DC

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 4xD | | | | | Drill length 5xD | | | | |
|-----------|--|---|----------|-------------|-------------------------------|-----------|-----------------|-----------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|---|
| | | | | | -S5W | -L5W | -L6W | | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W | | | |
| K | K1.1.C.NS | Malleable cast iron Low tensile strength | 200 | 4324 | 140 | 210 | 245 | 15.00-18.00 | - | 0.08-0.15 | 0.08-0.15 | 0.08-0.2 | - | - | 0.08-0.13 | 0.08-0.13 | 0.08-0.17 | - |
| | | | | 4334 | 110 | 170 | 200 | 18.01-22.00 | - | 0.08-0.18 | 0.08-0.18 | 0.08-0.23 | - | - | 0.08-0.15 | 0.08-0.15 | 0.08-0.2 | - |
| | | | | 4344 | 180 | 165 | 155 | 22.01-27.00 | - | 0.08-0.21 | 0.08-0.21 | 0.08-0.26 | - | - | 0.08-0.18 | 0.08-0.18 | 0.08-0.22 | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.24 | 0.1-0.24 | 0.1-0.29 | - | - | 0.1-0.2 | 0.1-0.2 | 0.1-0.25 | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.27 | 0.1-0.27 | 0.1-0.32 | - | - | 0.1-0.23 | 0.1-0.23 | 0.1-0.27 | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.27 | 0.12-0.27 | 0.12-0.32 | - | - | 0.12-0.23 | 0.12-0.23 | 0.12-0.27 | - |
| | | | | | 52.01-65.00 | - | 0.12-0.27 | 0.12-0.27 | 0.12-0.32 | - | - | 0.12-0.23 | 0.12-0.23 | 0.12-0.27 | - | | | |
| | K2.1.C.UT | Grey cast iron Low tensile strength | 180 | 4324 | 210 | 285 | 325 | 15.00-18.00 | - | 0.08-0.15 | 0.08-0.15 | 0.08-0.2 | - | - | 0.08-0.13 | 0.08-0.13 | 0.08-0.17 | - |
| | | | | 4334 | 170 | 235 | 270 | 18.01-22.00 | - | 0.08-0.18 | 0.08-0.18 | 0.08-0.23 | - | - | 0.08-0.15 | 0.08-0.15 | 0.08-0.2 | - |
| | | | | 4344 | 130 | 180 | 205 | 22.01-27.00 | - | 0.08-0.21 | 0.08-0.21 | 0.08-0.26 | - | - | 0.08-0.18 | 0.08-0.18 | 0.08-0.22 | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.24 | 0.1-0.24 | 0.1-0.29 | - | - | 0.1-0.2 | 0.1-0.2 | 0.1-0.25 | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.27 | 0.1-0.27 | 0.1-0.32 | - | - | 0.1-0.23 | 0.1-0.23 | 0.1-0.27 | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.27 | 0.12-0.27 | 0.12-0.32 | - | - | 0.12-0.23 | 0.12-0.23 | 0.12-0.27 | - |
| | | | | | 52.01-65.00 | - | 0.12-0.27 | 0.12-0.27 | 0.12-0.32 | - | - | 0.12-0.23 | 0.12-0.23 | 0.12-0.27 | - | | | |
| | K2.2.C.UT | Grey cast iron High tensile strength | 245 | 4324 | 125 | 205 | 245 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | 0.08-0.18 | - | - | 0.08-0.11 | 0.08-0.11 | 0.08-0.15 | - |
| | | | | 4334 | 100 | 160 | 195 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.21 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.18 | - |
| | | | | 4344 | 75 | 125 | 150 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.24 | - | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.2 | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | 0.1-0.27 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.23 | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | 0.1-0.3 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.26 | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - |
| | | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - | | | |
| | K3.1.C.UT | Nodular cast iron Ferritic | 155 | 4324 | 125 | 190 | 225 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | 0.08-0.18 | - | - | 0.08-0.11 | 0.08-0.11 | 0.08-0.15 | - |
| | | | | 4334 | 100 | 155 | 185 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.21 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.18 | - |
| | | | | 4344 | 80 | 120 | 145 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.24 | - | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.2 | - |
| | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | 0.1-0.27 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.23 | - | |
| | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | 0.1-0.3 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.26 | - | |
| | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - | |
| | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - | | | | |
| K3.3.C.UT | Nodular cast iron Pearlitic | 265 | 4324 | 110 | 175 | 210 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | 0.08-0.18 | - | - | 0.08-0.11 | 0.08-0.11 | 0.08-0.15 | - | |
| | | | 4334 | 90 | 145 | 175 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.21 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.18 | - | |
| | | | 4344 | 70 | 110 | 130 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.24 | - | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.2 | - | |
| | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | 0.1-0.27 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.23 | - | |
| | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | 0.1-0.3 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.26 | - | |
| | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - | |
| | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - | | | | |
| K4.2.C.UT | Compacted graphite iron High tensile strength (Pearlite>90%) | 230 | 4324 | 130 | 210 | 250 | 15.00-18.00 | - | 0.08-0.13 | 0.08-0.13 | 0.08-0.18 | - | - | 0.08-0.11 | 0.08-0.11 | 0.08-0.15 | - | |
| | | | 4334 | 110 | 170 | 200 | 18.01-22.00 | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.21 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.18 | - | |
| | | | 4344 | 85 | 125 | 150 | 22.01-27.00 | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.24 | - | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.2 | - | |
| | | | | | | | 27.01-33.00 | - | 0.1-0.22 | 0.1-0.22 | 0.1-0.27 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.23 | - | |
| | | | | | | | 33.01-40.00 | - | 0.1-0.25 | 0.1-0.25 | 0.1-0.3 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.26 | - | |
| | | | | | | | 40.01-52.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - | |
| | | | | 52.01-65.00 | - | 0.12-0.25 | 0.12-0.25 | 0.12-0.3 | - | - | 0.12-0.21 | 0.12-0.21 | 0.12-0.26 | - | | | | |
| H | H1.3.Z.HA | Extra hard steels Hardened & tempered | 60 (HRC) | 4324 | 30 | 65 | 85 | 15.00-18.00 | - | 0.06-0.13 | 0.06-0.13 | 0.06-0.13 | - | - | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - |
| | | | 4334 | 30 | 65 | 85 | 18.01-22.00 | - | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | |
| | | | 4344 | 30 | 65 | 85 | 22.01-27.00 | - | 0.06-0.15 | 0.06-0.15 | 0.06-0.15 | - | - | 0.06-0.13 | 0.06-0.13 | 0.06-0.13 | - | |
| | | | | | | | 27.01-33.00 | - | 0.08-0.16 | 0.08-0.16 | 0.08-0.16 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | |
| | | | | | | | 33.01-40.00 | - | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 | - | - | 0.08-0.15 | 0.08-0.15 | 0.08-0.15 | - | |
| | | | | | | | 40.01-52.00 | - | 0.1-0.18 | 0.1-0.18 | 0.1-0.18 | - | - | 0.1-0.15 | 0.1-0.15 | 0.1-0.15 | - | |
| | | | | 52.01-65.00 | - | 0.1-0.18 | 0.1-0.18 | 0.1-0.18 | - | - | 0.1-0.15 | 0.1-0.15 | 0.1-0.15 | - | | | | |

CoroDrill® DS20

4 – 5 × DC

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 4xD | | | | | Drill length 5xD | | | | |
|-------------|--|---|--------------|--------------|-------------------------------|------------------|-----------------|------------------|------------------|------------------|------------------|-----------|------------------|------------------|-----------|-----------|------|------|
| | | | | | | | | | -S5W | -L5W | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W |
| N | N1.2.Z.AG | Aluminum based alloys AlSi alloys (Si<1%) | 100 | H13A 4344 | 4-5xD | | | 15.00-18.00 | 0.06-0.16 | 0.06-0.16 | 0.06-0.16 | - | - | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - |
| | | | | | 18.01-22.00 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | - | - | 0.06-0.15 | 0.06-0.15 | 0.06-0.15 | - | - | | | |
| | | | | | 22.01-27.00 | 0.06-0.2 | 0.06-0.2 | 0.06-0.2 | - | - | 0.06-0.17 | 0.06-0.17 | 0.06-0.17 | - | - | | | |
| | | | | | 27.01-33.00 | 0.08-0.22 | 0.08-0.22 | 0.08-0.22 | - | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.19 | - | - | | | |
| | | | | | 33.01-40.00 | 0.08-0.25 | 0.08-0.25 | 0.08-0.25 | - | - | 0.08-0.21 | 0.08-0.21 | 0.08-0.21 | - | - | | | |
| | | | | | 40.01-52.00 | 0.1-0.25 | 0.1-0.25 | 0.1-0.25 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.21 | - | - | | | |
| | 52.01-65.00 | 0.1-0.25 | 0.1-0.25 | 0.1-0.25 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.21 | - | - | | | | | | | |
| | N1.3.C.UT | Aluminum based alloys AlSi cast alloys (1%<Si >13%) | 75 | H13A 4344 | 250 | 350 | 400 | 15.00-18.00 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - |
| | | | | | 250 | 350 | 400 | 18.01-22.00 | 0.06-0.16 | 0.06-0.16 | 0.06-0.16 | - | - | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - |
| | | | | | 22.01-27.00 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | - | - | 0.06-0.15 | 0.06-0.15 | 0.06-0.15 | - | - | | | |
| | | | | | 27.01-33.00 | 0.08-0.2 | 0.08-0.2 | 0.08-0.2 | - | - | 0.08-0.17 | 0.08-0.17 | 0.08-0.17 | - | - | | | |
| | | | | | 33.01-40.00 | 0.08-0.22 | 0.08-0.22 | 0.08-0.22 | - | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.19 | - | - | | | |
| | | | | | 40.01-52.00 | 0.1-0.22 | 0.1-0.22 | 0.1-0.22 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.19 | - | - | | | |
| | 52.01-65.00 | 0.1-0.22 | 0.1-0.22 | 0.1-0.22 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.19 | - | - | | | | | | | |
| | N1.3.C.AG | Aluminum based alloys AlSi cast and aged alloys (1%<Si>13%) | 90 | H13A 4344 | 250 | 315 | 350 | 15.00-18.00 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - |
| | | | | | 250 | 315 | 350 | 18.01-22.00 | 0.06-0.16 | 0.06-0.16 | 0.06-0.16 | - | - | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - |
| | | | | | 22.01-27.00 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | - | - | 0.06-0.15 | 0.06-0.15 | 0.06-0.15 | - | - | | | |
| | | | | | 27.01-33.00 | 0.08-0.2 | 0.08-0.2 | 0.08-0.2 | - | - | 0.08-0.17 | 0.08-0.17 | 0.08-0.17 | - | - | | | |
| | | | | | 33.01-40.00 | 0.08-0.22 | 0.08-0.22 | 0.08-0.22 | - | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.19 | - | - | | | |
| | | | | | 40.01-52.00 | 0.1-0.22 | 0.1-0.22 | 0.1-0.22 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.19 | - | - | | | |
| | 52.01-65.00 | 0.1-0.22 | 0.1-0.22 | 0.1-0.22 | - | - | 0.1-0.19 | 0.1-0.19 | 0.1-0.19 | - | - | | | | | | | |
| | N3.3.U.UT | Copper based alloys Free cutting copper based alloys | 110 | H13A 4344 | 250 | 350 | 400 | 15.00-18.00 | 0.06-0.16 | 0.06-0.16 | 0.06-0.16 | - | - | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - |
| | | | | | 250 | 350 | 400 | 18.01-22.00 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | - | - | 0.06-0.15 | 0.06-0.15 | 0.06-0.15 | - | - |
| | | | | | 22.01-27.00 | 0.06-0.2 | 0.06-0.2 | 0.06-0.2 | - | - | 0.06-0.17 | 0.06-0.17 | 0.06-0.17 | - | - | | | |
| 27.01-33.00 | | | | | 0.08-0.22 | 0.08-0.22 | 0.08-0.22 | - | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.19 | - | - | | | | |
| 33.01-40.00 | | | | | 0.08-0.25 | 0.08-0.25 | 0.08-0.25 | - | - | 0.08-0.21 | 0.08-0.21 | 0.08-0.21 | - | - | | | | |
| 40.01-52.00 | | | | | 0.1-0.25 | 0.1-0.25 | 0.1-0.25 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.21 | - | - | | | | |
| 52.01-65.00 | 0.1-0.25 | 0.1-0.25 | 0.1-0.25 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.21 | - | - | | | | | | | | |
| N3.2.C.UT | Copper based alloys Leaded brass and bronzes (Pb<1%) | 90 | H13A 4344 | 180 | 220 | 240 | 15.00-18.00 | 0.06-0.16 | 0.06-0.16 | 0.06-0.16 | - | - | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | - | - | |
| | | | | 180 | 220 | 240 | 18.01-22.00 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | - | - | 0.06-0.15 | 0.06-0.15 | 0.06-0.15 | - | - | |
| | | | | 22.01-27.00 | 0.06-0.2 | 0.06-0.2 | 0.06-0.2 | - | - | 0.06-0.17 | 0.06-0.17 | 0.06-0.17 | - | - | | | | |
| | | | | 27.01-33.00 | 0.08-0.22 | 0.08-0.22 | 0.08-0.22 | - | - | 0.08-0.19 | 0.08-0.19 | 0.08-0.19 | - | - | | | | |
| | | | | 33.01-40.00 | 0.08-0.25 | 0.08-0.25 | 0.08-0.25 | - | - | 0.08-0.21 | 0.08-0.21 | 0.08-0.21 | - | - | | | | |
| | | | | 40.01-52.00 | 0.1-0.25 | 0.1-0.25 | 0.1-0.25 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.21 | - | - | | | | |
| 52.01-65.00 | 0.1-0.25 | 0.1-0.25 | 0.1-0.25 | - | - | 0.1-0.21 | 0.1-0.21 | 0.1-0.21 | - | - | | | | | | | | |

CoroDrill® DS20

6 - 7 × DC

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 6xD | | | | | Drill length 7xD | | | | | |
|------|----------|--|---------------------------------|-------------|-------------------------------|------------------|-----------------|-----------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|--------------|---|
| | | | | | Min. | Rec. | Max. | | -S5W | -L5W | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W | |
| | | | | | | | | | | | | | | | | | | | Recommended start value at middle of feed range |
| | | | | | | | | | | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev | f_s mm/rev |
| P | P1.0.ZAN | Unalloyed steel C=0.05-0.10% | 110 | 4324 | 230 | 305 | 360 | 15.00-18.00 | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 | - | 0.04-0.08 | 0.04-0.05 | 0.04-0.05 | 0.04-0.05 | - | 0.04-0.07 | |
| | | | | 4334 | 210 | 255 | 295 | 18.01-22.00 | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | 0.04-0.09 | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 | - | 0.04-0.07 | |
| | | | | 4344 | 190 | 205 | 220 | 22.01-27.00 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | 0.04-0.1 | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | 0.04-0.08 | |
| | | | | | | | | 27.01-33.00 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.1 | 0.05-0.07 | 0.05-0.07 | 0.05-0.07 | - | 0.05-0.08 | |
| | | | | | | | | 33.01-40.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.13 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.1 | |
| | | | | | | | | 40.01-52.00 | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | 0.06-0.13 | 0.06-0.08 | 0.06-0.08 | 0.06-0.08 | - | 0.06-0.1 | |
| | | | | | 52.01-65.00 | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | 0.06-0.13 | 0.06-0.08 | 0.06-0.08 | 0.06-0.08 | - | 0.06-0.1 | | | | |
| | | P1.1.ZAN | Unalloyed steel C=0.05-0.25% | 125 | 4324 | 230 | 290 | 335 | 15.00-18.00 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | 0.04-0.08 | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | 0.04-0.07 |
| | 4334 | | | | 200 | 245 | 275 | 18.01-22.00 | 0.04-0.09 | 0.04-0.09 | 0.04-0.09 | - | 0.04-0.09 | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | 0.04-0.07 | |
| | 4344 | | | | 170 | 190 | 210 | 22.01-27.00 | 0.04-0.1 | 0.04-0.1 | 0.04-0.1 | - | 0.04-0.1 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | 0.04-0.08 | |
| | | | | | | | | 27.01-33.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 | |
| | | | | | | | | 33.01-40.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.13 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.1 | |
| | | | | | | | 40.01-52.00 | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - | 0.06-0.13 | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | 0.06-0.1 | | |
| | | | | 52.01-65.00 | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - | 0.06-0.13 | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | 0.06-0.1 | | | | | |
| | P1.2.ZAN | Unalloyed steel C=0.25-0.55% | 190 | 4324 | 190 | 240 | 275 | 15.00-18.00 | - | 0.05-0.08 | 0.06-0.09 | 0.06-0.1 | - | - | 0.05-0.07 | 0.06-0.08 | 0.06-0.09 | - | |
| 4334 | | | | 155 | 195 | 225 | 18.01-22.00 | - | 0.05-0.09 | 0.06-0.1 | 0.06-0.12 | - | - | 0.05-0.08 | 0.06-0.09 | 0.06-0.1 | - | | |
| 4344 | | | | 120 | 150 | 170 | 22.01-27.00 | - | 0.05-0.12 | 0.06-0.13 | 0.06-0.14 | - | - | 0.05-0.1 | 0.06-0.11 | 0.06-0.12 | - | | |
| | | | | | | | 27.01-33.00 | - | 0.07-0.14 | 0.08-0.16 | 0.08-0.17 | - | - | 0.07-0.12 | 0.08-0.13 | 0.08-0.14 | - | | |
| | | | | | | | 33.01-40.00 | - | 0.07-0.16 | 0.08-0.17 | 0.08-0.18 | - | - | 0.07-0.13 | 0.08-0.14 | 0.08-0.15 | - | | |
| | | | | | | | 40.01-52.00 | - | 0.09-0.16 | 0.1-0.17 | 0.1-0.18 | - | - | 0.09-0.13 | 0.1-0.14 | 0.1-0.15 | - | | |
| | | | | 52.01-65.00 | - | 0.09-0.16 | 0.1-0.17 | 0.1-0.18 | - | - | 0.09-0.13 | 0.1-0.14 | 0.1-0.15 | - | | | | | |
| | P1.3.ZAN | Unalloyed steel C=0.55-0.80% | 190 | 4324 | 170 | 225 | 260 | 15.00-18.00 | - | 0.05-0.08 | 0.06-0.09 | 0.06-0.1 | - | - | 0.05-0.07 | 0.06-0.08 | 0.06-0.09 | - | |
| 4334 | | | | 140 | 185 | 215 | 18.01-22.00 | - | 0.05-0.09 | 0.06-0.1 | 0.06-0.12 | - | - | 0.05-0.08 | 0.06-0.09 | 0.06-0.1 | - | | |
| 4344 | | | | 105 | 140 | 165 | 22.01-27.00 | - | 0.05-0.12 | 0.06-0.13 | 0.06-0.14 | - | - | 0.05-0.1 | 0.06-0.11 | 0.06-0.12 | - | | |
| | | | | | | | 27.01-33.00 | - | 0.07-0.14 | 0.08-0.16 | 0.08-0.17 | - | - | 0.07-0.12 | 0.08-0.13 | 0.08-0.14 | - | | |
| | | | | | | | 33.01-40.00 | - | 0.07-0.16 | 0.08-0.17 | 0.08-0.18 | - | - | 0.07-0.13 | 0.08-0.14 | 0.08-0.15 | - | | |
| | | | | | | | 40.01-52.00 | - | 0.09-0.16 | 0.1-0.17 | 0.1-0.18 | - | - | 0.09-0.13 | 0.1-0.14 | 0.1-0.15 | - | | |
| | | | | 52.01-65.00 | - | 0.09-0.16 | 0.1-0.17 | 0.1-0.18 | - | - | 0.09-0.13 | 0.1-0.14 | 0.1-0.15 | - | | | | | |
| | P1.5.CUT | Unalloyed steel Cast - untreated | 150 | 4324 | 140 | 235 | 295 | 15.00-18.00 | - | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | - | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | |
| 4334 | | | | 135 | 200 | 240 | 18.01-22.00 | - | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | - | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | | |
| 4344 | | | | 125 | 160 | 180 | 22.01-27.00 | - | 0.04-0.09 | 0.04-0.09 | 0.04-0.09 | - | - | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | | |
| | | | | | | | 27.01-33.00 | - | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | - | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | | |
| | | | | | | | 33.01-40.00 | - | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | - | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | | |
| | | | | | | | 40.01-52.00 | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | | |
| | | | | 52.01-65.00 | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | | | | | |
| | P2.1.ZAN | Low alloy steel Annealed | 175 | 4324 | 180 | 235 | 275 | 15.00-18.00 | - | - | 0.06-0.09 | 0.06-0.1 | - | - | - | 0.06-0.08 | 0.06-0.09 | - | |
| 4334 | | | | 150 | 195 | 225 | 18.01-22.00 | - | - | 0.06-0.1 | 0.06-0.12 | - | - | - | 0.06-0.09 | 0.06-0.1 | - | | |
| 4344 | | | | 115 | 150 | 170 | 22.01-27.00 | - | - | 0.06-0.13 | 0.06-0.14 | - | - | - | 0.06-0.11 | 0.06-0.12 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | 0.08-0.17 | - | - | - | 0.08-0.13 | 0.08-0.14 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | 0.08-0.18 | - | - | - | 0.08-0.14 | 0.08-0.15 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | |
| | | | | 52.01-65.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | | | | |
| | P2.2.ZAN | Low alloy steel Annealed | 240 | 4324 | 180 | 225 | 260 | 15.00-18.00 | - | - | 0.06-0.09 | 0.06-0.1 | - | - | - | 0.06-0.08 | 0.06-0.09 | - | |
| 4334 | | | | 150 | 180 | 205 | 18.01-22.00 | - | - | 0.06-0.1 | 0.06-0.12 | - | - | - | 0.06-0.09 | 0.06-0.1 | - | | |
| 4344 | | | | 115 | 160 | 185 | 22.01-27.00 | - | - | 0.06-0.13 | 0.06-0.14 | - | - | - | 0.06-0.11 | 0.06-0.12 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | 0.08-0.17 | - | - | - | 0.08-0.13 | 0.08-0.14 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | 0.08-0.18 | - | - | - | 0.08-0.14 | 0.08-0.15 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | |
| | | | | 52.01-65.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | | | | |
| | P2.5.ZHT | Low alloy steel Hardened and tempered | 330 | 4324 | 90 | 170 | 220 | 15.00-18.00 | - | - | 0.06-0.09 | 0.06-0.1 | - | - | - | 0.06-0.08 | 0.06-0.09 | - | |
| 4334 | | | | 85 | 140 | 175 | 18.01-22.00 | - | - | 0.06-0.1 | 0.06-0.12 | - | - | - | 0.06-0.09 | 0.06-0.1 | - | | |
| 4344 | | | | 75 | 115 | 135 | 22.01-27.00 | - | - | 0.06-0.13 | 0.06-0.14 | - | - | - | 0.06-0.11 | 0.06-0.12 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | 0.08-0.17 | - | - | - | 0.08-0.13 | 0.08-0.14 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.17 | 0.08-0.18 | - | - | - | 0.08-0.14 | 0.08-0.15 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | |
| | | | | 52.01-65.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | | | | |
| | P2.6.CUT | Low alloy steel Cast - untreated | 200 | 4324 | 110 | 190 | 240 | 15.00-18.00 | - | - | 0.06-0.1 | 0.06-0.12 | - | - | - | 0.06-0.09 | 0.06-0.1 | - | |
| 4334 | | | | 105 | 160 | 190 | 18.01-22.00 | - | - | 0.06-0.12 | 0.06-0.13 | - | - | - | 0.06-0.1 | 0.06-0.11 | - | | |
| 4344 | | | | 100 | 125 | 145 | 22.01-27.00 | - | - | 0.06-0.14 | 0.06-0.16 | - | - | - | 0.06-0.12 | 0.06-0.13 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.17 | 0.08-0.18 | - | - | - | 0.08-0.14 | 0.08-0.15 | - | | |
| | | | | | | | 33.01-40.00 | - | - | 0.08-0.18 | 0.08-0.2 | - | - | - | 0.08-0.15 | 0.08-0.17 | - | | |
| | | | | | | | 40.01-52.00 | - | - | 0.1-0.18 | 0.1-0.2 | - | - | - | 0.1-0.15 | 0.1-0.17 | - | | |
| | | | | 52.01-65.00 | - | - | 0.1-0.18 | 0.1-0.2 | - | - | - | 0.1-0.15 | 0.1-0.17 | - | | | | | |
| | P3.0.ZAN | High alloy steel Annealed | 200 | 4324 | 160 | 220 | 260 | 15.00-18.00 | - | - | 0.06-0.09 | 0.06-0.1 | - | - | - | 0.06-0.08 | 0.06-0.09 | - | |
| 4334 | | | | 130 | 180 | 215 | 18.01-22.00 | - | - | 0.06-0.1 | 0.06-0.12 | - | - | - | 0.06-0.09 | 0.06-0.1 | - | | |
| 4344 | | | | 100 | 135 | 160 | 22.01-27.00 | - | - | 0.06-0.13 | 0.06-0.14 | - | - | - | 0.06-0.11 | 0.06-0.12 | - | | |
| | | | | | | | 27.01-33.00 | - | - | 0.08-0.16 | 0.08-0.17 | | | | | | | | |

CoroDrill® DS20

6 – 7 × DC

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 6xD | | | | | Drill length 7xD | | | | |
|-------------|--|---|------------------|-------------|-------------------------------|------------------|------------------|-----------------|---|------------------|------------------|------------------|-----------------|------------------|------------------|-----------|------------------|-----------|
| | | | | | | | | | -S5W | -L5W | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W |
| | | | | | 6-7xD | | | | Recommended start value at middle of feed range | | | | | | | | | |
| P | P3.0.Z.HT | High alloy steel | 380 | 4324 | 80 | 150 | 190 | 15.00-18.00 | - | - | 0.06-0.09 | 0.06-0.1 | - | - | - | 0.06-0.08 | 0.06-0.09 | - |
| | | | | 4334 | 75 | 125 | 160 | 18.01-22.00 | - | - | 0.06-0.1 | 0.06-0.12 | - | - | - | 0.06-0.09 | 0.06-0.1 | - |
| | | | | 4344 | 70 | 100 | 115 | 22.01-27.00 | - | - | 0.06-0.13 | 0.06-0.14 | - | - | - | 0.06-0.11 | 0.06-0.12 | - |
| | | Hardened & tempered | 27.01-33.00 | - | - | 0.08-0.16 | 0.08-0.17 | - | - | - | - | - | - | 0.08-0.13 | 0.08-0.14 | - | | |
| | | | 33.01-40.00 | - | - | 0.08-0.17 | 0.08-0.18 | - | - | - | - | - | - | 0.08-0.14 | 0.08-0.15 | - | | |
| | | | 40.01-52.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | |
| | 52.01-65.00 | - | - | 0.1-0.17 | 0.1-0.18 | - | - | - | - | - | - | 0.1-0.14 | 0.1-0.15 | - | | | | |
| | P5.0.Z.AN | Ferritic/martensitic stainless steel Annealed | 200 | 4334 | 115 | 165 | 205 | 15.00-18.00 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 | 0.05-0.07 | 0.05-0.07 | 0.05-0.07 | - | 0.05-0.07 |
| | | | | 4344 | 115 | 140 | 160 | 18.01-22.00 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 2044 | 115 | 135 | 150 | 22.01-27.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 27.01-33.00 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.09 | 0.07-0.09 | 0.07-0.09 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.08 | |
| | | | | 33.01-40.00 | 0.07-0.12 | 0.07-0.12 | 0.07-0.12 | - | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.09 | |
| | | | | 40.01-52.00 | 0.09-0.12 | 0.09-0.12 | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.09 | |
| | 52.01-65.00 | 0.09-0.12 | 0.09-0.12 | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.09 | | | | |
| | P5.0.Z.HT | Ferritic/martensitic stainless steel Hardened & tempered | 330 | 4334 | 75 | 120 | 155 | 15.00-18.00 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 | 0.05-0.07 | 0.05-0.07 | 0.05-0.07 | - | 0.05-0.07 |
| 4344 | | | | 70 | 105 | 125 | 18.01-22.00 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.07 | |
| 2044 | | | | 70 | 105 | 125 | 22.01-27.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 | |
| 27.01-33.00 | | | | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.09 | 0.07-0.09 | 0.07-0.09 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.08 | | |
| 33.01-40.00 | | | | 0.07-0.12 | 0.07-0.12 | 0.07-0.12 | - | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.09 | | |
| 40.01-52.00 | | | | 0.09-0.12 | 0.09-0.12 | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.09 | | |
| 52.01-65.00 | 0.09-0.12 | 0.09-0.12 | 0.09-0.12 | - | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.09 | | | | | |
| M | M1.0.Z.AQ | Austenitic Stainless steel Annealed/quenched | 200 | 4334 | 115 | 165 | 205 | 15.00-18.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 115 | 150 | 170 | 18.01-22.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 115 | 140 | 160 | 22.01-27.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.08 |
| | | | | 27.01-33.00 | 0.07-0.12 | 0.07-0.12 | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.09 | |
| | | | | 33.01-40.00 | 0.07-0.13 | 0.07-0.13 | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | |
| | | | | 40.01-52.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | |
| | 52.01-65.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | | | | |
| | M1.1.Z.AQ | Austenitic Stainless steel Machinability improved | 200 | 4334 | 115 | 175 | 215 | 15.00-18.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 115 | 160 | 190 | 18.01-22.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 115 | 155 | 180 | 22.01-27.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.08 |
| | | | | 27.01-33.00 | 0.07-0.12 | 0.07-0.12 | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.09 | |
| | | | | 33.01-40.00 | 0.07-0.13 | 0.07-0.13 | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | |
| | | | | 40.01-52.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | |
| | 52.01-65.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | | | | |
| | M2.0.Z.AQ | Super Austenitic (Ni>20%) Stainless steel Annealed/quenched | 200 | 4334 | 80 | 115 | 135 | 15.00-18.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.07 |
| | | | | 4344 | 80 | 100 | 115 | 18.01-22.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 |
| | | | | 2044 | 80 | 100 | 115 | 22.01-27.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.08 |
| | | | | 27.01-33.00 | 0.07-0.12 | 0.07-0.12 | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.09 | |
| | | | | 33.01-40.00 | 0.07-0.13 | 0.07-0.13 | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | |
| | | | | 40.01-52.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | |
| | 52.01-65.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | | | | |
| M3.1.Z.AQ | Duplex stainless steel >60% ferrite (N<0.10%) | 230 | 4334 | 85 | 115 | 130 | 15.00-18.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.07 | |
| | | | 4344 | 85 | 105 | 115 | 18.01-22.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 | |
| | | | 2044 | 85 | 100 | 115 | 22.01-27.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.08 | |
| | | | 27.01-33.00 | 0.07-0.12 | 0.07-0.12 | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.09 | | |
| | | | 33.01-40.00 | 0.07-0.13 | 0.07-0.13 | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | | |
| | | | 40.01-52.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | | |
| 52.01-65.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | | | | | |
| M3.2.Z.AQ | Duplex stainless steel <60% ferrite (N>0.10%) | 260 | 4334 | 75 | 95 | 110 | 15.00-18.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.09 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.07 | |
| | | | 4344 | 75 | 90 | 105 | 18.01-22.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0.1 | - | 0.05-0.1 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | - | 0.05-0.08 | |
| | | | 2044 | 75 | 90 | 105 | 22.01-27.00 | 0.05-0.11 | 0.05-0.11 | 0.05-0.11 | - | 0.05-0.1 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | 0.05-0.08 | |
| | | | 27.01-33.00 | 0.07-0.12 | 0.07-0.12 | 0.07-0.12 | - | 0.07-0.11 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.09 | | |
| | | | 33.01-40.00 | 0.07-0.13 | 0.07-0.13 | 0.07-0.13 | - | 0.07-0.12 | 0.07-0.1 | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | 0.07-0.1 | - | 0.07-0.1 | | |
| | | | 40.01-52.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | | |
| 52.01-65.00 | 0.09-0.13 | 0.09-0.13 | 0.09-0.13 | - | 0.09-0.12 | 0.09-0.1 | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | 0.09-0.1 | - | 0.09-0.1 | | | | | |
| S | S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS | Heat resistant super alloys Ni based | 350 | 4334 | 20 | 35 | 45 | 15.00-18.00 | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 | - | - | 0.04-0.05 | 0.04-0.05 | 0.04-0.05 | - | |
| | | | | 4344 | 20 | 35 | 45 | 18.01-22.00 | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | - | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 | - | |
| | | | | 2044 | 20 | 35 | 45 | 22.01-27.00 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | - | - | 0.04-0.07 | 0.04-0.07 | 0.04-0.07 | - | |
| | | | | 27.01-33.00 | 0.05-0.09 | 0.05-0.09 | 0.05-0.09 | - | - | 0.05-0.07 | 0.05-0.07 | 0.05-0.07 | - | - | 0.05-0.07 | - | | |
| | | | | 33.01-40.00 | 0.05-0.1 | 0.05-0.1 | 0.05-0. | | | | | | | | | | | |

CoroDrill® DS20

6 – 7 × DC

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 6xD | | | | | Drill length 7xD | | | | |
|-----------|--|---|------|-------|-------------------------------|------|-------------|----------------|------------------|-----------|------------------|------------------|------|------------------|-----------|------------------|------------------|---|
| | | | | | 6-7xD | -S5W | -L5W | | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W | | |
| K | K1.1.C.NS | Malleable cast iron Low tensile strength | 200 | 4324 | 140 | 190 | 220 | 15.00-18.00 | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - | - | 0.08-0.08 | 0.08-0.08 | 0.08-0.11 | - |
| | | | | 4334 | 110 | 155 | 180 | 18.01-22.00 | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.15 | - | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - |
| | | | | 4344 | 180 | 150 | 140 | 22.01-27.00 | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.17 | - | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.14 | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.16 | 0.1-0.16 | 0.1-0.19 | - | - | 0.1-0.13 | 0.1-0.13 | 0.1-0.16 | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.18 | 0.1-0.18 | 0.1-0.21 | - | - | 0.1-0.15 | 0.1-0.15 | 0.1-0.18 | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.18 | 0.12-0.18 | 0.12-0.21 | - | - | 0.12-0.15 | 0.12-0.15 | 0.12-0.18 | - |
| | K2.1.C.UT | Grey cast iron Low tensile strength | 180 | 4324 | 210 | 255 | 295 | 15.00-18.00 | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - | - | 0.08-0.08 | 0.08-0.08 | 0.08-0.11 | - |
| | | | | 4334 | 170 | 210 | 245 | 18.01-22.00 | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.15 | - | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - |
| | | | | 4344 | 130 | 160 | 185 | 22.01-27.00 | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.17 | - | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.14 | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.16 | 0.1-0.16 | 0.1-0.19 | - | - | 0.1-0.13 | 0.1-0.13 | 0.1-0.16 | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.18 | 0.1-0.18 | 0.1-0.21 | - | - | 0.1-0.15 | 0.1-0.15 | 0.1-0.18 | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.18 | 0.12-0.18 | 0.12-0.21 | - | - | 0.12-0.15 | 0.12-0.15 | 0.12-0.18 | - |
| | K2.2.C.UT | Grey cast iron High tensile strength | 245 | 4324 | 125 | 185 | 220 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | 0.08-0.12 | - | - | 0.08-0.07 | 0.08-0.07 | 0.08-0.1 | - |
| | | | | 4334 | 100 | 145 | 175 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.14 | - | - | 0.08-0.09 | 0.08-0.09 | 0.08-0.12 | - |
| | | | | 4344 | 75 | 115 | 135 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.16 | - | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - |
| | | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.18 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.15 | - |
| | | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | 0.1-0.2 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.17 | - |
| | | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | 0.12-0.2 | - | - | 0.12-0.14 | 0.12-0.14 | 0.12-0.17 | - |
| K3.1.C.UT | Nodular cast iron Ferritic | 155 | 4324 | 125 | 170 | 205 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | 0.08-0.12 | - | - | 0.08-0.07 | 0.08-0.07 | 0.08-0.1 | - | |
| | | | 4334 | 100 | 140 | 165 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.14 | - | - | 0.08-0.09 | 0.08-0.09 | 0.08-0.12 | - | |
| | | | 4344 | 80 | 110 | 130 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.16 | - | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - | |
| | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.18 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.15 | - | |
| | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | 0.1-0.2 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.17 | - | |
| | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | 0.12-0.2 | - | - | 0.12-0.14 | 0.12-0.14 | 0.12-0.17 | - | |
| K3.3.C.UT | Nodular cast iron Pearlitic | 265 | 4324 | 110 | 160 | 190 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | 0.08-0.12 | - | - | 0.08-0.07 | 0.08-0.07 | 0.08-0.1 | - | |
| | | | 4334 | 90 | 130 | 160 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.14 | - | - | 0.08-0.09 | 0.08-0.09 | 0.08-0.12 | - | |
| | | | 4344 | 70 | 100 | 115 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.16 | - | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - | |
| | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.18 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.15 | - | |
| | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | 0.1-0.2 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.17 | - | |
| | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | 0.12-0.2 | - | - | 0.12-0.14 | 0.12-0.14 | 0.12-0.17 | - | |
| K4.2.C.UT | Compacted graphite iron High tensile strength (Pearlite>90%) | 230 | 4324 | 130 | 190 | 225 | 15.00-18.00 | - | 0.08-0.08 | 0.08-0.08 | 0.08-0.12 | - | - | 0.08-0.07 | 0.08-0.07 | 0.08-0.1 | - | |
| | | | 4334 | 110 | 155 | 180 | 18.01-22.00 | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.14 | - | - | 0.08-0.09 | 0.08-0.09 | 0.08-0.12 | - | |
| | | | 4344 | 85 | 115 | 135 | 22.01-27.00 | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.16 | - | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.13 | - | |
| | | | | | | | 27.01-33.00 | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.18 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.15 | - | |
| | | | | | | | 33.01-40.00 | - | 0.1-0.16 | 0.1-0.16 | 0.1-0.2 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.17 | - | |
| | | | | | | | 40.01-52.00 | - | 0.12-0.16 | 0.12-0.16 | 0.12-0.2 | - | - | 0.12-0.14 | 0.12-0.14 | 0.12-0.17 | - | |
| H | H1.3.Z.HA Extra hard steels Hardened & tempered | 60 (HRC) | 4324 | 30 | 60 | 75 | 15.00-18.00 | - | 0.06-0.08 | 0.06-0.08 | 0.06-0.08 | - | - | 0.06-0.07 | 0.06-0.07 | 0.06-0.07 | - | |
| | | | 4334 | 30 | 60 | 75 | 18.01-22.00 | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - | 0.06-0.08 | 0.06-0.08 | 0.06-0.08 | - | |
| | | | 4344 | 30 | 60 | 75 | 22.01-27.00 | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.08 | 0.06-0.08 | 0.06-0.08 | - | |
| | | | | | | | 27.01-33.00 | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.1 | - | - | 0.08-0.09 | 0.08-0.09 | 0.08-0.09 | - | |
| | | | | | | | 33.01-40.00 | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | - | - | 0.08-0.1 | 0.08-0.1 | 0.08-0.1 | - | |
| | | | | | | | 40.01-52.00 | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.12 | - | - | 0.1-0.1 | 0.1-0.1 | 0.1-0.1 | - | |

CoroDrill® DS20

6 – 7 × DC

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations | | | Drill diameter | Drill length 6xD | | | | | Drill length 7xD | | | | |
|-----------|--|---|--------------|-----------------|-------------------------------|----------|-------------|------------------|------------------|-----------------|-----------|----------|------------------|------------------|-----------|-----------|------|------|
| | | | | | | | | | -S5W | -L5W | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W |
| N | N1.2.Z.AG | Aluminum based alloys AlSi alloys (Si<1%) | 100 | H13A 4344 | 6-7xD | | | 15.00-18.00 | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - |
| | | | | | 300 | 330 | 360 | 18.01-22.00 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | 300 | 330 | 360 | 22.01-27.00 | 0.06-0.13 | 0.06-0.13 | 0.06-0.13 | - | - | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - | - |
| | | | | | | | | 27.01-33.00 | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 33.01-40.00 | 0.08-0.16 | 0.08-0.16 | 0.08-0.16 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - |
| | | | | | | | | 40.01-52.00 | 0.1-0.16 | 0.1-0.16 | 0.1-0.16 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - |
| | | | | 52.01-65.00 | 0.1-0.16 | 0.1-0.16 | 0.1-0.16 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | | | | |
| | N1.3.C.UT | Aluminum based alloys AlSi cast alloys (1%<Si >13%) | 75 | H13A 4344 | 6-7xD | | | 15.00-18.00 | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - | 0.06-0.08 | 0.06-0.08 | 0.06-0.08 | - | - |
| | | | | | 250 | 315 | 360 | 18.01-22.00 | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - |
| | | | | | 250 | 315 | 360 | 22.01-27.00 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 27.01-33.00 | 0.08-0.13 | 0.08-0.13 | 0.08-0.13 | - | - | 0.08-0.11 | 0.08-0.11 | 0.08-0.11 | - | - |
| | | | | | | | | 33.01-40.00 | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 40.01-52.00 | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.12 | - | - |
| | | | | 52.01-65.00 | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.12 | - | - | | | | |
| | N1.3.C.AG | Aluminum based alloys AlSi cast and aged alloys (1%<Si>13%) | 90 | H13A 4344 | 6-7xD | | | 15.00-18.00 | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - | 0.06-0.08 | 0.06-0.08 | 0.06-0.08 | - | - |
| | | | | | 250 | 285 | 315 | 18.01-22.00 | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - |
| | | | | | 250 | 285 | 315 | 22.01-27.00 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | | | | 27.01-33.00 | 0.08-0.13 | 0.08-0.13 | 0.08-0.13 | - | - | 0.08-0.11 | 0.08-0.11 | 0.08-0.11 | - | - |
| | | | | | | | | 33.01-40.00 | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | - | - |
| | | | | | | | | 40.01-52.00 | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.12 | - | - |
| | | | | 52.01-65.00 | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | 0.1-0.12 | 0.1-0.12 | 0.1-0.12 | - | - | | | | |
| | N3.3.U.UT | Copper based alloys Free cutting copper based alloys | 110 | H13A 4344 | 6-7xD | | | 15.00-18.00 | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - |
| | | | | | 250 | 315 | 360 | 18.01-22.00 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - |
| | | | | | 250 | 315 | 360 | 22.01-27.00 | 0.06-0.13 | 0.06-0.13 | 0.06-0.13 | - | - | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - | - |
| | | | | | | | 27.01-33.00 | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | - | - | |
| | | | | | | | 33.01-40.00 | 0.08-0.16 | 0.08-0.16 | 0.08-0.16 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - | |
| | | | | | | | 40.01-52.00 | 0.1-0.16 | 0.1-0.16 | 0.1-0.16 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | |
| | | | 52.01-65.00 | 0.1-0.16 | 0.1-0.16 | 0.1-0.16 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | | | | | |
| N3.2.C.UT | Copper based alloys Leaded brass and bronzes (Pb<1%) | 90 | H13A 4344 | 6-7xD | | | 15.00-18.00 | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | 0.06-0.09 | 0.06-0.09 | 0.06-0.09 | - | - | |
| | | | | 180 | 200 | 215 | 18.01-22.00 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | - | - | 0.06-0.1 | 0.06-0.1 | 0.06-0.1 | - | - | |
| | | | | 180 | 200 | 215 | 22.01-27.00 | 0.06-0.13 | 0.06-0.13 | 0.06-0.13 | - | - | 0.06-0.11 | 0.06-0.11 | 0.06-0.11 | - | - | |
| | | | | | | | 27.01-33.00 | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | - | - | |
| | | | | | | | 33.01-40.00 | 0.08-0.16 | 0.08-0.16 | 0.08-0.16 | - | - | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | - | - | |
| | | | | | | | 40.01-52.00 | 0.1-0.16 | 0.1-0.16 | 0.1-0.16 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | |
| | | | 52.01-65.00 | 0.1-0.16 | 0.1-0.16 | 0.1-0.16 | - | - | 0.1-0.14 | 0.1-0.14 | 0.1-0.14 | - | - | | | | | |

Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.05 mm/rev.

CoroDrill® 880

2 – 3 x DC

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (m/min) | Drill diameter DC mm | Geometry / Feed | | | |
|---------------------|---------------------------------|---|-------------------------------|-------------------------------|---------------------------------|--------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|
| | | | | | | | Drill length 2-3xD | | | |
| | | | | | | | -LM <i>f_n</i> mm/rev | -GM <i>f_n</i> mm/rev | -GR <i>f_n</i> mm/rev | -GT <i>f_n</i> mm/rev |
| P | P1.0.Z.AN (01.0) | Unalloyed steel Non hardened 0.05-0.10% C | 90-200 | 4324 4334 4344 | 230-400 210-325 190-245 | 12.00-13.99 | 0.04-0.08 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.08 | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 |
| | | | | | | 16.50-19.99 | 0.04-0.10 | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 |
| | | | | | | 20.00-23.99 | 0.04-0.12 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 |
| | | | | | | 24.00-29.99 | 0.04-0.12 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 |
| | | | | | | 30.00-35.99 | 0.06-0.14 | 0.06-0.10 | 0.06-0.10 | 0.06-0.10 |
| | | | | | | 36.00-43.99 | 0.06-0.16 | 0.06-0.10 | 0.06-0.10 | 0.06-0.10 |
| | | | | | | 44.00-52.99 | 0.08-0.16 | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 |
| | 53.00-63.50 | 0.08-0.16 | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | | | | | |
| | P1.1.Z.AN (01.1) | Non hardened 0.05-0.25% C | 90-200 | 4324 4334 4344 | 230-370 200-305 170-235 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 |
| | | | | | | 16.50-19.99 | 0.04-0.12 | 0.04-0.06 | 0.04-0.06 | 0.04-0.06 |
| | | | | | | 20.00-23.99 | 0.04-0.14 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 |
| | | | | | | 24.00-29.99 | 0.04-0.14 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 |
| | | | | | | 30.00-35.99 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 |
| | | | | | | 36.00-43.99 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 |
| | | | | | | 44.00-52.99 | 0.08-0.16 | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 |
| | 53.00-63.50 | 0.08-0.16 | 0.08-0.12 | 0.08-0.12 | 0.08-0.12 | | | | | |
| | P1.2.Z.AN (01.2) | Non hardened 0.25-0.55% C | 125-225 | 4324 4334 4344 | 190-305 155-250 120-190 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 |
| | | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 |
| | | | | | | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 |
| | | | | | | 24.00-29.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 |
| | | | | | | 30.00-35.99 | 0.06-0.22 | 0.06-0.22 | 0.06-0.22 | 0.06-0.22 |
| | | | | | | 36.00-43.99 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 |
| | | | | | | 44.00-52.99 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 |
| | 53.00-63.50 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | | | | | |
| | P1.3.Z.AN (01.3) | Non hardened 0.55-0.80% C | 150-250 | 4324 4334 4344 | 170-290 140-240 105-185 | 12.00-13.99 | 0.04-0.10 | | | |
| 14.00-16.49 | | | | | | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | |
| 16.50-19.99 | | | | | | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | |
| 20.00-23.99 | | | | | | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | |
| 24.00-29.99 | | | | | | 0.06-0.18 | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 | |
| 30.00-35.99 | | | | | | 0.06-0.24 | 0.08-0.24 | 0.08-0.24 | 0.08-0.24 | |
| 36.00-43.99 | | | | | | 0.06-0.24 | 0.08-0.24 | 0.08-0.24 | 0.08-0.24 | |
| 44.00-52.99 | | | | | | 0.06-0.24 | 0.08-0.24 | 0.08-0.24 | 0.08-0.24 | |
| 53.00-63.50 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | | | | | | |
| P1.3.Z.AN (01.4) | High carbon & carbon tool steel | 180-275 | 4324 4334 4344 | 200-290 155-240 105-180 | 12.00-13.99 | 0.04-0.10 | | | | |
| | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | |
| | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | |
| | | | | | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | |
| | | | | | 24.00-29.99 | 0.06-0.18 | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 | |
| | | | | | 30.00-35.99 | 0.06-0.24 | 0.08-0.24 | 0.08-0.24 | 0.08-0.24 | |
| | | | | | 36.00-43.99 | 0.06-0.24 | 0.08-0.24 | 0.08-0.24 | 0.08-0.24 | |
| | | | | | 44.00-52.99 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | |
| 53.00-63.50 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | | | | | | |
| P2.1.Z.AN (02.1) | Low alloy steel (Non-hardened) | 150-260 | 4324 4334 4344 | 180-305 150-250 115-190 | 12.00-13.99 | 0.04-0.10 | | | | |
| | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | |
| | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | |
| | | | | | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | |
| | | | | | 24.00-29.99 | 0.06-0.18 | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 | |
| | | | | | 30.00-35.99 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | |
| | | | | | 36.00-43.99 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | |
| | | | | | 44.00-52.99 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | |
| 53.00-63.50 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | | | | | | |
| P2.5.Z.HT (02.2) | Hardened steel | 220-450 | 4324 4334 4344 | 90-245 85-195 75-150 | 12.00-13.99 | 0.04-0.10 | | | | |
| | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | |
| | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | |
| | | | | | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | |
| | | | | | 24.00-29.99 | 0.06-0.18 | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 | |
| | | | | | 30.00-35.99 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | |
| | | | | | 36.00-43.99 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | |
| | | | | | 44.00-52.99 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | |
| 53.00-63.50 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | | | | | | |

Note: Bold text is recommended geometry
Central insert grade is always 1044.

CoroDrill® 880

2 – 3 x DC

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (m/min) | Drill diameter DC mm | Geometry / Feed Drill length 2-3xD | | | |
|---------------------|----------------------|-----------------------------|---------------------------|------------------|-----------------------------|---|---------------------------------------|---------------------|---------------------|---------------------|
| | | | | | | | -LM f_n mm/rev | -GM f_n mm/rev | -GR f_n mm/rev | -GT f_n mm/rev |
| P | P3.0.Z.AN (03.11) | High alloy steel (Annealed) | 150-250 | 4324 | 160-280 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 |
| | | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 |
| | | | | | | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 |
| | | | | | | 24.00-29.99 | 0.06-0.18 | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 |
| | | | | | | 30.00-35.99 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 |
| | | | | | | 36.00-43.99 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 | 0.06-0.24 |
| | | | | | | 44.00-52.99 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 |
| | | | | | | 53.00-63.50 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 | 0.10-0.24 |
| | | | | | | P3.0.Z.HT (03.21) | Hardened steel | 250-350 | 4324 | 80-210 |
| | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | | | | | |
| | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | | | | | |
| | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | | | | | |
| | 24.00-29.99 | 0.06-0.18 | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 | | | | | |
| | 30.00-35.99 | 0.06-0.20 | 0.06-0.20 | 0.06-0.20 | 0.06-0.20 | | | | | |
| | 36.00-43.99 | 0.06-0.22 | 0.06-0.22 | 0.06-0.22 | 0.06-0.22 | | | | | |
| | 44.00-52.99 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | | | | | |
| | 53.00-63.50 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | | | | | |
| | 06.1 | Steel castings (Unalloyed) | 90-225 | 4324 | 140-365 | | | | | |
| | | | | | | 14.00-16.49 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 |
| 16.50-19.99 | | | | | | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | |
| 20.00-23.99 | | | | | | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | |
| 24.00-29.99 | | | | | | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | |
| 30.00-35.99 | | | | | | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | |
| 36.00-43.99 | | | | | | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | 0.06-0.14 | |
| 44.00-52.99 | | | | | | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | |
| 53.00-63.50 | | | | | | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | 0.08-0.14 | |
| P1.5.C.UT (06.2) | | | | | | Low alloyed (alloying elements less than 5%) | 150-250 | 4324 | 110-265 | 12.00-13.99 |
| | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 | | | | | |
| | 16.50-19.99 | 0.04-0.14 | 0.04-0.14 | 0.04-0.14 | 0.04-0.14 | | | | | |
| | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | 0.06-0.18 | | | | | |
| | 24.00-29.99 | 0.06-0.18 | 0.08-0.18 | 0.08-0.18 | 0.08-0.18 | | | | | |
| | 30.00-35.99 | 0.06-0.20 | 0.06-0.20 | 0.06-0.20 | 0.06-0.20 | | | | | |
| | 36.00-43.99 | 0.06-0.22 | 0.06-0.22 | 0.06-0.22 | 0.06-0.22 | | | | | |
| | 44.00-52.99 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | | | | | |
| | 53.00-63.50 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | 0.10-0.22 | | | | | |

Note: Bold text is recommended geometry
Central insert grade is always 1044.

CoroDrill® 880

2 – 3 x DC

| ISO | MC No. | Material | Hardness Brinell | Grade | Cutting speed (m/min) | Drill diameter DC mm | Geometry/ feed (f _r , mm/rev.) | | | | | | | | | |
|--|---|---|----------------------|------------------|-----------------------|----------------------|---|-------------------|------------------|------------------|------------------|------------------|-----------|-----------|-----------|-----------|
| | | | | | | | Drill length 2-3xD | | | | | | | | | |
| | | | | | | | -LM | -MS ¹⁾ | -GM | -GR | -GT | | | | | |
| M | P5.0.Z.AN (05.11) | Stainless steel Ferritic/ Martensitic 13-25% Cr | 150-270 | 4324 | 120-280 | 12.00-13.99 | 0.04-0.12 | 0.04-0.12 | 0.04-0.08 | 0.04-0.08 | 0.04-0.14 | | | | | |
| | | | | | | 14.00-16.49 | 0.04-0.14 | 0.04-0.14 | 0.04-0.08 | 0.04-0.08 | 0.06-0.16 | | | | | |
| | | | | | | 16.50-19.99 | 0.06-0.16 | 0.06-0.16 | 0.04-0.08 | 0.04-0.08 | 0.06-0.16 | | | | | |
| | | | | | | 20.00-23.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.14 | 0.06-0.14 | 0.06-0.18 | | | | | |
| | | | | | | 4334 | 115-225 | 24.00-29.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.14 | 0.06-0.14 | 0.06-0.18 | | | |
| | | | | | | 4344 | 115-175 | 30.00-35.99 | 0.06-0.20 | 0.06-0.20 | 0.06-0.16 | 0.06-0.16 | 0.06-0.20 | | | |
| | 2044 | 115-165 | 36.00-43.99 | 0.06-0.20 | 0.06-0.20 | 0.06-0.16 | 0.06-0.16 | 0.10-0.24 | | | | | | | | |
| | | | 44.00-52.99 | 0.10-0.24 | 0.10-0.24 | 0.10-0.18 | 0.10-0.18 | 0.10-0.24 | | | | | | | | |
| | | | 53.00-63.50 | 0.10-0.24 | 0.10-0.24 | 0.10-0.18 | 0.10-0.18 | 0.10-0.24 | | | | | | | | |
| | M1.0.Z.AQ (05.21) | Austenitic Ni > 8%, 13-25% Cr | 150-275 | 4324 | 120-265 | 12.00-13.99 | 0.04-0.12 | 0.04-0.12 | 0.04-0.08 | 0.04-0.08 | 0.04-0.14 | | | | | |
| | | | | | | 14.00-16.49 | 0.04-0.14 | 0.04-0.14 | 0.04-0.08 | 0.04-0.08 | 0.04-0.14 | | | | | |
| | | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 | | | | | |
| | | | | | | 20.00-23.99 | 0.06-0.16 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 | | | | | |
| | | | | | | 4334 | 115-225 | 24.00-29.99 | 0.06-0.16 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 | | | |
| | | | | | | 4344 | 115-190 | 30.00-35.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.16 | 0.06-0.16 | 0.06-0.20 | | | |
| 2044 | 115-180 | 36.00-43.99 | 0.06-0.20 | 0.06-0.20 | 0.06-0.16 | 0.06-0.16 | 0.06-0.20 | | | | | | | | | |
| | | 44.00-52.99 | 0.10-0.20 | 0.10-0.20 | 0.10-0.16 | 0.10-0.16 | 0.10-0.20 | | | | | | | | | |
| | | 53.00-63.50 | 0.10-0.20 | 0.10-0.20 | 0.10-0.16 | 0.10-0.16 | 0.10-0.20 | | | | | | | | | |
| M3.1.Z.AQ (05.51) M3.2.Z.AQ (05.52) | Austenitic/Ferritic (Duplex) | 200-320 | 4324 | 90-155 | 12.00-13.99 | 0.04-0.12 | 0.04-0.12 | 0.04-0.08 | 0.04-0.08 | 0.04-0.14 | | | | | | |
| | | | | | 14.00-16.49 | 0.04-0.14 | 0.04-0.14 | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 | | | | | | |
| | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 | | | | | | |
| | | | | | 20.00-23.99 | 0.06-0.16 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 | | | | | | |
| | | | | | 4334 | 85-145 | 24.00-29.99 | 0.06-0.16 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 | | | | |
| | | | | | 4344 | 85-130 | 30.00-35.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.16 | 0.06-0.16 | 0.06-0.18 | | | | |
| 2044 | 85-125 | 36.00-43.99 | 0.06-0.20 | 0.06-0.20 | 0.06-0.16 | 0.06-0.16 | 0.06-0.20 | | | | | | | | | |
| | | 44.00-52.99 | 0.10-0.20 | 0.10-0.20 | 0.10-0.16 | 0.10-0.16 | 0.10-0.20 | | | | | | | | | |
| | | 53.00-63.50 | 0.10-0.20 | 0.10-0.20 | 0.10-0.16 | 0.10-0.16 | 0.10-0.20 | | | | | | | | | |
| M1.0.C.UT (15.21) | Austenitic castings | 150-250 | 4324 | 150-210 | 12.00-13.99 | 0.04-0.12 | 0.04-0.12 | 0.04-0.08 | 0.04-0.08 | 0.04-0.12 | | | | | | |
| | | | | | 14.00-16.49 | 0.04-0.12 | 0.04-0.12 | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 | | | | | | |
| | | | | | 16.50-19.99 | 0.06-0.14 | 0.06-0.14 | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 | | | | | | |
| | | | | | 20.00-23.99 | 0.06-0.16 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 | | | | | | |
| | | | | | 4334 | 115-185 | 24.00-29.99 | 0.06-0.16 | 0.06-0.16 | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 | | | | |
| | | | | | 4344 | 80-165 | 30.00-35.99 | 0.06-0.18 | 0.06-0.18 | 0.06-0.16 | 0.06-0.16 | 0.06-0.18 | | | | |
| 2044 | 80-155 | 36.00-43.99 | 0.06-0.20 | 0.06-0.20 | 0.06-0.16 | 0.06-0.16 | 0.06-0.20 | | | | | | | | | |
| | | 44.00-52.99 | 0.10-0.20 | 0.10-0.20 | 0.10-0.16 | 0.10-0.16 | 0.10-0.20 | | | | | | | | | |
| | | 53.00-63.50 | 0.10-0.20 | 0.10-0.20 | 0.10-0.16 | 0.10-0.16 | 0.10-0.20 | | | | | | | | | |
| S | S2.0.Z.AN (20.21) | Heat resistant alloys. Ni Based | 140-425 | 4344 | 20-95 | 12.00-13.99 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 | | | | | |
| | | | | | | 14.00-16.49 | 0.04-0.08 | 0.04-0.08 | 0.04-0.10 | 0.04-0.08 | 0.04-0.08 | | | | | |
| | | | | | | 16.50-19.99 | 0.05-0.08 | 0.05-0.08 | 0.05-0.10 | 0.05-0.08 | 0.05-0.08 | | | | | |
| | S2.0.Z.AG (20.22) | 2044 | 20-90 | 20.00-23.99 | 0.05-0.08 | 0.05-0.08 | 0.05-0.10 | 0.05-0.08 | 0.05-0.08 | 0.05-0.08 | | | | | | |
| | | | | 24.00-29.99 | 0.06-0.10 | 0.06-0.10 | 0.06-0.12 | 0.06-0.08 | 0.05-0.08 | | | | | | | |
| | | | | 30.00-35.99 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | | | | | | | |
| | S2.0.C.NS (20.24) | 36.00-43.99 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | | | | | | |
| | | | | | | | | | | | 44.00-52.99 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 | 0.06-0.12 |
| | | | | | | | | | | | 53.00-63.50 | 0.08-0.14 | 0.08-0.14 | 0.06-0.14 | 0.08-0.12 | 0.08-0.14 |
| | S4.2.Z.AN (23.21) | Titanium: Alfa- , near Alfa- and Alfa + Beta alloys in annealed condition | Rm (Mpa) 600-1500 | 4344 | 40-145 | 12.00-13.99 | 0.04-0.14 | 0.04-0.14 | 0.04-0.10 | 0.04-0.10 | 0.06-0.10 | | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.14 | 0.06-0.14 | 0.06-0.12 | 0.06-0.10 | 0.06-0.10 | | | | | |
| | | | | | | 16.50-19.99 | 0.08-0.16 | 0.08-0.16 | 0.08-0.14 | 0.08-0.12 | 0.08-0.12 | | | | | |
| 20.00-23.99 | | | | | | 0.08-0.16 | 0.08-0.16 | 0.08-0.14 | 0.08-0.12 | 0.08-0.12 | | | | | | |
| H13A | | | | | | 40-135 | 24.00-29.99 | 0.12-0.18 | 0.12-0.18 | 0.10-0.16 | 0.10-0.14 | 0.10-0.14 | | | | |
| 2044 | | | | | | 40-135 | 30.00-35.99 | 0.12-0.18 | 0.12-0.18 | 0.10-0.18 | 0.10-0.16 | 0.12-0.18 | | | | |
| S4.3.Z.AG (23.22) | Titanium: Alfa + Beta alloys in aged condition, Beta alloys in annealed or aged condition | 36.00-43.99 | 0.12-0.18 | 0.12-0.18 | 0.10-0.18 | 0.10-0.18 | 0.10-0.16 | 0.12-0.18 | 0.12-0.18 | | | | | | | |
| | | | | | | | | | | 44.00-52.99 | 0.12-0.18 | 0.12-0.18 | 0.10-0.18 | 0.10-0.16 | 0.12-0.18 | |
| | | | | | | | | | | 53.00-63.50 | 0.14-0.20 | 0.14-0.20 | 0.14-0.20 | 0.12-0.16 | 0.14-0.20 | |

Note: Bold text is recommended geometry
 1) -MS geometry is only available in GC2044
 GC1044 is the universal central insert grade for all materials
 GC1144 is the optimized central insert grade for ISO M materials



CoroDrill® 880

2 – 3 x DC

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (m/min) | Drill diameter DC mm | Geometry / Feed Drill length 2-3xD | | | |
|---------------------|------------------------------|--|---------------------------|------------------|-----------------------------|----------------------------|---------------------------------------|----------------------|----------------------|----------------------|
| | | | | | | | -LM f_n mm/rev. | -GM f_n mm/rev. | -GR f_n mm/rev. | -GT f_n mm/rev. |
| K | K1.1.C.NS (07.1) | Malleable cast iron Ferritic (Short chipping) | 110-145 | 4324 | 140-245 | 12.00-13.99 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | 0.06-0.20 | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | 0.08-0.22 | 0.08 - 0.22 |
| | | | | | | 20.00-23.99 | 0.08-0.14 | 0.10-0.18 | 0.14-0.28 | 0.10 - 0.26 |
| | | | | | | 24.00-29.99 | 0.08-0.14 | 0.10-0.20 | 0.16-0.32 | |
| | | | | | | 30.00-35.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | |
| | | | | | | 36.00-43.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.34 | |
| | 44.00-52.99 | 0.12-0.18 | 0.12-0.22 | 0.12-0.34 | | | | | | |
| | 53.00-63.50 | | | | | | | | | |
| | K1.1.C.NS (07.2) | Pearlitic (long chipping) | 150-270 | 4324 | 105-180 | 12.00-13.99 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | 0.06-0.16 | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | 0.08-0.18 | 0.08 - 0.18 |
| | | | | | | 20.00-23.99 | 0.08-0.14 | 0.10-0.16 | 0.10-0.24 | 0.10 - 0.24 |
| | | | | | | 24.00-29.99 | 0.08-0.14 | 0.10-0.18 | 0.10-0.28 | |
| | | | | | | 30.00-35.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.30 | |
| | | | | | | 36.00-43.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | |
| | 44.00-52.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | | | | | | |
| | 53.00-63.50 | | | | | | | | | |
| | K2.1.C.UT (08.1) | Grey cast iron: Low tensile strength | 150-220 | 4324 | 210-325 | 12.00-13.99 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | 0.06-0.20 | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | 0.08-0.22 | 0.08 - 0.22 |
| | | | | | | 20.00-23.99 | 0.08-0.14 | 0.10-0.18 | 0.10-0.28 | 0.10 - 0.28 |
| | | | | | | 24.00-29.99 | 0.08-0.14 | 0.10-0.20 | 0.10-0.32 | |
| | | | | | | 30.00-35.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | |
| 36.00-43.99 | | | | | | 0.10-0.16 | 0.10-0.20 | 0.10-0.34 | | |
| 44.00-52.99 | 0.12-0.18 | 0.12-0.22 | 0.12-0.34 | | | | | | | |
| 53.00-63.50 | | | | | | | | | | |
| K2.2.C.UT (08.2) | High tensile strength | 200-330 | 4324 | 125-245 | 12.00-13.99 | | | | | |
| | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | 0.06-0.16 | | |
| | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | 0.08-0.18 | 0.08 - 0.18 | |
| | | | | | 20.00-23.99 | 0.08-0.14 | 0.10-0.16 | 0.10-0.24 | 0.10 - 0.24 | |
| | | | | | 24.00-29.99 | 0.08-0.14 | 0.10-0.18 | 0.10-0.28 | | |
| | | | | | 30.00-35.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.30 | | |
| | | | | | 36.00-43.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | | |
| 44.00-52.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | | | | | | | |
| 53.00-63.50 | | | | | | | | | | |
| K3.1.C.UT (09.1) | Nodular cast iron (Ferritic) | 150-230 | 4324 | 125-225 | 12.00-13.99 | | | | | |
| | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | 0.08-0.16 | | |
| | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | 0.10-0.18 | 0.08 - 0.18 | |
| | | | | | 20.00-23.99 | 0.08-0.14 | 0.10-0.16 | 0.12-0.24 | 0.10 - 0.24 | |
| | | | | | 24.00-29.99 | 0.08-0.14 | 0.10-0.18 | 0.14-0.28 | | |
| | | | | | 30.00-35.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.30 | | |
| | | | | | 36.00-43.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | | |
| 44.00-52.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | | | | | | | |
| 53.00-63.50 | | | | | | | | | | |
| K3.3.C.UT (09.2) | Pearlitic | 200-330 | 4324 | 110-210 | 12.00-13.99 | | | | | |
| | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | 0.08-0.16 | | |
| | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | 0.10-0.18 | 0.08 - 0.18 | |
| | | | | | 20.00-23.99 | 0.08-0.14 | 0.10-0.16 | 0.12-0.24 | 0.10 - 0.24 | |
| | | | | | 24.00-29.99 | 0.08-0.14 | 0.10-0.18 | 0.14-0.28 | | |
| | | | | | 30.00-35.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.30 | | |
| | | | | | 36.00-43.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | | |
| 44.00-52.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | | | | | | | |
| 53.00-63.50 | | | | | | | | | | |

Note: Bold text is recommended geometry
Central insert grade is always 1044.

CoroDrill® 880

2 – 3 x DC

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (m/min) | Drill diameter DC mm | Geometry / Feed | | | |
|-------------|----------------------|--------------------------|-------------------------------|-------------|---------------------------------|--------------------------------|-------------------------------------|---|-------------------------------------|-------------------------------------|
| | | | | | | | Drill length 2-3xD | | | |
| | | | | | | | -LM <i>f_n</i> mm/rev. | -GM <i>f_n</i> mm/rev. | -GR <i>f_n</i> mm/rev. | -GT <i>f_n</i> mm/rev. |
| H | H1.3.Z.HA (04.1) | Hardened and tempered | 47-65 (HRC) | 4324 | 30-85 | 12.00-13.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.32 | |
| | | | | | | 14.00-16.49 | 0.04-0.08 | 0.04-0.12 | 0.04-0.08 | 0.04 - 0.08 |
| | | | | | | 16.50-19.99 | 0.05-0.12 | 0.06-0.14 | 0.05-0.12 | 0.05 - 0.12 |
| | | | | | | 20.00-23.99 | 0.05-0.14 | 0.06-0.18 | 0.05-0.14 | 0.05 - 0.14 |
| | | | | | | 24.00-29.99 | 0.05-0.14 | 0.06-0.18 | 0.05-0.14 | 0.05 - 0.14 |
| | | | | | | 30.00-35.99 | 0.06-0.16 | 0.06-0.20 | 0.06-0.16 | |
| | | | | | | 36.00-43.99 | 0.06-0.16 | 0.06-0.20 | 0.06-0.16 | |
| | | | | | | 44.00-52.99 | 0.10-0.16 | 0.10-0.20 | 0.10-0.16 | |
| | | | | | | 53.00-63.50 | | | | |
| | | | | | | N | N1.2.Z.AG (30.12) | Al. alloys Wrought or wrought and aged | 30-150 | 4344 |
| 14.00-16.49 | 0.04-0.14 | 0.04-0.12 | 0.04-0.12 | 0.04-0.12 | | | | | | |
| 16.50-19.99 | 0.04-0.16 | 0.04-0.14 | 0.04-0.14 | 0.04 - 0.14 | | | | | | |
| 20.00-23.99 | 0.06-0.18 | 0.06-0.16 | 0.06-0.16 | 0.06 - 0.16 | | | | | | |
| 24.00-29.99 | 0.10-0.20 | 0.10-0.18 | 0.10-0.18 | 0.10-0.18 | | | | | | |
| 30.00-35.99 | 0.10-0.25 | 0.10-0.20 | 0.10-0.20 | | | | | | | |
| 36.00-43.99 | 0.10-0.25 | 0.10-0.20 | 0.10-0.20 | | | | | | | |
| 44.00-52.99 | 0.12-0.28 | 0.12-0.22 | 0.12-0.22 | | | | | | | |
| 53.00-63.50 | 0.12-0.28 | 0.12-0.22 | 0.12-0.22 | | | | | | | |
| | N1.3.C.UT (30.21) | Cast. non aging | 40-100 | 4344 | 300-405 | | | | | |
| | | | | | | 14.00-16.49 | 0.04-0.12 | 0.04-0.14 | 0.04-0.12 | 0.04-0.12 |
| | | | | | | 16.50-19.99 | 0.04-0.14 | 0.04-0.16 | 0.04-0.14 | 0.04 - 0.14 |
| | | | | | | 20.00-23.99 | 0.06-0.16 | 0.06-0.18 | 0.06-0.16 | 0.06 - 0.16 |
| | | | | | | 24.00-29.99 | 0.10-0.18 | 0.10-0.20 | 0.10-0.18 | 0.10-0.18 |
| | | | | | | 30.00-35.99 | 0.10-0.20 | 0.10-0.22 | 0.10-0.20 | |
| | | | | | | 36.00-43.99 | 0.10-0.20 | 0.10-0.24 | 0.10-0.20 | |
| | | | | | | 44.00-52.99 | 0.12-0.22 | 0.12-0.26 | 0.12-0.22 | |
| | | | | | | 53.00-63.50 | 0.12-0.22 | 0.12-0.26 | 0.12-0.22 | |
| | | | | | | | N1.3.C.AG (30.22) | Cast or cast and aged | 70-140 | 4344 |
| 14.00-16.49 | 0.04-0.12 | 0.04-0.14 | 0.04-0.12 | 0.04-0.12 | | | | | | |
| 16.50-19.99 | 0.04-0.14 | 0.04-0.16 | 0.04-0.14 | 0.04 - 0.14 | | | | | | |
| 20.00-23.99 | 0.06-0.16 | 0.06-0.18 | 0.06-0.16 | 0.06 - 0.16 | | | | | | |
| 24.00-29.99 | 0.10-0.18 | 0.10-0.20 | 0.10-0.18 | 0.10-0.18 | | | | | | |
| 30.00-35.99 | 0.10-0.20 | 0.10-0.22 | 0.10-0.20 | | | | | | | |
| 36.00-43.99 | 0.10-0.20 | 0.10-0.24 | 0.10-0.20 | | | | | | | |
| 44.00-52.99 | 0.12-0.22 | 0.12-0.26 | 0.12-0.22 | | | | | | | |
| 53.00-63.50 | 0.12-0.22 | 0.12-0.26 | 0.12-0.22 | | | | | | | |
| | N3.3.U.UT (33.1) | Copper and copper alloys | 70-160 | 4344 | 250-400 | | | | | |
| | | | | | | 14.00-16.49 | 0.04-0.14 | 0.04-0.12 | 0.04-0.12 | 0.04-0.12 |
| | | | | | | 16.50-19.99 | 0.04-0.16 | 0.04-0.14 | 0.04-0.14 | 0.04 - 0.14 |
| | | | | | | 20.00-23.99 | 0.06-0.18 | 0.06-0.16 | 0.06-0.16 | 0.06 - 0.16 |
| | | | | | | 24.00-29.99 | 0.10-0.20 | 0.10-0.18 | 0.10-0.18 | 0.10-0.18 |
| | | | | | | 30.00-35.99 | 0.10-0.25 | 0.10-0.20 | 0.10-0.20 | |
| | | | | | | 36.00-43.99 | 0.10-0.25 | 0.10-0.20 | 0.10-0.20 | |
| | | | | | | 44.00-52.99 | 0.12-0.28 | 0.12-0.22 | 0.12-0.22 | |
| | | | | | | 53.00-63.50 | 0.12-0.28 | 0.12-0.22 | 0.12-0.22 | |
| | | | | | | | N3.2.C.UT (33.2) | Brass and leaded alloys (Pb < 1%) | 50-200 | 4344 |
| 14.00-16.49 | 0.04-0.14 | 0.04-0.12 | 0.04-0.12 | 0.04-0.12 | | | | | | |
| 16.50-19.99 | 0.04-0.16 | 0.04-0.14 | 0.04-0.14 | 0.04 - 0.14 | | | | | | |
| 20.00-23.99 | 0.06-0.18 | 0.06-0.16 | 0.06-0.16 | 0.06 - 0.16 | | | | | | |
| 24.00-29.99 | 0.10-0.20 | 0.10-0.18 | 0.10-0.18 | 0.10-0.18 | | | | | | |
| 30.00-35.99 | 0.10-0.25 | 0.10-0.20 | 0.10-0.20 | | | | | | | |
| 36.00-43.99 | 0.10-0.25 | 0.10-0.20 | 0.10-0.20 | | | | | | | |
| 44.00-52.99 | 0.12-0.28 | 0.12-0.22 | 0.12-0.22 | | | | | | | |
| 53.00-63.50 | 0.12-0.28 | 0.12-0.22 | 0.12-0.22 | | | | | | | |

Note: Bold text is recommended geometry
Central insert grade is always 1044.

Trepanning tool

| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia. DC mm | Feed f_n mm/r | Speed v_c m/min | Geometry / Grade |
|-----------------------|--------------------------------------|---------------------------------|------------------------|---------------------|--------------------|----------------------|------------------|
| P | Unalloyed steel | | | | | | |
| | 01.0 | Non hardened 0,05–0,10% C | 80–170 | | 0.07–0.10 | 250–345 | -58/3040 |
| | 01.1 | Non hardened 0,05–0,25% C | 90–200 | | 0.07–0.12 | 225–315 | -58/3040 |
| | 01.2 | Non hardened 0,25–0,55% C | 125–225 | | | | |
| | 01.3 | Non hardened 0,55–0,80% C | 150–250 | 60–110 | 0.10–0.20 | 130–210 | -53/3040 |
| | 01.4 | High carbon & carbon tool steel | 180–275 | | | | |
| | Low alloy steel | | | | | | |
| | 02.1 | Non-hardened | 150–260 | 60–110 | 0.11–0.18 | 145–210 | -53/3040 |
| | 02.2 | Hardened | 220–400 | | 0.10–0.20 | 100–165 | |
| | High alloy steel | | | | | | |
| | 03.11 | Annealed | 50–250 | | 0.10–0.20 | 125–200 | |
| | 03.13 | Annealed HSS | | 60–110 | | | -53/3040 |
| | 03.21 | Hardened tool steel | 250–450 | | 0.11–0.18 | 90–145 | |
| | 03.22 | Hardened steel | | | | | |
| Steel castings | | | | | | | |
| 06.1 | Unalloyed | 90–225 | 60–110 | 0.06–0.12 | 195–280 | -58/3040 | |
| 06.2 | Low alloyed (alloying elements ≤ 5%) | 150–250 | | 0.11–0.18 | 120–175 | -53/3040 | |
| M | Stainless steel | | | | | | |
| | 05.1 | Ferritic, Martensitic 13–25% Cr | 150–270 | 60–110 | 0.10–0.20 | 170–240 | -58/3040 |
| 05.2 | Austenitic Ni > 8% 13–25% Cr | 150–270 | 60–110 | 0.10–0.16 | 100–140 | -58/235 | |
| K | Malleable | | | | | | |
| | 07.1 | Ferritic (short chipping) | 110–145 | 60–110 | 0.16–0.26 | 140–210 | -53/3040 |
| | 07.2 | Pearlitic (long chipping) | 150–270 | | 0.14–0.20 | 105–155 | |
| | Grey cast iron | | | | | | |
| | 08.1 | Low tensile | 150–220 | 60–110 | 0.16–0.26 | 210–280 | -53/3040 |
| | 08.2 | High tensile | 200–300 | | 0.14–0.20 | 125–210 | |
| | Nodular cast iron | | | | | | |
| 09.1 | Ferritic | 125–230 | | 0.14–0.20 | 125–195 | | |
| 09.2 | Ferritic | 200–300 | 60–110 | 0.14–0.20 | 100–180 | -53/3040 | |
| N | Aluminium alloys | | | | | | |
| | 30.12 | Wrought or wrought and aged | 75–150 | | | | |
| | 30.21 | Forged | 40–100 | 60–110 | 0.12–0.22 | 250–400 | -53/H13A |
| | 30.22 | Cast, solution treated & aged | 70–125 | | | | |
| | Copper and copper alloys | | | | | | |
| 33.1 | Free cutting alloys (Pb ≥ 1%) | 50–160 | 60–110 | 0.12–0.22 | 180–350 | -53/H13A | |
| 33.2 | Brass and leaded bronzes (Pb ≤ 1%) | | | | | | |

Coromant U indexable insert plunge drill

| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia DC mm | Feed f _n mm/r | Speed v _c m/min | Geometry / Grade | | | |
|----------------|--------------------------------------|--|------------------------|--------------------|-----------------------------|-------------------------------|--------------------------------------|----------|---------------|-----------|
| | | | | | | | FIRST CHOICE Highest productivity | | Complementary | |
| | | | | | | | P | C | P | C |
| P | 01.0 | Unalloyed steel Non hardened 0,05–0,10% C | 80–170 | 12.7–17.0 | 0.04–0.08 | 290 (230–380) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.04–0.08 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 |
| | | | | 26.0–30.0 | 0.05–0.08 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.07–0.10 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | | | | 42.0–80.0 | 0.08–0.12 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | 01.1 | Non hardened 0,05–0,25% C | 90–200 | 12.7–17.0 | 0.04–0.08 | 270 (225–345) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.04–0.08 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 |
| | | | | 26.0–30.0 | 0.05–0.10 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.07–0.12 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | | | | 42.0–80.0 | 0.08–0.14 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | 01.2 | Non hardened 0,25–0,55% C | 125–225 | 12.7–17.0 | 0.04–0.10 | 230 (190–290) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.04–0.14 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 |
| | | | | 26.0–30.0 | 0.08–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.10–0.20 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | | | | 42.0–80.0 | 0.12–0.24 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | 01.3 | Non hardened 0,55–0,80% C | 150–225 | 12.7–17.0 | 0.04–0.10 | 210 (170–275) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.06–0.14 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 |
| | | | | 26.0–30.0 | 0.08–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| 31.0–41.3 | | | | 0.10–0.20 | -53/3040 | | -53/1020 | -53/1020 | -53/1020 | |
| 42.0–80.0 | | | | 0.12–0.24 | -53/3040 | | -53/1020 | -53/1020 | -53/1020 | |
| 01.4 | High carbon & carbon tool steel | 180–275 | 12.7–17.0 | 0.04–0.10 | 210 (200–275) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.06–0.14 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 | |
| | | | 26.0–30.0 | 0.08–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 31.0–41.3 | 0.10–0.20 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 42.0–80.0 | 0.12–0.24 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| 02.1 | Low alloy steel Non-hardened | 150–260 | 12.7–17.0 | 0.04–0.10 | 220 (180–290) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.06–0.12 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 | |
| | | | 26.0–30.0 | 0.10–0.16 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 31.0–41.3 | 0.11–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 42.0–80.0 | 0.12–0.22 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| 02.2 | Hardened | 220–450 | 12.7–17.0 | 0.04–0.10 | 170 (90–230) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.06–0.14 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 | |
| | | | 26.0–30.0 | 0.10–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 31.0–41.3 | 0.10–0.20 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 42.0–80.0 | 0.12–0.24 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| 03.11 | High alloy steel Annealed | 50–250 | 12.7–17.0 | 0.04–0.08 | 180 (160–275) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.04–0.14 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 | |
| | | | 26.0–30.0 | 0.08–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 31.0–41.3 | 0.10–0.20 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 42.0–80.0 | 0.12–0.24 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| 03.21 | Hardened steel | 250–450 | 12.7–17.0 | 0.04–0.10 | 130 (80–200) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.06–0.12 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 | |
| | | | 26.0–30.0 | 0.10–0.16 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 31.0–41.3 | 0.11–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 42.0–80.0 | 0.12–0.22 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| 06.1 | Steel castings Unalloyed | 90–225 | 12.7–17.0 | 0.04–0.08 | 200 (140–310) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.04–0.08 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 | |
| | | | 26.0–30.0 | 0.05–0.10 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 31.0–41.3 | 0.06–0.12 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 42.0–80.0 | 0.07–0.14 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| 06.2 | Low alloyed (alloying elements ≤ 5%) | 150–250 | 12.7–17.0 | 0.04–0.10 | 160 (110–250) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.06–0.12 | | -53/3040 | -53/1020 | -53/1020 | T-53/1020 | |
| | | | 26.0–30.0 | 0.10–0.16 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 31.0–41.3 | 0.11–0.18 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| | | | 42.0–80.0 | 0.12–0.22 | | -53/3040 | -53/1020 | -53/1020 | -53/1020 | |
| M | 05.11 | Stainless steel Ferritic, Martensitic 13–25% Cr | 150–270 | 12.7–17.0 | 0.04–0.10 | 170 (120–265) | 53/3040 | 53/1020 | 53/1120 | 53/1020 |
| | | | | 17.5–25.4 | 0.04–0.14 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| | | | | 26.0–30.0 | 0.08–0.18 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| | | | | 31.0–41.3 | 0.10–0.20 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| | | | | 42.0–80.0 | 0.12–0.24 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| | 05.21 | Austenitic Ni > 8% 13–25% Cr | 150–275 | 12.7–17.0 | 0.04–0.10 | 150 (120–250) | 53/3040 | 53/1020 | 53/1120 | 53/1020 |
| | | | | 17.5–25.4 | 0.04–0.12 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| | | | | 26.0–30.0 | 0.08–0.14 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| | | | | 31.0–41.3 | 0.10–0.16 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| | | | | 42.0–80.0 | 0.11–0.18 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 |
| 05.51 05.52 | Austenitic Ferritic (duplex) | 180–320 | 12.7–17.0 | 0.04–0.10 | 110 (90–145) | 53/3040 | 53/1020 | 53/1120 | 53/1020 | |
| | | | 17.5–25.4 | 0.04–0.12 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 | |
| | | | 26.0–30.0 | 0.08–0.14 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 | |
| | | | 31.0–41.3 | 0.10–0.16 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 | |
| | | | 42.0–80.0 | 0.11–0.18 | | 53/3040 | 53/1020 | 53/1020 | 53/1020 | |

Insert positioning: C = Central
P = Peripheral

Wiper -WM geometry for machining steel and cast iron with hardness < 200 HB in stable conditions, increase feed (f_n) with 50%. For easy to machine stainless steels in stable conditions, increase feed (f_n) with 25%.



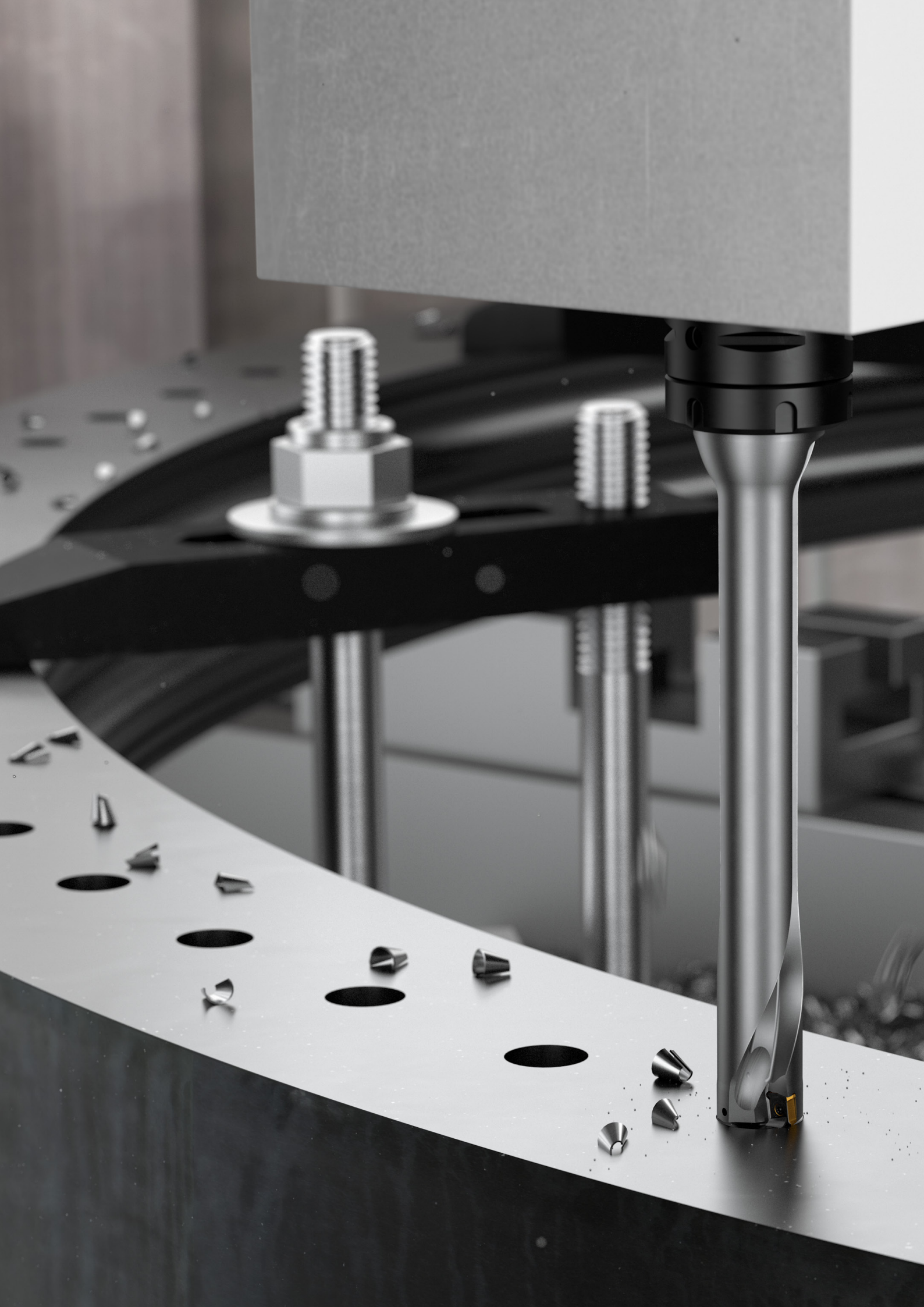
Coromant U indexable insert plunge drill

| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia DC mm | Feed f_r mm/r | Speed v_c m/min | Geometry / Grade | | | |
|-----------|--|--|------------------------|--------------------|--------------------|----------------------|--------------------------------------|----------|---------------|-----------|
| | | | | | | | FIRST CHOICE Highest productivity | | Complementary | |
| | | | | | | | P | C | P | C |
| M | 15.21 | Stainless steel Austenitic castings | 150–250 | 12.7–17.0 | 0.04–0.08 | 110 (80–155) | -53/1120 | | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.04–0.12 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 26.0–30.0 | 0.05–0.12 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.06–0.14 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 42.0–80.0 | 0.06–0.14 | | | -53/1020 | -53/1020 | -53/1020 |
| S | 20.21 20.22 20.24 | Heat resistant alloys Ni based | 140–425 | 12.7–17.0 | 0.03–0.08 | 50 (20–88) | -53/1120 | | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.04–0.08 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 26.0–30.0 | 0.06–0.10 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.08–0.12 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 42.0–80.0 | 0.09–0.14 | | | -53/1020 | -53/1020 | -53/1020 |
| | 23.21 23.22 | Titanium alloys α , near α and $\alpha+\beta$ alloys. Alloys in annealed or aged conditions | 600–1500 | 12.7–17.0 | 0.04–0.10 | 60 (40–132) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.08–0.14 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 26.0–30.0 | 0.12–0.16 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 31.0–41.3 | 0.14–0.18 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 42.0–80.0 | 0.16–0.20 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| K | 07.1 | Malleable cast iron Ferritic (short chipping) | 110–145 | 12.7–17.0 | 0.04–0.14 | 170 (140–230) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.10–0.18 | | | -53/1020 | -53/1020 | T-53/1020 |
| | | | | 26.0–30.0 | 0.14–0.20 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.16–0.26 | | | -53/1020 | -53/1020 | -53/1020 |
| | 07.2 | Pearlitic (long chipping) | 150–270 | 12.7–17.0 | 0.04–0.10 | 140 (105–170) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.08–0.14 | | | -53/1020 | -53/1020 | T-53/1020 |
| | | | | 26.0–30.0 | 0.12–0.18 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.14–0.20 | | | -53/1020 | -53/1020 | -53/1020 |
| | 08.1 | Grey cast iron Low tensile strength | 150–220 | 12.7–17.0 | 0.04–0.14 | 250 (210–310) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.10–0.18 | | | -53/1020 | -53/1020 | T-53/1020 |
| | | | | 26.0–30.0 | 0.14–0.20 | | | -53/1020 | -53/1020 | -53/1020 |
| | | | | 31.0–41.3 | 0.16–0.26 | | | -53/1020 | -53/1020 | -53/1020 |
| | 08.2 | High tensile strength | 200–330 | 12.7–17.0 | 0.04–0.10 | 170 (125–230) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.08–0.14 | | | -53/1020 | -53/1020 | T-53/1020 |
| 26.0–30.0 | | | | 0.12–0.18 | | | -53/1020 | -53/1020 | -53/1020 | |
| 31.0–41.3 | | | | 0.14–0.20 | | | -53/1020 | -53/1020 | -53/1020 | |
| 09.1 | Nodular cast iron Ferritic | 125–230 | 12.7–17.0 | 0.04–0.10 | 170 (125–215) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.08–0.14 | | | -53/1020 | -53/1020 | T-53/1020 | |
| 09.2 | Pearlitic | 200–300 | 12.7–17.0 | 0.04–0.10 | 150 (110–200) | -53/3040 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.08–0.14 | | | -53/1020 | -53/1020 | -53/1020 | |
| H | 04.1 | Extra hard steel Hardened and tempered | 450 | 12.7–17.0 | 0.05–0.08 | 40 (30–80) | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| 17.5–25.4 | 0.07–0.15 | | -53/1120 | | | | | | | |
| 26.0–30.0 | 0.07–0.15 | | | | | | | | | |
| 31.0–41.3 | 0.10–0.15 | | | | | | | | | |
| 42.0–80.0 | 0.10–0.15 | | | | | | | | | |
| N | 30.12 | Aluminium alloys Wrought or wrought and aged | 30–150 | 12.7–17.0 | 0.04–0.12 | 350 (300–440) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.06–0.16 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 26.0–30.0 | 0.10–0.18 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 31.0–41.3 | 0.12–0.22 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 42.0–80.0 | 0.14–0.26 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 30.21 | Cast. non aging | 40–100 | 12.7–17.0 | 0.04–0.12 | 150 (30–440) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.06–0.16 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 26.0–30.0 | 0.10–0.18 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 31.0–41.3 | 0.12–0.22 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 42.0–80.0 | 0.14–0.26 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 30.22 | Cast or cast and aged | 70–140 | 12.7–17.0 | 0.04–0.12 | 300 (250–385) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.06–0.16 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 26.0–30.0 | 0.10–0.18 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 31.0–41.3 | 0.12–0.22 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 42.0–80.0 | 0.14–0.26 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 33.1 | Copper and copper alloys Free cutting alloys (Pb \geq 1%) | 50–160 | 12.7–17.0 | 0.04–0.12 | 300 (250–385) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | 17.5–25.4 | 0.06–0.16 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 26.0–30.0 | 0.10–0.18 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| 31.0–41.3 | | | | 0.12–0.22 | -53/H13A | | -53/H13A | -53/H13A | -53/H13A | |
| 42.0–80.0 | | | | 0.14–0.26 | -53/H13A | | -53/H13A | -53/H13A | -53/H13A | |
| 33.2 | Brass and leaded alloys (Pb \leq 1%) | 50–160 | 12.7–17.0 | 0.04–0.12 | 230 (180–265) | -53/1120 | -53/1020 | -53/1120 | -53/1020 | |
| | | | 17.5–25.4 | 0.06–0.16 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A | |
| | | | 26.0–30.0 | 0.10–0.18 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A | |
| | | | 31.0–41.3 | 0.12–0.22 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A | |
| | | | 42.0–80.0 | 0.14–0.26 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A | |

Insert positioning:

C = Central

P = Peripheral



Boring

| | |
|--|-----|
| Rough boring | K3 |
| CoroBore® BR10 | K4 |
| CoroBore® BR20 | K6 |
| CoroBore® BR30 | K17 |
| CoroBore® 820 XL | K23 |
| Fine boring | K34 |
| 391.37A/B boring bars and fine boring head | K38 |
| CoroBore® 824 | K35 |
| CoroBore® 825 | K43 |
| CoroBore® 826 | K44 |
| CoroBore® 825 XL | K53 |
| CoroBore® 826 XL | K53 |
| Face grooving | K66 |
| CoroCut® MB adaptor | K67 |
| CoroBore® 825 SL | K68 |
| SpiroGrooving™ | K71 |
| Interpolation turning | K74 |
| Adaptors | K76 |
| CoroBore® cartridges for boring | K78 |

How to choose your boring tool

Identify tool concepts

- 1
 - Define type of application
 - Identify your application type: roughing, finishing or face grooving. Note characteristics regarding the hole to be machined, limitations, material and the machine.
 - Select a boring system
 - Identify your operation type: multi-edge boring, single-edge boring, step-boring, backboring or external boring to find available diameter ranges and required accessories.

Note: Always try to use the largest applicable coupling. Remember to calculate the power and torque consumption of the application.

Select your insert

- 2
 - Choose the inserts depending on your hole requirements: define entering angle and insert type. Dedicated boring inserts can be found here in the boring chapter. ISO inserts are found in the general turning chapter of the Turning tools catalogue.
 - For information regarding start recommendations and insert recommendations for boring operations see page K91.

Selection of tooling systems components

- 3
 - If needed, find the complete selection of machine interface adaptors, extensions and reductions to build your modular assembly, see page L2.
 - Always try to keep the tools as short as possible.

Boring tool components

- Included parts and additional components can be found at www.sandvik.coromant.com

Accessories and spare parts

- Related accessories and spare parts to all boring tool families can be found at www.sandvik.coromant.com

How to choose a face grooving tool

Select your tool

- 1
 - The tool assembly without SL head and insert is chosen depending on your requirements of diameter and machine side coupling.

Selection of SL heads

- 2
 - Identify SL heads for face grooving:
 - The first cut diameter of the SL head needs to correspond to the diameter of the face grooving application.
 - The width of the groove will influence the choice of SL heads and inserts.
 - Use only SL heads with machine side interface SL32, left-hand, A-curved.
 - The SL head dimension LF=18 mm grants maximum diameter according to tool kit code. LF=14 mm reduces the diameter range of face grooving tool with 8 mm.
 - See CoroCut 1-2 in the Turning tools catalogue for SL head assortment.

Selection of inserts

- 3
 - Choose between CoroCut 1-2 system inserts. See Turning tools catalogue.

Rough boring

| | Tool concept | Diameter range, mm | Hole tolerance | Cutting edges | Operation | Insert choice | Machine side interface | Page |
|---|--------------|--------------------|----------------|---------------|--|--|------------------------------------|---------|
|  <p>CoroBore® BR10</p> | Conventional | 32-170 | IT9 | 1 | - Single edge back-boring | - CoroTurn® 107 | - Coromant Capto® - Coromant EH | K4-K5 |
|  <p>CoroBore® BR20</p> | Conventional | 23-150 | IT9 | 2 | - Single edge back-boring - Boring - Step boring - Single edge boring | - CoroTurn® 107 - T-Max® P - CoroBore® 111 | - Coromant Capto® - Coromant EH | K6-K10 |
|  | Damped | 23-150 | IT9 | 2 | - Boring - Step boring - Single edge boring | - CoroTurn® 107 - CoroBore® 111 | - Coromant Capto® | K14 |
|  <p>CoroBore® BR30</p> | Conventional | 35-214 | IT9 | 3 | - Boring - Step boring - Single edge boring | - CoroTurn® 107 - T-Max® P - CoroBore® 111 | - Coromant Capto® | K17-K21 |
| <p>Cavity boring</p>  | Conventional | 85-205 | IT9 | 4,6,8 | - Boring - Step boring | - CoroTurn® 107* - CoroBore® 111 | - Coromant Capto® | K22 |
|  <p>CoroBore® 820 XL</p> | Conventional | 148-300 (350**) | IT9 | 2 | - Boring - Step boring - Single edge boring | - CoroTurn® 107 - T-Max® P - CoroBore® 111 | - Coromant Capto® | K24-K25 |
| | | 298-1260 | | | | | - 40X with 4 bolt circle | K28-K31 |
|  | Lightweight | 148-300 | IT9 | 2 | - Boring - Step boring - Single edge boring | - CoroTurn® 107 - CoroBore® 111 | - 40S with 4 bolt circle | K26 |
|  | Damped | 148-300 | IT9 | 2 | - Boring - Step boring - Single edge boring | - CoroTurn® 107 - CoroBore® 111 | - A33 damped adaptor | K27 |

*Not included in kit, components to be ordered separately

**Components to be ordered separately

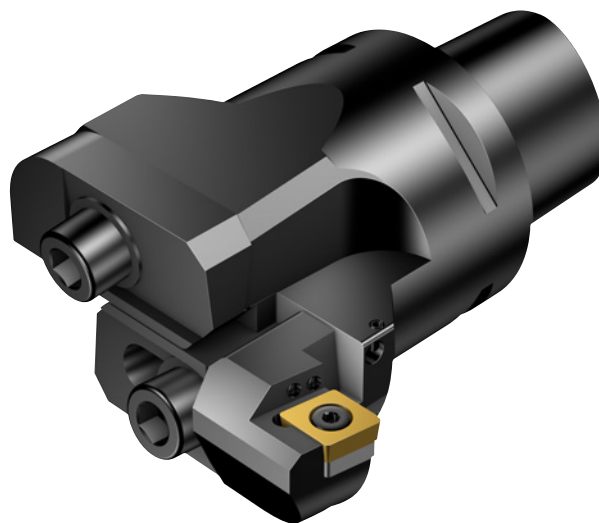
CoroBore® BR10

Single-edge back boring tools

Application

- Rough boring
- Back boring

ISO application area:



Benefits and features

- Laser-marked scale on adaptor for increased user-friendliness when setting diameter
- Possibility to easily be assembled as a twin edge boring tool, using BR20 slides
- Coolant nozzles with high precision capability built into slide for precise coolant direction
- Cutting fluid through the tool for good chip evacuation
- Modularity with Coromant Capto® and Coromant EH

www.sandvik.coromant.com/coroborebr10

Tools

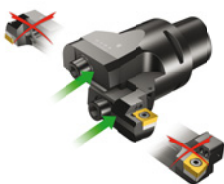
Couplings:

- Coromant Capto®
- Coromant EH

Inserts

- Standard CoroTurn® 107 inserts with a wide selection of grades and geometries for all materials.

The back boring tool is based on the CoroBore® BR20 adaptor together with a unique back boring slide and cover.



Available as complete back boring assembly kit or separate back boring slide and cover as additional items.

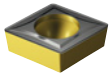
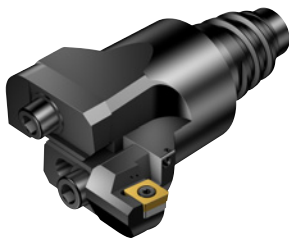


CoroBore® BR10 rough boring tool for back-boring

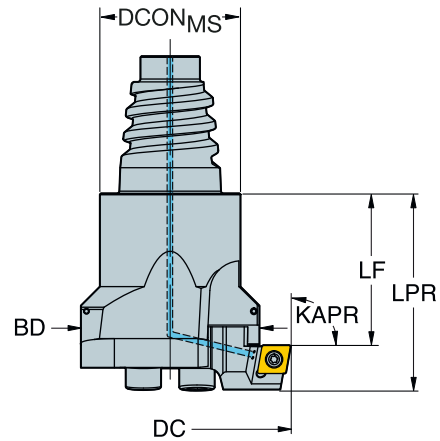
Coromant EH - Internal coolant supply

KAPR




90°



-  CCMT, CCGT
CCGX, CCET
-  CCMW



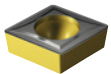
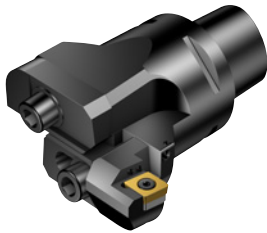
Dimensions, mm

| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | LPR | BD ₁ |  |  | CICT | MIID |
|-------|-------|---|-------------------|------|-------------------|--------------------|----------------------|-------|-------|-----------------|---|--|------|---------------|
| 32.00 | 38.00 | 06 | E20 | 1 | BR10-38CC06F-EH20 | 19.30 | 3.00 | 15.00 | 25.00 | 20.00 | 70 | 0.070 | 1 | CCMT 06 02 04 |
| 37.00 | 45.00 | 06 | E25 | 1 | BR10-45CC06F-EH25 | 24.20 | 4.00 | 14.00 | 24.00 | 24.00 | 70 | 0.110 | 1 | CCMT 06 02 04 |

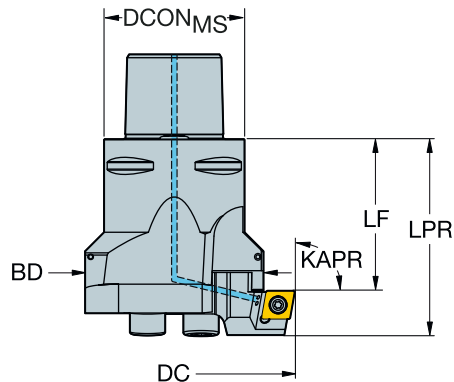
Coromant Capto® - Internal coolant supply

KAPR




90°



-  CCMT, CCGT
CCGX, CCET
-  CCMW



Dimensions, mm

| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | LPR | BD ₁ |  |  | CICT | MIID |
|--------|--------|---|-------------------|------|------------------|--------------------|----------------------|-------|-------|-----------------|---|--|------|---------------|
| 44.00 | 54.00 | 06 | C3 | 3 | BR10-54CC06F-C3 | 32.00 | 5.00 | 35.00 | 45.00 | 30.00 | 70 | 0.560 | 1 | CCMT 06 02 04 |
| 53.00 | 65.00 | 06 | C4 | 3 | BR10-65CC06F-C4 | 40.00 | 6.00 | 43.00 | 53.00 | 39.00 | 70 | 0.560 | 1 | CCMT 06 02 04 |
| 64.00 | 76.00 | 09 | C4 | 3 | BR10-76CC09F-C4 | 40.00 | 6.00 | 43.00 | 58.00 | 39.00 | 70 | 0.560 | 1 | CCMT 09 T3 08 |
| 75.00 | 91.00 | 12 | C5 | 3 | BR10-91CC12F-C5 | 50.00 | 8.00 | 48.00 | 68.00 | 50.00 | 70 | 0.860 | 1 | CCMT 12 04 08 |
| 90.00 | 110.00 | 12 | C5 | 3 | BR10-110CC12F-C5 | 50.00 | 10.00 | 50.00 | 70.00 | 63.00 | 70 | 1.230 | 1 | CCMT 12 04 08 |
| 109.00 | 136.00 | 12 | C6 | 3 | BR10-136CC12F-C6 | 63.00 | 13.50 | 68.00 | 88.00 | 82.00 | 70 | 2.080 | 1 | CCMT 12 04 08 |
| 135.00 | 170.00 | 12 | C6 | 3 | BR10-170CC12F-C6 | 63.00 | 17.50 | 78.00 | 98.00 | 108.00 | 70 | 2.380 | 1 | CCMT 12 04 08 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



L2



M1



N23



N15

CoroBore® BR20

Twin-edge rough boring tools for flexible boring

Application

- Rough boring
- Twin-edge boring
- Step boring
- Back boring
- Single edge boring

ISO application area:



Benefits and features

- Laser-marked scale on adaptor for increased user-friendliness when setting diameter
- Possibility to easily be assembled as a back boring tool, using a unique slide and cover
- Built-in step boring functionality without any additional need of an extra shim
- Differential pitch reduces vibration tendencies - tools can be used at longer overhangs and larger depth of cuts
- Dedicated four-edged inserts with grades optimized for rough boring
- Coolant nozzles with high precision capability built into slide for precise coolant direction.
- Cutting fluid through the tool for good chip evacuation
- Also available as damped boring tool assortment

www.sandvik.coromant.com/coroborebr20

Tools

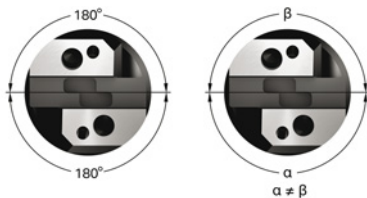
Couplings:

- Coromant Capto®
- Coromant EH

Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroBore® 111
- CoroTurn® 107



The differential pitch reduces vibration tendencies – tools can be used at longer overhangs and larger depth of cuts.



Dedicated CoroBore® 111 rough boring inserts. With excellent chip breaking and increased lifetime.



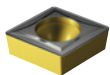
● ● ● ● SilentTools®

Problem-solver when working with long overhangs. When using Silent Tools™, you have the opportunity to double the depth of cut, while maintaining productive boring.

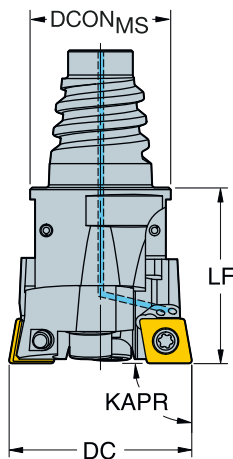
CoroBore® BR20 twin-edge rough boring tool




Coromant EH - Internal coolant supply

KAPR 90°



-  CCMT, CCGT
CCGX, CCET
-  CCMW



| | | | | | Dimensions, mm | | | | | | | |
|-------|-------|---|-------------------|------|-------------------|--------------------|----------------------|-------|---|---|------|---------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF |  |  | CICT | MIID |
| 23.00 | 29.00 | 06 | E20 | 1 | BR20-29CC06F-EH20 | 19.30 | 3.00 | 25.00 | 70 | 0.070 | 2 | CCMT 06 02 04 |
| 28.00 | 36.00 | 06 | E25 | 1 | BR20-36CC06F-EH25 | 24.20 | 4.00 | 25.00 | 70 | 0.110 | 2 | CCMT 06 02 04 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue



L2



M1



N23



N15

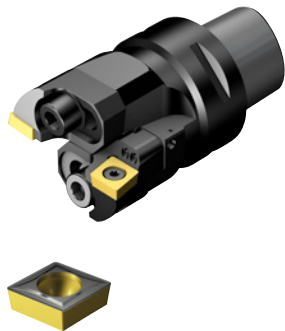


K85



CoroBore® BR20 twin-edge rough boring tool

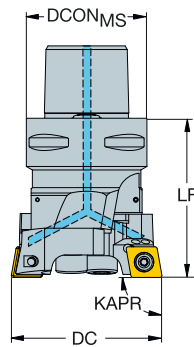
Coromant Capto® - Internal coolant supply



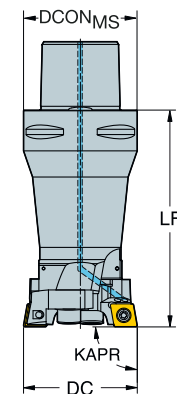
- CCMT, CCGT
CCGX, CCET
- CCMW

KAPR
DSGN

90°
1



90°
2



K

| | | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|------|------------------|--------------------|----------------------|------|--------|-----------------|----|-------|------|---------------|--|
| DCN | DCX | | CZC _{MS} | CNSC | DSGN | Ordering code | DCON _{MS} | ADJLX _{RDL} | ULDR | LF | BD ₁ | | | CICT | MIID | |
| 23.00 | 29.00 | 06 | C3 | 3 | 2 | BR20-29CC06F-C3 | 32.00 | 3.00 | 2.00 | 76.00 | 20.00 | 70 | 0.260 | 2 | CCMT 06 02 04 | |
| 28.00 | 36.00 | 06 | C3 | 3 | 2 | BR20-36CC06F-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 24.00 | 70 | 0.360 | 2 | CCMT 06 02 04 | |
| 35.00 | 45.00 | 09 | C3 | 3 | 1 | BR20-45CC09F-C3 | 32.00 | 5.00 | | 48.00 | | 70 | 0.270 | 2 | CCMT 09 T3 08 | |
| 35.00 | 45.00 | 09 | C4 | 3 | 2 | BR20-45CC09F-C4 | 40.00 | 5.00 | 1.50 | 83.00 | 30.00 | 70 | 0.560 | 2 | CCMT 09 T3 08 | |
| 44.00 | 56.00 | 09 | C4 | 3 | 1 | BR20-56CC09F-C4 | 40.00 | 6.00 | | 56.00 | | 70 | 0.480 | 2 | CCMT 09 T3 08 | |
| 44.00 | 56.00 | 09 | C5 | 3 | 2 | BR20-56CC09F-C5 | 50.00 | 6.00 | 1.50 | 98.00 | 39.00 | 70 | 1.030 | 2 | CCMT 09 T3 08 | |
| 55.00 | 71.00 | 12 | C5 | 3 | 1 | BR20-71CC12F-C5 | 50.00 | 8.00 | | 66.00 | | 70 | 0.860 | 2 | CCMT 12 04 08 | |
| 55.00 | 71.00 | 12 | C6 | 3 | 2 | BR20-71CC12F-C6 | 63.00 | 8.00 | 1.50 | 120.00 | 50.00 | 70 | 1.940 | 2 | CCMT 12 04 08 | |
| 70.00 | 90.00 | 12 | C5 | 3 | 1 | BR20-90CC12F-C5 | 50.00 | 10.00 | | 70.00 | | 70 | 1.230 | 2 | CCMT 12 04 08 | |
| 70.00 | 90.00 | 12 | C6 | 3 | 1 | BR20-90CC12F-C6 | 63.00 | 10.00 | | 78.00 | | 70 | 1.580 | 2 | CCMT 12 04 08 | |
| 89.00 | 116.00 | 12 | C6 | 3 | 1 | BR20-116CC12F-C6 | 63.00 | 13.50 | | 90.00 | | 70 | 2.080 | 2 | CCMT 12 04 08 | |
| 89.00 | 116.00 | 12 | C8 | 3 | 1 | BR20-116CC12F-C8 | 80.00 | 13.50 | | 94.00 | | 70 | 2.990 | 2 | CCMT 12 04 08 | |
| 115.00 | 150.00 | 12 | C6 | 3 | 1 | BR20-150CC12F-C6 | 63.00 | 17.50 | | 90.00 | | 70 | 2.380 | 2 | CCMT 12 04 08 | |
| 115.00 | 150.00 | 12 | C8 | 3 | 1 | BR20-150CC12F-C8 | 80.00 | 17.50 | | 100.00 | | 70 | 3.630 | 2 | CCMT 12 04 08 | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC*ULDR

M

N

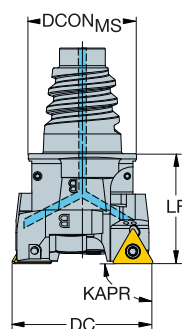




CoroBore® BR20 twin-edge rough boring tool




Coromant EH - Internal coolant supply

KAPR

90°



-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW

| | | | | | Dimensions, mm | | | | | | | |
|-------|-------|---|-------------------|------|-------------------|--------------------|---------------------|-------|---|---|------|---------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJL _{RDL} | LF |  |  | CICT | MIID |
| 28.00 | 36.00 | 09 | E25 | 1 | BR20-36TC09F-EH25 | 24.20 | 4.00 | 25.00 | 70 | 0.130 | 2 | TCMT 09 02 04 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



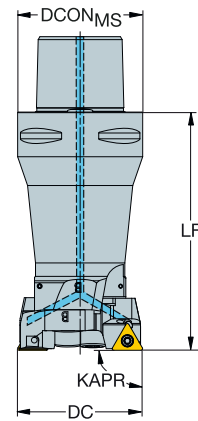
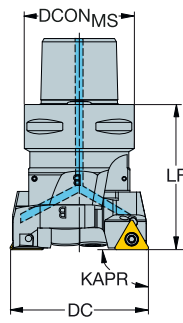
CoroBore® BR20 twin-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR
DSGN

90°
1

90°
2



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | | | | | | Dimensions, mm | | | | | | |
|--------|--------|----|--------------------|------|------|------------------|--------------------|----------------------|------|----------------|-----------------|----|-------|------|---------------|--|
| DCN | DCX | | CZC _{1MS} | CNSC | DSGN | Ordering code | DCON _{MS} | ADJLX _{RDL} | ULDR | LF | BD ₁ | | | CICT | MIID | |
| 28.00 | 36.00 | 09 | C3 | 3 | 2 | BR20-36TC09F-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 24.00 | 70 | 0.380 | 2 | TCMT 09 02 04 | |
| 35.00 | 45.00 | 11 | C3 | 3 | 1 | BR20-45TC11F-C3 | 32.00 | 5.00 | | 48.00 | | 70 | 0.270 | 2 | TCMT 11 03 04 | |
| 44.00 | 56.00 | 11 | C4 | 3 | 1 | BR20-56TC11F-C4 | 40.00 | 6.00 | | 56.00 | | 70 | 0.500 | 2 | TCMT 11 03 04 | |
| 55.00 | 71.00 | 16 | C5 | 3 | 1 | BR20-71TC16F-C5 | 50.00 | 8.00 | | 66.00 | | 70 | 0.860 | 2 | TCMT 16 T3 08 | |
| 70.00 | 90.00 | 16 | C5 | 3 | 1 | BR20-90TC16F-C5 | 50.00 | 10.00 | | 70.00 | | 70 | 1.250 | 2 | TCMT 16 T3 08 | |
| 70.00 | 90.00 | 16 | C6 | 3 | 1 | BR20-90TC16F-C6 | 63.00 | 10.00 | | 78.00 | | 70 | 1.600 | 2 | TCMT 16 T3 08 | |
| 89.00 | 116.00 | 16 | C6 | 3 | 1 | BR20-116TC16F-C6 | 63.00 | 13.50 | | 90.00 | | 70 | 2.100 | 2 | TCMT 16 T3 08 | |
| 115.00 | 150.00 | 16 | C8 | 3 | 1 | BR20-150TC16F-C8 | 80.00 | 17.50 | | 100.00 | | 70 | 3.650 | 2 | TCMT 16 T3 08 | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC*ULDR

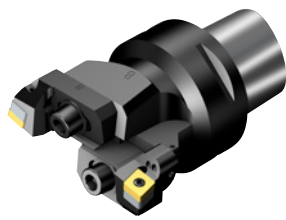


CoroBore® BR20 twin-edge rough boring tool

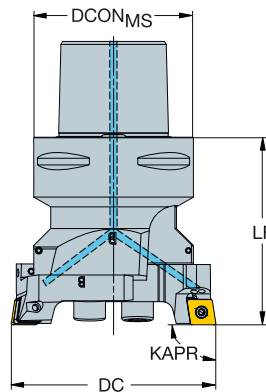
Coromant Capto® - Internal coolant supply




KAPR

90°



CNMU



| | | | | | Dimensions, mm | | | | | | | | |
|--------|--------|---|-------------------|------|------------------|--------------------|----------------------|--------|---|---|------|---------------|--|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF |  |  | CICT | MIID | |
| 70.00 | 90.00 | 12 | C6 | 3 | BR20-90CN12F-C6 | 63.00 | 10.00 | 78.00 | 70 | 2.200 | 2 | CNMU 12 04 12 | |
| 89.00 | 116.00 | 12 | C8 | 3 | BR20-116CN12F-C8 | 80.00 | 13.50 | 94.00 | 70 | 2.900 | 2 | CNMU 12 04 12 | |
| 115.00 | 150.00 | 12 | C8 | 3 | BR20-150CN12F-C8 | 80.00 | 17.50 | 100.00 | 70 | 3.690 | 2 | CNMU 12 04 12 | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

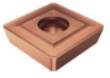
For inserts, see Turning tools catalogue



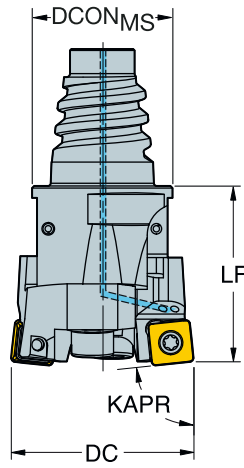
CoroBore® BR20 twin-edge rough boring tool

Coromant EH - Internal coolant supply

KAPR 84°



SPMT



K

| | | | | | Dimensions, mm | | | | | | | | |
|-------|-------|-------------------|------|---------------------|--------------------|----------------------|-------|----|-------|------|--------------|--|--|
| DCN | DCX | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | | | CICT | MIID | | |
| 23.00 | 29.00 | 06 | E20 | 1 BR20-29SP06Y-EH20 | 19.30 | 3.00 | 25.00 | 70 | 0.070 | 2 | SPMT 0606-BM | | |
| 28.00 | 36.00 | 06 | E25 | 1 BR20-36SP06Y-EH25 | 24.20 | 4.00 | 25.00 | 70 | 0.110 | 2 | SPMT 0606-BM | | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

L

M

N



CoroBore® BR20 twin-edge rough boring tool

Coromant Capto® - Internal coolant supply

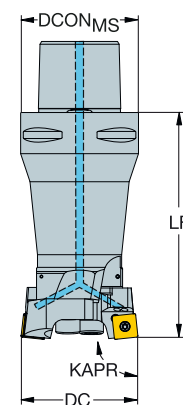
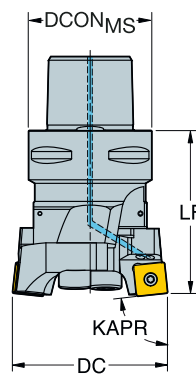
KAPR
DSGN

84°
1

84°
2



SPMT



| | | Dimensions, mm | | | | | | | | | | | | | |
|--------|--------|-------------------|------|------|---------------|--------------------|---------------------|-------|------|-----------------|-------|----|-------|------|--------------|
| DCN | DCX | CZC _{MS} | CNSC | DSGN | Ordering code | DCON _{MS} | ADJL _{RDL} | ULDR | LF | BD ₁ | BAR | KG | CICT | MIID | |
| 23.00 | 29.00 | 06 | C3 | 3 | 2 | BR20-29SP06Y-C3 | 32.00 | 3.00 | 2.00 | 76.00 | 20.00 | 70 | 0.260 | 2 | SPMT 0606-BM |
| 28.00 | 36.00 | 06 | C3 | 3 | 2 | BR20-36SP06Y-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 24.00 | 70 | 0.360 | 2 | SPMT 0606-BM |
| 35.00 | 45.00 | 08 | C3 | 3 | 1 | BR20-45SP08Y-C3 | 32.00 | 5.00 | | 48.00 | | 70 | 0.270 | 2 | SPMT 0808-BM |
| 35.00 | 45.00 | 08 | C4 | 3 | 2 | BR20-45SP08Y-C4 | 40.00 | 5.00 | 1.50 | 83.00 | 30.00 | 70 | 0.560 | 2 | SPMT 0808-BM |
| 44.00 | 56.00 | 08 | C4 | 3 | 1 | BR20-56SP08Y-C4 | 40.00 | 6.00 | | 56.00 | | 70 | 0.480 | 2 | SPMT 0808-BM |
| 44.00 | 56.00 | 08 | C5 | 3 | 2 | BR20-56SP08Y-C5 | 50.00 | 6.00 | 1.50 | 98.00 | 39.00 | 70 | 1.030 | 2 | SPMT 0808-BM |
| 55.00 | 71.00 | 12 | C5 | 3 | 1 | BR20-71SP12Y-C5 | 50.00 | 8.00 | | 66.00 | | 70 | 0.860 | 2 | SPMT 1210-BM |
| 55.00 | 71.00 | 12 | C6 | 3 | 2 | BR20-71SP12Y-C6 | 63.00 | 8.00 | 1.50 | 120.00 | 50.00 | 70 | 1.940 | 2 | SPMT 1210-BM |
| 70.00 | 90.00 | 12 | C5 | 3 | 1 | BR20-90SP12Y-C5 | 50.00 | 10.00 | | 70.00 | | 70 | 1.230 | 2 | SPMT 1210-BM |
| 70.00 | 90.00 | 12 | C6 | 3 | 1 | BR20-90SP12Y-C6 | 63.00 | 10.00 | | 78.00 | | 70 | 1.580 | 2 | SPMT 1210-BM |
| 89.00 | 116.00 | 12 | C6 | 3 | 1 | BR20-116SP12Y-C6 | 63.00 | 13.50 | | 90.00 | | 70 | 2.080 | 2 | SPMT 1210-BM |
| 89.00 | 116.00 | 12 | C8 | 3 | 1 | BR20-116SP12Y-C8 | 80.00 | 13.50 | | 94.00 | | 70 | 2.990 | 2 | SPMT 1210-BM |
| 115.00 | 150.00 | 12 | C6 | 3 | 1 | BR20-150SP12Y-C6 | 63.00 | 17.50 | | 90.00 | | 70 | 2.380 | 2 | SPMT 1210-BM |
| 115.00 | 150.00 | 12 | C8 | 3 | 1 | BR20-150SP12Y-C8 | 80.00 | 17.50 | | 100.00 | | 70 | 3.630 | 2 | SPMT 1210-BM |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For all DSGN 2; LU = DC*ULDR



K32



L2



M1



N23



N15



K85



CoroBore® BR20 twin-edge damped rough boring tool

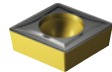
Coromant Capto® - Internal coolant supply

KAPR
DSGN

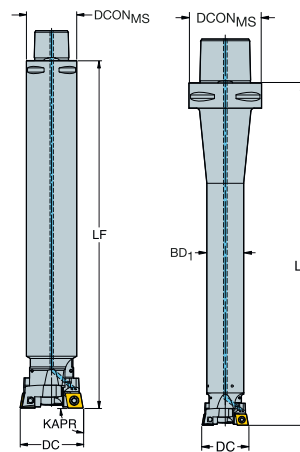
90°
1

90°
2

●●●● SilentTools®



CCMT, CCGT
CCGX, CCET
 CCMW



Dimensions, mm

| DCN | DCX | | CZC _{MS} | CNSC | DSGN | Ordering code | DCON _{MS} | ADJLX _{RDL} | ULDR | LF | BD ₁ | | | CICT | MIID |
|--------|--------|----|-------------------|------|------|--------------------|--------------------|----------------------|------|--------|-----------------|----|--------|------|---------------|
| 23.00 | 29.00 | 06 | C4 | 3 | 2 | BR20D-29CC06F-C4L | 40.00 | 3.00 | 6.00 | 199.00 | 20.00 | 70 | 0.740 | 2 | CCMT 06 02 04 |
| 28.00 | 36.00 | 06 | C3 | 3 | 2 | BR20D-36CC06F-C3L | 32.00 | 4.00 | 6.00 | 216.00 | 25.00 | 70 | 1.030 | 2 | CCMT 06 02 04 |
| 35.00 | 45.00 | 09 | C3 | 3 | 1 | BR20D-45CC09F-C3L | 32.00 | 5.00 | | 221.00 | 70 | 70 | 1.540 | 2 | CCMT 09 T3 08 |
| 35.00 | 45.00 | 09 | C4 | 3 | 2 | BR20D-45CC09F-C4L | 40.00 | 5.00 | 6.00 | 270.00 | 32.00 | 70 | 1.980 | 2 | CCMT 09 T3 08 |
| 35.00 | 45.00 | 09 | C6 | 3 | 2 | BR20D-45CC09F-C6L | 63.00 | 5.00 | 6.00 | 297.00 | 32.00 | 70 | 2.620 | 2 | CCMT 09 T3 08 |
| 44.00 | 56.00 | 09 | C4 | 3 | 1 | BR20D-56CC09F-C4L | 40.00 | 6.00 | | 220.00 | 70 | 70 | 2.380 | 2 | CCMT 09 T3 08 |
| 44.00 | 56.00 | 09 | C5 | 3 | 2 | BR20D-56CC09F-C5L | 50.00 | 6.00 | 6.00 | 336.00 | 40.00 | 70 | 3.720 | 2 | CCMT 09 T3 08 |
| 44.00 | 56.00 | 09 | C6 | 3 | 2 | BR20D-56CC09F-C6L | 63.00 | 6.00 | 6.00 | 363.00 | 40.00 | 70 | 4.350 | 2 | CCMT 09 T3 08 |
| 55.00 | 71.00 | 12 | C5 | 3 | 1 | BR20D-71CC12F-C5M | 50.00 | 8.00 | | 300.00 | 70 | 70 | 5.080 | 2 | CCMT 12 04 08 |
| 55.00 | 71.00 | 12 | C6 | 3 | 2 | BR20D-71CC12F-C6M | 63.00 | 8.00 | 5.60 | 400.00 | 50.00 | 70 | 6.940 | 2 | CCMT 12 04 08 |
| 70.00 | 90.00 | 12 | C6 | 3 | 1 | BR20D-90CC12F-C6M | 63.00 | 10.00 | | 400.00 | 70 | 70 | 9.910 | 2 | CCMT 12 04 08 |
| 70.00 | 90.00 | 12 | C8 | 3 | 2 | BR20D-90CC12F-C8M | 80.00 | 10.00 | 5.60 | 500.00 | 63.00 | 70 | 12.660 | 2 | CCMT 12 04 08 |
| 89.00 | 116.00 | 12 | C8 | 3 | 1 | BR20D-116CC12F-C8M | 80.00 | 13.50 | | 500.00 | 70 | 70 | 18.490 | 2 | CCMT 12 04 08 |
| 89.00 | 116.00 | 12 | C8 | 3 | 1 | BR20D-116CC12F-C8S | 80.00 | 13.50 | | 410.00 | 70 | 70 | 16.140 | 2 | CCMT 12 04 08 |
| 115.00 | 150.00 | 12 | C8 | 3 | 1 | BR20D-150CC12F-C8M | 80.00 | 17.50 | | 500.00 | 70 | 70 | 18.620 | 2 | CCMT 12 04 08 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC*ULDR



L2



M1



N23



N15



K85

CoroBore® BR20 twin-edge damped rough boring tool

Coromant Capto® - Internal coolant supply

KAPR
DSGN

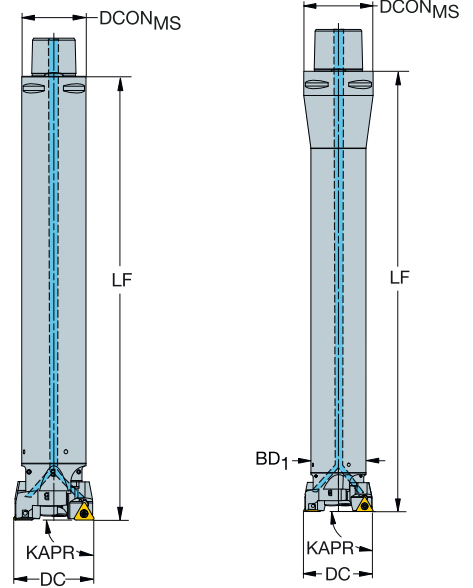
90°
1

90°
2

●●● SilentTools®



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



| | | | | | | | Dimensions, mm | | | | | | | | |
|--------|--------|----|-------------------|------|------|--------------------|--------------------|----------------------|------|--------|-----------------|----|--------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | DSGN | Ordering code | DCON _{MS} | ADJLX _{RDL} | ULDR | LF | BD ₁ | | | CICT | MIID |
| 28.00 | 36.00 | 09 | C3 | 3 | 2 | BR20D-36TC09F-C3L | 32.00 | 4.00 | 6.00 | 216.00 | 25.00 | 70 | 1.718 | 2 | TCMT 09 02 04 |
| 35.00 | 45.00 | 11 | C3 | 3 | 1 | BR20D-45TC11F-C3L | 32.00 | 5.00 | | 221.00 | | 70 | 2.330 | 2 | TCMT 11 03 04 |
| 35.00 | 45.00 | 11 | C4 | 3 | 2 | BR20D-45TC11F-C4L | 40.00 | 5.00 | 6.00 | 270.00 | 32.00 | 70 | 1.980 | 2 | TCMT 11 03 04 |
| 44.00 | 56.00 | 11 | C4 | 3 | 1 | BR20D-56TC11F-C4L | 40.00 | 6.00 | | 220.00 | | 70 | 2.400 | 2 | TCMT 11 03 04 |
| 44.00 | 56.00 | 11 | C5 | 3 | 2 | BR20D-56TC11F-C5L | 50.00 | 6.00 | 6.00 | 336.00 | 40.00 | 70 | 5.740 | 2 | TCMT 11 03 04 |
| 55.00 | 71.00 | 16 | C5 | 3 | 1 | BR20D-71TC16F-C5M | 50.00 | 8.00 | | 300.00 | | 70 | 5.080 | 2 | TCMT 16 T3 08 |
| 70.00 | 90.00 | 16 | C6 | 3 | 1 | BR20D-90TC16F-C6M | 63.00 | 10.00 | | 400.00 | | 70 | 9.930 | 2 | TCMT 16 T3 08 |
| 89.00 | 116.00 | 16 | C8 | 3 | 1 | BR20D-116TC16F-C8M | 80.00 | 13.50 | | 500.00 | | 70 | 22.085 | 2 | TCMT 16 T3 08 |
| 89.00 | 116.00 | 16 | C8 | 3 | 1 | BR20D-116TC16F-C8S | 80.00 | 13.50 | | 410.00 | | 70 | 16.160 | 2 | TCMT 16 T3 08 |
| 115.00 | 150.00 | 16 | C8 | 3 | 1 | BR20D-150TC16F-C8M | 80.00 | 17.50 | | 500.00 | | 70 | 23.200 | 2 | TCMT 16 T3 08 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC*ULDR



L2



M1



N23



N15



K85



CoroBore® BR20 twin-edge damped rough boring tool

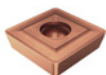
Coromant Capto® - Internal coolant supply

KAPR
DSGN

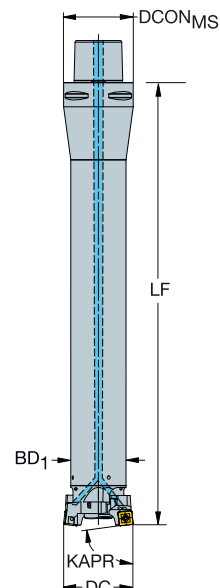
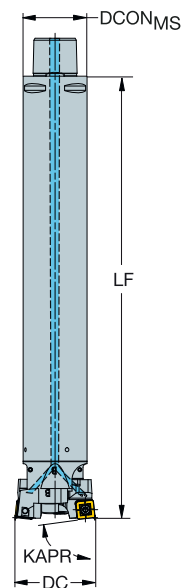
84°
1




84°
2

●●● SilentTools®



SPMT



| | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|---|--------|------|------|--------------------|--------------------|----------------------|------|--------|-----------------|--|--|------|--------------|
| DCN | DCX |  | CZC1MS | CNSC | DSGN | Ordering code | DCON _{MS} | ADJLX _{RDL} | ULDR | LF | BD ₁ |  |  | CICT | MIID |
| 23.00 | 29.00 | 06 | C4 | 3 | 2 | BR20D-29SP06Y-C4L | 40.00 | 3.00 | 6.00 | 199.00 | 20.00 | 70 | 0.740 | 2 | SPMT 0606-BM |
| 28.00 | 36.00 | 06 | C3 | 3 | 2 | BR20D-36SP06Y-C3L | 32.00 | 4.00 | 6.00 | 216.00 | 25.00 | 70 | 1.030 | 2 | SPMT 0606-BM |
| 35.00 | 45.00 | 08 | C3 | 3 | 1 | BR20D-45SP08Y-C3L | 32.00 | 5.00 | | 221.00 | | 70 | 2.330 | 2 | SPMT 0808-BM |
| 35.00 | 45.00 | 08 | C4 | 3 | 2 | BR20D-45SP08Y-C4L | 40.00 | 5.00 | 6.00 | 270.00 | 32.00 | 70 | 4.500 | 2 | SPMT 0808-BM |
| 35.00 | 45.00 | 08 | C6 | 3 | 2 | BR20D-45SP08Y-C6L | 63.00 | 5.00 | 6.00 | 297.00 | 32.00 | 70 | 2.630 | 2 | SPMT 0808-BM |
| 44.00 | 56.00 | 08 | C4 | 3 | 1 | BR20D-56SP08Y-C4L | 40.00 | 6.00 | | 220.00 | | 70 | 5.120 | 2 | SPMT 0808-BM |
| 44.00 | 56.00 | 08 | C5 | 3 | 2 | BR20D-56SP08Y-C5L | 50.00 | 6.00 | 6.00 | 336.00 | 40.00 | 70 | 3.720 | 2 | SPMT 0808-BM |
| 44.00 | 56.00 | 08 | C6 | 3 | 1 | BR20D-56SP08Y-C6L | 63.00 | 6.00 | 6.00 | 363.00 | 40.00 | 70 | 4.350 | 2 | SPMT 0808-BM |
| 55.00 | 71.00 | 12 | C5 | 3 | 1 | BR20D-71SP12Y-C5M | 50.00 | 8.00 | | 300.00 | | 70 | 7.672 | 2 | SPMT 1210-BM |
| 55.00 | 71.00 | 12 | C6 | 3 | 2 | BR20D-71SP12Y-C6M | 63.00 | 8.00 | 5.60 | 400.00 | 50.00 | 70 | 6.940 | 2 | SPMT 1210-BM |
| 70.00 | 90.00 | 12 | C6 | 3 | 1 | BR20D-90SP12Y-C6M | 63.00 | 10.00 | | 400.00 | | 70 | 12.000 | 2 | SPMT 1210-BM |
| 70.00 | 90.00 | 12 | C8 | 3 | 2 | BR20D-90SP12Y-C8M | 80.00 | 10.00 | 5.60 | 500.00 | 63.00 | 70 | 16.183 | 2 | SPMT 1210-BM |
| 89.00 | 116.00 | 12 | C8 | 3 | 1 | BR20D-116SP12Y-C8M | 80.00 | 13.50 | | 500.00 | | 70 | 22.125 | 2 | SPMT 1210-BM |
| 89.00 | 116.00 | 12 | C8 | 3 | 1 | BR20D-116SP12Y-C8S | 80.00 | 13.50 | | 410.00 | | 70 | 16.140 | 2 | SPMT 1210-BM |
| 115.00 | 150.00 | 12 | C8 | 3 | 1 | BR20D-150SP12Y-C8M | 80.00 | 17.50 | | 500.00 | | 70 | 18.620 | 2 | SPMT 1210-BM |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For all DSGN 2; LU = DC*ULDR



L2



M1



N23



N15



K85

CoroBore® BR30

Multi-edge rough boring tools for maximum productivity

Application

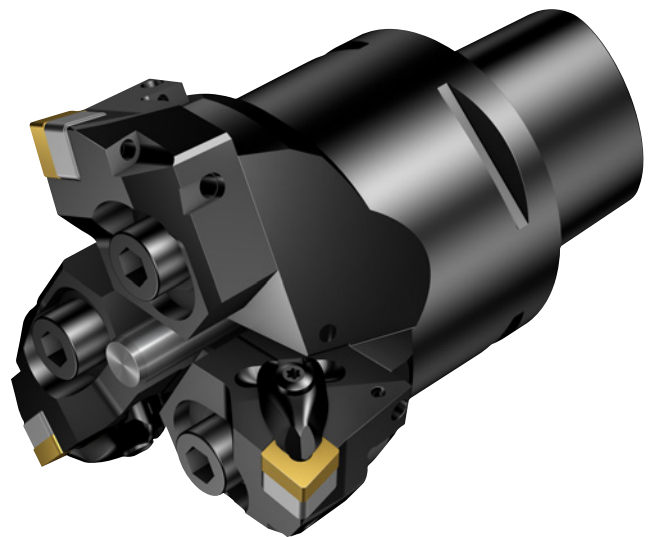
- Rough boring
- Multi-edge boring
- Step boring
- Single edge boring

ISO application area



Benefits and features

- Highly productive multi cutting edge tool for maximum metal removal rate.
- Laser-marked scale on adaptor for increased user-friendliness when setting diameter.
- Modularity with Coromant Capto® .
- High pressure coolant through adaptor
- Step boring: Additional shims available, to be ordered separately
- Short, rigid and compact giving maximum stability



www.sandvik.coromant.com/coroborebr30

Tools

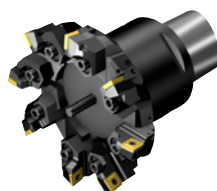
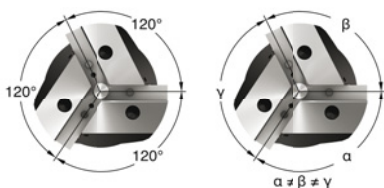
Couplings:

- Coromant Capto®

Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroBore® 111
- CoroTurn® 107
- T-max® P



The differential pitch reduces vibration tendencies – tools can be used at longer overhangs and larger depth of cuts.

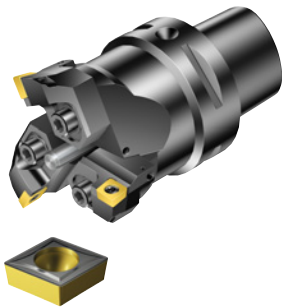
From diameter 85 to 205 mm, CoroBore® BR30 is available with up to 8 cutting edges for maximum metal removal rate.

If no pre-setter is available, adjust diameter of CoroBore BR30 by measuring the distance from pin to insert and subtract half the pin diameter. Multiply by two for the effective boring diameter.

Dedicated CoroBore® 111 rough boring inserts. With excellent chip breaking and increased lifetime.

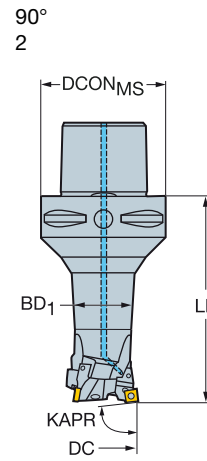
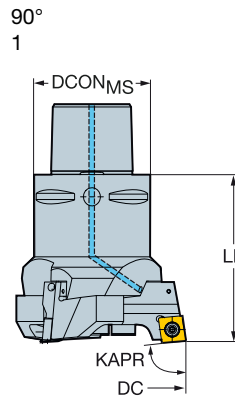
CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply



- CCMT, CCGT
CCGX, CCET
- CCMW

KAPR
DSGN



K

| | | | | | | | Dimensions, mm | | | | | | | | |
|--------|--------|----|-------|------|------|------------------|--------------------|----------------------|------|--------|-----------------|----|-------|------|---------------|
| DCN | DCX | | CZC15 | CNSC | DSGN | Ordering code | DCON _{MS} | ADJLX _{RDL} | ULDR | LF | BD ₁ | | | CICT | MID |
| 35.00 | 40.50 | 06 | C3 | 3 | 1 | BR30-41CC06F-C3 | 32.00 | 2.75 | | 48.00 | | 70 | 0.250 | 3 | CCMT 06 02 04 |
| 35.00 | 40.50 | 06 | C4 | 3 | 2 | BR30-41CC06F-C4 | 40.00 | 2.75 | 1.50 | 83.00 | 31.50 | 70 | 0.640 | 3 | CCMT 06 02 04 |
| 39.50 | 45.00 | 06 | C3 | 3 | 1 | BR30-45CC06F-C3 | 32.00 | 2.75 | | 48.00 | | 70 | 0.280 | 3 | CCMT 06 02 04 |
| 39.50 | 45.00 | 06 | C4 | 3 | 2 | BR30-45CC06F-C4 | 40.00 | 2.75 | 1.50 | 83.00 | 31.50 | 70 | 0.670 | 3 | CCMT 06 02 04 |
| 44.00 | 50.50 | 06 | C4 | 3 | 1 | BR30-51CC06F-C4 | 40.00 | 3.25 | | 56.00 | | 70 | 0.620 | 3 | CCMT 06 02 04 |
| 44.00 | 50.50 | 06 | C5 | 3 | 2 | BR30-51CC06F-C5 | 50.00 | 3.25 | 1.50 | 98.00 | 39.60 | 70 | 1.180 | 3 | CCMT 06 02 04 |
| 49.50 | 56.00 | 06 | C4 | 3 | 1 | BR30-56CC06F-C4 | 40.00 | 3.25 | | 56.00 | | 70 | 0.650 | 3 | CCMT 06 02 04 |
| 49.50 | 56.00 | 09 | C4 | 3 | 1 | BR30-56CC09F-C4 | 40.00 | 3.25 | | 58.00 | | 70 | 0.641 | 3 | CCMT 09 T3 08 |
| 49.50 | 56.00 | 06 | C5 | 3 | 2 | BR30-56CC06F-C5 | 50.00 | 3.25 | 1.50 | 98.00 | 39.60 | 70 | 1.210 | 3 | CCMT 06 02 04 |
| 49.50 | 56.00 | 09 | C5 | 3 | 2 | BR30-56CC09F-C5 | 50.00 | 3.25 | 1.50 | 100.00 | 39.60 | 70 | 1.240 | 3 | CCMT 09 T3 08 |
| 55.00 | 63.00 | 09 | C5 | 3 | 1 | BR30-63CC09F-C5 | 50.00 | 4.00 | | 66.00 | | 70 | 0.890 | 3 | CCMT 09 T3 08 |
| 55.00 | 63.00 | 09 | C6 | 3 | 2 | BR30-63CC09F-C6 | 63.00 | 4.00 | 1.50 | 120.00 | 49.50 | 70 | 1.980 | 3 | CCMT 09 T3 08 |
| 62.00 | 70.00 | 09 | C5 | 3 | 1 | BR30-70CC09F-C5 | 50.00 | 4.00 | | 66.00 | | 70 | 0.920 | 3 | CCMT 09 T3 08 |
| 62.00 | 70.00 | 12 | C5 | 3 | 1 | BR30-70CC12F-C5 | 50.00 | 4.00 | | 68.00 | | 70 | 0.980 | 3 | CCMT 12 04 08 |
| 62.00 | 70.00 | 09 | C6 | 3 | 2 | BR30-70CC09F-C6 | 63.00 | 4.00 | 1.50 | 120.00 | 49.50 | 70 | 2.312 | 3 | CCMT 09 T3 08 |
| 62.00 | 70.00 | 12 | C6 | 3 | 2 | BR30-70CC12F-C6 | 63.00 | 4.00 | 1.50 | 122.00 | 49.50 | 70 | 2.070 | 3 | CCMT 12 04 08 |
| 69.00 | 78.50 | 12 | C5 | 3 | 1 | BR30-79CC12F-C5 | 50.00 | 4.75 | | 70.00 | | 70 | 1.180 | 3 | CCMT 12 04 08 |
| 69.00 | 78.50 | 12 | C6 | 3 | 1 | BR30-79CC12F-C6 | 63.00 | 4.75 | | 78.00 | | 70 | 2.130 | 3 | CCMT 12 04 08 |
| 77.50 | 87.00 | 12 | C5 | 3 | 1 | BR30-87CC12F-C5 | 50.00 | 4.75 | | 70.00 | | 70 | 1.210 | 3 | CCMT 12 04 08 |
| 77.50 | 87.00 | 12 | C6 | 3 | 1 | BR30-87CC12F-C6 | 63.00 | 4.75 | | 78.00 | | 70 | 1.967 | 3 | CCMT 12 04 08 |
| 86.00 | 97.00 | 12 | C6 | 3 | 1 | BR30-97CC12F-C6 | 63.00 | 5.50 | | 90.00 | | 70 | 2.280 | 3 | CCMT 12 04 08 |
| 86.00 | 97.00 | 12 | C8 | 3 | 1 | BR30-97CC12F-C8 | 80.00 | 5.50 | | 94.00 | | 70 | 3.300 | 3 | CCMT 12 04 08 |
| 96.00 | 107.00 | 12 | C6 | 3 | 1 | BR30-107CC12F-C6 | 63.00 | 5.50 | | 90.00 | | 70 | 2.340 | 3 | CCMT 12 04 08 |
| 96.00 | 107.00 | 12 | C8 | 3 | 1 | BR30-107CC12F-C8 | 80.00 | 5.50 | | 94.00 | | 70 | 3.360 | 3 | CCMT 12 04 08 |
| 106.00 | 122.00 | 12 | C8 | 3 | 1 | BR30-122CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.100 | 3 | CCMT 12 04 08 |
| 121.00 | 137.00 | 12 | C8 | 3 | 1 | BR30-137CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.250 | 3 | CCMT 12 04 08 |
| 136.00 | 152.00 | 12 | C8 | 3 | 1 | BR30-152CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.760 | 3 | CCMT 12 04 08 |
| 151.00 | 167.00 | 12 | C8 | 3 | 1 | BR30-167CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.880 | 3 | CCMT 12 04 08 |
| 166.00 | 191.00 | 12 | C8 | 3 | 1 | BR30-191CC12F-C8 | 80.00 | 12.50 | | 115.00 | | 70 | 6.860 | 3 | CCMT 12 04 08 |
| 189.00 | 214.00 | 12 | C8 | 3 | 1 | BR30-214CC12F-C8 | 80.00 | 12.50 | | 115.00 | | 70 | 7.130 | 3 | CCMT 12 04 08 |

L

M

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue
 For all DSGN 2; LU = DC*ULDR

N

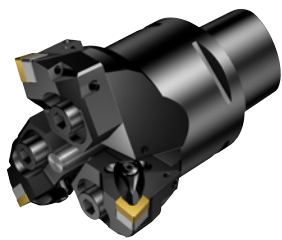


CoroBore® BR30 three-edge rough boring tool

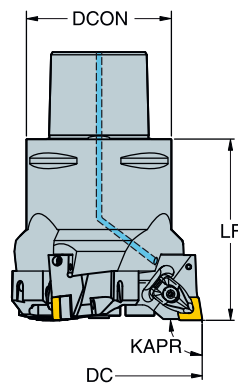
Coromant Capto® - Internal coolant supply


KAPR

90°



-  CNMM
-  CNMG
-  CNMA, CNGA



| | | | | | Dimensions, mm | | | | | | | | |
|--------|--------|---|-------------------|------|------------------|--------------------|----------------------|--------|-----|--------|------|---------------|--|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | BAR | KG | CICT | MIID | |
| 106.00 | 122.00 | 12 | C8 | 3 | BR30-122CN12F-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.190 | 3 | CNMG 12 04 08 | |
| 121.00 | 137.00 | 12 | C8 | 3 | BR30-137CN12F-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.340 | 3 | CNMG 12 04 08 | |
| 136.00 | 152.00 | 12 | C8 | 3 | BR30-152CN12F-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.820 | 3 | CNMG 12 04 08 | |
| 151.00 | 167.00 | 12 | C8 | 3 | BR30-167CN12F-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.970 | 3 | CNMG 12 04 08 | |
| 166.00 | 191.00 | 16 | C8 | 3 | BR30-191CN16F-C8 | 80.00 | 12.50 | 119.00 | 70 | 7.430 | 3 | CNMG 16 06 12 | |
| 189.00 | 214.00 | 16 | C8 | 3 | BR30-214CN16F-C8 | 80.00 | 12.50 | 119.00 | 70 | 22.400 | 3 | CNMG 16 06 12 | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue



L2



M1



N23



N15

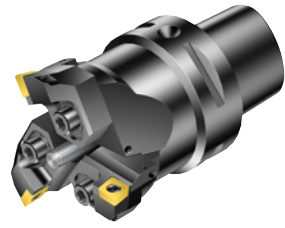


K86



CoroBore® BR30 three-edge rough boring tool

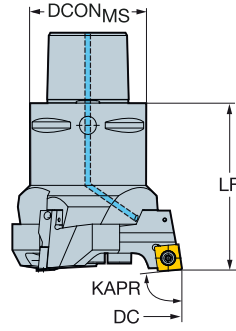
Coromant Capto® - Internal coolant supply






SPMT

KAPR

84°



K

| | | | | | Dimensions, mm | | | | | | | |
|--------|--------|---|-------------------|------|------------------|--------------------|----------------------|--------|---|---|------|--------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF |  |  | CICT | MIID |
| 35.00 | 40.50 | 06 | C3 | 3 | BR30-41SP06Y-C3 | 32.00 | 2.75 | 48.00 | 70 | 0.250 | 3 | SPMT 0606-BM |
| 39.50 | 45.00 | 06 | C3 | 3 | BR30-45SP06Y-C3 | 32.00 | 2.75 | 48.00 | 70 | 0.280 | 3 | SPMT 0606-BM |
| 44.00 | 50.50 | 06 | C4 | 3 | BR30-51SP06Y-C4 | 40.00 | 3.25 | 56.00 | 70 | 0.620 | 3 | SPMT 0606-BM |
| 49.50 | 56.00 | 08 | C4 | 3 | BR30-56SP08Y-C4 | 40.00 | 3.25 | 58.00 | 70 | 0.640 | 3 | SPMT 0808-BM |
| 55.00 | 63.00 | 08 | C5 | 3 | BR30-63SP08Y-C5 | 50.00 | 4.00 | 66.00 | 70 | 0.890 | 3 | SPMT 0808-BM |
| 62.00 | 70.00 | 12 | C5 | 3 | BR30-70SP12Y-C5 | 50.00 | 4.00 | 68.00 | 70 | 0.980 | 3 | SPMT 1210-BM |
| 69.00 | 78.50 | 12 | C6 | 3 | BR30-79SP12Y-C6 | 63.00 | 4.75 | 78.00 | 70 | 1.922 | 3 | SPMT 1210-BM |
| 77.50 | 87.00 | 12 | C6 | 3 | BR30-87SP12Y-C6 | 63.00 | 4.75 | 78.00 | 70 | 2.190 | 3 | SPMT 1210-BM |
| 86.00 | 97.00 | 12 | C8 | 3 | BR30-97SP12Y-C8 | 80.00 | 5.50 | 94.00 | 70 | 3.300 | 3 | SPMT 1210-BM |
| 96.00 | 107.00 | 12 | C8 | 3 | BR30-107SP12Y-C8 | 80.00 | 5.50 | 94.00 | 70 | 3.360 | 3 | SPMT 1210-BM |
| 106.00 | 122.00 | 12 | C8 | 3 | BR30-122SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.100 | 3 | SPMT 1210-BM |
| 121.00 | 137.00 | 12 | C8 | 3 | BR30-137SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.250 | 3 | SPMT 1210-BM |
| 136.00 | 152.00 | 12 | C8 | 3 | BR30-152SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.760 | 3 | SPMT 1210-BM |
| 151.00 | 167.00 | 12 | C8 | 3 | BR30-167SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.880 | 3 | SPMT 1210-BM |
| 166.00 | 191.00 | 12 | C8 | 3 | BR30-191SP12Y-C8 | 80.00 | 12.50 | 115.00 | 70 | 6.860 | 3 | SPMT 1210-BM |
| 189.00 | 214.00 | 12 | C8 | 3 | BR30-214SP12Y-C8 | 80.00 | 12.50 | 115.00 | 70 | 7.130 | 3 | SPMT 1210-BM |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

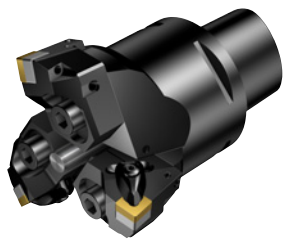
M

N



CoroBore® BR30 three-edge rough boring tool

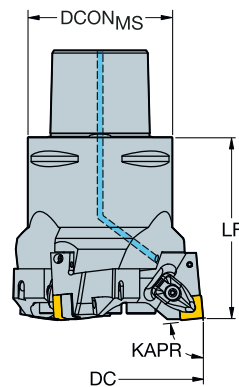
Coromant Capto® - Internal coolant supply






-  SNMM
-  SNMG
-  SNMA, SNGA

KAPR

84°



| | | | | | Dimensions, mm | | | | | | | |
|--------|--------|---|-------------------|------|------------------|--------------------|----------------------|--------|---|---|------|---------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF |  |  | CICT | MIID |
| 106.00 | 122.00 | 12 | C8 | 3 | BR30-122SN12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.190 | 3 | SNMG 12 04 08 |
| 121.00 | 137.00 | 12 | C8 | 3 | BR30-137SN12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.340 | 3 | SNMG 12 04 08 |
| 136.00 | 152.00 | 12 | C8 | 3 | BR30-152SN12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.820 | 3 | SNMG 12 04 08 |
| 151.00 | 167.00 | 12 | C8 | 3 | BR30-167SN12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.970 | 3 | SNMG 12 04 08 |
| 166.00 | 191.00 | 15 | C8 | 3 | BR30-191SN15Y-C8 | 80.00 | 12.50 | 119.00 | 70 | 7.480 | 3 | SNMG 15 06 12 |
| 189.00 | 214.00 | 15 | C8 | 3 | BR30-214SN15Y-C8 | 80.00 | 12.50 | 119.00 | 70 | 7.790 | 3 | SNMG 15 06 12 |

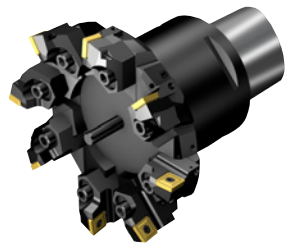
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue



CoroBore® BR30 multi-edge rough boring tool

Coromant Capto® - Internal coolant supply

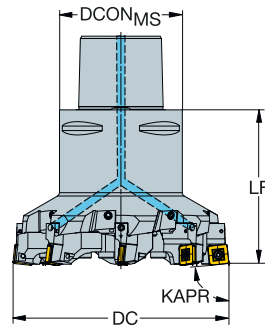
Dedicated for cavity boring operations






SPMT

KAPR

84°



| | | | | | Dimensions, mm | | | | | | | | |
|--------|--------|---|-------------------|------|---------------------|--------------------|----------------------|--------|---|---|------|--------------|--|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RGL} | LF |  |  | CICT | MIID | |
| 85.00 | 94.50 | 12 | C6 | 3 | BR30-095-4-SP12Y-C6 | 63.00 | 4.75 | 80.00 | 70 | 2.050 | 4 | SPMT 1210-BM | |
| 93.50 | 103.00 | 12 | C6 | 3 | BR30-103-4-SP12Y-C6 | 63.00 | 4.75 | 80.00 | 70 | 2.130 | 4 | SPMT 1210-BM | |
| 102.00 | 111.50 | 12 | C8 | 3 | BR30-112-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.110 | 6 | SPMT 1210-BM | |
| 110.50 | 120.00 | 12 | C8 | 3 | BR30-120-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.230 | 6 | SPMT 1210-BM | |
| 119.00 | 128.50 | 12 | C8 | 3 | BR30-129-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.510 | 8 | SPMT 1210-BM | |
| 127.50 | 137.00 | 12 | C8 | 3 | BR30-137-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.670 | 8 | SPMT 1210-BM | |
| 136.00 | 145.50 | 12 | C8 | 3 | BR30-146-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.900 | 8 | SPMT 1210-BM | |
| 144.50 | 154.00 | 12 | C8 | 3 | BR30-154-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 6.300 | 8 | SPMT 1210-BM | |
| 153.00 | 162.50 | 12 | C8 | 3 | BR30-163-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.150 | 6 | SPMT 1210-BM | |
| 161.50 | 171.00 | 12 | C8 | 3 | BR30-171-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.270 | 6 | SPMT 1210-BM | |
| 170.00 | 179.50 | 12 | C8 | 3 | BR30-180-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.730 | 6 | SPMT 1210-BM | |
| 178.50 | 188.00 | 12 | C8 | 3 | BR30-188-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.850 | 6 | SPMT 1210-BM | |
| 187.00 | 196.50 | 12 | C8 | 3 | BR30-197-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 6.470 | 6 | SPMT 1210-BM | |
| 195.50 | 205.00 | 12 | C8 | 3 | BR30-205-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 6.590 | 6 | SPMT 1210-BM | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com



CoroBore® 820 XL

Rough boring tool for large diameters

Application

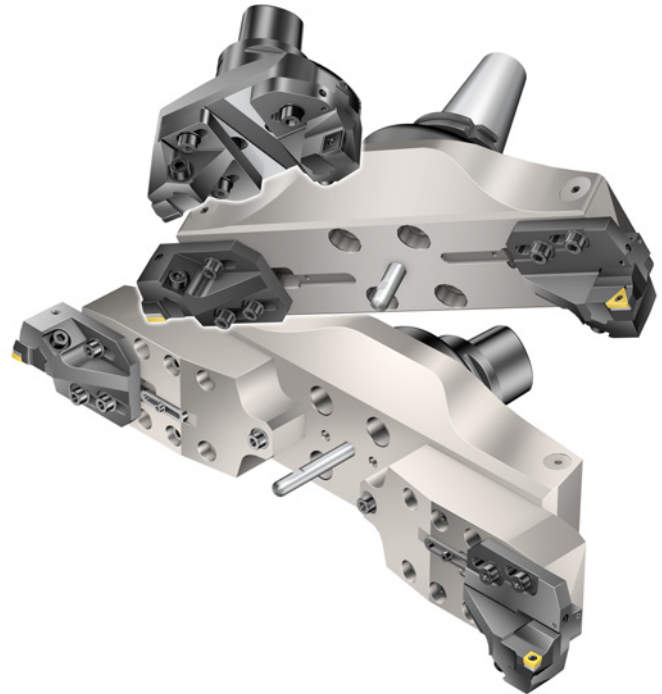
- Rough boring
- Twin-edge boring
- Step boring
- Single edge boring

ISO application area



Benefits and features

- Short, rigid and compact giving maximum stability at large diameter rough boring
- Axial and radial adjustable
- Cutting fluid through the tool for good chip evacuation
- Strong modular base for building assemblies in different applications (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)



www.sandvik.coromant.com/corobore820

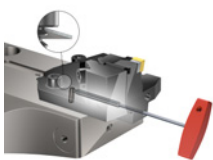
●●●● SilentTools®

Tools

- Couplings:
- Coromant Capto®
 - Arbor

Inserts

- Standard inserts with dedicated grades and geometries for all materials
- CoroBore® 111
 - CoroTurn® 107
 - T-max® P



For easy radial adjustment of slides, slightly tighten screws and adjust diameter with key. Cartridges are possible to adjust in axial direction, for step boring.



Use same bridge/bridge extension for roughing, finishing and face grooving from diameter 148 mm (counterweight needed for finishing).



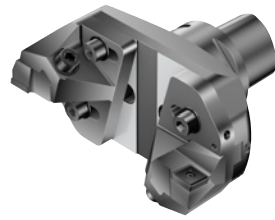
Bore large diameter without increasing tool weight.



Dedicated CoroBore® 111 rough boring inserts. With excellent chip breaking and increased lifetime.

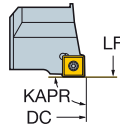
CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

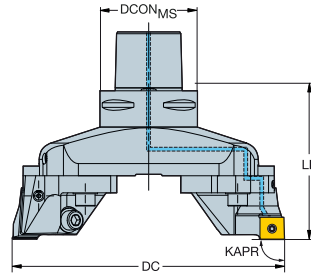
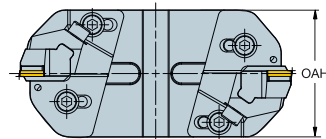


SPMT


KAPR



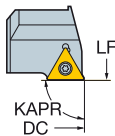
90°



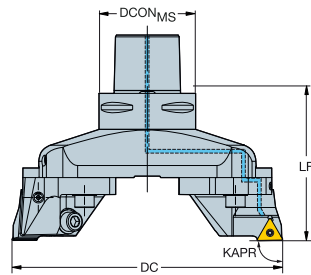
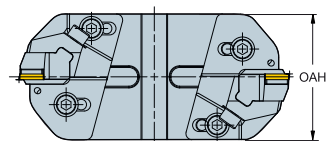
Dimensions, mm

| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|--------|--------|---|-------------------|------|-----------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|--------------|
| 148.00 | 200.00 | 18 | C8 | 3 | 820-200SP18-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 6.900 | 2 | SPMT 1810-BM |
| 148.00 | 200.00 | 18 | C10 | 3 | 820-200SP18-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 9.900 | 2 | SPMT 1810-BM |
| 198.00 | 250.00 | 18 | C8 | 3 | 820-250SP18-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.700 | 2 | SPMT 1810-BM |
| 198.00 | 250.00 | 18 | C10 | 3 | 820-250SP18-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.308 | 2 | SPMT 1810-BM |
| 248.00 | 300.00 | 18 | C8 | 3 | 820-300SP18-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 10.620 | 2 | SPMT 1810-BM |
| 248.00 | 300.00 | 18 | C10 | 3 | 820-300SP18-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 12.640 | 2 | SPMT 1810-BM |


KAPR



90°



Dimensions, mm

| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|--------|--------|---|-------------------|------|-----------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|---------------|
| 148.00 | 200.00 | 22 | C8 | 3 | 820-200TC22-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.390 | 2 | TCMT 22 04 08 |
| 148.00 | 200.00 | 22 | C10 | 3 | 820-200TC22-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 10.170 | 2 | TCMT 22 04 08 |
| 198.00 | 250.00 | 22 | C8 | 3 | 820-250TC22-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.800 | 2 | TCMT 22 04 08 |
| 198.00 | 250.00 | 22 | C10 | 3 | 820-250TC22-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.400 | 2 | TCMT 22 04 08 |
| 248.00 | 300.00 | 22 | C8 | 3 | 820-300TC22-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 10.600 | 2 | TCMT 22 04 08 |
| 248.00 | 300.00 | 22 | C10 | 3 | 820-300TC22-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 12.660 | 2 | TCMT 22 04 08 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



K32



L2



M1



N23



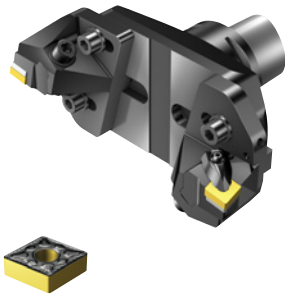
N15



K87

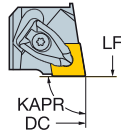
CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

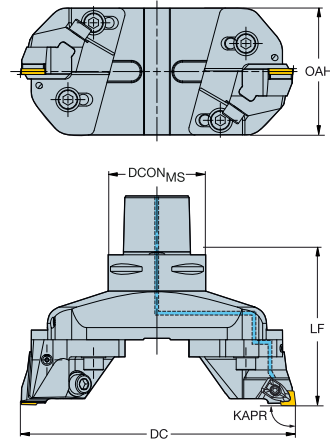



-  CNMM
-  CNMG
-  CNMA, CNGA

KAPR

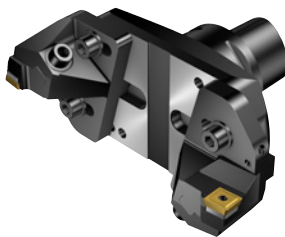


90°



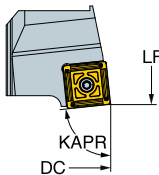
| | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|---|-------------------|------|-----------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|---------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
| 148.00 | 200.00 | 19 | C8 | 3 | 820-200CN19-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.240 | 2 | CNMG 19 06 12 |
| 148.00 | 200.00 | 19 | C10 | 3 | 820-200CN19-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 10.100 | 2 | CNMG 19 06 12 |
| 198.00 | 250.00 | 19 | C8 | 3 | 820-250CN19-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 9.620 | 2 | CNMG 19 06 12 |
| 198.00 | 250.00 | 19 | C10 | 3 | 820-250CN19-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.520 | 2 | CNMG 19 06 12 |
| 248.00 | 300.00 | 19 | C8 | 3 | 820-300CN19-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 10.000 | 2 | CNMG 19 06 12 |
| 248.00 | 300.00 | 19 | C10 | 3 | 820-300CN19-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 12.685 | 2 | CNMG 19 06 12 |

For inserts, see Turning tools catalogue

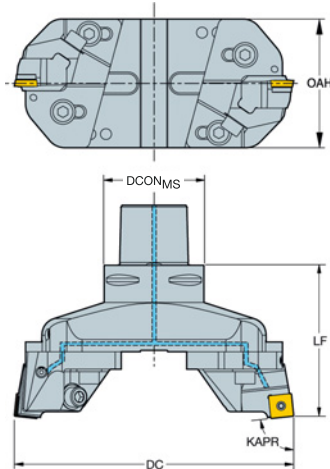



-  SPMT

KAPR



84°



| | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|---|-------------------|------|------------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|--------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
| 148.00 | 200.00 | 18 | C8 | 3 | 820-200SP18Y-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 7.030 | 2 | SPMT 1810-BM |
| 148.00 | 200.00 | 18 | C10 | 3 | 820-200SP18Y-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 8.940 | 2 | SPMT 1810-BM |
| 198.00 | 250.00 | 18 | C8 | 3 | 820-250SP18Y-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.260 | 2 | SPMT 1810-BM |
| 198.00 | 250.00 | 18 | C10 | 3 | 820-250SP18Y-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 10.190 | 2 | SPMT 1810-BM |
| 248.00 | 300.00 | 18 | C8 | 3 | 820-300SP18Y-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 9.460 | 2 | SPMT 1810-BM |
| 248.00 | 300.00 | 18 | C10 | 3 | 820-300SP18Y-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.510 | 2 | SPMT 1810-BM |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

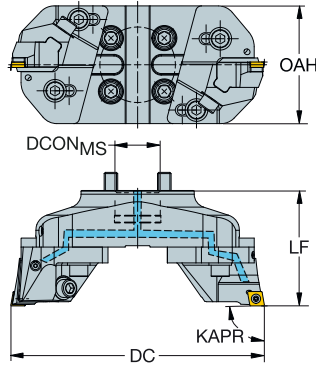
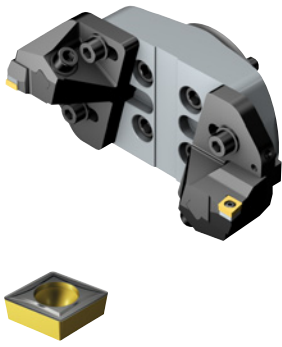


CoroBore® 820 XL lightweight rough boring tool

Arbor - Internal coolant supply

KAPR

90°



- CCMT, CCGT
CCGX, CCET
- CCMW

K

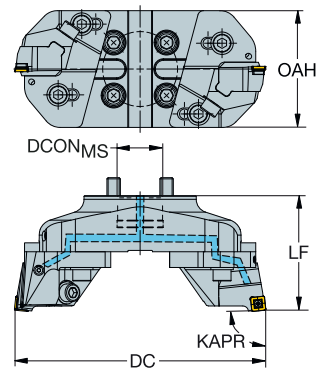
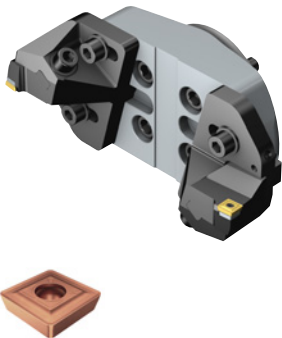
Dimensions, mm

| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|--------|--------|----|-------------------|------|---------------|--------------------|----------------------|----------------------|--------|--------|-----|-------|------|---------------|
| 148.00 | 200.00 | 12 | 40S | 1 | 820L-200CC12F | 40.00 | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 3.860 | 2 | CCMT 12 04 08 |
| 198.00 | 250.00 | 12 | 40S | 1 | 820L-250CC12F | 40.00 | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.390 | 2 | CCMT 12 04 08 |
| 248.00 | 300.00 | 12 | 40S | 1 | 820L-300CC12F | 40.00 | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.870 | 2 | CCMT 12 04 08 |

For inserts, see Turning tools catalogue

KAPR

84°



- SPMT

M

Dimensions, mm

| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|--------|--------|----|-------------------|------|---------------|--------------------|----------------------|----------------------|--------|--------|-----|-------|------|--------------|
| 148.00 | 200.00 | 12 | 40S | 1 | 820L-200SP12Y | 40.00 | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 3.860 | 2 | SPMT 1210-BM |
| 198.00 | 250.00 | 12 | 40S | 1 | 820L-250SP12Y | 40.00 | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.390 | 2 | SPMT 1210-BM |
| 248.00 | 300.00 | 12 | 40S | 1 | 820L-300SP12Y | 40.00 | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.870 | 2 | SPMT 1210-BM |

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.

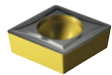
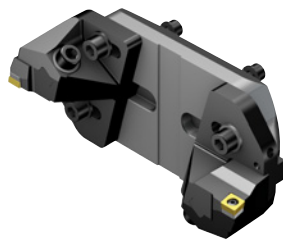
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

N



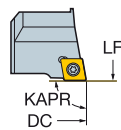
CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply
Dedicated for Silent Tools boring

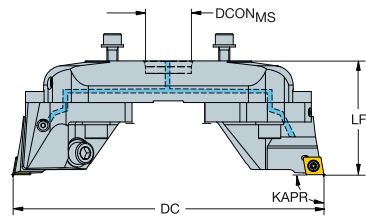
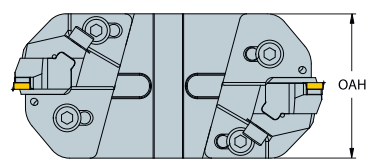


- CCMT, CCGT
CCGX, CCET
- CCMW

KAPR

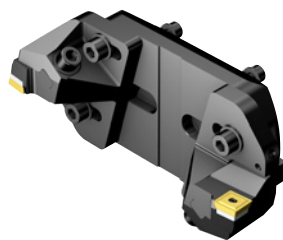


90°



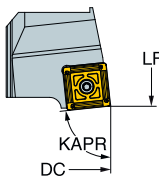
| | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|---------------|--------------------|----------------------------------|----------------------------------|-------|--------|-----|-------|------|---------------|--|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJL _X _{AXL} | ADJL _X _{RDL} | LF | OAH | BAR | KG | CICT | MIID | |
| 148.00 | 200.00 | 12 | 33 | 1 | 820D-200CC12 | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.350 | 2 | CCMT 12 04 08 | |
| 198.00 | 250.00 | 12 | 33 | 1 | 820D-250CC12 | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.670 | 2 | CCMT 12 04 08 | |
| 248.00 | 300.00 | 12 | 33 | 1 | 820D-300CC12 | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 4.030 | 2 | CCMT 12 04 08 | |

For inserts, see Turning tools catalogue

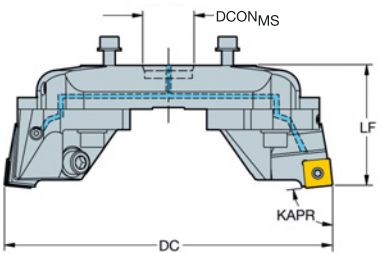
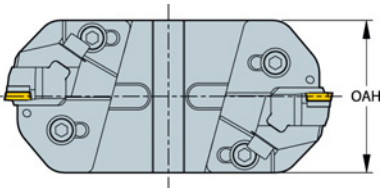


- SPMT

KAPR



84°



| | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|---------------|--------------------|----------------------------------|----------------------------------|-------|--------|-----|-------|------|--------------|--|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJL _X _{AXL} | ADJL _X _{RDL} | LF | OAH | BAR | KG | CICT | MIID | |
| 148.00 | 200.00 | 12 | 33 | 1 | 820D-200SP12Y | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.350 | 2 | SPMT 1210-BM | |
| 198.00 | 250.00 | 12 | 33 | 1 | 820D-250SP12Y | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.670 | 2 | SPMT 1210-BM | |
| 248.00 | 300.00 | 12 | 33 | 1 | 820D-300SP12Y | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 4.030 | 2 | SPMT 1210-BM | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see page K77.



K32



N23



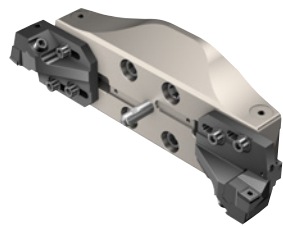
N15



K87

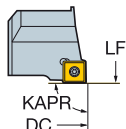
CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

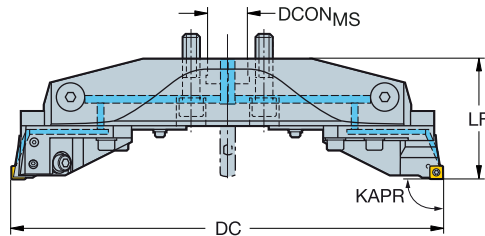
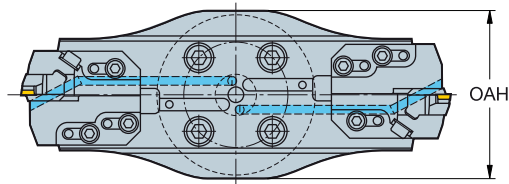


SPMT

KAPR



90°



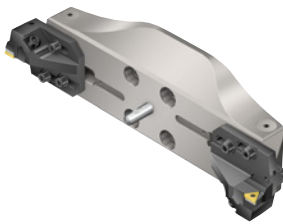
K

| DCN | DCX | CZC _{MS} | CNSC | Ordering code |
|--------|--------|-------------------|------|---------------|
| 298.00 | 380.00 | 18 | 40X | 820-380SP18 |
| 378.00 | 460.00 | 18 | 40X | 820-460SP18 |
| 458.00 | 540.00 | 18 | 40X | 820-540SP18 |

Dimensions, mm

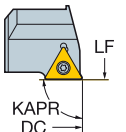
| DCN _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|-------------------|----------------------|----------------------|--------|--------|-----|--------|------|--------------|
| 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 10.000 | 2 | SPMT 1810-BM |
| 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 13.131 | 2 | SPMT 1810-BM |
| 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 16.741 | 2 | SPMT 1810-BM |

L

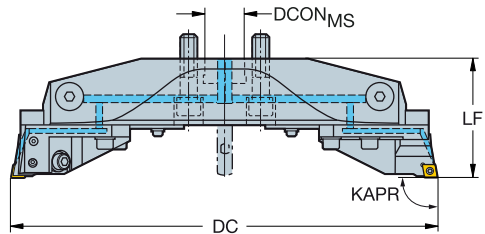
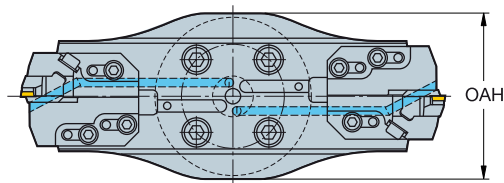


TCMT, TCMX, TCGT, TCGX, TCEX, TCMW

KAPR



90°



M

| DCN | DCX | CZC _{MS} | CNSC | Ordering code |
|--------|--------|-------------------|------|---------------|
| 298.00 | 380.00 | 22 | 40X | 820-380TC22 |
| 378.00 | 460.00 | 22 | 40X | 820-460TC22 |
| 458.00 | 540.00 | 22 | 40X | 820-540TC22 |

Dimensions, mm

| DCN _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|-------------------|----------------------|----------------------|--------|--------|-----|--------|------|---------------|
| 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 10.980 | 2 | TCMT 22 04 08 |
| 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 12.720 | 2 | TCMT 22 04 08 |
| 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 16.580 | 2 | TCMT 22 04 08 |

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

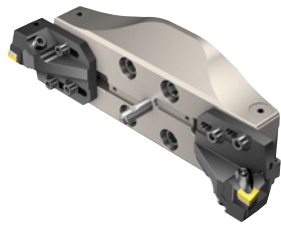
For inserts, see Turning tools catalogue

N



CoroBore® 820 XL rough boring tool

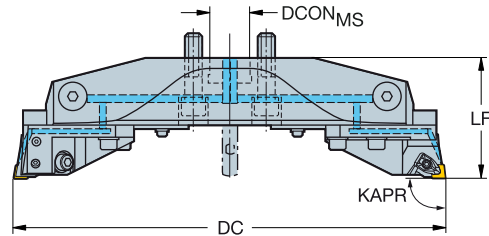
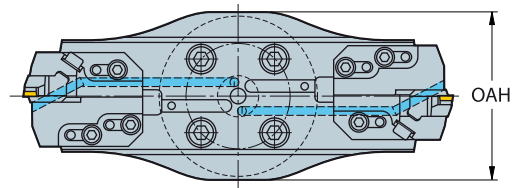
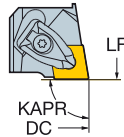
Arbor - Internal coolant supply



- CNMM
- CNMG
- CNMA, CNGA

KAPR

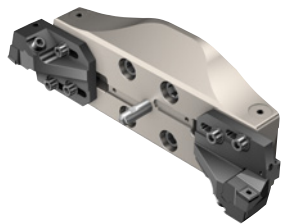
90°



Dimensions, mm

| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AVL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|--------|--------|----|-------------------|------|---------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|---------------|
| 298.00 | 380.00 | 19 | 40X | 1 | 820-380CN19 | 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 10.815 | 2 | CNMG 19 06 12 |
| 378.00 | 460.00 | 19 | 40X | 1 | 820-460CN19 | 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 12.685 | 2 | CNMG 19 06 12 |
| 458.00 | 540.00 | 19 | 40X | 1 | 820-540CN19 | 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 16.780 | 2 | CNMG 19 06 12 |

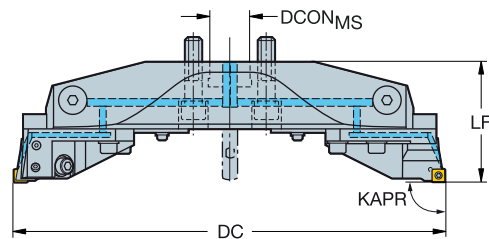
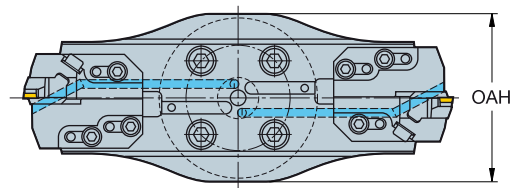
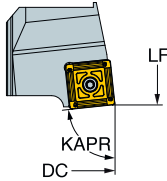
For inserts, see Turning tools catalogue



- SPMT

KAPR

84°



Dimensions, mm

| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AVL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|--------|--------|----|-------------------|------|---------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|--------------|
| 298.00 | 380.00 | 18 | 40X | 1 | 820-380SP18Y | 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 9.050 | 2 | SPMT 1810-BM |
| 378.00 | 460.00 | 18 | 40X | 1 | 820-460SP18Y | 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 10.810 | 2 | SPMT 1810-BM |
| 458.00 | 540.00 | 18 | 40X | 1 | 820-540SP18Y | 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 12.740 | 2 | SPMT 1810-BM |

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.
In case of direct flange to the machine spindle, use centering plug, see page K77

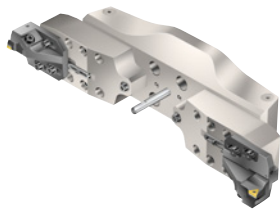
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com



CoroBore® 820 XL rough boring tool

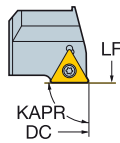
Arbor - Internal coolant supply

With bridge extension

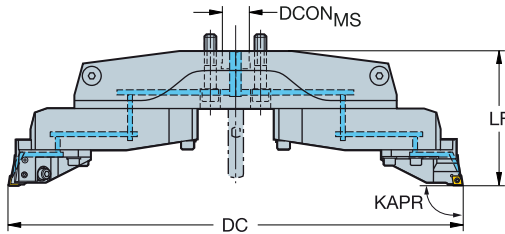
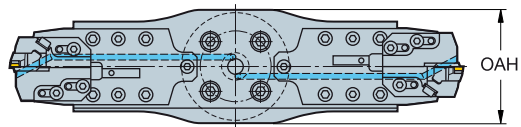


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR



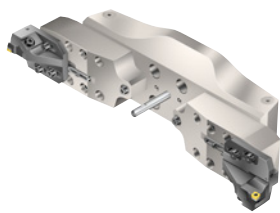
90°



Dimensions, mm

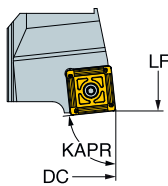
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AVL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|---------|---------|----|-------------------|------|---------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|---------------|
| 538.00 | 780.00 | 22 | 40X | 1 | 820-780TC22 | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 28.000 | 2 | TCMT 22 04 08 |
| 778.00 | 1020.00 | 22 | 40X | 1 | 820-1020TC22 | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 48.000 | 2 | TCMT 22 04 08 |
| 1018.00 | 1260.00 | 22 | 40X | 1 | 820-1260TC22 | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.730 | 2 | TCMT 22 04 08 |

For inserts, see Turning tools catalogue

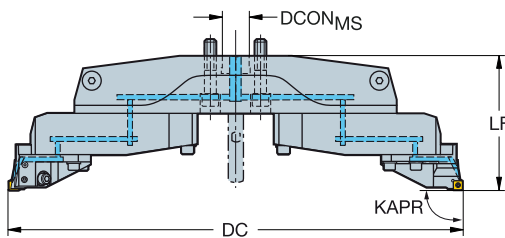
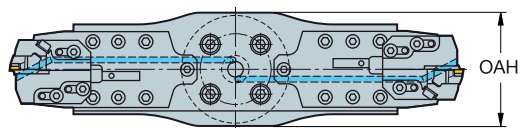


SPMT

KAPR



84°



Dimensions, mm

| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AVL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
|---------|---------|----|-------------------|------|---------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|--------------|
| 538.00 | 780.00 | 18 | 40X | 1 | 820-780SP18Y | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 25.190 | 2 | SPMT 1810-BM |
| 778.00 | 1020.00 | 18 | 40X | 1 | 820-1020SP18Y | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 36.380 | 2 | SPMT 1810-BM |
| 1018.00 | 1260.00 | 18 | 40X | 1 | 820-1260SP18Y | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.810 | 2 | SPMT 1810-BM |

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

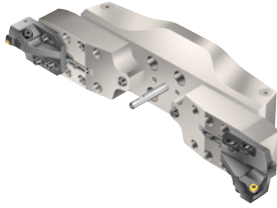
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com



CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

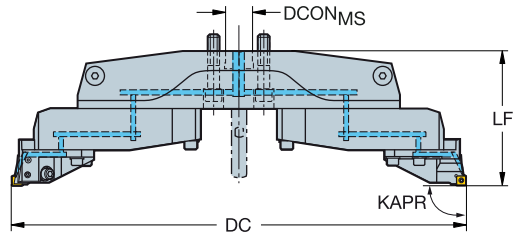
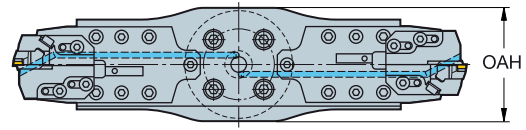
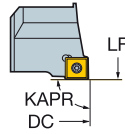
With bridge extension



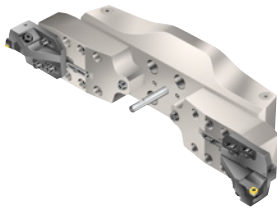
SPMT

KAPR

90°



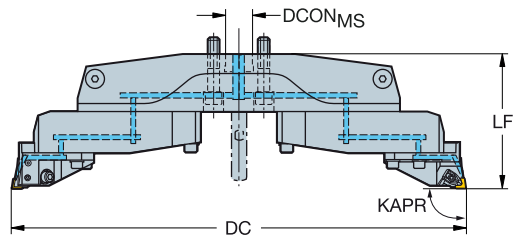
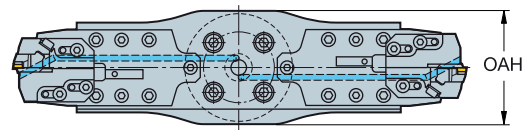
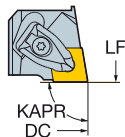
| | | | | | Dimensions, mm | | | | | | | | | |
|---------|---------|----|-------------------|------|----------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|--------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
| 538.00 | 780.00 | 18 | 40X | 1 | 820-780SP18 | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 39.000 | 2 | SPMT 1810-BM |
| 778.00 | 1020.00 | 18 | 40X | 1 | 820-1020SP18 | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 36.380 | 2 | SPMT 1810-BM |
| 1018.00 | 1260.00 | 18 | 40X | 1 | 820-1260SP18 | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.810 | 2 | SPMT 1810-BM |



CNMM
CNMG
CNMA, CNGA

KAPR

90°



| | | | | | Dimensions, mm | | | | | | | | | |
|---------|---------|----|-------------------|------|----------------|--------------------|----------------------|----------------------|--------|--------|-----|--------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{AXL} | ADJLX _{RDL} | LF | OAH | BAR | KG | CICT | MIID |
| 538.00 | 780.00 | 19 | 40X | 1 | 820-780CN19 | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 34.000 | 2 | CNMG 19 06 12 |
| 778.00 | 1020.00 | 19 | 40X | 1 | 820-1020CN19 | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.000 | 2 | CNMG 19 06 12 |
| 1018.00 | 1260.00 | 19 | 40X | 1 | 820-1260CN19 | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.830 | 2 | CNMG 19 06 12 |

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



K32



K76



N23



N15

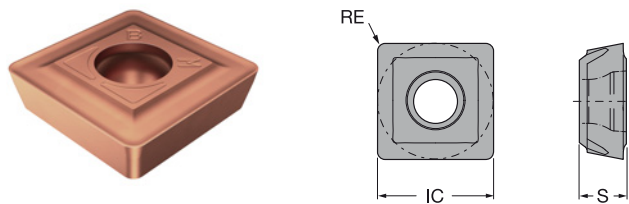



K87

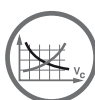


CoroBore® 111 inserts for rough boring

S-style insert (Square)



| | |  | | | ISO CODE | P | M | K | S | |
|----------|----|---|-------|------|----------|-------------|------|------|------|--|
| | | IC | S | RE | | 4325 | 2025 | 3210 | 1145 | |
| Medium | BM | 06 | 6.0 | 2.60 | 0.60 | SPMT0606-BM | ☆ | ☆ | ☆ | |
| | | 08 | 8.9 | 3.00 | 0.80 | SPMT0808-BM | | | | |
| | | 12 | 12.65 | 4.00 | 1.00 | SPMT1210-BM | ☆ | ☆ | ☆ | |
| | | 18 | 18.6 | 5.50 | 1.00 | SPMT1810-BM | ☆ | ☆ | ☆ | |
| Roughing | BR | 06 | 6.0 | 2.60 | 0.60 | SPMT0606-BR | ☆ | ☆ | ☆ | |
| | | 08 | 8.9 | 3.00 | 0.80 | SPMT0808-BR | ☆ | ☆ | ☆ | |
| | | 12 | 12.65 | 4.00 | 1.20 | SPMT1212-BR | ☆ | ☆ | ☆ | |
| | | 18 | 18.6 | 5.50 | 1.20 | SPMT1812-BR | ☆ | ☆ | ☆ | |



K91

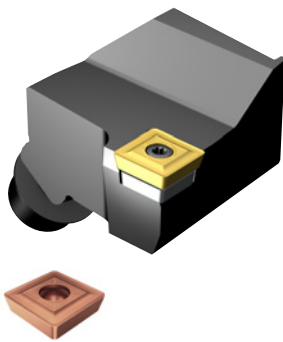


N23

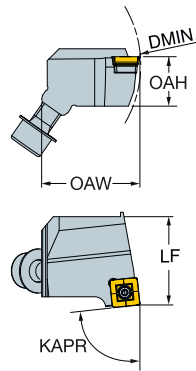
Cartridge for CoroBore® XL

KAPR

84°



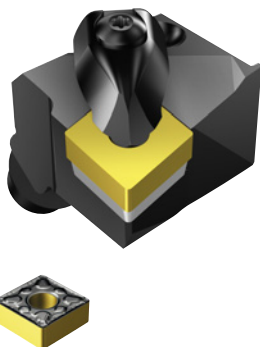
SPMT



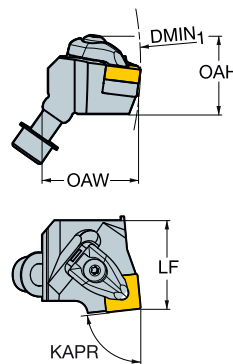
| | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|----------------|---------------------|-------|-------|-------|-------|-------|-------|------|--------------|
| DMIN ₁ | CZC _{MS} | Ordering code | LF | HF | WF | OAH | OAL | | CICT | MIID | |
| 148.0 | 12 | S12 | S12-R820XLR40SSYP12 | 40.00 | 22.40 | 42.00 | 30.16 | 43.30 | 0.250 | 1 | SPMT 1210-BM |

KAPR

84°



SNMM
 SNMG
 SNMA, SNGA



| | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|----------------|---------------------|-------|-------|-------|-------|-------|-------|-------|------|---------------|
| DMIN ₁ | CZC _{MS} | Ordering code | LF | LPR | HF | WF | OAH | OAL | | CICT | MIID | |
| 148.0 | 15 | S12 | S12-R820XLR40DSYN15 | 40.00 | 41.80 | 20.00 | 42.00 | 39.70 | 43.80 | 0.310 | 1 | SNMG 15 06 08 |

For inserts, see Turning tools catalogue

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



Fine boring

| | Tool concept | Diameter range, mm | Hole tolerance | Cutting edge | Operation | Insert choice | Machine side interface | Page |
|---|--------------|---------------------|----------------|--|--|--|---|--------------------|
| CoroBore® 824  | Conventional | 1-20 | IT6 | - Solid carbide bars - Indexable carbide bars | - Single edge boring | - CoroTurn® 107 - CoroTurn® XS | - Coromant Capto® - Coromant EH | K35-K37 |
| 391.37A/B  | Conventional | 3-36 | IT6 | - Solid carbide bars - Indexable carbide bars - Indexable steel bars | - Single edge boring | - CoroTurn® 107 - Solid bars with ground geometry | - Coromant Capto® - HSK | K38-K40 |
| CoroBore® 826 HP  | Conventional | 35-154 | IT6 | - Indexable cartridges | - Single edge boring | - CoroTurn® 107 | - Coromant Capto® | K48-K50 |
| CoroBore® 825  | Conventional | 19-167 | IT6 | - Indexable cartridges | - Single edge boring - Back boring | - CoroTurn® 107 | - Coromant Capto® - Cylindrical shank - Coromant EH | K43-K50 |
|  | Lightweight | 69-167 | IT6 | - Indexable cartridges | - Single edge boring - Back boring | - CoroTurn® 107 | - Coromant Capto® | K51 |
|  | Damped | 19-167 | IT6 | - Indexable cartridges | - Single edge boring - Back boring | - CoroTurn® 107 | - Coromant Capto® | K52 |
| CoroBore® 825 XL/CoroBore® 826 XL  | Conventional | 148-315 298-1275 | IT6 | - Indexable cartridges | - Single edge boring - Back boring - External boring | - CoroTurn® 107 | - Coromant Capto® - 40X with 4 bolt circle | K53-K61 K62-K65 |
|  | Lightweight | 148-315 | IT6 | - Indexable cartridges | - Single edge boring - Back boring - External boring | - CoroTurn® 107 | - Coromant Capto® - 40S with 4 bolt circle | K56-K59 |
|  | Damped | 148-315 | IT6 | - Indexable cartridges | - Single edge boring - Back boring - External boring | - CoroTurn® 107 | - A33 damped adaptor | K60-K61 |

CoroBore® 824

Small-diameter fine boring

Application

- Fine boring
- Single edge boring

ISO application area



Benefits and features

- Broad diameter range, from 1-20 mm
- Increased accessibility with Coromant Capto and Coromant EH modular interfaces in small diameters
- Fine boring tool with precision diameter adjustment of 2 microns (nonius scale) to obtain tight tolerances of IT6
- CoroTurn® XS inserts to be used from diameter 1 mm
- Solid carbide boring bars with standard CoroTurn® 107 indexable inserts available from diameter 6 mm
- Better accessibility with small boring head diameters, making it possible to bore in hard to reach areas
- Rigid system for maximum stability with internal coolant supply



www.sandvik.coromant.com/corobore824

Tools

Couplings:

- Coromant Capto®
- Coromant EH

Inserts and cutting tools

Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® XS
- CoroTurn® 107

| DCON _{WS} | RPMX | ADJRG (mm) |
|--------------------|-------|------------|
| 4 | 28000 | 1 |
| 6 | 20000 | 1 |
| 8 | 14000 | 1 |
| 10 | 10000 | 1.5 |



- CoroTurn® XS for small diameter holes. For assortment, see Turning catalogue.



Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

Coromant Capto® to CoroTurn® XS adaptor

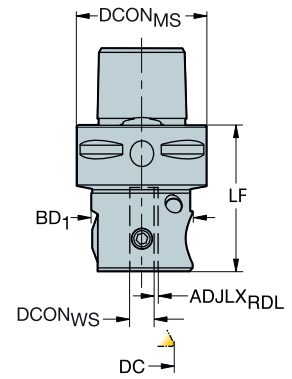
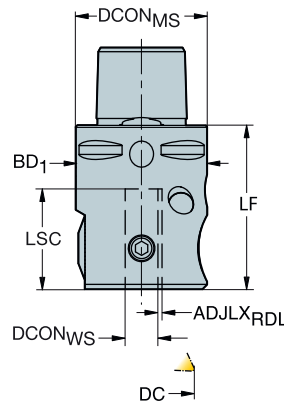
CoroBore® 824 XS

Internal coolant supply

DSGN

1

2

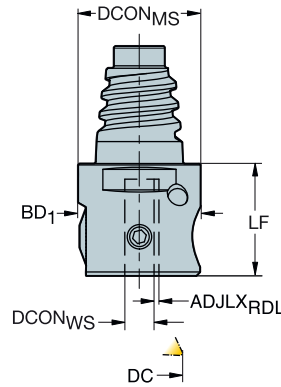


| | | | | | | | Dimensions, mm | | | | | |
|-------|-------|-------------------|-------------------|------|------|-----------------|--------------------|--------------------|----------|-------|-----|-------|
| DCN | DCX | CZC _{MS} | CZC _{WS} | CNSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | ADJLXRDL | LF | BAR | KG |
| 1.00 | 6.00 | C3 | 4 | 3 | 2 | C3-R824XS04-021 | 32.00 | 4.00 | 1.00 | 36.00 | 20 | 0.213 |
| 6.00 | 10.00 | C3 | 6 | 3 | 2 | C3-R824XS06-016 | 32.00 | 6.00 | 1.00 | 36.00 | 20 | 0.210 |
| 10.00 | 14.00 | C3 | 8 | 3 | 1 | C3-R824XS08-015 | 32.00 | 8.00 | 1.00 | 40.00 | 20 | 0.269 |
| 14.00 | 20.00 | C4 | 10 | 3 | 1 | C4-R824XS10-017 | 40.00 | 10.00 | 1.50 | 42.00 | 20 | 0.451 |

Coromant EH to CoroTurn® XS adaptor

CoroBore® 824 XS

Internal coolant supply



| | | | | | | | Dimensions, mm | | | | | |
|-------|-------|-------------------|-------------------|------|-------------------|--------------------|--------------------|----------|-------|-----|-------|--|
| DCN | DCX | CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLXRDL | LF | BAR | KG | |
| 1.00 | 6.00 | E25 | 4 | 1 | EH25-R824XS04-008 | 24.20 | 4.00 | 1.00 | 23.00 | 20 | 0.174 | |
| 6.00 | 10.00 | E25 | 6 | 1 | EH25-R824XS06-003 | 24.20 | 6.00 | 1.00 | 23.00 | 20 | 0.172 | |
| 10.00 | 14.00 | E25 | 8 | 1 | EH25-R824XS08-013 | 24.20 | 8.00 | 1.00 | 38.00 | 20 | 0.285 | |
| 14.00 | 20.00 | E25 | 10 | 1 | EH25-R824XS10-013 | 24.20 | 10.00 | 1.50 | 38.00 | 20 | 0.368 | |

Note:

To be used with CoroTurn® XS boring bar for boring

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



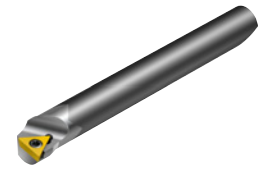
CoroTurn® XS boring bar for boring



CXS connection - Internal coolant supply

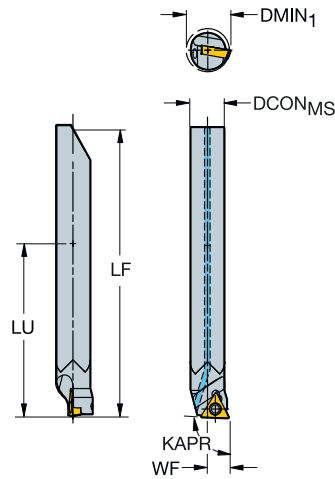
Indexable solid carbide bar

KAPR

92°



-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW



| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|---------------|--------------------|-------|-------|-------|------|----|-------|-----|------------------|
| DMIN ₁ | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | LU | LF | WF | BAR | KG | CICT | MID | |
| 6.0 | 05 | 6 | 1 | CXS-06-06 030TC05 | 6.00 | 30.00 | 49.90 | 3.00 | 20 | 0.028 | 1 | TCEX 05 01 00L-F |
| 8.0 | 05 | 6 | 1 | CXS-06-08 030TC05 | 6.00 | 30.00 | 49.90 | 4.00 | 20 | 0.031 | 1 | TCEX 05 01 00L-F |
| 10.0 | 06 | 8 | 1 | CXS-08-10 040TC06 | 8.00 | 40.00 | 64.04 | 5.00 | 20 | 0.050 | 1 | TCMT 06 T1 02 |
| 12.0 | 06 | 8 | 1 | CXS-08-12 040TC06 | 8.00 | 40.00 | 64.04 | 6.00 | 20 | 0.050 | 1 | TCMT 06 T1 02 |
| 14.0 | 09 | 10 | 1 | CXS-10-14 050TC09 | 10.00 | 50.00 | 73.17 | 7.00 | 20 | 0.104 | 1 | TCMT 09 02 02 |
| 17.0 | 09 | 10 | 1 | CXS-10-17 050TC09 | 10.00 | 50.00 | 73.17 | 8.50 | 20 | 0.106 | 1 | TCMT 09 02 02 |

Recommended adaptors: CoroBore 824XS

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

For inserts, see Turning tools catalogue



K36



N23



N15

391.37A/B Fine boring head

Small diameter boring and face grooving

Application

- Fine boring
- Face grooving

Benefits and features

- Boring bars with increased performance to its length/diameter ratio
- Flexible solutions for a broad diameter range (3-36 mm)
- Excellent for small o-ring grooves
- 391.37B High speed fine boring head with rotation speed on 20 000 rev/min
- Choose between conventional (.37A and high speed (.37B) fine boring head:
- Internal coolant supply
- Diameter adjustment: 0.002 mm



Tools

Couplings:

- Coromant Capto®
- Coromant EH

Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® XS
- CoroTurn® 107
- CoroCut® MB - 09FA

391.37A/B Fine boring head

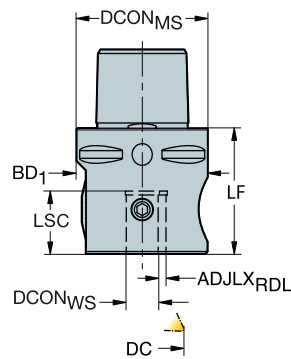
| DCON _{WS} | Max. rotation speed: RPMX | Diameter range ADJRG (mm) |
|--------------------|------------------------------|------------------------------|
| 12 | 7000 | 3 |
| 16 | 5000 | 3 |
| 20 | 3500 | 5 |



Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

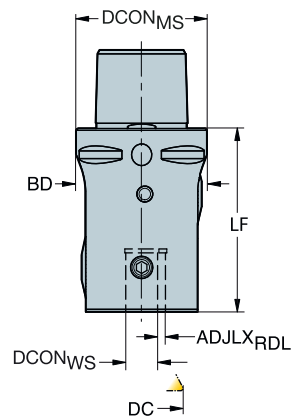
Coromant Capto® to fine boring head adaptor

Internal coolant supply



391.37A adaptor

| | | | | | | Dimensions, mm | | | | | |
|-------|-------|-------------------|-------------------|------|--------------------|--------------------|--------------------|----------------------|-------|-----|-------|
| DCN | DCX | CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLX _{RDL} | LF | BAR | KG |
| 3.00 | 26.00 | C4 | 12 | 3 | C4-391.37A-12 055B | 40.00 | 12.00 | 3.00 | 55.00 | 20 | 0.714 |
| 3.00 | 26.00 | C5 | 12 | 3 | C5-391.37A-12 048B | 50.00 | 12.00 | 3.00 | 48.00 | 20 | 0.799 |
| 3.00 | 32.00 | C5 | 16 | 3 | C5-391.37A-16 070A | 50.00 | 16.00 | 3.00 | 70.00 | 20 | 1.450 |
| 3.00 | 32.00 | C6 | 16 | 3 | C6-391.37A-16 075A | 63.00 | 16.00 | 3.00 | 75.00 | 20 | 1.896 |
| 17.00 | 36.00 | C5 | 20 | 3 | C5-391.37A-20 085A | 50.00 | 20.00 | 5.00 | 85.00 | 20 | 1.616 |
| 17.00 | 36.00 | C6 | 20 | 3 | C6-391.37A-20 085A | 63.00 | 20.00 | 5.00 | 85.00 | 20 | 2.886 |



391.37B adaptor with adjustable counterweight

| | | | | | | Dimensions, mm | | | | | |
|------|-------|-------------------|-------------------|------|--------------------|--------------------|--------------------|----------------------|-------|-----|-------|
| DCN | DCX | CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLX _{RDL} | LF | BAR | KG |
| 3.00 | 26.00 | C5 | 12 | 3 | C5-391.37B-12 070B | 50.00 | 12.00 | 3.00 | 70.00 | 20 | 1.090 |

To be used with R429U/R429.90 boring bars

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



L2



M26



N23

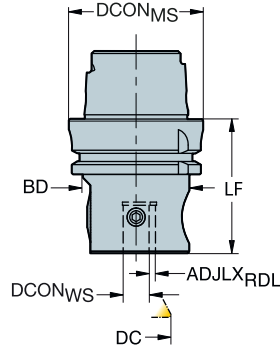
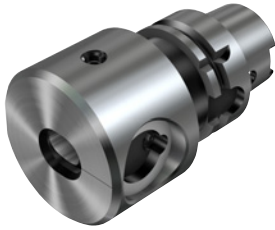


N15



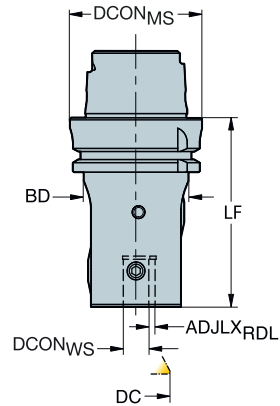
HSK to fine boring head adaptor

Internal coolant supply



391.37A adaptor

| | | | | | | Dimensions, mm | | | | | | | |
|-------|-------|-------------------|-------------------|------|-----------------------|--------------------|--------------------|-----|----------------------|--------|-----------------|-----|-------|
| DCN | DCX | CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ISO | ADJLX _{RDL} | LF | BD ₁ | BAR | KG |
| 3.00 | 26.00 | 63 | 12 | 1 | 392.41037A-6312063B | 63.00 | 12.00 | A | 3.00 | 63.00 | 50.00 | 20 | 1.181 |
| 3.00 | 26.00 | 100 | 12 | 1 | 392.41037A-10012076B | 100.00 | 12.00 | A | 3.00 | 76.00 | 50.00 | 20 | 2.700 |
| 3.00 | 32.00 | 63 | 16 | 1 | 392.41037A-6316085A | 63.00 | 16.00 | A | 3.00 | 85.00 | 63.00 | 20 | 1.770 |
| 17.00 | 36.00 | 63 | 20 | 1 | 392.41037A-63 20 100A | 63.00 | 20.00 | A | 5.00 | 100.00 | 80.00 | 20 | 2.788 |



391.37B adaptor with adjustable counterweight

| | | | | | | Dimensions, mm | | | | | | | |
|------|-------|-------------------|-------------------|------|---------------------|--------------------|--------------------|-----|----------------------|-------|-----------------|-----|-------|
| DCN | DCX | CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ISO | ADJLX _{RDL} | LF | BD ₁ | BAR | KG |
| 3.00 | 26.00 | 63 | 12 | 1 | 392.41037B-6312090B | 63.00 | 12.00 | A | 3.00 | 90.00 | 50.00 | 20 | 1.502 |

To be used with R429U/R429.90 boring bars

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



Boring bar with indexable insert for fine boring heads

Cylindrical shank - Internal coolant supply

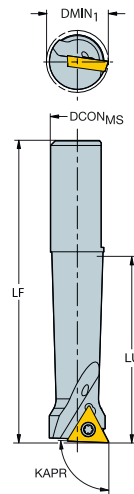
Steel bar

KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|---------------|-----------------------|-------|-------|--------|-------|----|-------|-----|---------------|
| DMIN ₁ | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | LU | LF | WF | BAR | KG | CICT | MID | |
| 8.0 | 06 | 12 | 1 | R429U-A12-08028TC06 | 12.00 | 28.00 | 54.00 | 4.00 | 20 | 0.036 | 1 | TCMT 06 T1 02 |
| 8.0 | 06 | 12 | 1 | R429U-A12-08040TC06 | 12.00 | 40.00 | 66.00 | 4.00 | 20 | 0.040 | 1 | TCMT 06 T1 02 |
| 11.0 | 06 | 12 | 1 | R429U-A12-11039TC06 | 12.00 | 39.00 | 65.00 | 5.50 | 20 | 0.048 | 1 | TCMT 06 T1 02 |
| 11.0 | 06 | 12 | 1 | R429U-A12-11055TC06 | 12.00 | 55.00 | 81.00 | 5.50 | 20 | 0.053 | 1 | TCMT 06 T1 02 |
| 14.0 | 09 | 12 | 1 | R429U-A12-14042TC09 | 12.00 | 42.00 | 68.00 | 7.00 | 20 | 0.060 | 1 | TCMT 09 02 02 |
| 14.0 | 09 | 12 | 1 | R429U-A12-14060TC09 | 12.00 | 60.00 | 86.00 | 7.00 | 20 | 0.070 | 1 | TCMT 09 02 02 |
| 17.0 | 09 | 12 | 1 | R429U-A12-17042TC09 | 12.00 | 42.00 | 68.00 | 8.50 | 20 | 0.060 | 1 | TCMT 09 02 02 |
| 17.0 | 09 | 12 | 1 | R429U-A12-17060TC09 | 12.00 | 60.00 | 86.00 | 8.50 | 20 | 0.071 | 1 | TCMT 09 02 02 |
| 20.0 | 09 | 12 | 1 | R429U-A12-20042TC09 | 12.00 | 42.00 | 68.00 | 10.00 | 20 | 0.063 | 1 | TCMT 09 02 02 |
| 20.0 | 09 | 12 | 1 | R429U-A12-20060TC09 | 12.00 | 60.00 | 86.00 | 10.00 | 20 | 0.072 | 1 | TCMT 09 02 02 |
| 8.0 | 06 | 16 | 1 | R429U-A16-08028 TC06A | 16.00 | 28.00 | 89.00 | 4.00 | 20 | 0.114 | 1 | TCMT 06 T1 02 |
| 8.0 | 06 | 16 | 1 | R429U-A16-08040TC06 | 16.00 | 40.00 | 101.00 | 4.00 | 20 | 0.103 | 1 | TCMT 06 T1 02 |
| 11.0 | 06 | 16 | 1 | R429U-A16-11039 TC06A | 16.00 | 39.00 | 100.00 | 5.50 | 20 | 0.124 | 1 | TCMT 06 T1 02 |
| 11.0 | 06 | 16 | 1 | R429U-A16-11055TC06 | 16.00 | 55.00 | 116.00 | 5.50 | 20 | 0.120 | 1 | TCMT 06 T1 02 |
| 14.0 | 09 | 16 | 1 | R429U-A16-14049 TC09A | 16.00 | 49.00 | 110.00 | 1.50 | 20 | 0.148 | 1 | TCMT 09 02 02 |
| 14.0 | 09 | 16 | 1 | R429U-A16-14070TC09 | 16.00 | 70.00 | 131.00 | 7.00 | 20 | 0.156 | 1 | TCMT 09 02 02 |
| 17.0 | 09 | 16 | 1 | R429U-A16-17056 TC09A | 16.00 | 56.00 | 117.00 | 8.50 | 20 | 0.165 | 1 | TCMT 09 02 02 |
| 17.0 | 09 | 16 | 1 | R429U-A16-17080TC09 | 16.00 | 80.00 | 141.00 | 8.50 | 20 | 0.193 | 1 | TCMT 09 02 02 |
| 20.0 | 09 | 16 | 1 | R429U-A16-20056 TC09A | 16.00 | 56.00 | 117.00 | 10.00 | 20 | 7.400 | 1 | TCMT 09 02 02 |
| 20.0 | 09 | 16 | 1 | R429U-A16-20080TC09 | 16.00 | 80.00 | 141.00 | 10.00 | 20 | 0.195 | 1 | TCMT 09 02 02 |
| 23.0 | 09 | 16 | 1 | R429U-A16-23056 TC09A | 16.00 | 56.00 | 117.00 | 11.50 | 20 | 0.160 | 1 | TCMT 09 02 02 |
| 23.0 | 09 | 16 | 1 | R429U-A16-23080TC09 | 16.00 | 80.00 | 141.00 | 11.50 | 20 | 0.192 | 1 | TCMT 09 02 02 |
| 26.0 | 09 | 16 | 1 | R429U-A16-26056 TC09A | 16.00 | 56.00 | 117.00 | 13.00 | 20 | 0.160 | 1 | TCMT 09 02 02 |
| 26.0 | 09 | 16 | 1 | R429U-A16-26080TC09 | 16.00 | 80.00 | 141.00 | 13.00 | 20 | 0.194 | 1 | TCMT 09 02 02 |
| 17.0 | 09 | 20 | 1 | R429U-A20-17060 TC09A | 20.00 | 60.00 | 134.00 | 8.50 | 20 | 0.260 | 1 | TCMT 09 02 02 |
| 20.0 | 09 | 20 | 1 | R429U-A20-20070 TC09A | 20.00 | 70.00 | 144.00 | 10.00 | 20 | 0.270 | 1 | TCMT 09 02 02 |
| 23.0 | 09 | 20 | 1 | R429U-A20-23070 TC09A | 20.00 | 70.00 | 144.00 | 11.50 | 20 | 0.290 | 1 | TCMT 09 02 02 |
| 26.0 | 09 | 20 | 1 | R429U-A20-26070 TC09A | 20.00 | 70.00 | 144.00 | 13.00 | 20 | 0.290 | 1 | TCMT 09 02 02 |

Recommended adaptors:
A12: 391.37A/B
A16 and A20: 391.37A

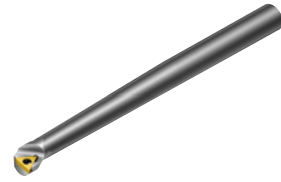
For spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue



Boring bar with indexable insert for fine boring heads

Cylindrical shank - Internal coolant supply

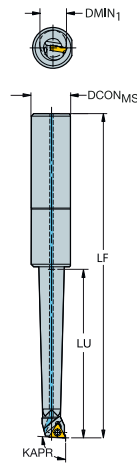
Carbide bar with brazed steel head



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR

92°



| | | | | Dimensions, mm | | | | | | | | | |
|------------------|-------------------|------|---------------------|--------------------|-------|--------|-------|-----|-------|------|---------------|--|--|
| DMN ₁ | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | LU | LF | WF | BAR | KG | CICT | MIID | | |
| 8.0 | 06 | 16 | R429U-E16-08048TC06 | 16.00 | 48.00 | 109.00 | 4.00 | 20 | 0.130 | 1 | TCMT 06 T1 02 | | |
| 11.0 | 06 | 16 | R429U-E16-11066TC06 | 16.00 | 66.00 | 127.00 | 5.50 | 20 | 0.170 | 1 | TCMT 06 T1 02 | | |
| 14.0 | 09 | 16 | R429U-E16-14084TC09 | 16.00 | 84.00 | 145.00 | 7.00 | 20 | 0.275 | 1 | TCMT 09 02 02 | | |
| 17.0 | 09 | 16 | R429U-E16-17096TC09 | 16.00 | 96.00 | 157.00 | 8.50 | 20 | 0.391 | 1 | TCMT 09 02 02 | | |
| 20.0 | 09 | 16 | R429U-E16-20096TC09 | 16.00 | 96.00 | 157.00 | 10.00 | 20 | 0.394 | 1 | TCMT 09 02 02 | | |
| 23.0 | 09 | 16 | R429U-E16-23096TC09 | 16.00 | 96.00 | 157.00 | 11.50 | 20 | 0.395 | 1 | TCMT 09 02 02 | | |
| 26.0 | 09 | 16 | R429U-E16-26096TC09 | 16.00 | 96.00 | 157.00 | 13.00 | 20 | 0.395 | 1 | TCMT 09 02 02 | | |

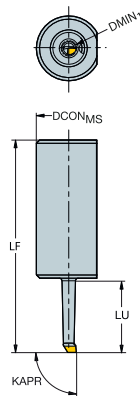
For inserts, see Turning tools catalogue

Solid boring bar for fine boring head



KAPR

90°



| | | | | Dimensions, mm | | | | | | | | | | | | | | | |
|------------------|-------------------|------|----------------------|----------------|---|---|---|---|------|------|------|------|------|--------------------|-------|-------|------|-----|-------|
| DMN ₁ | CZC _{MS} | CNSC | Ordering code | P | M | K | N | S | HT0F | HT0F | HT0F | HT0F | HT0F | DCON _{MS} | LU | LF | WF | BAR | KG |
| 3.0 | 12 | 1 | R429.90-03-013-01-CB | * | * | * | * | * | * | * | * | * | * | 12.00 | 13.50 | 40.00 | 1.50 | 20 | 0.039 |
| 5.0 | 12 | 1 | R429.90-05-021-02-CB | * | * | * | * | * | * | * | * | * | * | 12.00 | 21.00 | 48.00 | 2.50 | 20 | 0.042 |

| | | | | Dimensions, mm | | | | | | | | | |
|------------------|-------------------|------|--------------------|----------------|-------|-------|------|-----|-------|--|--|--|--|
| DMN ₁ | CZC _{MS} | CNSC | Ordering code | DCON | LU | LF | WF | BAR | KG | | | | |
| 3.0 | 16 | 1 | R429U-E16-0301501A | 16.00 | 15.00 | 76.00 | 1.50 | 20 | 0.102 | | | | |
| 5.0 | 16 | 1 | R429U-E16-0502502A | 16.00 | 25.00 | 86.00 | 2.50 | 20 | 0.100 | | | | |

Recommended adaptors:
A12: A391.37A/B
A16: A391.37A



CoroBore® 825

Fine boring tool for high precision boring

Application

- Conventional fine boring
- Back boring

ISO application area



Benefits and features

- Flexible solutions linking to any machine interface; choose between Coromant Capto and EH modular interfaces
- Achieve required overhang even at small diameters with the EH modular system
- Reliable system with rigid interfaces between head and cartridge for stable and vibration-free boring
- CoroBore 825 accurately adjusts the cutting edge manually with a resolution of 0.01 mm on diameter
- Close hole tolerances of IT6
- Available as damped tool for vibration-free boring even at long overhangs
- Coolant through the tool



www.sandvik.coromant.com/corobore825

Tools

Couplings:

- Coromant Capto®
- Coromant EH
- Cylindrical shank

Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® 107
- CoroTurn® 111 (not available as kits)



Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.



With a Silent Tools™ damper built closer to the cutting edge and a fine boring head in aluminum with reduced length, higher performance and increased productivity can be achieved.



Also available as lightweight tools. Bore large diameters with increased stability without increasing the tool weight.

CoroBore® 826

Fine boring tool for high precision boring

Application

- High precision fine boring

ISO application area



Benefits and features

- High precision coolant directed at the cutting edge for excellent chip control up to 70 bars
- Coolant through the tool and cartridge
- Stepwise click function for easy tool setting
- Reliable system with rigid interfaces between head and cartridge for stable and vibration-free boring
- Close hole tolerances up to IT6
- CoroBore® 826 high precision adjusts the cutting edge with a resolution of 2 micrometer on diameter



www.sandvik.coromant.com/corobore826

Tools

Couplings:

- Coromant Capto®

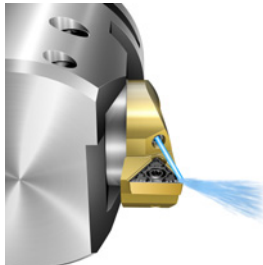
Inserts

Standard inserts with dedicated grades and geometries for all materials

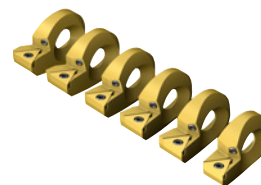
- CoroTurn® 107



Each click adjusts diameter 0.002 mm. A 360° turn change diameter by 0.1 mm. Total diameter change on fine boring head 1.1-1.3 mm.



High precision coolant nozzle for precise coolant flow to cutting edge



Extend diameter range by using cartridge kits! See page K84

CoroBore® 825 fine boring tool

Coromant Capto® - Internal coolant supply

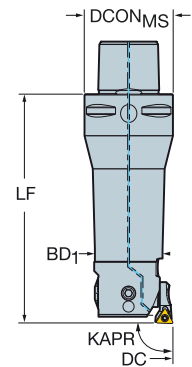
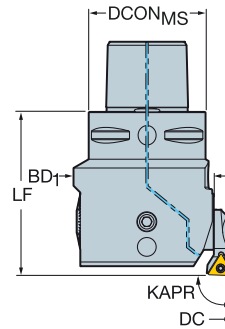
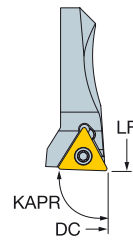


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR
DSGN

92°
1

92°
2



| | | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|------|----------------|--------------------|---------------------|------|--------|-----------------|----|-------|------|---------------|--|
| DCN | DCX | | CZC _{MS} | CNSC | DSGN | Ordering code | DCON _{MS} | ADJL _{RDL} | ULDR | LF | BD ₁ | | | CICT | MIID | |
| 19.00 | 23.00 | 06 | C3 | 3 | 2 | 825-23TC06-C3 | 32.00 | 2.00 | 3.00 | 89.00 | 18.00 | 70 | 0.430 | 1 | TCMT 06 T1 02 | |
| 23.00 | 29.00 | 06 | C3 | 3 | 2 | 825-29TC06-C3 | 32.00 | 3.00 | 2.00 | 76.00 | 20.00 | 70 | 0.414 | 1 | TCMT 06 T1 02 | |
| 23.00 | 29.00 | 06 | C4 | 3 | 2 | 825-29TC06-C4 | 40.00 | 3.00 | 2.00 | 85.00 | 20.00 | 70 | 0.897 | 1 | TCMT 06 T1 02 | |
| 28.00 | 36.00 | 06 | C3 | 3 | 2 | 825-36TC06-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 25.00 | 70 | 0.692 | 1 | TCMT 06 T1 02 | |
| 28.00 | 36.00 | 06 | C4 | 3 | 2 | 825-36TC06-C4 | 40.00 | 4.00 | 2.00 | 95.00 | 25.00 | 70 | 0.992 | 1 | TCMT 06 T1 02 | |
| 35.00 | 45.00 | 09 | C3 | 3 | 1 | 825-45TC09-C3 | 32.00 | 5.00 | | 48.00 | 32.00 | 70 | 0.641 | 1 | TCMT 09 02 04 | |
| 35.00 | 45.00 | 09 | C4 | 3 | 2 | 825-45TC09-C4 | 40.00 | 5.00 | 1.50 | 83.00 | 32.00 | 70 | 1.007 | 1 | TCMT 09 02 04 | |
| 44.00 | 56.00 | 09 | C4 | 3 | 1 | 825-56TC09-C4 | 40.00 | 6.00 | | 56.00 | 40.00 | 70 | 0.874 | 1 | TCMT 09 02 04 | |
| 44.00 | 56.00 | 09 | C5 | 3 | 2 | 825-56TC09-C5 | 50.00 | 6.00 | 1.50 | 98.00 | 40.00 | 70 | 1.600 | 1 | TCMT 09 02 04 | |
| 55.00 | 70.00 | 11 | C5 | 3 | 1 | 825-70TC11-C5 | 50.00 | 7.50 | | 66.00 | 50.00 | 70 | 1.430 | 1 | TCMT 11 03 04 | |
| 55.00 | 70.00 | 11 | C6 | 3 | 2 | 825-70TC11-C6 | 63.00 | 7.50 | 1.50 | 120.00 | 50.00 | 70 | 2.620 | 1 | TCMT 11 03 04 | |
| 69.00 | 87.00 | 11 | C5 | 3 | 1 | 825-87TC11-C5 | 50.00 | 9.00 | | 70.00 | 63.00 | 70 | 1.930 | 1 | TCMT 11 03 04 | |
| 69.00 | 87.00 | 11 | C6 | 3 | 1 | 825-87TC11-C6 | 63.00 | 9.00 | | 78.00 | 63.00 | 70 | 2.360 | 1 | TCMT 11 03 04 | |
| 86.00 | 107.00 | 11 | C5 | 3 | 1 | 825-107TC11-C5 | 50.00 | 10.50 | | 76.00 | 80.00 | 70 | 2.240 | 1 | TCMT 11 03 04 | |
| 86.00 | 107.00 | 11 | C6 | 3 | 1 | 825-107TC11-C6 | 63.00 | 10.50 | | 90.00 | 80.00 | 70 | 3.180 | 1 | TCMT 11 03 04 | |
| 106.00 | 137.00 | 11 | C6 | 3 | 1 | 825-137TC11-C6 | 63.00 | 15.50 | | 90.00 | 100.00 | 70 | 3.792 | 1 | TCMT 11 03 04 | |
| 106.00 | 137.00 | 11 | C8 | 3 | 1 | 825-137TC11-C8 | 80.00 | 15.50 | | 100.00 | 100.00 | 70 | 5.045 | 1 | TCMT 11 03 04 | |
| 136.00 | 167.00 | 11 | C6 | 3 | 1 | 825-167TC11-C6 | 63.00 | 15.50 | | 90.00 | 130.00 | 70 | 4.430 | 1 | TCMT 11 03 04 | |
| 136.00 | 167.00 | 11 | C8 | 3 | 1 | 825-167TC11-C8 | 80.00 | 15.50 | | 100.00 | 130.00 | 70 | 5.570 | 1 | TCMT 11 03 04 | |

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC*ULDR





K89



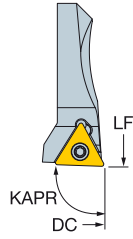
CoroBore® 825 fine boring tool

Cylindrical shank - Internal coolant supply

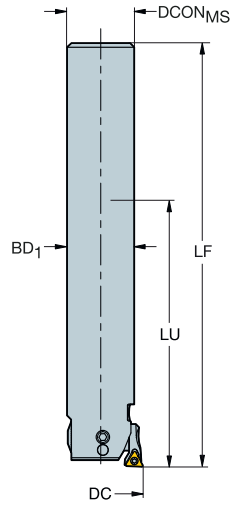


-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW




KAPR



92°



Dimensions, mm

| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{ROL} | LU | LF | BD ₁ |  |  | CICT | MID |
|-------|-------|---|-------------------|------|----------------|--------------------|----------------------|--------|--------|-----------------|---|---|------|---------------|
| 19.00 | 23.00 | 06 | 18 | 1 | 825-23TC06-A18 | 18.00 | 2.00 | 77.00 | 128.00 | 18.00 | 70 | 0.731 | 1 | TCMT 06 T1 02 |
| 23.00 | 29.00 | 06 | 20 | 1 | 825-29TC06-A20 | 20.00 | 3.00 | 81.00 | 132.00 | 20.00 | 70 | 0.606 | 1 | TCMT 06 T1 02 |
| 28.00 | 36.00 | 06 | 25 | 1 | 825-36TC06-A25 | 25.00 | 4.00 | 101.00 | 158.00 | 25.00 | 70 | 0.951 | 1 | TCMT 06 T1 02 |

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com



For inserts, see Turning tools catalogue



CoroBore® 825 fine boring tool

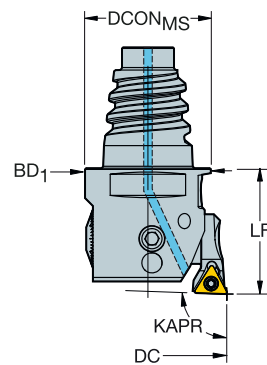
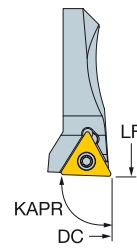
Coromant EH coupling - Internal coolant supply






-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW

KAPR

92°



| | | | | | Dimensions, mm | | | | | | | | |
|-------|-------|---|-------------------|------|-----------------|--------------------|----------------------|-------|-----------------|---|--|------|---------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | BD ₁ |  BAR |  KG | CICT | MIID |
| 19.00 | 23.00 | 06 | E16 | 1 | 825-23TC06-EH16 | 15.50 | 2.00 | 25.00 | 18.00 | 70 | 0.500 | 1 | TCMT 06 T1 02 |
| 23.00 | 29.00 | 06 | E20 | 1 | 825-29TC06-EH20 | 19.30 | 3.00 | 25.00 | 20.00 | 70 | 0.600 | 1 | TCMT 06 T1 02 |
| 28.00 | 36.00 | 06 | E25 | 1 | 825-36TC06-EH25 | 24.20 | 4.00 | 25.00 | 25.00 | 70 | 0.687 | 1 | TCMT 06 T1 02 |

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

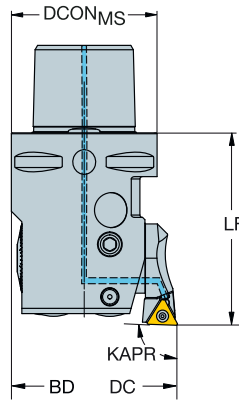


CoroBore® 826 fine boring tool

Coromant Capto® - Precision coolant supply

KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | | Dimensions, mm | | | | | | | |
|-------|-------|----|-------------------|------|-----------------|--------------------|----------------------|-------|-----------------|----|-------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{FDL} | LF | BD ₁ | | | CICT | MIID |
| 35.45 | 36.55 | 09 | C3 | 3 | 826-36TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.566 | 1 | TCMT 09 02 04 |
| 36.45 | 37.55 | 09 | C3 | 3 | 826-37TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.565 | 1 | TCMT 09 02 04 |
| 37.45 | 38.55 | 09 | C3 | 3 | 826-38TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.631 | 1 | TCMT 09 02 04 |
| 38.45 | 39.55 | 09 | C3 | 3 | 826-39TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.640 | 1 | TCMT 09 02 04 |
| 39.45 | 40.55 | 09 | C3 | 3 | 826-40TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.647 | 1 | TCMT 09 02 04 |
| 40.45 | 41.55 | 09 | C3 | 3 | 826-41TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| 41.45 | 42.55 | 09 | C3 | 3 | 826-42TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| 42.45 | 43.55 | 09 | C3 | 3 | 826-43TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| 43.45 | 44.55 | 09 | C3 | 3 | 826-44TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| 44.45 | 45.55 | 09 | C4 | 3 | 826-45TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.591 | 1 | TCMT 09 02 04 |
| 45.45 | 46.55 | 09 | C4 | 3 | 826-46TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| 46.45 | 47.55 | 09 | C4 | 3 | 826-47TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 1.104 | 1 | TCMT 09 02 04 |
| 47.45 | 48.55 | 09 | C4 | 3 | 826-48TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| 48.45 | 49.55 | 09 | C4 | 3 | 826-49TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| 49.45 | 50.55 | 09 | C4 | 3 | 826-50TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.918 | 1 | TCMT 09 02 04 |
| 50.45 | 51.55 | 09 | C4 | 3 | 826-51TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| 51.45 | 52.55 | 09 | C4 | 3 | 826-52TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.940 | 1 | TCMT 09 02 04 |
| 52.45 | 53.55 | 09 | C4 | 3 | 826-53TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| 53.45 | 54.55 | 09 | C4 | 3 | 826-54TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| 54.45 | 55.55 | 09 | C4 | 3 | 826-55TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| 55.35 | 56.65 | 11 | C5 | 3 | 826-56TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.397 | 1 | TCMT 11 03 04 |
| 56.35 | 57.65 | 11 | C5 | 3 | 826-57TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.455 | 1 | TCMT 11 03 04 |
| 57.35 | 58.65 | 11 | C5 | 3 | 826-58TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.414 | 1 | TCMT 11 03 04 |
| 58.35 | 59.65 | 11 | C5 | 3 | 826-59TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 59.35 | 60.65 | 11 | C5 | 3 | 826-60TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.466 | 1 | TCMT 11 03 04 |
| 60.35 | 61.65 | 11 | C5 | 3 | 826-61TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 61.35 | 62.65 | 11 | C5 | 3 | 826-62TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 62.35 | 63.65 | 11 | C5 | 3 | 826-63TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.426 | 1 | TCMT 11 03 04 |
| 63.35 | 64.65 | 11 | C5 | 3 | 826-64TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.503 | 1 | TCMT 11 03 04 |
| 64.35 | 65.65 | 11 | C5 | 3 | 826-65TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.520 | 1 | TCMT 11 03 04 |
| 65.35 | 66.65 | 11 | C5 | 3 | 826-66TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 66.35 | 67.65 | 11 | C5 | 3 | 826-67TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 67.35 | 68.65 | 11 | C5 | 3 | 826-68TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 68.35 | 69.65 | 11 | C5 | 3 | 826-69TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 69.35 | 70.65 | 11 | C5 | 3 | 826-70TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.455 | 1 | TCMT 11 03 04 |
| 70.35 | 71.65 | 11 | C5 | 3 | 826-71TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 71.35 | 72.65 | 11 | C5 | 3 | 826-72TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| 72.35 | 73.65 | 11 | C5 | 3 | 826-73TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.557 | 1 | TCMT 11 03 04 |
| 73.35 | 74.65 | 11 | C6 | 3 | 826-74TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 74.35 | 75.65 | 11 | C6 | 3 | 826-75TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 75.35 | 76.65 | 11 | C6 | 3 | 826-76TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 2.400 | 1 | TCMT 11 03 04 |
| 76.35 | 77.65 | 11 | C6 | 3 | 826-77TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 77.35 | 78.65 | 11 | C6 | 3 | 826-78TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 78.35 | 79.65 | 11 | C6 | 3 | 826-79TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



L2



N23



N15





K89

CoroBore® 826 fine boring tool

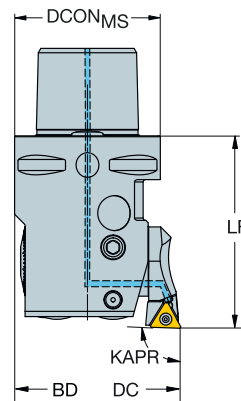
Coromant Capto® - Precision coolant supply






-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW

KAPR

92°



| | | | | | Dimensions, mm | | | | | | | | |
|-------|-------|---|-------------------|------|-----------------|--------------------|----------------------|-------|-----------------|---|---|------|---------------|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | BD ₁ |  |  | CICT | MIID |
| 79.35 | 80.65 | 11 | C6 | 3 | 826-80TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 80.35 | 81.65 | 11 | C6 | 3 | 826-81TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 81.35 | 82.65 | 11 | C6 | 3 | 826-82TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 82.35 | 83.65 | 11 | C6 | 3 | 826-83TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 83.35 | 84.65 | 11 | C6 | 3 | 826-84TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 84.35 | 85.65 | 11 | C6 | 3 | 826-85TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 85.35 | 86.65 | 11 | C6 | 3 | 826-86TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 86.35 | 87.65 | 11 | C6 | 3 | 826-87TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 87.35 | 88.65 | 11 | C6 | 3 | 826-88TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 88.35 | 89.65 | 11 | C6 | 3 | 826-89TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 89.35 | 90.65 | 11 | C6 | 3 | 826-90TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| 90.35 | 91.65 | 11 | C6 | 3 | 826-91TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



L2



N23



N15



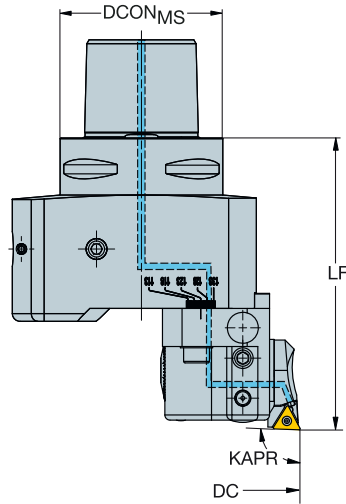
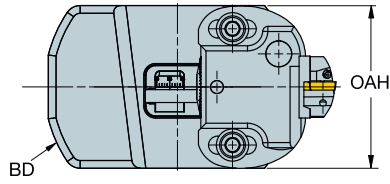
K89

CoroBore® 826 fine boring tool

Coromant Capto® - Internal coolant supply

KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

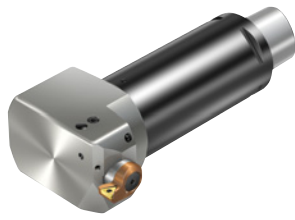
| | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|------------------|--------------------|----------------------|--------|-------|-----------------|----|-------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | OAH | BD ₁ | | | CICT | MIID |
| 91.35 | 112.65 | 11 | C6 | 3 | 826-112TC11-C6HP | 63.00 | 10.65 | 113.00 | 63.00 | 85.00 | 70 | 3.215 | 1 | TCMT 11 03 04 |
| 112.35 | 133.65 | 11 | C6 | 3 | 826-133TC11-C6HP | 63.00 | 10.65 | 113.00 | 63.00 | 105.00 | 70 | 3.645 | 1 | TCMT 11 03 04 |
| 133.35 | 154.65 | 11 | C6 | 3 | 826-154TC11-C6HP | 63.00 | 10.65 | 113.00 | 63.00 | 125.00 | 70 | 3.940 | 1 | TCMT 11 03 04 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue



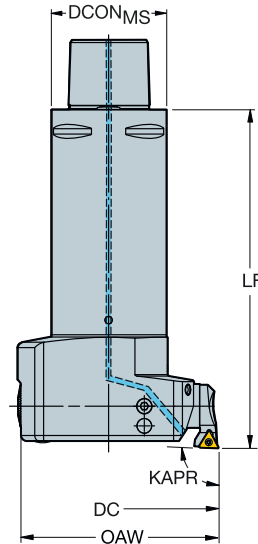
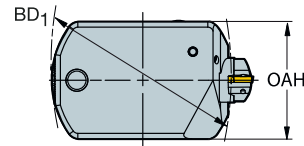
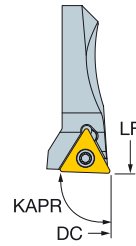
CoroBore® 825 lightweight fine boring tool

Coromant Capto® - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | Dimensions, mm | | | | | | | | | | | |
|--------|--------|----|-------------------|------|-----------------|--------------------|-----------------------|--------|-------|-----------------|----|-------|------|---------------|--|--|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{REDL} | LF | OAH | BD ₁ | | | CICT | MIID | | |
| 69.00 | 87.00 | 11 | C5 | 3 | 825L-87TC11-C5 | 50.00 | 9.00 | 150.00 | 51.00 | 63.00 | 70 | 2.150 | 1 | TCMT 11 03 04 | | |
| 86.00 | 107.00 | 11 | C5 | 3 | 825L-107TC11-C5 | 50.00 | 10.50 | 156.00 | 51.00 | 80.00 | 70 | 2.230 | 1 | TCMT 11 03 04 | | |
| 106.00 | 137.00 | 11 | C6 | 3 | 825L-137TC11-C6 | 63.00 | 15.50 | 190.00 | 64.00 | 100.00 | 70 | 3.970 | 1 | TCMT 11 03 04 | | |
| 106.00 | 137.00 | 11 | C8 | 3 | 825L-137TC11-C8 | 80.00 | 15.50 | 200.00 | 80.00 | 100.00 | 70 | 4.885 | 1 | TCMT 11 03 04 | | |
| 136.00 | 167.00 | 11 | C8 | 3 | 825L-167TC11-C8 | 80.00 | 15.50 | 200.00 | 80.00 | 130.00 | 70 | 5.160 | 1 | TCMT 11 03 04 | | |

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



K89



CoroBore® 825 damped fine boring tool

Coromant Capto® - Internal coolant supply

KAPR
DSGN

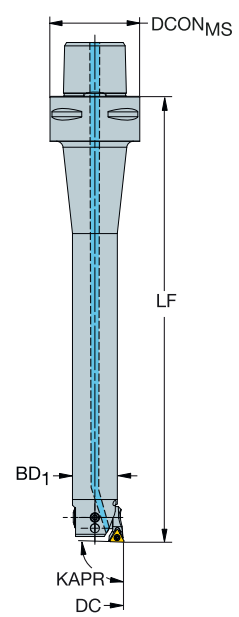
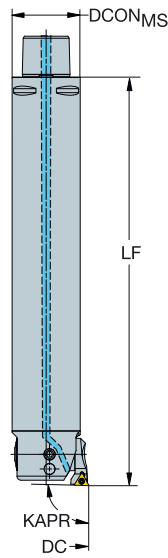
92°
1

92°
2

●●● SilentTools®



- TCMT, TCMX, TCGT, TCGX, TCXEX
- TCMW



| | | Dimensions, mm | | | | | | | | | | | | | | |
|--------|--------|----------------|-------------------|------|------|-------------------|--------------------|----------------------|------|--------|-------|-----------------|----|--------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | DSGN | Ordering code | DCON _{MS} | ADJLX _{RDL} | ULDR | LF | OAH | BD ₁ | | | CICT | MIID |
| 19.00 | 23.00 | 06 | C4 | 3 | 2 | 825D-23TC06U-C4L | 40.00 | 2.00 | 6.00 | 163.00 | | 18.00 | 70 | 0.568 | 1 | TCMT 06 T1 02 |
| 23.00 | 29.00 | 06 | C4 | 3 | 2 | 825D-29TC06U-C4L | 40.00 | 3.00 | 6.00 | 199.00 | | 20.00 | 70 | 0.728 | 1 | TCMT 06 T1 02 |
| 28.00 | 36.00 | 06 | C3 | 3 | 2 | 825D-36TC06U-C3L | 32.00 | 4.00 | 6.00 | 216.00 | | 25.00 | 70 | 0.968 | 1 | TCMT 06 T1 02 |
| 35.00 | 45.00 | 09 | C3 | 3 | 1 | 825D-45TC09U-C3L | 32.00 | 5.00 | 6.00 | 221.00 | | 32.00 | 70 | 1.484 | 1 | TCMT 09 02 04 |
| 35.00 | 45.00 | 09 | C4 | 3 | 2 | 825D-45TC09U-C4L | 40.00 | 5.00 | 6.00 | 270.00 | | 32.00 | 70 | 1.924 | 1 | TCMT 09 02 04 |
| 35.00 | 45.00 | 09 | C6 | 3 | 2 | 825D-45TC09U-C6L | 63.00 | 5.00 | 6.00 | 297.00 | | 32.00 | 70 | 2.574 | 1 | TCMT 09 02 04 |
| 44.00 | 56.00 | 09 | C4 | 3 | 1 | 825D-56TC09U-C4L | 40.00 | 6.00 | 6.00 | 220.00 | | 40.00 | 70 | 2.124 | 1 | TCMT 09 02 04 |
| 44.00 | 56.00 | 09 | C5 | 3 | 2 | 825D-56TC09U-C5L | 50.00 | 6.00 | 6.00 | 336.00 | | 40.00 | 70 | 3.744 | 1 | TCMT 09 02 04 |
| 44.00 | 56.00 | 09 | C6 | 3 | 2 | 825D-56TC09U-C6L | 63.00 | 6.00 | 6.00 | 363.00 | | 40.00 | 70 | 4.384 | 1 | TCMT 09 02 04 |
| 55.00 | 70.00 | 11 | C5 | 3 | 1 | 825D-70TC11U-C5M | 50.00 | 7.50 | 6.00 | 300.00 | | 50.00 | 70 | 4.940 | 1 | TCMT 11 03 04 |
| 55.00 | 70.00 | 11 | C6 | 3 | 2 | 825D-70TC11U-C6M | 63.00 | 7.50 | 5.60 | 400.00 | | 50.00 | 70 | 6.789 | 1 | TCMT 11 03 04 |
| 69.00 | 87.00 | 11 | C6 | 3 | 1 | 825D-87TC11U-C6M | 63.00 | 9.00 | 6.00 | 400.00 | | 63.00 | 70 | 9.659 | 1 | TCMT 11 03 04 |
| 69.00 | 87.00 | 11 | C8 | 3 | 2 | 825D-87TC11U-C8S | 80.00 | 9.00 | 5.60 | 500.00 | | 63.00 | 70 | 12.869 | 1 | TCMT 11 03 04 |
| 86.00 | 107.00 | 11 | C6 | 3 | 1 | 825D-107TC11U-C6M | 63.00 | 10.50 | 6.00 | 400.00 | 64.00 | 80.00 | 70 | 9.729 | 1 | TCMT 11 03 04 |
| 86.00 | 107.00 | 11 | C8 | 3 | 1 | 825D-107TC11U-C8M | 80.00 | 10.50 | 6.00 | 500.00 | | 80.00 | 70 | 18.089 | 1 | TCMT 11 03 04 |
| 86.00 | 107.00 | 11 | C8 | 3 | 1 | 825D-107TC11U-C8S | 80.00 | 10.50 | 6.00 | 410.00 | | 80.00 | 70 | 15.669 | 1 | TCMT 11 03 04 |
| 106.00 | 137.00 | 11 | C6 | 3 | 1 | 825D-137TC11U-C6M | 63.00 | 15.50 | 6.00 | 400.00 | 64.00 | 100.00 | 70 | 9.809 | 1 | TCMT 11 03 04 |
| 106.00 | 137.00 | 11 | C8 | 3 | 1 | 825D-137TC11U-C8M | 80.00 | 15.50 | 6.00 | 500.00 | 81.00 | 100.00 | 70 | 18.199 | 1 | TCMT 11 03 04 |
| 106.00 | 137.00 | 11 | C8 | 3 | 1 | 825D-137TC11U-C8S | 80.00 | 15.50 | 6.00 | 400.00 | 81.00 | 100.00 | 70 | 15.759 | 1 | TCMT 11 03 04 |
| 136.00 | 167.00 | 11 | C8 | 3 | 1 | 825D-167TC11U-C8S | 80.00 | 15.50 | 6.00 | 500.00 | 81.00 | 130.00 | 70 | 18.359 | 1 | TCMT 11 03 04 |

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



L2



N23



N15



K89

CoroBore® 825 XL/CoroBore® 826 XL

Fine boring tool for large diameters

Application

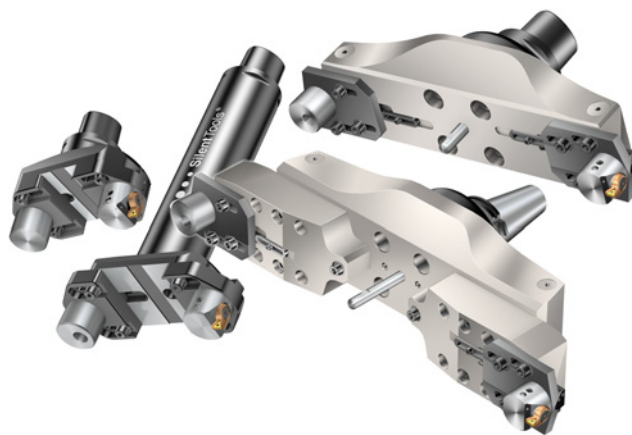
- Fine boring
- Back boring
- External operations

ISO application area



Benefits and features

- Reliable system with rigid interfaces between head and cartridge for stable and vibration-free boring
- Dedicated tool holders optimized for large diameter boring
- Close hole tolerances (up to IT5 for CoroBore 826)
- Cartridge designed for highest stability
- Cutting fluid through the tool
- Diameter 298-1275 mm is made of high strength aluminium, which reduces assembly weight
- Hard coated for surface protection
- Use slide extensions for radial adjustment and back boring
- Strong modular base for building assemblies in different application (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)



www.sandvik.coromant.com/corobore825

●●●● SilentTools®

Tools

Couplings:

- Coromant Capto®
- Arbor

Inserts

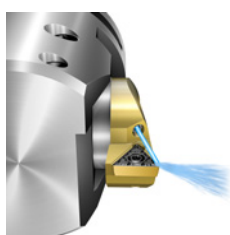
Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® 107

Diameter adjustment:

825 - Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

826 - Each click adjusts diameter 0.002 mm. A 360° turn change diameter by 0.1 mm. Total diameter change on fine boring head 1.1-1.3 mm.



High precision coolant nozzle for precise coolant flow to cutting edge

Available as lightweight tools. Bore large diameters without increasing the tool weight.



Use same bridge/bridge extension for roughing, finishing and face grooving from diameter 150 mm (counterweight needed for finishing).

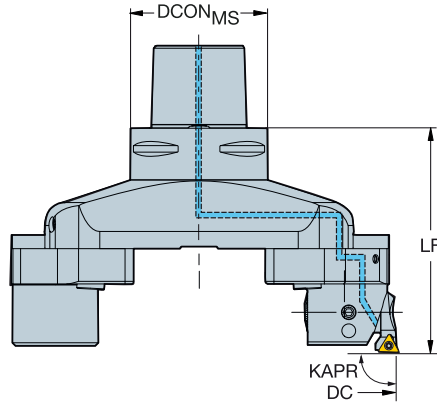
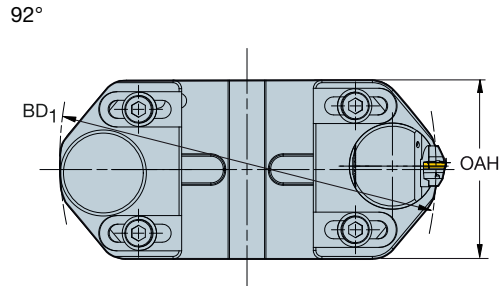
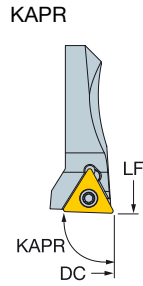
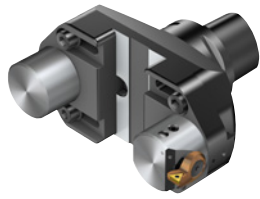


Use slide extensions for radial adjustment and back boring



CoroBore® 825 XL fine boring tool

Coromant Capto® - Internal coolant supply



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|-----------------|--------------------|----------------------|--------|--------|-----------------|----|--------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{ROL} | LF | OAH | BD ₁ | | | CICT | MIID |
| 148.00 | 215.00 | 11 | C6 | 3 | 825-215TC11-C6 | 63.00 | 33.50 | 118.00 | 104.00 | 145.00 | 70 | 4.534 | 1 | TCMT 11 03 04 |
| 148.00 | 215.00 | 11 | C8 | 3 | 825-215TC11-C8 | 80.00 | 33.50 | 130.00 | 104.00 | 145.00 | 70 | 7.500 | 1 | TCMT 11 03 04 |
| 148.00 | 215.00 | 11 | C10 | 3 | 825-215TC11-C10 | 100.00 | 33.50 | 136.00 | 104.00 | 145.00 | 70 | 9.460 | 1 | TCMT 11 03 04 |
| 198.00 | 265.00 | 11 | C6 | 3 | 825-265TC11-C6 | 63.00 | 33.50 | 118.00 | 104.00 | 195.00 | 70 | 4.750 | 1 | TCMT 11 03 04 |
| 198.00 | 265.00 | 11 | C8 | 3 | 825-265TC11-C8 | 80.00 | 33.50 | 130.00 | 104.00 | 195.00 | 70 | 9.100 | 1 | TCMT 11 03 04 |
| 198.00 | 265.00 | 11 | C10 | 3 | 825-265TC11-C10 | 100.00 | 33.50 | 136.00 | 104.00 | 195.00 | 70 | 10.850 | 1 | TCMT 11 03 04 |
| 248.00 | 315.00 | 11 | C6 | 3 | 825-315TC11-C6 | 63.00 | 33.50 | 118.00 | 104.00 | 245.00 | 70 | 5.400 | 1 | TCMT 11 03 04 |
| 248.00 | 315.00 | 11 | C8 | 3 | 825-315TC11-C8 | 80.00 | 33.50 | 130.00 | 104.00 | 245.00 | 70 | 10.350 | 1 | TCMT 11 03 04 |
| 248.00 | 315.00 | 11 | C10 | 3 | 825-315TC11-C10 | 100.00 | 33.50 | 136.00 | 104.00 | 245.00 | 70 | 12.570 | 1 | TCMT 11 03 04 |

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

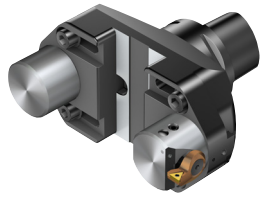
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For inserts, see Turning tools catalogue



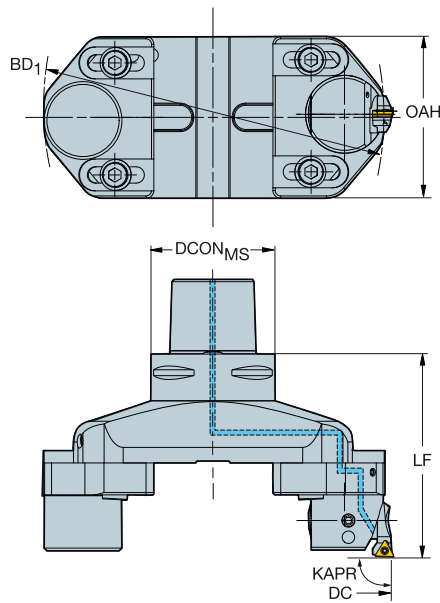
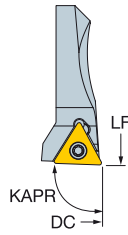
CoroBore® 826 XL fine boring tool

Coromant Capto® - Internal coolant supply



KAPR
STDNO

92°
ISO26623-1



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | | | Dimensions, mm | | | | | | | | |
|--------|--------|----|-----|-------------------|------|------------------|--------------------|----------------------|--------|--------|-----------------|----|-------|------|---------------|
| DCN | DCX | | | GZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{FDL} | LF | OAH | BD ₁ | | | CICT | MIID |
| 154.35 | 207.65 | 11 | 1/4 | C6 | 3 | 826-207TC11-C6HP | 63.00 | 26.65 | 125.00 | 104.00 | 145.00 | 70 | 3.560 | 1 | TCMT 11 03 04 |
| 154.35 | 207.65 | 11 | 1/4 | C8 | 3 | 826-207TC11-C8HP | 80.00 | 26.65 | 137.00 | 104.00 | 145.00 | 70 | 6.430 | 1 | TCMT 11 03 04 |
| 204.35 | 257.65 | 11 | 1/4 | C6 | 3 | 826-257TC11-C6HP | 63.00 | 26.65 | 125.00 | 104.00 | 195.00 | 70 | 3.880 | 1 | TCMT 11 03 04 |
| 204.35 | 257.65 | 11 | 1/4 | C8 | 3 | 826-257TC11-C8HP | 80.00 | 26.65 | 137.00 | 104.00 | 195.00 | 70 | 7.630 | 1 | TCMT 11 03 04 |
| 254.35 | 307.65 | 11 | 1/4 | C6 | 3 | 826-307TC11-C6HP | 63.00 | 26.65 | 125.00 | 104.00 | 245.00 | 70 | 4.240 | 1 | TCMT 11 03 04 |
| 254.35 | 307.65 | 11 | 1/4 | C8 | 3 | 826-307TC11-C8HP | 80.00 | 26.65 | 137.00 | 104.00 | 245.00 | 70 | 8.720 | 1 | TCMT 11 03 04 |

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about use of slide extensions, see page K92

For more information about external boring, see page K94

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

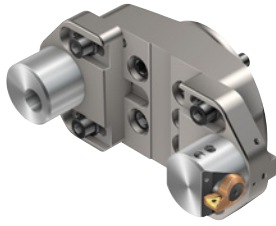


K90



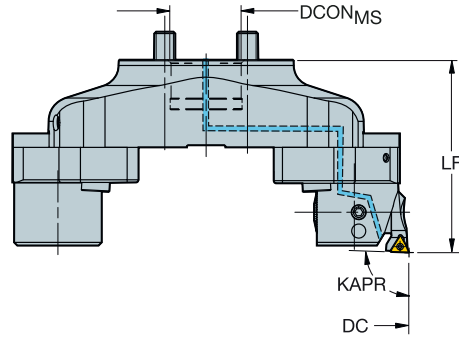
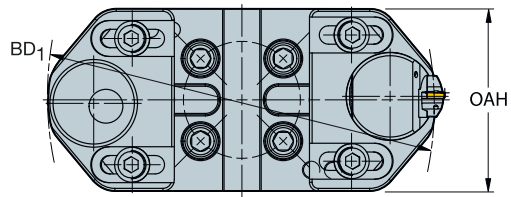
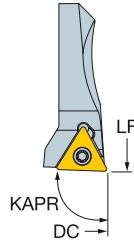
CoroBore® 825 XL lightweight fine boring tool

Arbor - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | Dimensions, mm | | | | | | | | | | | |
|--------|--------|----|-------------------|------|----------------|--------------------|----------------------|--------|--------|-----------------|-----|-------|------|---------------|--|--|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{ROL} | LF | OAH | BD ₁ | BAR | KG | CICT | MIID | | |
| 148.00 | 215.00 | 11 | 40S | 1 | 825L-215TC11 | 40.00 | 33.50 | 110.00 | 104.00 | 145.00 | 70 | 4.450 | 1 | TCMT 11 03 04 | | |
| 198.00 | 265.00 | 11 | 40S | 1 | 825L-265TC11 | 40.00 | 33.50 | 110.00 | 104.00 | 195.00 | 70 | 4.920 | 1 | TCMT 11 03 04 | | |
| 248.00 | 315.00 | 11 | 40S | 1 | 825L-315TC11 | 40.00 | 33.50 | 110.00 | 104.00 | 245.00 | 70 | 5.370 | 1 | TCMT 11 03 04 | | |

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

For more information about external boring, see page K94

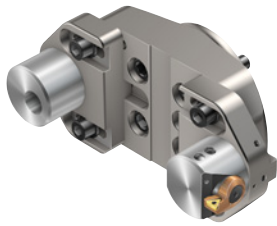
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



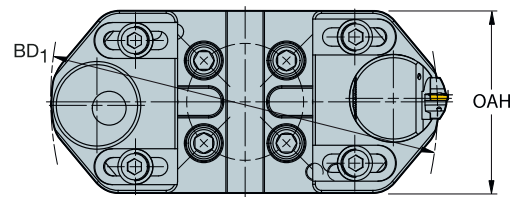
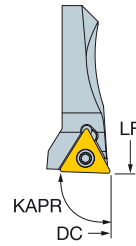
CoroBore® 826 XL lightweight fine boring tool

Arbor - Internal coolant supply

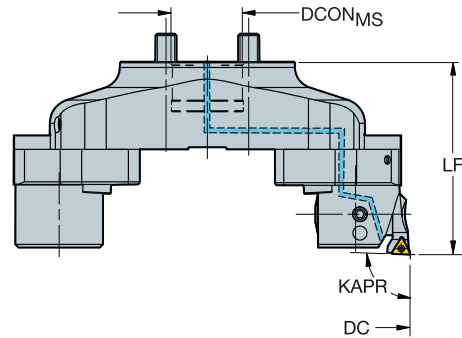


KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



| | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|----------------|--------------------|-----|----------------------|--------|--------|-----------------|----|-------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ISO | ADJLX _{RDL} | LF | OAH | BD ₁ | | | CICT | MID |
| 154.35 | 207.65 | 11 | 40S | 1 | 826L-207TC11HP | 40.00 | C | 26.65 | 117.00 | 104.00 | 145.00 | 70 | 3.310 | 1 | TCMT 11 03 04 |
| 204.35 | 257.65 | 11 | 40S | 1 | 826L-257TC11HP | 40.00 | C | 26.65 | 117.00 | 104.00 | 195.00 | 70 | 3.650 | 1 | TCMT 11 03 04 |
| 254.35 | 307.65 | 11 | 40S | 1 | 826L-307TC11HP | 40.00 | C | 26.65 | 117.00 | 104.00 | 245.00 | 70 | 4.320 | 1 | TCMT 11 03 04 |

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

Diameters are valid when frontboring.

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

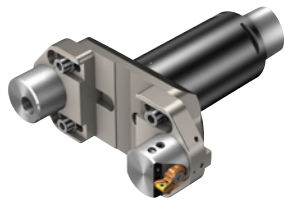


K90



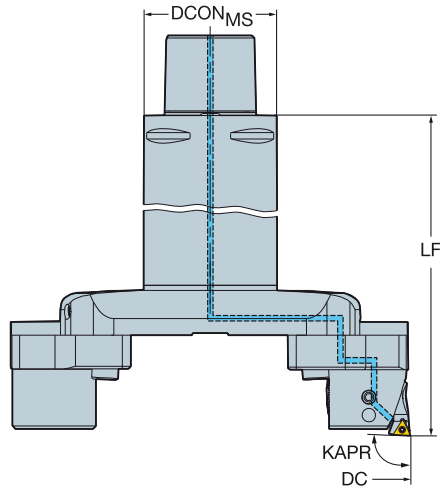
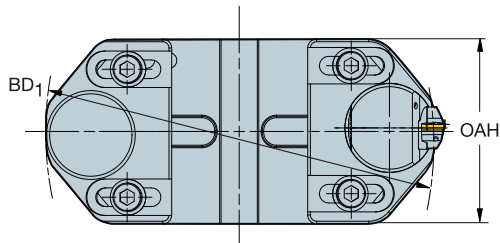
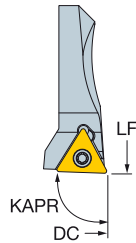
CoroBore® 825 XL lightweight fine boring tool

Coromant Capto® - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|-----------------|--------------------|----------------------|--------|--------|-----------------|-----|-------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | OAH | BD ₁ | BAR | KG | CICT | MIID |
| 148.00 | 215.00 | 11 | C8 | 3 | 825L-215TC11-C8 | 80.00 | 33.50 | 230.00 | 104.00 | 145.00 | 70 | 7.640 | 1 | TCMT 11 03 04 |
| 198.00 | 265.00 | 11 | C8 | 3 | 825L-265TC11-C8 | 80.00 | 33.50 | 230.00 | 104.00 | 195.00 | 70 | 8.320 | 1 | TCMT 11 03 04 |
| 248.00 | 315.00 | 11 | C8 | 3 | 825L-315TC11-C8 | 80.00 | 33.50 | 230.00 | 104.00 | 245.00 | 70 | 8.680 | 1 | TCMT 11 03 04 |

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

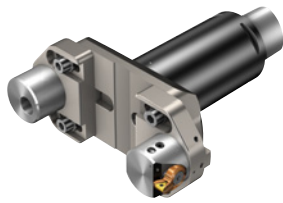
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



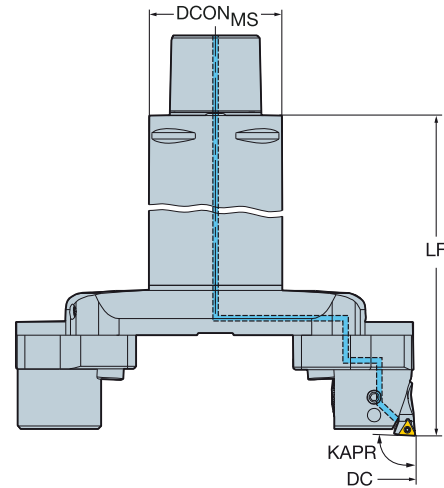
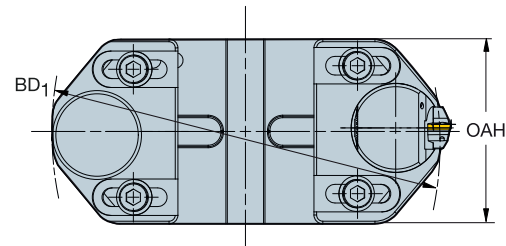
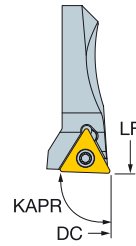
CoroBore® 826 XL lightweight fine boring tool

Coromant Capto® - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|-------------------|--------------------|----------------------|--------|--------|-----------------|----|-------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | OAH | BD ₁ | | | CICT | MIID |
| 154.35 | 207.65 | 11 | C8 | 3 | 826L-207TC11-C8HP | 80.00 | 26.65 | 237.00 | 104.00 | 145.00 | 70 | 6.300 | 1 | TCMT 11 03 04 |
| 204.35 | 257.65 | 11 | C8 | 3 | 826L-257TC11-C8HP | 80.00 | 26.65 | 237.00 | 104.00 | 195.00 | 70 | 6.660 | 1 | TCMT 11 03 04 |
| 254.35 | 307.65 | 11 | C8 | 3 | 826L-307TC11-C8HP | 80.00 | 26.65 | 237.00 | 104.00 | 245.00 | 70 | 7.030 | 1 | TCMT 11 03 04 |

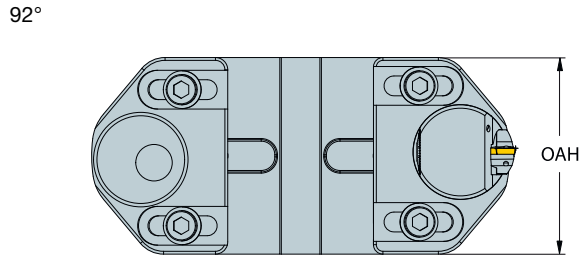
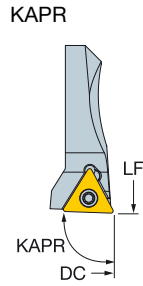
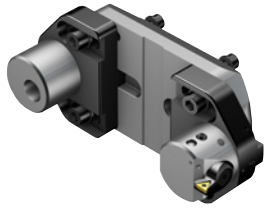
Backboring is not recommended with CoroBore® 826
 For more information about external boring, see page K94
 For more information about use of slide extensions, see page K90
 Diameters are valid when frontboring.
 For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue



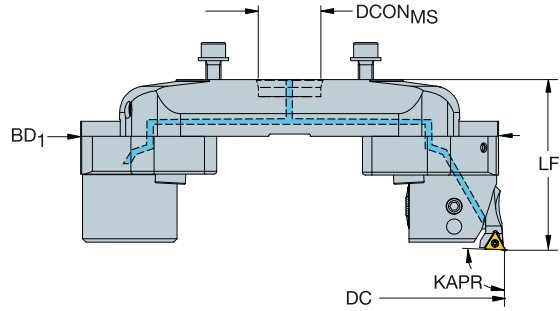
CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply

Dedicated for Silent Tools boring



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



| | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|----------------|--------------------|----------------------|-------|--------|-----------------|----|-------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | OAH | BD ₁ | | | CICT | MIID |
| 148.00 | 215.00 | 11 | 33 | 1 | 825D-215TC11 | 33.00 | 33.50 | 90.00 | 104.00 | 145.00 | 70 | 2.620 | 1 | TCMT 11 03 04 |
| 198.00 | 265.00 | 11 | 33 | 1 | 825D-265TC11 | 33.00 | 33.50 | 90.00 | 104.00 | 195.00 | 70 | 2.940 | 1 | TCMT 11 03 04 |
| 248.00 | 315.00 | 11 | 33 | 1 | 825D-315TC11 | 33.00 | 33.50 | 90.00 | 104.00 | 245.00 | 70 | 4.190 | 1 | TCMT 11 03 04 |

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see page K77.

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



K77



N23



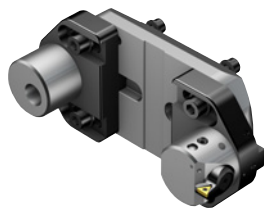
N15



K90

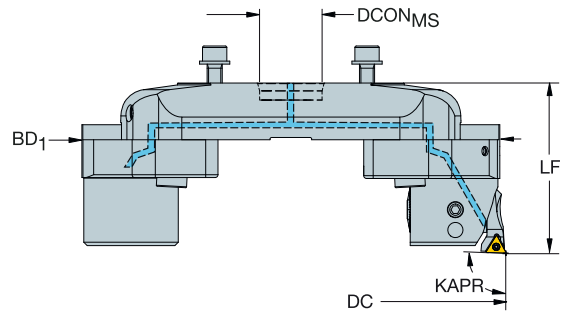
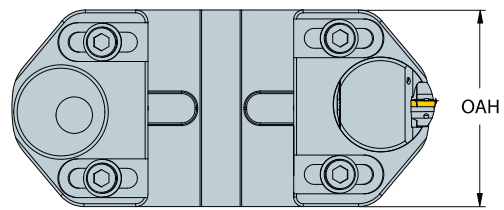
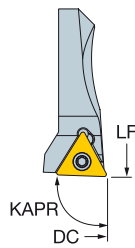
CoroBore® 826 XL fine boring tool

Arbor - Internal coolant supply
Dedicated for Silent Tools boring



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

| | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|----|-------------------|------|----------------|--------------------|----------------------|-------|--------|-----------------|----|-------|------|---------------|--|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | OAH | BD ₁ | | | CICT | MIID | |
| 154.35 | 207.65 | 11 | 33 | 1 | 826D-207TC11HP | 33.00 | 26.65 | 97.00 | 104.00 | 145.00 | 70 | 2.770 | 1 | TCMT 11 03 04 | |
| 204.35 | 257.65 | 11 | 33 | 1 | 826D-257TC11HP | 33.00 | 26.65 | 97.00 | 104.00 | 195.00 | 70 | 3.110 | 1 | TCMT 11 03 04 | |
| 254.35 | 307.65 | 11 | 33 | 1 | 826D-307TC11HP | 33.00 | 26.65 | 97.00 | 104.00 | 245.00 | 70 | 3.470 | 1 | TCMT 11 03 04 | |

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see page K77.

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



K77



N23



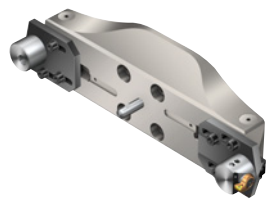
N15



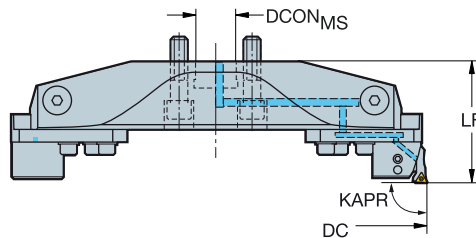
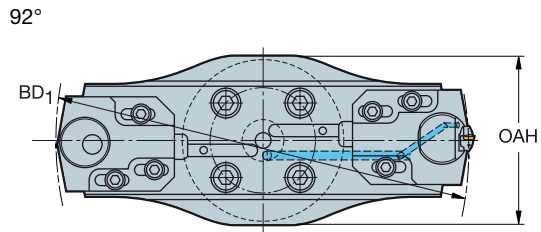
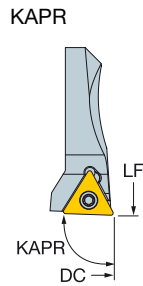
K90

CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



| | | | | | Dimensions, mm | | | | | | | | | | |
|--------|--------|----|-------------------|------|----------------|--------------------|----------------------|--------|--------|-----------------|----|--------|------|---------------|--|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{ROL} | LF | OAH | BD ₁ | | | CICT | MIID | |
| 298.00 | 395.00 | 11 | 40X | 1 | 825-395TC11 | 40.00 | 48.50 | 114.00 | 164.00 | 295.00 | 70 | 10.385 | 1 | TCMT 11 03 04 | |
| 378.00 | 475.00 | 11 | 40X | 1 | 825-475TC11 | 40.00 | 48.50 | 119.00 | 164.00 | 375.00 | 70 | 12.280 | 1 | TCMT 11 03 04 | |
| 458.00 | 555.00 | 11 | 40X | 1 | 825-555TC11 | 40.00 | 48.50 | 124.00 | 164.00 | 455.00 | 70 | 16.400 | 1 | TCMT 11 03 04 | |

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

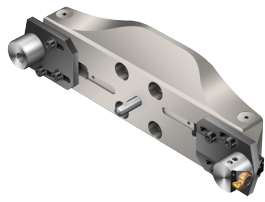
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



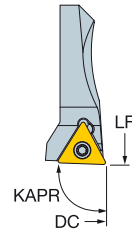
CoroBore® 826 XL fine boring tool

Arbor - Internal coolant supply

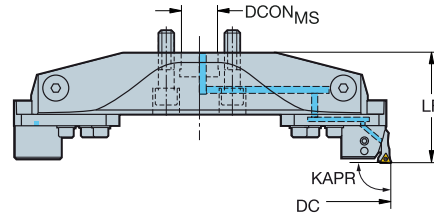
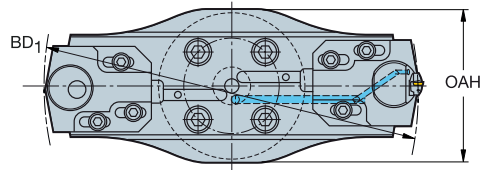


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR



92°



| | | | | | | | Dimensions, mm | | | | | | | | |
|--------|--------|----|-----|-------------------|------|---------------|--------------------|----------------------|--------|--------|-----------------|----|--------|------|---------------|
| DCN | DCX | | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{BDL} | LF | OAH | BD ₁ | | | CICT | MIID |
| 304.35 | 387.65 | 11 | 1/4 | 40X | 1 | 826-387TC11HP | 40.00 | 41.65 | 121.00 | 164.00 | 295.00 | 70 | 8.870 | 1 | TCMT 11 03 04 |
| 384.35 | 467.65 | 11 | 1/4 | 40X | 1 | 826-467TC11HP | 40.00 | 41.65 | 126.00 | 164.00 | 375.00 | 70 | 10.400 | 1 | TCMT 11 03 04 |
| 464.35 | 547.65 | 11 | 1/4 | 40X | 1 | 826-547TC11HP | 40.00 | 41.65 | 131.00 | 164.00 | 455.00 | 70 | 12.340 | 1 | TCMT 11 03 04 |

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



K76



N23



N15



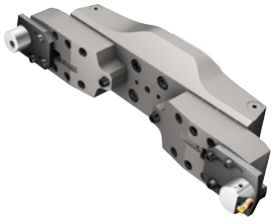
K90



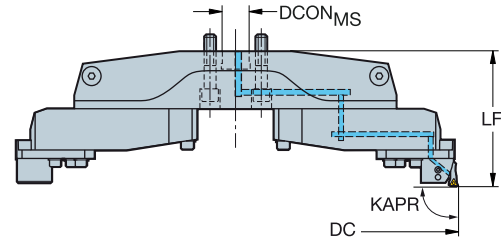
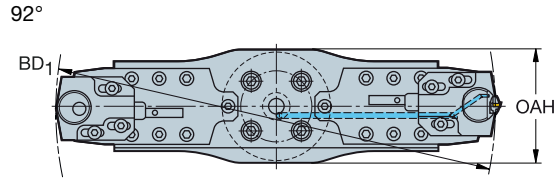
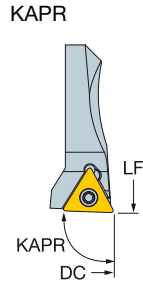
CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply

With bridge extension



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



| | | | | | Dimensions, mm | | | | | | | | | |
|---------|---------|----|-------------------|------|----------------|--------------------|----------------------|--------|--------|-----------------|----|--------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{TOL} | LF | OAH | BD ₁ | | | CICT | MIID |
| 538.00 | 795.00 | 11 | 40X | 1 | 825-795TC11 | 40.00 | 128.50 | 198.00 | 164.00 | 535.00 | 70 | 25.640 | 1 | TCMT 11 03 04 |
| 778.00 | 1035.00 | 11 | 40X | 1 | 825-1035TC11 | 40.00 | 128.50 | 218.00 | 164.00 | 775.00 | 70 | 36.830 | 1 | TCMT 11 03 04 |
| 1018.00 | 1275.00 | 11 | 40X | 1 | 825-1275TC11 | 40.00 | 128.50 | 218.00 | 164.00 | 1015.00 | 70 | 44.260 | 1 | TCMT 11 03 04 |

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

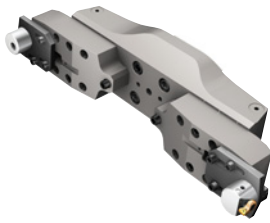
For inserts, see Turning tools catalogue



CoroBore® 826 XL fine boring tool

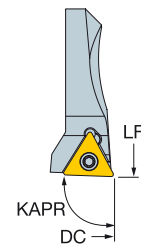
Arbor - Internal coolant supply

With bridge extension

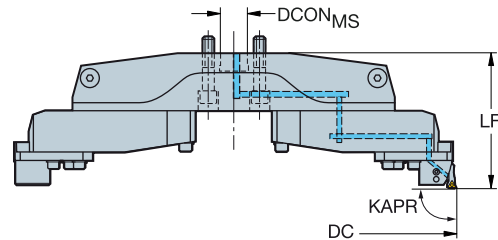
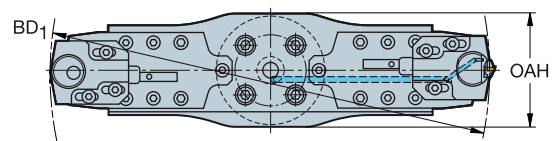


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR



92°



| | | | | | Dimensions, mm | | | | | | | | | | | |
|---------|---------|----|-------------------|------|----------------|--------------------|----------------------|--------|--------|-----------------|----|--------|------|---------------|--|--|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LF | OAH | BD ₁ | | | CICT | MIID | | |
| 544.35 | 787.65 | 11 | 40X | 1 | 826-787TC11HP | 40.00 | 121.65 | 205.00 | 164.00 | 535.00 | 70 | 24.430 | 1 | TCMT 11 03 04 | | |
| 784.35 | 1027.65 | 11 | 40X | 1 | 826-1027TC11HP | 40.00 | 121.65 | 225.00 | 164.00 | 775.00 | 70 | 35.060 | 1 | TCMT 11 03 04 | | |
| 1024.35 | 1267.65 | 11 | 40X | 1 | 826-1267TC11HP | 40.00 | 121.65 | 225.00 | 164.00 | 1015.00 | 70 | 44.110 | 1 | TCMT 11 03 04 | | |

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



K76



N23



N15



K90

Face grooving

| | Diameter range, mm | Hole tolerance | Cutting edges | Operation | Insert choice | Machine side interface | Page |
|---|--------------------|----------------|-----------------------------|-----------------|-----------------|---|---------|
| CoroCut® MB  | 14-50 | IT7 | 1 | - Face grooving | - CoroCut® MB | - Coromant Capto® | K67 |
| CoroBore® 825 SL  | 47-150 | IT7 | 1 | - Face grooving | - CoroCut® | - Coromant Capto® | K68-K69 |
| CoroBore® 825 SL XL  | 148-1275 | IT7 | 1 | - Face grooving | - CoroCut® | - Coromant Capto® - 40X with 4 bolt circle | K70 |
| SpiroGrooving™  | 30-289 | | 1 (Internal and external) | - Spirogrooving | - CoroTurn® 107 | - Coromant Capto® | K71-K73 |

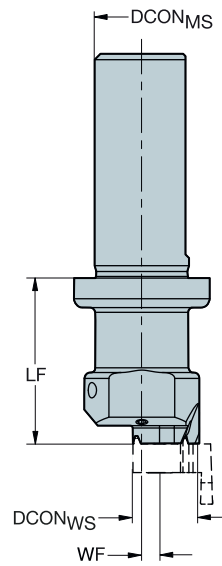
Cylindrical shank to CoroCut® MB adaptor

For face grooving

Internal coolant supply



MB...FA



| | | | | Dimensions, mm | | | | | | |
|-------------------|-------------------|------|---------------------|--------------------|--------------------|-------|-------|-----|-------|--|
| CZC _{MS} | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | WF | BAR | KG | |
| 16 | 09 | 1 | R429U-A16-14032MB09 | 16.00 | 9.00 | 32.00 | -2.00 | 20 | 0.115 | |
| 16 | 09 | 1 | R429U-A16-19030MB09 | 16.00 | 9.00 | 30.00 | 0.50 | 20 | 0.114 | |
| 16 | 09 | 1 | R429U-A16-24028MB09 | 16.00 | 9.00 | 28.00 | 3.00 | 20 | 0.120 | |
| 16 | 09 | 1 | R429U-A16-29026MB09 | 16.00 | 9.00 | 26.00 | 5.50 | 20 | 0.120 | |
| 16 | 09 | 1 | R429U-A16-34024MB09 | 16.00 | 9.00 | 24.00 | 8.00 | 20 | 0.129 | |
| 16 | 09 | 1 | R429U-A16-39022MB09 | 16.00 | 9.00 | 22.00 | 10.50 | 20 | 0.145 | |
| 16 | 09 | 1 | R429U-A16-44020MB09 | 16.00 | 9.00 | 20.00 | 13.00 | 20 | 0.153 | |

For CoroCut® MB cutting tools, see Turning tools catalogue

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

Recommended adaptors:

A16: 391.37A



L2



N23



N15

CoroBore® 825 SL

Face grooving

Application

- Face grooving
- Axial grooving

ISO application area:



Benefits and features

- Increased productivity compared to milling
- Excellent chip control thanks to internal coolant to the cutting edge
- Builds on our large assortment of standard CoroTurn® SL heads and CoroCut system 1-2 inserts. (Type left hand, A-curve)
- Radial fine-adjustable face grooving heads for pre-setting
- Rigid design with dedicated tools for small and large diameter face grooving
- Internal coolant



Tools

Couplings:

- Coromant Capto®
- Arbor

Inserts

- CoroCut® 1-2 system inserts
- Dedicated grades and geometries for all materials

CoroTurn® SL head and inserts are ordered separately.

825 - Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.



First choice geometries: -CM or -TF depending on chosen nose radius. Recommended starting value for feed: 0.15 mm/rev

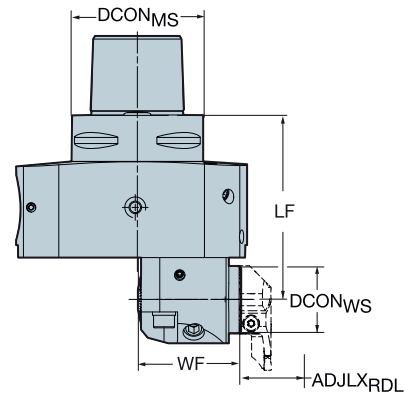
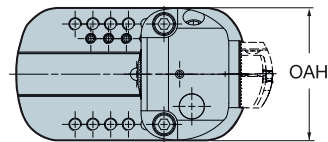
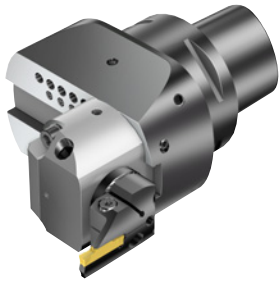
If grooves with larger width tolerance is required, chose -GF geometry. Recommended starting value for feed: 0.10 mm/rev



Radially fine adjustable face grooving heads for pre-setting with same interface as CoroBore 825 fine boring head

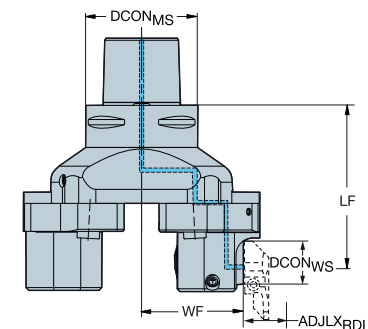
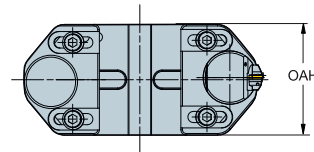
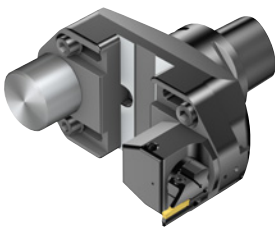
Coromant Capto® to CoroTurn® SL adjustable adaptor

Coromant Capto® - Internal coolant supply



CoroBore® 825 fine adjustment

| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|----------------|--------------------|--------------------|-----------------------|-------|--------|------|-------|--------|-----|-------|
| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLXR _D L | LF | LPR | WF | OAH | OAW | BAR | KG |
| C6 | 32 | 3 | 825-150SL32-C6 | 63.00 | 32.00 | 51.50 | 88.00 | 109.00 | 5.50 | 63.40 | 106.00 | 20 | 4.320 |
| C8 | 32 | 3 | 825-150SL32-C8 | 80.00 | 32.00 | 51.50 | 96.00 | 117.00 | 5.50 | 80.40 | 106.00 | 20 | 5.470 |



CoroBore® 825 XL

| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|----------------|--------------------|--------------------|-----------------------|--------|--------|--------|--------|--------|-----|--------|
| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLXR _D L | LF | LPR | WF | OAH | OAW | BAR | KG |
| C8 | 32 | 3 | 825-215SL32-C8 | 80.00 | 32.00 | 33.50 | 112.00 | 133.00 | 56.00 | 104.00 | 130.00 | 20 | 8.040 |
| C8 | 32 | 3 | 825-265SL32-C8 | 80.00 | 32.00 | 33.50 | 112.00 | 133.00 | 81.00 | 104.00 | 180.00 | 20 | 9.120 |
| C8 | 32 | 3 | 825-315SL32-C8 | 80.00 | 32.00 | 33.50 | 112.00 | 133.00 | 106.00 | 104.00 | 230.00 | 20 | 10.750 |

CoroTurn® SL head diameter and tool diameter range should match the requirement of the component. For more information about CoroTurn® SL heads, see Turning tools catalogue

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com



L2



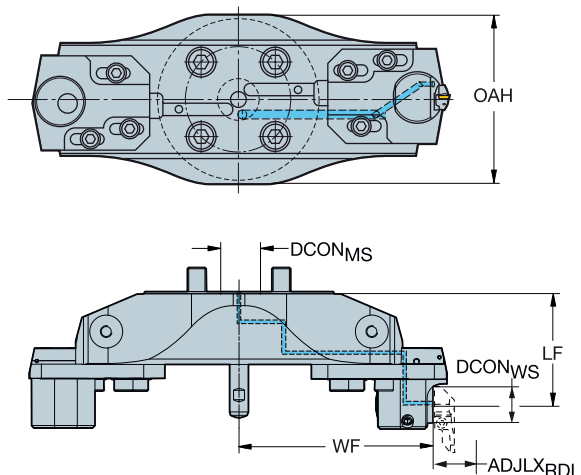
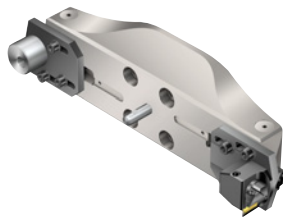
N23



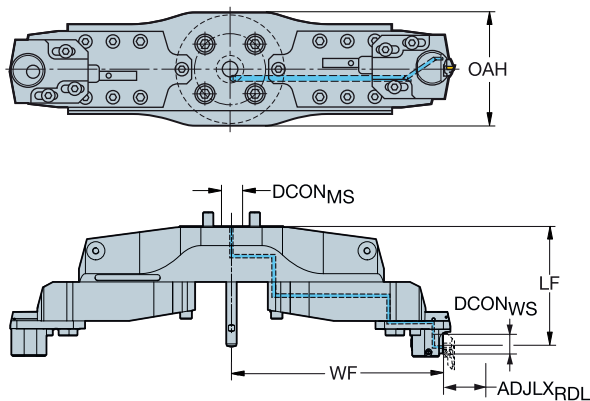
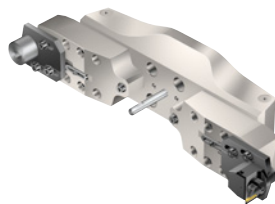
N15

Arbor to CoroTurn® SL adjustable adaptor

Arbor - Internal coolant supply



| | | | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|------|---------------|--------------------|--------------------|----------------------|--------|--------|--------|--------|--------|-----|--------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLX _{RDL} | LF | LPR | WF | OAH | OAW | BAR | KG | | |
| 40X | 32 | 1 | 825-395SL32 | 40.00 | 32.00 | 48.50 | 96.00 | 117.00 | 131.00 | 164.00 | 334.00 | 20 | 8.980 | | |
| 40X | 32 | 1 | 825-475SL32 | 40.00 | 32.00 | 48.50 | 101.00 | 122.00 | 171.00 | 164.00 | 414.00 | 20 | 12.830 | | |
| 40X | 32 | 1 | 825-555SL32 | 40.00 | 32.00 | 48.50 | 106.00 | 127.00 | 211.00 | 104.00 | 494.00 | 20 | 12.670 | | |



With bridge extension

| | | | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|------|---------------|--------------------|--------------------|----------------------|--------|--------|--------|--------|---------|-----|--------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLX _{RDL} | LF | LPR | WF | OAH | OAW | BAR | KG | | |
| 40X | 32 | 1 | 825-1035SL32 | 40.00 | 32.00 | 128.50 | 200.00 | 221.00 | 371.00 | 164.00 | 838.00 | 20 | 36.310 | | |
| 40X | 32 | 1 | 825-1275SL32 | 40.00 | 32.00 | 128.50 | 200.00 | 221.00 | 491.00 | 164.00 | 1078.00 | 20 | 43.740 | | |
| 40X | 32 | 1 | 825-795SL32 | 40.00 | 32.00 | 128.50 | 180.00 | 201.00 | 251.00 | 164.00 | 598.00 | 20 | 25.120 | | |

CoroTurn® SL head diameter and tool diameter range should match the requirement of the component. For more information about CoroTurn® SL heads, see Turning tools catalogue

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.
 In case of direct flange to the machine spindle, use centering plug, see page K77
 For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com



K76



N23



N15

SpiroGrooving™

Machining of seal ring grooves with maximum productivity

Application

- All 23°, R-RX and BX grooves
- Not to be used for 45° chamfer on the outer flank on BX grooves
- The SpiroGrooving™ software is required
- Recommended to programming 'mid-tolerance' sizes for depth & diameter.
- Transfer the generated NC-code to the machine control

ISO application area:



Benefits and features

Process security

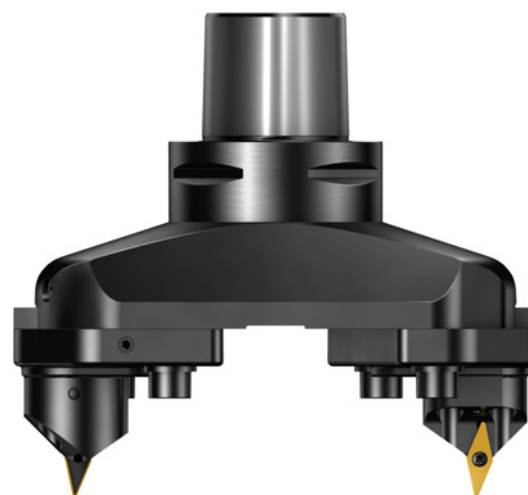
- Controlled chip breakage with SpiroGrooving™ tool path
- Internal coolant
- Vibration-free

High productivity

- High machine utilization due to good chip control
- Highly efficient machining method
- Reduced cutting time through higher cutting data

Quick and easy programming

- SpiroGrooving™ calculator for NC-code generation
- Strong modular base for building assemblies in different application (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)



www.sandvik.coromant.com/spirogrooving

Tools

- Coromant Capto®
- Built on CoroBore® XL - rigid and reliable system for maximum stability
- Cartridges available with axial and radial adjustability



Inserts

- CoroTurn® 107 inserts (VCMT) for size 30-75 mm
- CoroTurn® 107 inserts (VBMT) for size 48-289 mm

SpiroGrooving uses a circular spirograph tool movement in a taper. This reduces chip thickness, enabling light cutting action and increased feed. Parts of the insert cutting edge have an interrupted cutting behaviour, eliminating long chips tangling to the tool and spindle.

SpiroGrooving is a unique solution for secure and productive machining of seal ring grooves on non-rotating components. Get the complete package for this unique machining method with tools and NC-code generator.

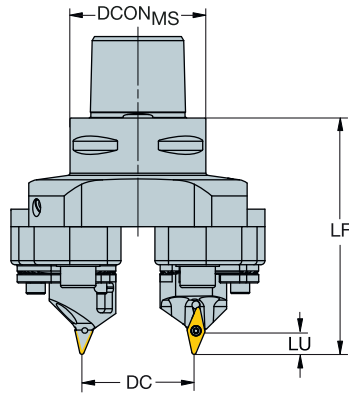
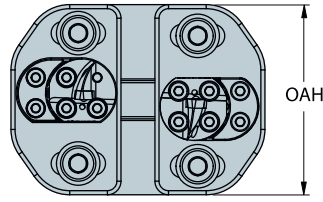
Wondering how to program?

With the SpiroGrooving NC-code generator you can get your NC code in a few quick steps.
NC-code generator – input groove geometry and cutting parameters and receive an NC-code

CoroBore® XL adjustable tool for SpiroGrooving™

Coromant Capto® - Internal coolant supply

KAPR 67°



VCMT

Radially and axially adjustable

| | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------|----|-------------------|------|----------------|--------------------|----------------------|------|-------|-------|-----|-------|------|---------------|
| DCN | DCX | | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{FDL} | LU | LF | OAH | BAR | KG | CICT | MIID |
| 30.00 | 75.60 | 11 | C5 | 1 | 820-75VC11X-C5 | 50.00 | 22.80 | 9.00 | 87.00 | 70.00 | 80 | 2.655 | 1 | VBMT 11 03 04 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
 For inserts, see Turning tools catalogue

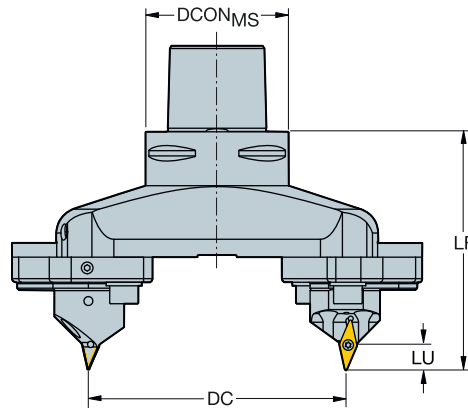
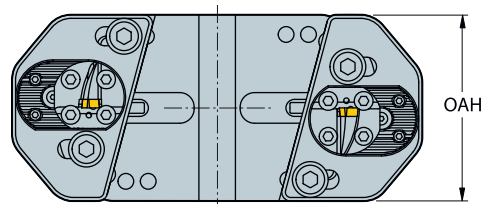
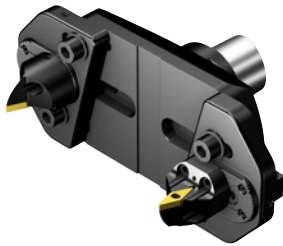


CoroBore® XL adjustable tool for SpiroGrooving™

Coromant Capto® - Internal coolant supply


KAPR

67°



 VBMT

Radially and axially adjustable

| | | | | | | Dimensions, mm | | | | | | | | | |
|--------|--------|---|-------------------|------|-----------------|--------------------|----------------------|-------|--------|--------|-----|-------|------|---------------|--|
| DCN | DCX |  | CZC _{MS} | CNSC | Ordering code | DCON _{MS} | ADJLX _{RDL} | LU | LF | OAH | BAR | KG | CICT | MIID | |
| 48.00 | 139.60 | 16 | C6 | 1 | 820-139VB16X-C6 | 63.00 | 45.80 | 15.00 | 121.00 | 104.00 | 80 | 5.060 | 1 | VBMT 16 04 08 | |
| 48.00 | 139.60 | 16 | C8 | 1 | 820-139VB16X-C8 | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 6.390 | 1 | VBMT 16 04 08 | |
| 98.00 | 189.60 | 16 | C6 | 1 | 820-189VB16X-C6 | 63.00 | 45.80 | 15.00 | 121.00 | 104.00 | 80 | 6.210 | 1 | VBMT 16 04 08 | |
| 98.00 | 189.60 | 16 | C8 | 1 | 820-189VB16X-C8 | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 7.620 | 1 | VBMT 16 04 08 | |
| 148.00 | 239.60 | 16 | C8 | 1 | 820-239VB16X-C8 | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 8.820 | 1 | VBMT 16 04 08 | |
| 198.00 | 289.60 | 16 | C8 | 1 | 820-289VB16X-C8 | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 9.860 | 1 | VBMT 16 04 08 | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue



L2



N23



N15

Interpolation turning

Turning the unturnable

Application

Interpolation turning is a new, flexible turning method developed for advanced machining centres and B-axis multi-task machines.

ISO application area:



Benefits and features

- Flexible solution, making it possible to use machining centres with modular tool set-ups instead of dedicated boring machines with U- or W-axis facing heads
- The component can be machined completely without moving it - especially beneficial for large non-symmetrical components
- Reduced tool investment cost
- Built on CoroBore® XL - rigid and reliable system for maximum stability for building assemblies in different application (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)

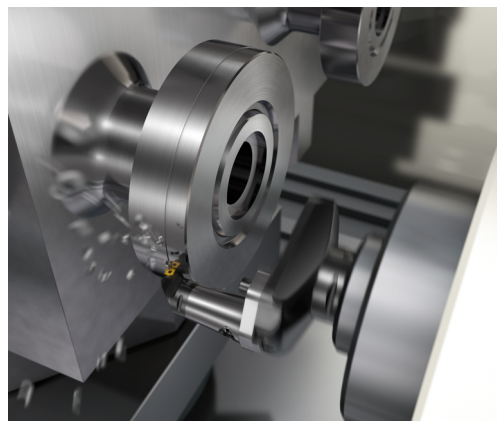


Tools

- Coromant Capto®

Inserts

- CoroTurn® 107

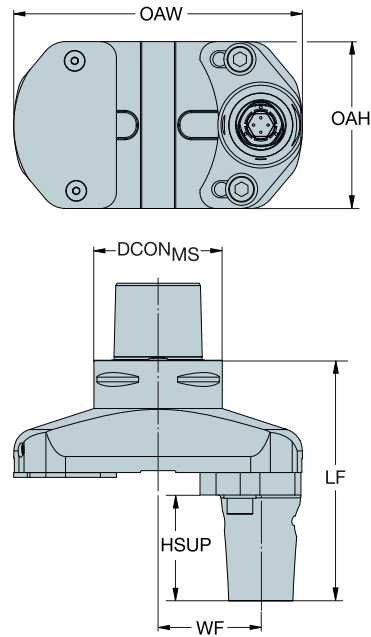
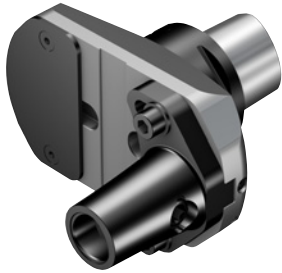


Component can be machined completely without moving it - especially beneficial for large non-symmetrical components

Coromant Capto® adjustable adaptor with Quick change

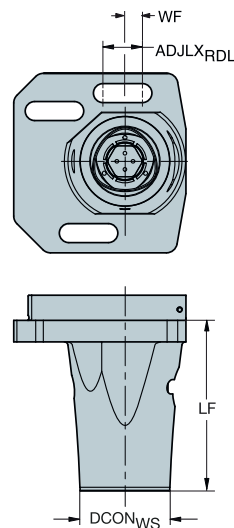
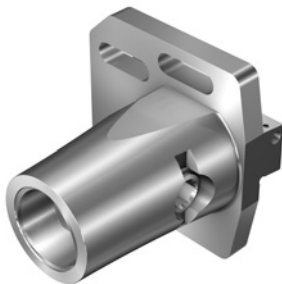
For Interpolation Turning

Internal coolant supply



| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|-----------------|--------------------|--------------------|----------------------|--------|-------|--------|--------|-----|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | ADJLX _{RDL} | LF | WF | OAH | OAW | BAR | KG | |
| C8 | C4 | 3 | 820-100C4-QC-C8 | 80.00 | 40.00 | 26.00 | 150.00 | 51.00 | 104.00 | 180.00 | 70 | 7.090 | |
| C8 | C4 | 3 | 820-150C4-QC-C8 | 80.00 | 40.00 | 51.00 | 150.00 | 51.00 | 104.00 | 230.00 | 70 | 9.430 | |
| C8 | C4 | 3 | 820-50C4-QC-C8 | 80.00 | 40.00 | 13.50 | 150.00 | 38.50 | 104.00 | 130.00 | 70 | 5.860 | |

Slide for CoroBore® XL



| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|--------------------|--------------------|----------------------|-------|------|--------|-------|-----|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{WS} | ADJLX _{RDL} | LF | WF | OAH | OAW | BAR | KG | | |
| S24R | C5 | 4 | S24-R820XLC5QC-095 | 50.00 | 22.00 | 95.00 | 9.75 | 100.00 | 96.00 | 70 | 2.350 | | |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For cutting heads and inserts, see Turning tools catalogue



L2



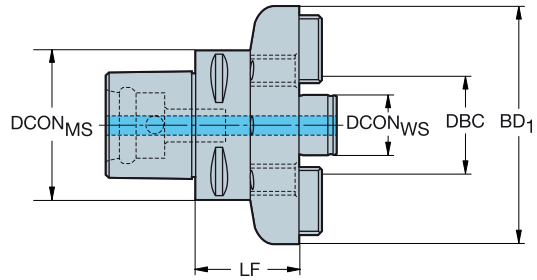
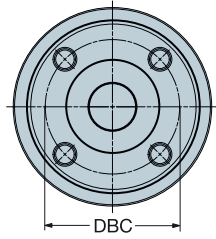
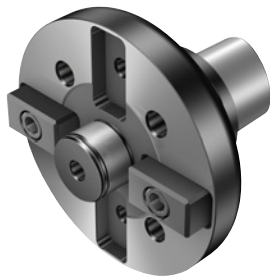
N23



N15

Coromant Capto® to CoroBore® XL adaptor

Internal coolant supply

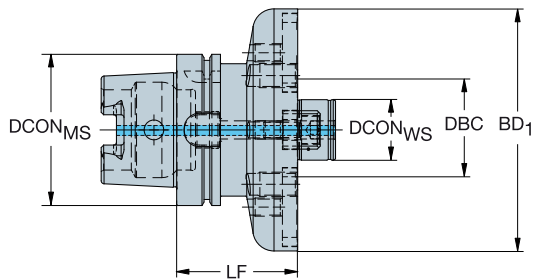
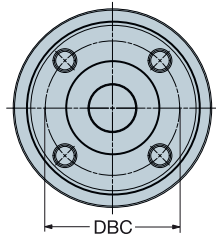
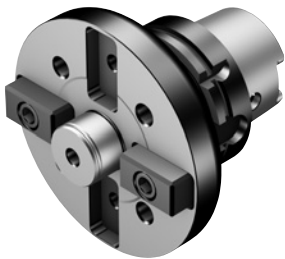


Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LF | BD ₁ | BAR | KG |
|-------------------|-------------------|------|------|-------------------|--------------------|-------|--------------------|------|-----------------|-----|------|
| C8 | 40X | 1 | 1 | C8-391.XL-40 065 | 80.0 | 101.6 | 40.0 | 65.0 | 160.0 | 80 | 7.09 |
| C10 | 40X | 1 | 1 | C10-391.XL-40 070 | 100.0 | 101.6 | 40.0 | 70.0 | 160.0 | 80 | 8.67 |

HSK to CoroBore® XL adaptor

Internal coolant supply

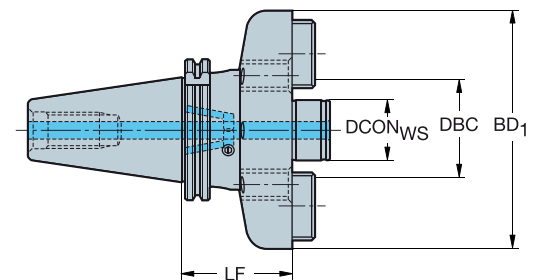
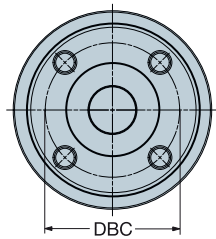


Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LF | BD ₁ | BAR | KG |
|-------------------|-------------------|------|------|------|---------------------|--------------------|-------|--------------------|------|-----------------|-----|------|
| 100 | 40X | 1 | 1 | 1 | 392.410XL-10040 080 | 100.0 | 101.6 | 40.0 | 80.0 | 160.0 | 80 | 8.16 |

ISO 7388-1 to CoroBore® XL adaptor

Internal coolant supply



ISO7388.1/MAS-BT 403

Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DBC | DCON _{WS} | LF | LB ₁ | BD ₁ | BAR | KG |
|-------------------|-------------------|------|------|------|--------------------|-------|--------------------|------|-----------------|-----------------|-----|------|
| 50 | 40X | 7 | 1 | 1 | 392.644XL-5040 075 | 101.6 | 40.0 | 75.0 | 75.0 | 160.0 | 80 | 8.46 |
| | 40X | 7 | 1 | 1 | 392.646XL-5040 080 | 101.6 | 40.0 | 80.0 | 80.0 | 160.0 | 80 | 8.46 |

All CoroBore XL solid holders have ground backside of flange and threads for the option to mount a shim to increase stability if needed. Shim needs to be ordered separately and ground to fit the specific machine and holder, see accessories page M12.



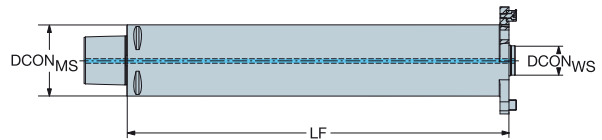
N23



N15

Coromant Capto® to CoroBore® XL damped tool body

Internal coolant supply



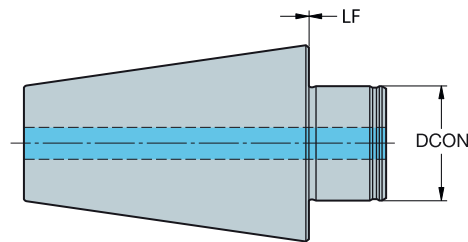
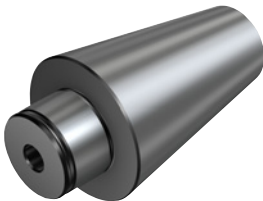
● ● ● ● SilentTools®

| | | | | Dimensions, mm | | | | |
|-------------------|-------------------|------|--------------------|--------------------|--------------------|--------|-----|--------|
| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | BAR | KG |
| C8 | 33 | 3 | C8-R822XLA33-F410 | 80.00 | 33.00 | 410.00 | 70 | 17.800 |
| C10 | 33 | 3 | C10-R822XLA33-F560 | 100.00 | 33.00 | 560.00 | 70 | 26.400 |

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
See page K27 for boring tool kit to be used with this adaptor

Centering plug

Internal coolant supply



ISO7388.1/MAS-BT 403

| | | | | Dimensions, mm | | | |
|-------------------|-------------------|------|------|----------------|-----|-----|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | LF | BAR | KG |
| 50 | 40 plug | 1 | 1 | 392.647XL-5040 | 0.0 | 80 | 8.93 |



L2



N23



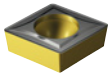
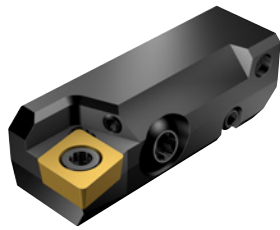
N15

Indexable boring cartridge

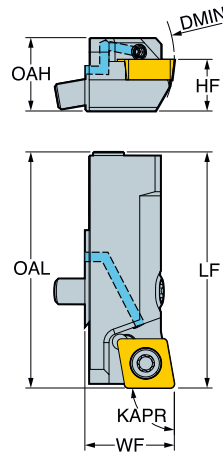
Axial and radial adjustment

KAPR

90°



 CCMT, CCGT
CCGX, CCET
 CCMW



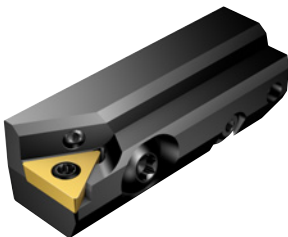
K



| | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|---------------|----------------------|----------------------|------|-------|-------|-------|-------|-------|----|-------|------|---------------|
| DMIN ₁ | CZC _{MS} | CNSC | Ordering code | ADJLX _{AVL} | ADJLX _{RDL} | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID | |
| 25.0 | 06 | 08CB | 2 | SCFCR08CBX06 | 0.50 | 0.20 | 40.00 | 8.00 | 13.50 | 12.20 | 40.00 | 70 | 0.050 | 1 | CCMT 06 02 04 |
| 40.0 | 09 | 10CB | 2 | SCFCR10CBX09 | 0.50 | 0.20 | 45.00 | 10.00 | 16.50 | 14.20 | 45.00 | 70 | 0.070 | 1 | CCMT 09 T3 08 |
| 50.0 | 12 | 12CB | 2 | SCFCR12CBX12 | 0.50 | 0.20 | 50.00 | 12.00 | 19.00 | 16.20 | 50.00 | 70 | 0.100 | 1 | CCMT 12 04 08 |

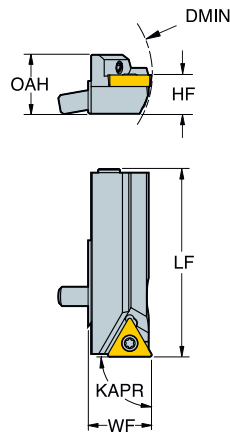
L

KAPR

90°



 TCMT, TCMX,
TCGT, TCGX
TCEX
 TCMW



M

| | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|---------------|----------------------|----------------------|------|-------|-------|-------|-------|-------|----|-------|------|---------------|
| DMIN ₁ | CZC _{MS} | CNSC | Ordering code | ADJLX _{AVL} | ADJLX _{RDL} | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID | |
| 25.0 | 09 | 08CB | 2 | STFCR08CBX09 | 0.50 | 0.20 | 40.00 | 8.00 | 13.50 | 12.20 | 40.00 | 70 | 0.050 | 1 | TCMT 09 02 04 |
| 40.0 | 11 | 10CB | 2 | STFCR10CBX11 | 0.50 | 0.20 | 45.00 | 10.00 | 16.50 | 14.20 | 45.00 | 70 | 0.070 | 1 | TCMT 11 03 04 |
| 50.0 | 16 | 12CB | 2 | STFCR12CBX16 | 0.50 | 0.20 | 50.00 | 12.00 | 19.00 | 16.20 | 50.00 | 70 | 0.100 | 1 | TCMT 16 T3 08 |

For inserts, see Turning tools catalogue

N



N23



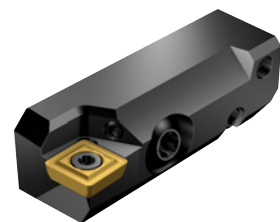
N15

Indexable boring cartridge

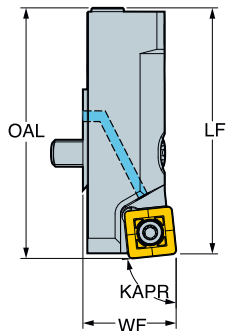
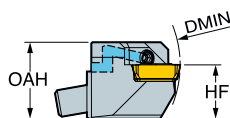
Axial and radial adjustment

KAPR

84°



SPMT



| | | Dimensions, mm | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|---------------|----------------------|----------------------|------|-------|-------|-------|-------|-------|----|-------|------|--------------|--|
| DMIN _i | CZC _{MS} | CNSC | Ordering code | ADJLX _{4YL} | ADJLX _{4DL} | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID | | |
| 25.0 | 06 | 08CB | 2 | SSYPR08CBX06 | 0.50 | 0.20 | 40.00 | 8.00 | 13.50 | 12.20 | 40.60 | 70 | 0.050 | 1 | SPMT 0606-BM | |
| 40.0 | 08 | 10CB | 2 | SSYPR10CBX08 | 0.50 | 0.20 | 45.00 | 10.00 | 16.50 | 14.20 | 45.80 | 70 | 0.070 | 1 | SPMT 0808-BM | |
| 50.0 | 12 | 12CB | 2 | SSYPR12CBX12 | 0.50 | 0.20 | 50.00 | 12.00 | 19.00 | 16.20 | 51.20 | 70 | 0.100 | 1 | SPMT 1210-BM | |



K32



N23

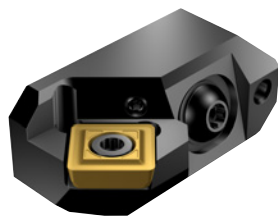


N15

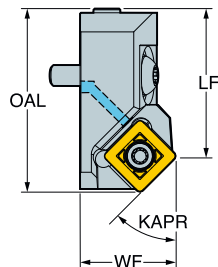
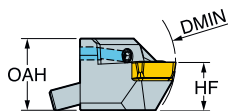
Indexable boring cartridge

Axial adjustment

KAPR 45°



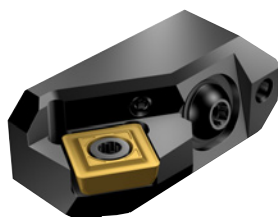
SPMT



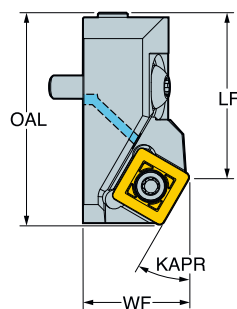
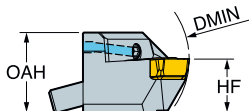
K

| DMIN ₁ | | CZC _{MS} | | CNSC | Ordering code | Dimensions, mm | | | | | | CICT | MIID | |
|----------------------|----|-------------------|----|--------------|---------------|----------------|-------|-------|-------|-------|----|-------|------|--------------|
| ADJLX _{AVL} | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID | | | | | |
| 20.0 | 06 | 06CC | 2 | SSSPR06CCX06 | 0.50 | 21.00 | 6.00 | 11.00 | 10.20 | 24.80 | 70 | 0.020 | 1 | SPMT 0606-BM |
| 25.0 | 08 | 08CC | 2 | SSSPR08CCX08 | 0.50 | 25.00 | 8.00 | 16.00 | 12.20 | 30.70 | 70 | 0.040 | 1 | SPMT 0808-BM |
| 40.0 | 12 | 10CC | 2 | SSSPR10CCX12 | 0.50 | 32.00 | 10.00 | 21.00 | 14.00 | 40.20 | 70 | 0.070 | 1 | SPMT 1210-BM |

KAPR 30°



SPMT



L

| DMIN ₁ | | CZC _{MS} | | CNSC | Ordering code | Dimensions, mm | | | | | | CICT | MIID | |
|----------------------|----|-------------------|----|--------------|---------------|----------------|-------|-------|-------|-------|----|-------|------|--------------|
| ADJLX _{AVL} | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID | | | | | |
| 20.0 | 06 | 06CC | 2 | SSTPR06CCX06 | 0.50 | 21.00 | 6.00 | 11.00 | 10.20 | 25.60 | 70 | 0.020 | 1 | SPMT 0606-BM |
| 25.0 | 08 | 08CC | 2 | SSTPR08CCX08 | 0.50 | 25.00 | 8.00 | 16.00 | 12.20 | 31.90 | 70 | 0.040 | 1 | SPMT 0808-BM |
| 40.0 | 12 | 10CC | 2 | SSTPR10CCX12 | 0.50 | 32.00 | 10.00 | 21.00 | 14.20 | 42.00 | 70 | 0.080 | 1 | SPMT 1210-BM |

For inserts, see Turning tools catalogue

M

N

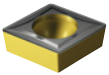
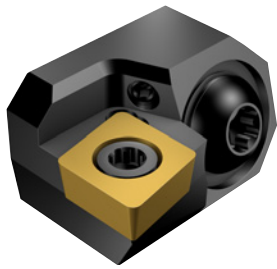


Indexable boring cartridge

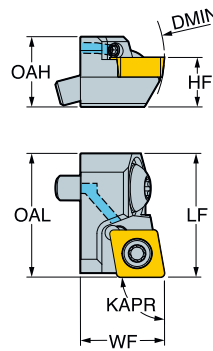
No adjustment

KAPR

90°



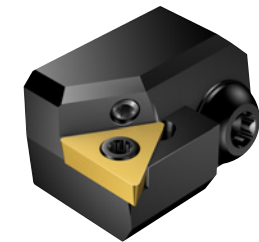
- CCMT, CCGT
CCGX, CCET
- CCMW



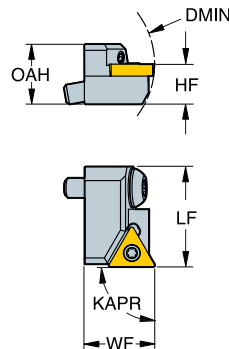
| | | Dimensions, mm | | | | | | | | | | | |
|-------------------|----|-------------------|------|---------------|-------|-------|-------|-------|-------|----|-------|------|---------------|
| DMIN ₁ | | CZC _{MS} | CNSC | Ordering code | LF | HF | WF | OAH | OAL | | | CICT | MIID |
| 20.0 | 06 | 06CD | 2 | STFCR06CDX06 | 16.00 | 6.00 | 11.00 | 10.20 | 16.00 | 70 | 0.020 | 1 | CCMT 06 02 04 |
| 25.0 | 06 | 08CD | 2 | STFCR08CDX06 | 20.00 | 8.00 | 14.00 | 12.20 | 20.00 | 70 | 0.030 | 1 | CCMT 06 02 04 |
| 40.0 | 09 | 10CD | 2 | STFCR10CDX09 | 25.00 | 10.00 | 17.00 | 14.20 | 25.00 | 70 | 0.050 | 1 | CCMT 09 T3 08 |
| 50.0 | 12 | 12CD | 2 | STFCR12CDX12 | 30.00 | 12.00 | 20.00 | 16.20 | 30.00 | 70 | 0.070 | 1 | CCMT 12 04 08 |

KAPR

90°



- TCMT, TCMX,
TCGT, TCGX
TCEX
- TCMW



| | | Dimensions, mm | | | | | | | | | | | |
|-------------------|----|-------------------|------|---------------|-------|-------|-------|-------|-------|----|-------|------|---------------|
| DMIN ₁ | | CZC _{MS} | CNSC | Ordering code | LF | HF | WF | OAH | OAL | | | CICT | MIID |
| 20.0 | 06 | 06CD | 2 | STFCR06CDX06 | 16.00 | 6.00 | 11.00 | 10.20 | 16.00 | 70 | 0.020 | 1 | TCMT 06 T1 02 |
| 25.0 | 09 | 08CD | 2 | STFCR08CDX09 | 20.00 | 8.00 | 14.00 | 12.20 | 20.00 | 70 | 0.030 | 1 | TCMT 09 02 04 |
| 40.0 | 11 | 10CD | 2 | STFCR10CDX11 | 25.00 | 10.00 | 17.00 | 14.20 | 25.00 | 70 | 0.050 | 1 | TCMT 11 03 04 |
| 50.0 | 16 | 12CD | 2 | STFCR12CDX16 | 30.00 | 12.00 | 20.00 | 16.20 | 30.00 | 70 | 0.070 | 1 | TCMT 16 T3 08 |

For inserts, see Turning tools catalogue



N23



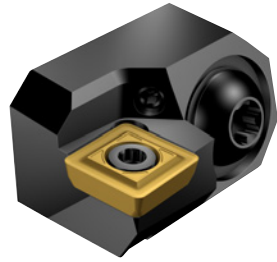
N15

Indexable boring cartridge

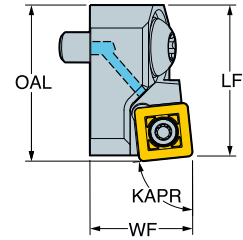
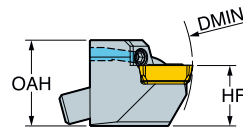
No adjustment

KAPR

84°



 SPMT



| | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|----------------|---------------|--------------|-------|-------|-------|-------|-------|----|-------|------|--------------|
| DMIN ₁ | CZC _{MS} | CNSC | Ordering code | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID | |
| 20.0 | 06 | 06CD | 2 | SSYPR06CDX06 | 16.00 | 6.00 | 11.00 | 10.20 | 16.60 | 70 | 0.020 | 1 | SPMT 0606-BM |
| 25.0 | 08 | 08CD | 2 | SSYPR08CDX08 | 20.00 | 8.00 | 14.00 | 12.20 | 20.80 | 70 | 0.030 | 1 | SPMT 0808-BM |
| 40.0 | 08 | 10CD | 2 | SSYPR10CDX08 | 25.00 | 10.00 | 17.00 | 14.00 | 25.80 | 70 | 0.050 | 1 | SPMT 0808-BM |
| 50.0 | 12 | 12CD | 2 | SSYPR12CDX12 | 30.00 | 12.00 | 20.00 | 16.20 | 31.20 | 70 | 0.070 | 1 | SPMT 1210-BM |



K32



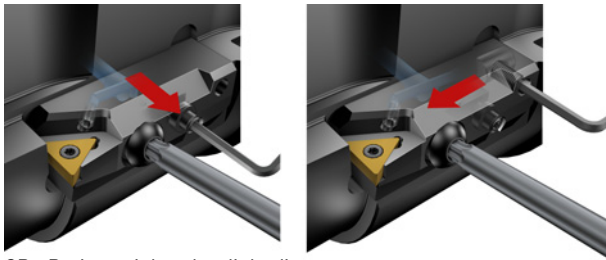
N23



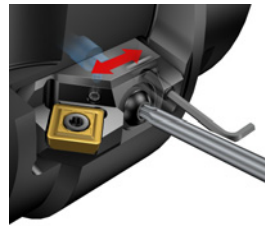
N15

CoroBore®

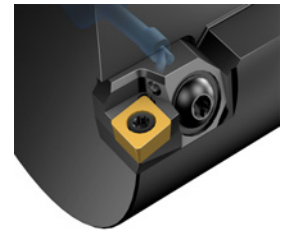
Built-in cartridges - CB, CC and CD



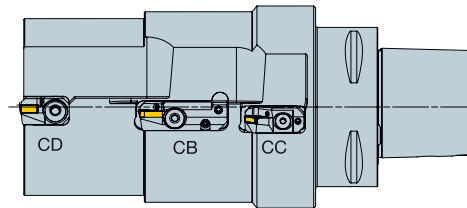
CB - Boring axial and radial adjustment



CC - Chamfer axial adjustment



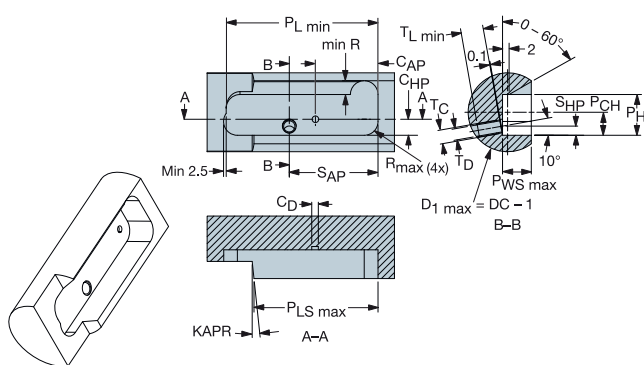
CD - Fixed, no adjustment



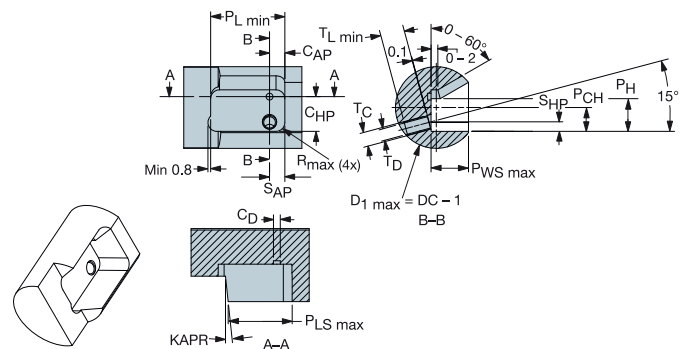
| Size/type | Clamping set | Clamping torque (Nm) | Key size |
|-----------|--------------|----------------------|----------|
| 06CB | 5519 201-01 | 4.8 | 15IP |
| 10CB | 5519 201-02 | 9.0 | 20IP |
| 12CB | 5519 201-03 | 16.0 | 25IP |
| 06CC | 5519 202-01 | 3.2 | 10IP |
| 08CC | 5519 202-02 | 4.8 | 15IP |
| 10CC | 5519 202-04 | 16.0 | 25IP |
| 06CD | 5519 202-01 | 3.2 | 10IP |
| 08CD | 5519 202-02 | 4.8 | 15IP |
| 10CD | 5519 202-03 | 16.0 | 25IP |
| 12CD | 5519 202-04 | 16.0 | 25IP |

| Parameter | Description |
|---------------------|---------------------------|
| P _L min | Pocket length min |
| P _{CH} | Pocket center height |
| P _H | Pocket height |
| P _{LS} max | Pocket length support max |
| KAPR | Tool cutting edge angle |
| P _{WS} max | Pocket width support max |
| R _{max} | Radius max |
| S _{AP} | Screw axial position |
| S _{HP} | Screw height position |
| T _D | Thread size |
| T _C | Thread counterbore dia |
| T _L min | Thread length min |
| C _{AP} | Coolant axial position |
| C _{HP} | Coolant height position |
| C _D | Coolant hole dia |

Type CB

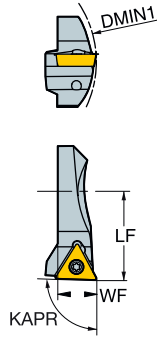
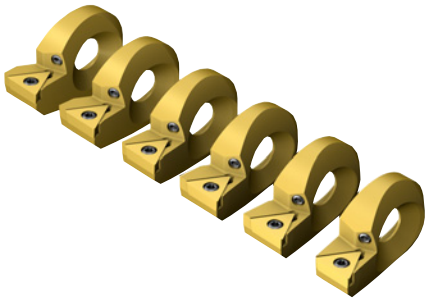


Type CC and CD



CoroBore® 826 HP

Cartridge set



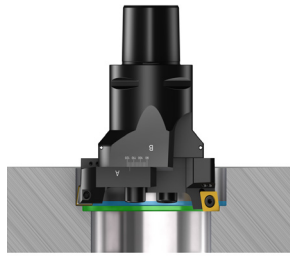
| | Ordering code | Included cartridges | WF |
|------------|---------------|---------------------|------|
| Size B set | 826B-4-TC09U | R826B-AF17STUC09HP | 7.0 |
| | | R826B-BF17STUC09HP | 7.5 |
| | | R826B-CF17STUC09HP | 8.0 |
| | | R826B-DF17STUC09HP | 8.5 |
| Size C set | 826C-6-TC11U | R826C-AF23STUC11HP | 10.0 |
| | | R826C-BF23STUC11HP | 10.5 |
| | | R826C-CF23STUC11HP | 11.0 |
| | | R826C-DF23STUC11HP | 11.5 |
| | | R826C-EF23STUC11HP | 12.0 |
| | | R826C-FF23STUC11HP | 12.5 |

CoroBore® BR20

Operations



1



2

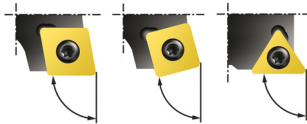
1. Twin-edge boring

- Increased feed rate is applicable.

2. Twin-edge step boring

- High cutting depth is applicable.
- Built in functionality in slide

Insert choice



Entering angle
Lead angle

90°
0°

84°
6°

90°
0°

CoroTurn® 107 screw clamping

For applications that require lower cutting forces



84°
6°

CoroBore® 111 screw clamping

Dedicated rough boring insert with optimized grade selection for P,M,K,S

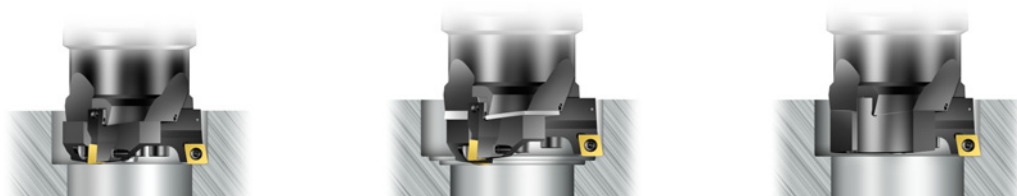
Maximum cutting speed, V_c max:

BR20: 1200 m/min

BR20 Damped: 900 m/min

CoroBore® BR30

Operations



1

2

3

1. Multi-edge boring
 - Increased feed rate is applicable.

2. Multi-edge step boring
 - High cutting depth is applicable.
 - Shim-set is required, to be ordered separately. LF-dimension when using shim set increases 1-2 mm.
 - Slides of R820x-AR... and R820x-BR... with kappa 90 degree can be combined

3. Single-edge boring:
 - Two covers are required, to be ordered separately.

Shim-set and cover - CoroBore® BR30

| Adaptor size | Shim set | Thickness mm | Cover |
|--------------|-------------|--------------|-------------|
| A | R820A-AS00B | 0.5+1 | R820A-AC10B |
| B | R820B-AS00B | 0.5+1 | R820B-AC11B |
| C | R820C-AS00B | 0.5+1 | R820C-AC15B |
| D | R820D-AS00B | 0.5+1 | R820D-AC17A |
| E | R820E-AS00B | 0.8+1.6 | R820E-AC20A |
| F | R820F-AS00B | 0.8+1.6 | R820F-AC22A |
| G | R820G-AS00B | 0.8+1.6 | R820G-AC22A |
| H | R820H-AS00B | 1+2 | R820H-BC24A |

Maximum cutting speed, Vc max: Conventional: Vc 1200 m/min

Insert choice



Entering angle
Lead angle

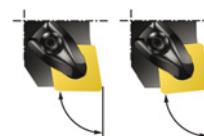
90°
0°

CoroTurn® 107 screw clamping
For applications that require lower cutting forces



84°
6°

CoroBore® 111 screw clamping
Dedicated rough boring insert with optimized grade selection for P,M,K,S

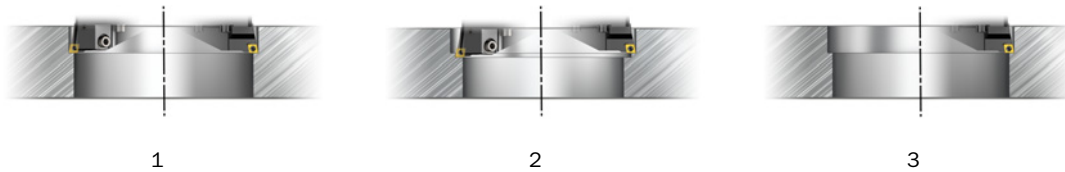


90°
0° 84°
6°

T-Max® P, CoroTurn® RC rigid clamping
For applications that require strong inserts in stable conditions

CoroBore® 820 XL

Operations



1. Twin-edge boring
 - Increased feed rate is applicable.

2. Twin-edge step boring
 - High cutting depth is applicable.
 - Axially adjustable cartridges +1.5 mm.
 - Cartridges with Kappa 90° (0°) entering angle (lead angle) should be used when step-boring.

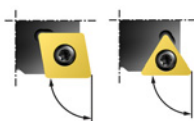
3. Single-edge boring:
 - Adjust unused cutting edge to a smaller diameter and use it as a counterweight.

Holders for CoroBore XL, diameter 150–1275 mm

Must be bought separately. Available interfaces: C8,C10, HSK-A 100, HSK-A 125, CAT-V 50, ISO 7388/1 50, MAS BT 50

Maximum cutting speed, V_c max: Conventional: 1200 m/min, Light weight: 600 m/min

Insert choice

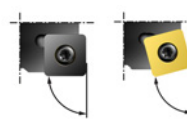


Entering angle
Lead angle

90° 90°
0° 0°

CoroTurn® 107 screw clamping

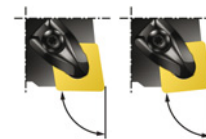
- For applications that require lower cutting forces



90° 84°
0° 6°

CoroBore® 111 screw clamping

- Dedicated rough boring insert with optimized grade selection for PM,K,S



90° 84°
0° 6°

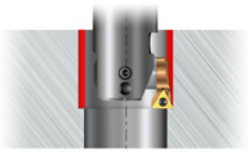
T-Max® P, CoroTurn® RC rigid clamping

- For applications that require strong inserts in stable conditions

CoroBore® 826 HP

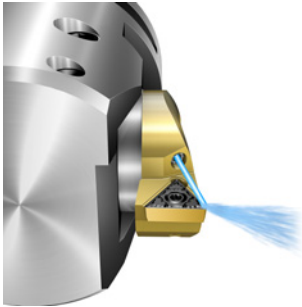
Operations

J



Boring

K



- Use the High precision coolant for improved chip breaking

L



- Feel the microns! Every diameter increment of 0.002 mm can be felt with a click

M

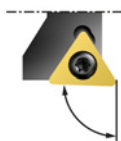


- The CB826 cartridge is rotated 90 degrees compared to CB825 cartridge!

Maximum cutting speed, V_c max: V_c 1200 m/min

Insert choice

CoroTurn® 107 inserts



Entering angle 92°
Lead angle -2°



CoroTurn® 107:
TC.. 1103

N

CoroBore® 825

Operations



Conventional:

The geometrical restriction (LU) is only valid when boring diameter (DC) is smaller than the coupling diameter (DCON_{MS}). Maximum recommended hole depth (for forward boring) when the boring diameter (DC) is larger than the coupling diameter (DCON_{MS})

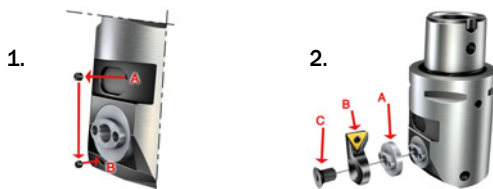
CoroBore® 825 EH:

The single cutting-edge position will be correct when using cylindrical or conical EH holders (available in steel, solid carbide, heavy metal) as it is possible to rotate the assembly in the chuck (using a CoroChuck 930, shrink fit, collet chuck) to find the single edge cutting position.

Backboring with CoroBore® 825 (Conventional)

1. Remove grub screw from coolant duct A and screw it into coolant duct B.
2. Lock A (if used) + B + C with correct torque.
3. Change spindle direction to counter clockwise (M04).

Backboring for CoroBore® 825D (Damped)



| Diameter mm | Slide extension | Thickness mm | Diameter extension mm |
|-------------|-----------------|--------------|-----------------------|
| 19-36 | 825A-030A | 3 | +6 |
| 35-56 | 825B-036A | 3.6 | +7.2 |
| 55-1275 | 825C-048A | 4.8 | +9.6 |

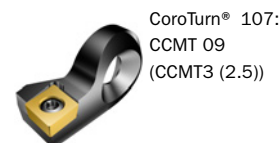
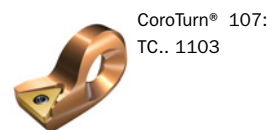
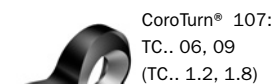
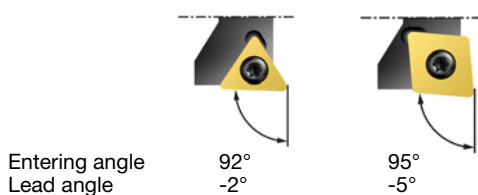
| Diameter range, forward boring, mm | Diameter range, back boring, mm | Back boring cartridge kit (1pcs cartridge, 1pcs slide extension) | Back boring cartridge | Slide extension |
|------------------------------------|---------------------------------|--|-----------------------|-----------------|
| 19-36 | 31-48 | 825A-TC06U-BW | L825A-AF11STUC06T1 | 825A-030A |
| 35-56 | 48-69 | 825B-TC06U-BW | L825B-AF15STUC06T1 | 825B-036A |
| 55-167 | 69-181 | 825C-TC09U-BW | L825C-AF20STUC0902 | 825C-048A |

Every back boring kit includes 1 slide extension and 1 back boring cartridge. Be aware that back boring diameters are different from forward boring. Please check the information table for correct diameter ranges.

Maximum cutting speed, V_c max: **Conventional:** V_c 1200 m/min, **Light weight:** V_c 600 m/min **Damped:** V_c 900m/min

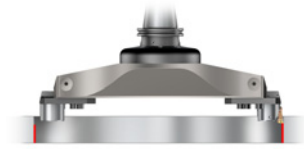
Insert choice

CoroTurn® 107 inserts

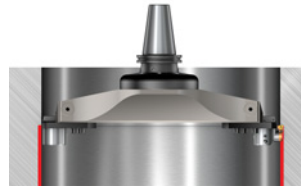


CoroBore® 825 XL/CoroBore® 826 XL

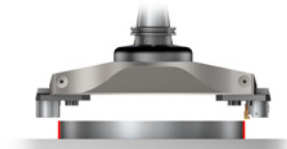
Operations



Boring



Back boring



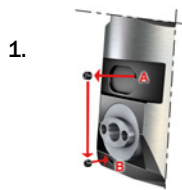
External operations

Holders for CoroBore XL

Must be bought separately. Available interfaces: C8,C10, HSK-A 100, HSK-A 125, CAT-V 50, ISO 7388/1 50, MAS BT 50

Back boring (not for CoroBore® 826HP and 825 SL)

1. Remove grub screw from coolant duct A and screw it into coolant duct B.
2. Lock A (if used) + B + C with correct torque.
3. Change spindle direction to counter clockwise (M04).



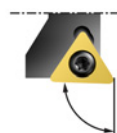
| Diameter mm | Slide extension (A) | Thickness mm | Diameter extension mm |
|-------------|---------------------|--------------|-----------------------|
| 55-1275 | 825C-048A | +4.8 | +9.6 |

Maximum cutting speed, V_c max:

Conventional: V_c 1200 m/min, Light weight: V_c 600 m/min, Damped: V_c 600 m/min

Insert choice

CoroTurn® 107 inserts



Entering angle
Lead angle

92°
-2°



95°
-5°



CoroTurn® 107
TCMT1103
(TCMT 22)



CoroTurn® 107:
TC.. 1103



CoroTurn® 107:
CCMT 09
(CCMT3 (2.5))

Start recommendations

- Cutting speed must be reduced when working with long overhangs. Silent Tools can be used to achieve higher cutting speeds at certain overhangs.

Rough boring

- Maximum recommended starting value for cutting speed is 200 m/min for rough boring to ensure proper chip evacuation and to secure a stable process.

| CoroBore® 111 | | Feed (f_n) mm/r | | | Cutting depth (a_p), mm | | | Cutting speed (v_c) m/min | | |
|---------------|---------------|---------------------|------|------|-----------------------------|------|-----|-------------------------------|-----|-----|
| Grade | Ordering code | Min | Max | Rec | Min | Max | Rec | Min | Max | Rec |
| 4325 | SPMT0606-BR | 0.10 | 0.25 | 0.20 | 0.6 | 4.5 | 2.0 | 365 | 460 | 395 |
| | SPMT0808-BR | 0.15 | 0.35 | 0.20 | 0.8 | 6.5 | 2.5 | 325 | 425 | 395 |
| | SPMT1212-BR | 0.15 | 0.40 | 0.25 | 1.2 | 9.0 | 3.0 | 305 | 425 | 365 |
| | SPMT1812-BR | 0.20 | 0.40 | 0.30 | 1.2 | 12.0 | 3.8 | 305 | 395 | 345 |
| 2025 | SPMT0606-BM | 0.10 | 0.15 | 0.10 | 0.6 | 4.5 | 1.8 | 260 | 265 | 265 |
| | SPMT0808-BM | 0.10 | 0.25 | 0.20 | 0.8 | 6.5 | 2.2 | 225 | 265 | 240 |
| | SPMT1210-BM | 0.10 | 0.30 | 0.20 | 1.0 | 9.0 | 2.5 | 205 | 265 | 240 |
| | SPMT1810-BM | 0.20 | 0.30 | 0.25 | 1.0 | 12.0 | 3.0 | 205 | 240 | 225 |
| 3210 | SPMT0606-BR | 0.15 | 0.30 | 0.25 | 0.6 | 4.5 | 2.0 | 285 | 330 | 300 |
| | SPMT0808-BR | 0.20 | 0.50 | 0.30 | 0.8 | 6.5 | 2.5 | 235 | 315 | 285 |
| | SPMT1212-BR | 0.20 | 0.50 | 0.30 | 1.2 | 9.0 | 3.0 | 235 | 315 | 285 |
| | SPMT1812-BR | 0.25 | 0.50 | 0.30 | 1.2 | 12.0 | 3.8 | 235 | 300 | 285 |
| 1145 | SPMT0606-BM | 0.10 | 0.15 | 0.10 | 0.6 | 4.5 | 1.8 | 15 | 20 | 20 |
| | SPMT0808-BM | 0.10 | 0.15 | 0.10 | 0.8 | 6.5 | 2.2 | 15 | 20 | 20 |
| | SPMT1210-BM | 0.10 | 0.20 | 0.15 | 1.0 | 9.0 | 2.5 | 10 | 20 | 15 |
| | SPMT1810-BM | 0.10 | 0.20 | 0.15 | 1.0 | 12.0 | 3.0 | 10 | 20 | 15 |

Fine boring

- Maximum recommended starting value for cutting speed is 240 m/min for fine boring, to ensure proper chip evacuation and to secure a stable process.
- The recommended starting value for cutting speed for fine boring head 391.37A with steel or carbide bars with inserts is 90-120 m/min, use lower values for long steel bars). Recommended starting value for ground carbide bars is 60 m/min.
- See below matrix for selection of geometry and grade depending on your fine boring application.
- Maximum recommended depth of cut for fine boring is 0.5 mm. If the tool is adjusted to the minimum possible diameter, chip evacuation will be more critical and a reduction of cutting depth might be necessary.
- Maximum feed in fine boring is limited by desired surface finish. The possibility to influence chip form is therefore limited. By using a wiper insert, the surface finish can be retained at higher feeds. However, the wiper inserts exert more radial pressure, increasing the risk for an unstable process.

These start recommendations are general. For more detailed information, please visit CoroPlus ToolGuide on www.sandvik.coromant.com

| Fine boring | | | | | | | | | | | | |
|-------------|-------------|-------------------------------|--------|----------|----------|---------|----------|---------|--------|------------|----------|--------------|
| AP | Nose radius | Max feed for required surface | | Material | | | | | | | | |
| | | Ra 1.6 | Ra 0.8 | P | | M | | K | N | S (nickel) | | S (titanium) |
| 0.1-0.15 | 02 | 0.08 | 0.05 | PF 5015 | L-K 1515 | MF-1115 | L-K 1515 | PF 1515 | AL H10 | MF 1115 | L-K 1115 | AL H10 |
| 0.15-0.3 | 04 | 0.12 | 0.07 | PF 5015 | L-K 1515 | MF 2015 | L-K 1515 | PF 4215 | AL H10 | MF 1115 | L-K 1115 | AL H10 |
| 0.3-0.5 | 08 | 0.15 | 0.10 | PF 5015 | | MF 2015 | | PF 4215 | AL H10 | MF 1115 | L-K 1115 | AL H10 |

Face grooving

First choice is the CoroCut 2-system insert.

Use -TF geometry for low feed, -CM geometry for medium feed and -RM geometry for radial bottom face grooving.

The -TF and -CM geometries have positive geometries that eliminate the risk of built-up edge. The -TF geometry gives good chip control and generates high surface finish due to the Wiper design. The -GF enables larger widths to be selected.

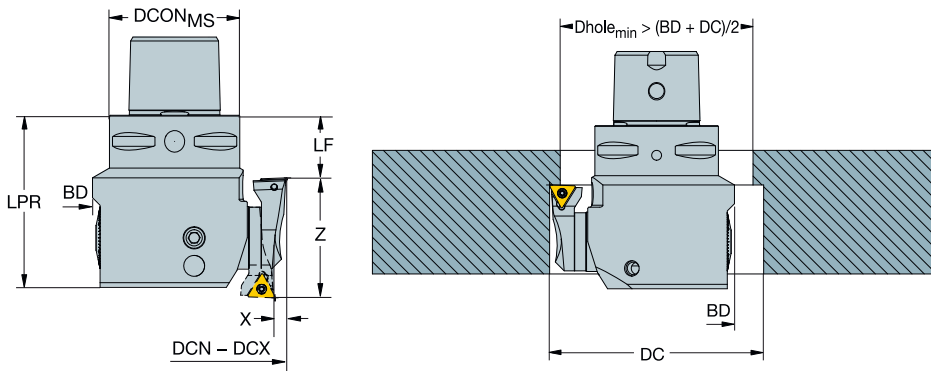
Depending on chosen nose radius:

- Choose -CM for smaller nose radius (0.2)
- Choose -TF for larger nose radius (>0.3)
- Recommended start feed: 0.15 mm/rev
- If grooves with tighter tolerance are required, choose -GF
- Recommended start feed: 0.10 mm/rev

To improve chip control:

- increase feed rate
- increase cutting speed

Backboring with CoroBore® 825 (Conventional)



| Cartridge size | Z (mm) | X (mm) |
|----------------|--------|--------|
| A | 22 | 3.0 |
| B | 34 | 3.6 |
| C | 46 | 4.8 |

Backboring for CoroBore® 825

In case of backboring, LF will be reduced by twice LF of cartridge. That means:

- LF – 22 mm for Size A (e.g. R825A-AF11STUC06T1A)
- LF – 34 mm for Size B (e.g. R825B-AF17STUC0902A)
- LF – 46 mm for Size C (e.g. R825C-AF23STUC1103A)
- Attention change rotation direction -> left hand!

DC will be increased by twice WF of slide extension. That means:

- $2 \times 3.0 = 6.0$ mm for Size A (825A-030A)
- $2 \times 3.6 = 7.2$ mm for Size B (825B-036A)
- $2 \times 4.8 = 9.6$ mm for Size C (825C-048A)
- Calculation of minimum possible hole diameter: $D_{hole_{min}} = (BD+DC)/2+1$

Backboring for CoroBore® 825XL

In case of backboring, LF will be reduced by twice LF of cartridge. That means:

- LF – 46 mm for Size C (e.g. R825C-AF23STUC1103A)
- Attention change rotation direction -> left hand!

DC will be increased by twice WF of slide extension. That means:

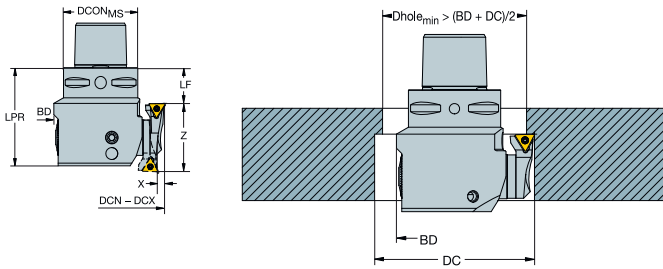
- $2 \times 4.8 = 9.6$ mm for Size C (825C-048A)
- Calculation of minimum possible hole diameter: $D_{hole_{min}} > (DC+DC-26)/2$

Additionally it is necessary to adjust A34 fine boring head to maximum.

Example: Diameter range for 825-215TC11-C6

- **DCN (backboring)** = (DCN(forward)) + (2x A34-R825 stroke) + (2x slide extension) = 148 mm + 15 mm + 9,6 mm = **172,6 mm**
- **DCX (backboring)** = (DCX(forward)) + (2x slide extension) = 215 mm + 9,6 mm = **224,6 mm**

Backboring for CoroBore® 825D (Damped)



Cartridge

Slide extension

| Size | Cartridge | | Slide extension | | | | |
|------|---------------|---------------|-----------------|----------------|-----|-----|----|
| | LF Forward | WF Forward | LF Backward | WF Backward | WF | X | Z |
| A | 11 | 5 | 11 | 8.0 | 3.0 | 6.0 | 22 |
| B | 17 | 7 | 15 | 9.9 | 3.6 | 6.5 | 32 |
| C | 23 | 10 | 20 | 12.2 | 4.8 | 7.0 | 43 |

Backboring for CoroBore® 825D

In case of backboring, LF will be reduced by the LF forward + LF backward. That means:

- LF – 22 mm for Size A
- LF – 32 mm for Size B
- LF – 43 mm for Size C
- Attention: rotation direction will stay right hand!

DC will be increased by twice the WF of slide extension - WF forward + WF backward. That means:

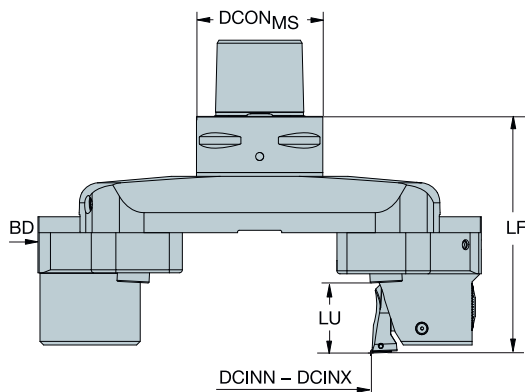
- $DC + 2 \times (3.0 - 5.0 + 8.0) = 12.0$ mm for Size A
- $DC + 2 \times (3.6 - 7.0 + 9.9) = 13.0$ mm for Size B
- $DC + 2 \times (4.8 - 10.0 + 12.2) = 14.0$ mm for Size C
- Calculation of minimum possible hole diameter: $D_{hole_{min}} = (BD+DC)/2+1$

Note! Backboring is only valid for CoroBore® 825D and not CoroBore® 825D XL or CoroBore® 825



N23

External boring



External boring for CoroBore® 825XL

In case of external boring, LF will remain the same.

Example: Diameter range for 825-215TC11-C6

- **DCN (external)** = DCN(forward)-(2x DMIN A34-R825)-(2x A34-R825 stroke) = 148 mm-110 mm-15 mm = **23 mm**
- **DCX (external)** = DCX(forward)-(2x DMIN A34-R825)-(2x A34-R825 stroke) = 215 mm- 110 mm -15 mm = **90 mm**
- Attention change rotation direction -> left hand!

The usable length for external boring at diameter 23 mm to 190 mm (Forward boring: 148 mm to 315 mm) is 34 mm.

The usable length for external at diameter 173 mm to 1150 mm (Forward boring: 298 mm to 1275 mm) is 28 mm.

External boring for CoroBore® 826XL

In case of external boring, LF will remain the same.

Example: Diameter range for 826-200TC11-C6

- **DCN (external)** = DCN(forward)-(2x DMIN A34-R825) = 148 mm-110 mm = **38 mm**
- **DCX (external)** = DCX(forward)-(2x DMIN A34-R825) = 200 mm- 110 mm = **90 mm**
- Attention change rotation direction -> left hand!

The usable length for external boring at diameter 38 mm to 190 mm (Forward boring: 148 mm to 300 mm) is 34 mm.

The usable length for external at diameter 188 mm to 1150 mm (Forward boring: 298 mm to 1260 mm) is 28 mm.

Tightening torque

Coromant Capto®

| Coromant Capto® size | NM |
|----------------------|---------|
| C3 | 40-50 |
| C4 | 50-60 |
| C5 | 90-100 |
| C6-C8 | 160-180 |
| C10 | 380 |

Insert screw

| Insert | NM |
|--|-----|
| TC05 / TC06 / TP06 | 0.6 |
| TC09 / TP09 / SP06 | 0.8 |
| TC1103 / TP1103 / CC06 | 0.9 |
| SP08 | 1.7 |
| SP12 | 2 |
| CC09 / CC12 / SC09 / SC12 / TC16 / TC22 / SP18 | 3 |
| CN12 / SN12 | 3.9 |
| CN16 / SN15 | 6.4 |

Coromant EH coupling

| Size | NM |
|------|----|
| 16 | 30 |
| 20 | 50 |
| 25 | 65 |

CoroBore® BR10

| Tightening torque for slide. | | | | |
|------------------------------|-----------|-----------|-----|------------|
| Size | DCN mm | DCX mm | NM | Screw size |
| A | 32 | 38 | 4.8 | M4 |
| B | 37 | 45 | 4.8 | M4 |
| C | 44 | 54 | 9 | M5 |
| D | 53 | 65 | 16 | M6 |
| DX | 64 | 76 | 16 | M6 |
| E | 75 | 91 | 38 | M8 |
| F | 90 | 110 | 75 | M10 |
| G | 109 | 136 | 75 | M10 |
| H | 135 | 170 | 75 | M10 |

CoroBore® BR20

| Tightening torque for slide. | | | | |
|------------------------------|-----------|-----------|-----|------------|
| Size | DCN mm | DCX mm | NM | Screw size |
| A | 23 | 29 | 4.8 | M4 |
| B | 28 | 36 | 4.8 | M4 |
| C | 35 | 45 | 9 | M5 |
| D | 44 | 56 | 16 | M6 |
| E | 55 | 71 | 38 | M8 |
| F | 70 | 90 | 75 | M10 |
| G | 89 | 116 | 75 | M10 |
| H | 115 | 150 | 75 | M10 |

CoroBore® BR30

| Tightening torque for slide. | | | | |
|------------------------------|-----------|-----------|---------|------------|
| Size | DCN mm | DCX mm | NM | Screw size |
| A | 35 | 45 | 4.8 | M4 |
| B | 44 | 56 | 9 | M5 |
| C | 55 | 70 | 16 | M6 |
| D | 69 | 87 | 16 | M6 |
| E | 86 | 107 | 38 | M8 |
| F | 106 | 137 | 75 | M10 |
| G | 136 | 167 | 75 | M10 |
| H | 166 | 214 | 75; 120 | M10; M12 |

Tightening torque

CoroBore® 820 XL / 820L XL

| Diameter range, mm | NM | |
|--------------------|-----|------------|
| | | Screw size |
| 148-300 | | |
| Bridge | 100 | M12 |
| Slide | 60 | M10 |
| Cartridge | 60 | M10 |

CoroBore® 820 XL

| Diameter range, mm | NM | |
|--------------------|-----|------------|
| | | Screw size |
| 298-1260 | | |
| Bridge | 200 | M16 |
| Bridge extension | 100 | M12 |
| Slide | 60 | M10 |
| Cartridge | 60 | M10 |

CoroBore® 825 XL / 826 XL / 825D XL / 826D XL / 825L XL / 826L XL

| Diameter range, mm | NM | |
|------------------------------|-----|------------|
| | | Screw size |
| 825: 148-315 826: 148-300 | | |
| Bridge | 100 | M12 |
| Slide | 60 | M10 |
| Counterweight | 60 | M10 |
| Fine boring head | 14 | M6 |
| Locking screw CB825 | 6 | M8 |
| Locking screw CB826HP | 8 | M8 |
| Cartridge screw | 6 | M8 |

CoroBore® 825 XL / 826 XL

| Diameter range, mm | NM | |
|--------------------------------|-----|------------|
| | | Screw size |
| 825: 298-1275 826: 298-1260 | | |
| Bridge | 200 | M16 |
| Bridge extension | 100 | M12 |
| Slide | 60 | M10 |
| Counterweight | 60 | M10 |
| Fine boring head | 14 | M6 |
| Locking screw CB825 | 6 | M8 |
| Locking screw CB826HP | 8 | M8 |
| Cartridge screw | 6 | M8 |

CoroBore® 825, 825D and 826HP

| | NM | |
|----------------------------|----------|------------|
| | | Screw size |
| Cartridge screw | | |
| R825A... | 1.2 | M3.5 |
| R825B..., R826B... | 3.0 | M5 |
| R825C..., R826C... | 6.0 | M8 |
| Locking screw | | |
| ...R825A-xA18/...R825A-xAA | 0.9 | M4 |
| ...R825A-xAB | 1.2 | M5 |
| ...R825B...;...R826B | 3.0; 4.0 | M6 |
| ...R825C...;...R826C | 6.0; 8.0 | M8 |

CoroBore® 824 XS

| Diameter range, mm | NM | |
|---|-----|------------|
| | | Screw size |
| 1-20 | | |
| Locking screw / Boring bar (Insert) screw | | |
| Size | | |
| XS04 | 1.2 | M5 |
| XS06 | 1.2 | M5 |
| XS08 | 3 | M6 |
| XS10 | 3 | M6 |

CoroBore® 825 SL

| Diameter range, mm | NM | |
|--------------------------|----|------------|
| | | Screw size |
| 47-150 | | |
| Face grooving head (S20) | 14 | M6 |
| Locking screw | 8 | M10 |
| Counterweight | 8 | M10 |
| Blade | 9 | M5 |

CoroBore® 825 SL XL

| Diameter range, mm | NM | |
|--------------------------|----|------------|
| | | Screw size |
| 150-1275 | | |
| Face grooving head (A34) | 14 | M6 |
| Locking screw | 12 | M10 |
| Blade | 9 | M5 |

Other components, see CoroBore® 825XL

Fine boring head, 391.37A / 391.37B / Boring bars

| Diameter mm | NM | |
|------------------------------|----|------------|
| | | Screw size |
| Screw for boring bar: | | |
| 12 | 10 | M8 |
| 16 | 10 | M8 |
| 20 | 18 | M10 |
| Locking screw: | | |
| 12 | 8 | M8 |
| 16 | 8 | M8 |
| 20 | 12 | M10 |

Rotating tool adaptors

Adaptors

| | |
|-------------------|-----------|
| Coromant Capto® | L4-L26 |
| HSK | L27-L41 |
| BIG-PLUS® ISO | L42-L50 |
| BIG-PLUS® MAS-BT | L51-L59 |
| ISO 7388-1 | L60-L72 |
| MAS-BT | L73-L85 |
| DIN 2080 | L86-L88 |
| DIN 2079 | L89-L90 |
| Cylindrical shank | L91-L98 |
| Weldon shank | L99-L100 |
| Bridgeport | L101-L102 |
| Coromant EH | L103-L104 |
| ER | L105-L107 |
| Coolant inducer | L108 |

Damped adaptors

| | |
|-----------------|-----------|
| | L109 |
| Coromant Capto® | L110-L111 |
| HSK | L112 |

Adaptors

| | | Machine side | | | | | |
|----------------|-------------------------|---|----------------------------------|---------------------------|---------------------------|---|---|
| | | Coromant Capto® | HSK | BIG-PLUS® ISO | BIG-PLUS® MAS-BT | ISO 7388-1 | MAS-BT |
| Workpiece side | Coromant Capto® | -Extension -Extension with Quick change -Reduction L4-L7 Coolant inducer L108 | -Adaptor -Quick change | -Adaptor -Quick change | -Adaptor -Quick change | -Adaptor -Quick change | -Adaptor -Quick change |
| | Coromant EH | -Adaptor L8-L9 | -Adaptor | | | -Adaptor L62 | -Adaptor L74-L75 L76 |
| | Arbor | -Adaptor -With driving screws -Side and face mill L10-L12 | -Adaptor -With driving screws | -Adaptor | -Adaptor | -Adaptor -With driving screws -Side and face mill | -Adaptor -With driving screws -Side and face mill |
| | VL | -Adaptor L13 | -Adaptor | -Adaptor | -Adaptor | -Adaptor | -Adaptor |
| | Weldon | -Adaptor L14 | -Adaptor | | | -Adaptor L66 | -Adaptor L79 |
| | MDI | -Adaptor L15 | -Adaptor | | | | |
| | ISO 9766 | -Adaptor L16 Coolant inducer L108 | -Adaptor | | | -Adaptor -Adjustable adaptor | -Adaptor -Adjustable adaptor |
| | Weldon/ISO 9766 | -Adaptor L17 | | -Adaptor | -Adaptor | | |
| | CoroMill® 327 | -Adaptor L17 | | | | | |
| | CoroChuck™ 930 | -Adaptor L18-L22 | -Adaptor | -Adaptor | -Adaptor | -Adaptor | -Adaptor |
| | Shrink fit chuck | -Adaptor L23 | -Adaptor | | | | |
| | ER | -Collet chuck -Drill chuck L24-L25 | -Collet chuck | -Collet chuck | -Collet chuck | -Collet chuck | -Collet chuck |
| | CoroChuck™ 970 | -Adaptor L26 | -Adaptor | -Adaptor | -Adaptor | -Adaptor | -Adaptor |

Damped adaptors

| | | Machine side | |
|----------------|--------------------|--|----------------------|
| | | Coromant Capto® | HSK |
| Workpiece side | Coromant EH | -Adaptor L110 | |
| | Arbor | -Adaptor -With driving screws L111 | -Adaptor L112 |

ENG

| DIN 2080 | DIN 2079 | Cylindrical shank | Weldon shank | Bridgeport | Coromant EH | ER |
|----------|---------------------------|-----------------------------|------------------|------------------|------------------|------------------|
| -Adaptor | -Adaptor -Quick change | | | | | |
| L87 | L90 | | | | | |
| | | -Adaptor L92-L95 | | | | -Adaptor L106 |
| | | -With driving screws L96 | | -Adaptor L102 | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | -Adaptor L100 | | -Adaptor L104 | -Adaptor L107 |
| | | | | | | |
| | | | | | | |
| | | -Collet chuck L98 | | | -Adaptor L104 | |
| | | -Adaptor L98 | -Adaptor L100 | | -Adaptor L104 | |

J

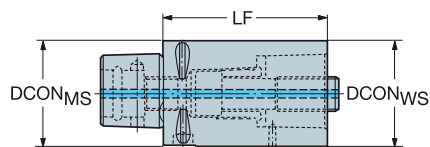
K

L

M

N

Coromant Capto® extension adaptor



| | | | | | Dimensions, mm | | | | | |
|-------------------|-------------------|------|------|--------------------|--------------------|--------------------|-------|-----|--------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | BAR | NM | KG |
| C3 | C3 | 3 | 1 | C3-391.01-32 060A | 32.0 | 32.0 | 60.0 | 80 | 45.00 | 0.36 |
| | C3 | 3 | 1 | C3-391.01-32 080A | 32.0 | 32.0 | 80.0 | 80 | 45.00 | 0.47 |
| | C3 | 3 | 1 | C3-391.01-32 095 | 32.0 | 32.0 | 95.0 | 80 | 45.00 | 0.56 |
| | C4 | 3 | 1 | C4-391.01-40 060A | 40.0 | 40.0 | 60.0 | 80 | 55.00 | 0.57 |
| | C4 | 3 | 1 | C4-391.01-40 080A | 40.0 | 40.0 | 80.0 | 80 | 55.00 | 0.70 |
| | C4 | 3 | 1 | C4-391.01-40 120 | 40.0 | 40.0 | 120.0 | 80 | 55.00 | 1.11 |
| | C5 | 3 | 1 | C5-391.01-50 080A | 50.0 | 50.0 | 80.0 | 80 | 95.00 | 1.15 |
| | C5 | 3 | 1 | C5-391.01-50 100A | 50.0 | 50.0 | 100.0 | 80 | 95.00 | 1.38 |
| | C5 | 3 | 1 | C5-391.01-50 150 | 50.0 | 50.0 | 150.0 | 80 | 95.00 | 2.17 |
| | C6 | 3 | 1 | C6-391.01-63 100A | 63.0 | 63.0 | 100.0 | 80 | 170.00 | 2.26 |
| | C6 | 3 | 1 | C6-391.01-63 140A | 63.0 | 63.0 | 140.0 | 80 | 170.00 | 3.17 |
| | C6 | 3 | 1 | C6-391.01-63 185 | 63.0 | 63.0 | 185.0 | 80 | 170.00 | 4.19 |
| | C8 | 3 | 1 | C8-391.01-80 100A | 80.0 | 80.0 | 100.0 | 80 | 170.00 | 3.70 |
| | C8 | 3 | 1 | C8-391.01-80 125A | 80.0 | 80.0 | 125.0 | 80 | 170.00 | 4.64 |
| | C8 | 3 | 1 | C8-391.01-80 200 | 80.0 | 80.0 | 200.0 | 80 | 170.00 | 7.47 |
| | C10 | 3 | 1 | C10-391.01-100 140 | 100.0 | 100.0 | 140.0 | 80 | 380.00 | 7.93 |
| | C10 | 3 | 1 | C10-391.01-100 200 | 100.0 | 100.0 | 200.0 | 80 | 380.00 | 11.49 |

Short design, for segment clamping only

| | | | | | Dimensions, mm | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | BAR | NM | KG |
| C3 | C3 | 3 | 1 | C3-391.01-32 035 | 32.0 | 32.0 | 35.0 | 80 | 45.00 | 0.22 |
| | C4 | 3 | 1 | C4-391.01-40 040 | 40.0 | 40.0 | 40.0 | 80 | 55.00 | 0.40 |
| | C5 | 3 | 1 | C5-391.01-50 050 | 50.0 | 50.0 | 50.0 | 80 | 95.00 | 0.73 |
| | C6 | 3 | 1 | C6-391.01-63 060 | 63.0 | 63.0 | 60.0 | 80 | 170.00 | 1.36 |
| | C8 | 3 | 1 | C8-391.01-80 065 | 80.0 | 80.0 | 65.0 | 80 | 170.00 | 2.41 |

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



M1



N23

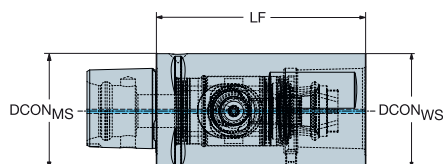


N6



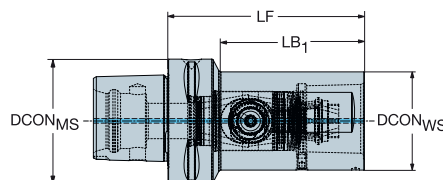
N15

Coromant Capto® extension adaptor with Quick change



| | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|----------------|--------------------|--------------------|-------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | BAR | NM | KG | RPMX |
| C4 | C4 | 3 | 1 | C4-QC-C4-085 | 40.0 | 40.0 | 85.0 | 150 | 50.00 | 0.75 | 39000 |
| C5 | C5 | 3 | 1 | C5-QC-C5-100 | 50.0 | 50.0 | 100.0 | 150 | 70.00 | 1.39 | 28000 |
| C6 | C6 | 3 | 1 | C6-QC-C6-115 | 63.0 | 63.0 | 115.0 | 150 | 90.00 | 2.53 | 20000 |
| C8 | C8 | 3 | 1 | C8-QC-C8-145 | 80.0 | 80.0 | 145.0 | 150 | 130.00 | 5.16 | 14000 |

Coromant Capto® reduction adaptor with Quick change



| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|------|----------------|--------------------|--------------------|-------|-----------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BAR | NM | KG | RPMX |
| C5 | C4 | 3 | 1 | C5-QC-C4-085 | 50.0 | 40.0 | 85.0 | 60.5 | 150 | 50.00 | 0.95 | 28000 |
| C6 | C5 | 3 | 1 | C6-QC-C5-100 | 63.0 | 50.0 | 100.0 | 73.0 | 150 | 70.00 | 1.75 | 20000 |
| C8 | C6 | 3 | 1 | C8-QC-C6-120 | 80.0 | 63.0 | 120.0 | 84.5 | 150 | 90.00 | 3.48 | 14000 |
| C10 | C8 | 3 | 1 | C10-QC-C8-150 | 100.0 | 80.0 | 150.0 | 108.0 | 150 | 130.00 | 6.83 | 10000 |

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



M1



N23

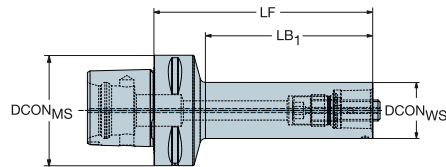


N6

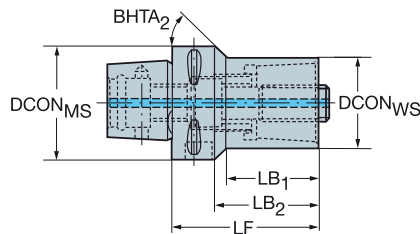


N15

Coromant Capto® reduction adaptor



| | | | | | Dimensions, mm | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BAR | NM | KG |
| C4 | C3 | 3 | 1 | C4-391.02-32 055A | 40.0 | 32.0 | 55.0 | 31.0 | 80 | 45.00 | 0.49 |
| | C3 | 3 | 1 | C4-391.02-32 120 | 40.0 | 32.0 | 120.0 | 95.7 | 80 | 45.00 | 0.81 |
| C5 | C3 | 3 | 1 | C5-391.02-32 060A | 50.0 | 32.0 | 60.0 | 34.8 | 80 | 45.00 | 0.68 |
| | C3 | 3 | 1 | C5-391.02-32 120 | 50.0 | 32.0 | 120.0 | 94.4 | 80 | 45.00 | 0.99 |
| | C4 | 3 | 1 | C5-391.02-40 065A | 50.0 | 40.0 | 65.0 | 40.0 | 80 | 55.00 | 0.80 |
| | C4 | 3 | 1 | C5-391.02-40 140 | 50.0 | 40.0 | 140.0 | 115.5 | 80 | 55.00 | 1.46 |
| C6 | C3 | 3 | 1 | C6-391.02-32 070A | 63.0 | 32.0 | 70.0 | 39.0 | 80 | 45.00 | 1.12 |
| | C3 | 3 | 1 | C6-391.02-32 125 | 63.0 | 32.0 | 125.0 | 95.6 | 80 | 45.00 | 1.43 |
| | C4 | 3 | 1 | C6-391.02-40 080A | 63.0 | 40.0 | 80.0 | 51.4 | 80 | 55.00 | 1.32 |
| | C4 | 3 | 1 | C6-391.02-40 145 | 63.0 | 40.0 | 145.0 | 116.7 | 80 | 55.00 | 1.86 |
| | C5 | 3 | 1 | C6-391.02-50 080A | 63.0 | 50.0 | 80.0 | 51.5 | 80 | 95.00 | 1.53 |
| | C5 | 3 | 1 | C6-391.02-50 175 | 63.0 | 50.0 | 175.0 | 148.1 | 80 | 95.00 | 2.79 |
| C8 | C3 | 3 | 1 | C8-391.02-32 060B | 80.0 | 32.0 | 60.0 | 20.7 | 80 | 45.00 | 2.07 |
| | C3 | 3 | 1 | C8-391.02-32 135 | 80.0 | 32.0 | 135.0 | 95.7 | 80 | 45.00 | 2.53 |
| | C4 | 3 | 1 | C8-391.02-40 070B | 80.0 | 40.0 | 70.0 | 31.4 | 80 | 55.00 | 2.20 |
| | C4 | 3 | 1 | C8-391.02-40 155 | 80.0 | 40.0 | 155.0 | 116.4 | 80 | 55.00 | 2.97 |
| | C5 | 3 | 1 | C8-391.02-50 080B | 80.0 | 50.0 | 80.0 | 42.8 | 80 | 95.00 | 2.43 |
| | C5 | 3 | 1 | C8-391.02-50 185 | 80.0 | 50.0 | 185.0 | 147.8 | 80 | 95.00 | 3.88 |
| | C6 | 3 | 1 | C8-391.02-63 080B | 80.0 | 63.0 | 80.0 | 44.5 | 80 | 170.00 | 2.65 |
| | C6 | 3 | 1 | C8-391.02-63 200 | 80.0 | 63.0 | 200.0 | 164.5 | 80 | 170.00 | 5.37 |
| C10 | C6 | 3 | 1 | C10-391.02-63 200 | 100.0 | 63.0 | 200.0 | 155.8 | 80 | 170.00 | 6.92 |
| | C8 | 3 | 1 | C10-391.02-80 200 | 100.0 | 80.0 | 200.0 | 158.1 | 80 | 170.00 | 8.92 |



| | | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-------|-----------------|-----------------|-------------------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BHTA ₂ | BAR | NM | KG |
| C8 | C6 | 3 | 1 | C8-391.02-63 120A | 80.0 | 63.0 | 120.0 | 10.0 | 89.2 | 6° | 80 | 170.00 | 4.10 |
| C10 | C3 | 3 | 1 | C10-391.02-32 085 | 100.0 | 32.0 | 85.0 | 36.7 | 48.2 | 71° | 80 | 45.00 | 4.15 |
| | C4 | 3 | 1 | C10-391.02-40 090 | 100.0 | 40.0 | 90.0 | 42.7 | 53.2 | 71° | 80 | 55.00 | 4.25 |
| | C5 | 3 | 1 | C10-391.02-50 095 | 100.0 | 50.0 | 95.0 | 49.1 | 58.2 | 70° | 80 | 95.00 | 4.42 |
| | C6 | 3 | 1 | C10-391.02-63 095 | 100.0 | 63.0 | 95.0 | 50.8 | 58.2 | 68° | 80 | 170.00 | 4.68 |
| | C8 | 3 | 1 | C10-391.02-80 100 | 100.0 | 80.0 | 100.0 | 58.1 | 63.2 | 63° | 80 | 170.00 | 5.25 |

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



M1



N23

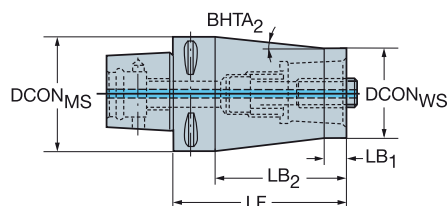


N6



N15

Coromant Capto® reduction adaptor



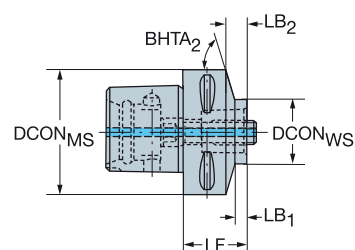
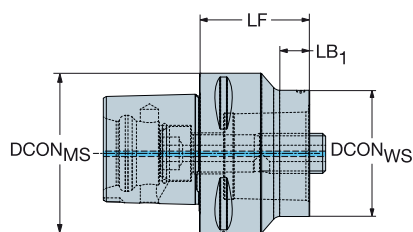
| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-------|-----------------|-----------------|-------------------|-----|-------|------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BHTA ₂ | BAR | NM | KG | | |
| C4 | C3 | 3 | 1 | C4-391.02-32 070A | 40.0 | 32.0 | 70.0 | 10.0 | 59.2 | 6° | 80 | 45.00 | 0.59 | | |
| C5 | C3 | 3 | 1 | C5-391.02-32 150 | 50.0 | 32.0 | 150.0 | 5.0 | 129.2 | 4° | 80 | 45.00 | 1.65 | | |
| | C4 | 3 | 1 | C5-391.02-40 085A | 50.0 | 40.0 | 85.0 | 10.0 | 64.2 | 5° | 80 | 45.00 | 1.10 | | |
| C6 | C3 | 3 | 1 | C6-391.02-32 185 | 63.0 | 32.0 | 185.0 | 5.0 | 162.2 | 6° | 80 | 45.00 | 2.99 | | |
| | C4 | 3 | 1 | C6-391.02-40 185 | 63.0 | 40.0 | 185.0 | 5.0 | 162.2 | 4° | 80 | 55.00 | 3.23 | | |
| C6 | C5 | 3 | 1 | C6-391.02-50 110A | 63.0 | 50.0 | 110.0 | 10.0 | 87.2 | 5° | 80 | 95.00 | 2.23 | | |
| | C4 | 3 | 1 | C8-391.02-40 200 | 80.0 | 40.0 | 200.0 | 5.0 | 169.2 | 7° | 80 | 55.00 | 5.42 | | |
| C8 | C5 | 3 | 1 | C8-391.02-50 200 | 80.0 | 50.0 | 200.0 | 5.0 | 169.2 | 5° | 80 | 95.00 | 5.84 | | |

Short design, for segment clamping only

DSGN

2

7



| | | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|--------------------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|--------|------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₂ | BD ₃ | BHTA ₂ | BAR | NM | KG | | |
| C5 | C3 | 3 | 1 | 2 | C5-391.02-32 033A | 50.0 | 32.0 | 33.0 | 5.0 | 33.0 | | 50.0 | | 0° | 80 | 45.00 | 0.54 | | |
| | C4 | 3 | 1 | 2 | C5-391.02-40 040A | 50.0 | 40.0 | 40.0 | 15.0 | 40.0 | | 50.0 | | 0° | 80 | 55.00 | 0.59 | | |
| C6 | C3 | 3 | 1 | 2 | C6-391.02-32 032 | 63.0 | 32.0 | 32.0 | 6.0 | 32.0 | | 63.0 | | 0° | 80 | 45.00 | 0.91 | | |
| | C4 | 3 | 1 | 2 | C6-391.02-40 040 | 63.0 | 40.0 | 40.0 | 11.0 | 40.0 | | 63.0 | | 0° | 80 | 55.00 | 0.98 | | |
| | C5 | 3 | 1 | 2 | C6-391.02-50 050A | 63.0 | 50.0 | 50.0 | 20.0 | 50.0 | | 63.0 | | 0° | 80 | 95.00 | 1.11 | | |
| C8 | C5 | 3 | 1 | 2 | C8-391.02-50 045A | 80.0 | 50.0 | 45.0 | 5.0 | 45.0 | | 80.0 | | 0° | 80 | 95.00 | 2.00 | | |
| | C6 | 3 | 1 | 2 | C8-391.02-63 055A | 80.0 | 63.0 | 55.0 | 15.0 | 55.0 | | 80.0 | | 0° | 80 | 170.00 | 2.15 | | |
| C10 | C6 | 3 | 1 | 7 | C10-391.02-63 055 | 100.0 | 63.0 | 55.0 | 14.0 | 19.0 | 55.0 | 63.0 | 100.0 | 75° | 80 | 170.00 | 3.70 | | |
| | C8 | 3 | 1 | 7 | C10-391.02-80 065 | 100.0 | 80.0 | 65.0 | 25.4 | 29.0 | 65.0 | 80.0 | 100.0 | 70° | 80 | 170.00 | 3.92 | | |

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

M1



N23



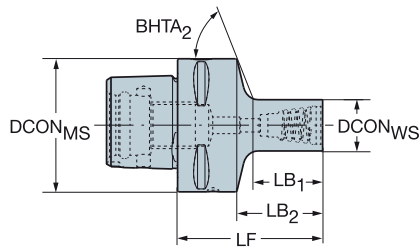
N6



N15

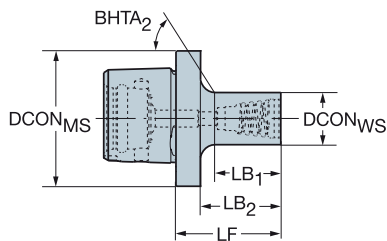
Coromant Capto® to Coromant EH adaptor

Short design



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|------|-----------------|-----------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BHTA ₂ | BAR | NM | KG | RPMX |
| C3 | E10 | 3 | 1 | C3-391.EH-10 035 | 32.0 | 9.6 | 35.0 | 13.2 | 20.0 | 58° | 150 | 12.00 | 0.19 | 40000 |
| | E12 | 3 | 1 | C3-391.EH-12 038 | 32.0 | 11.6 | 38.0 | 16.4 | 23.0 | 57° | 150 | 15.00 | 0.21 | 40000 |
| | E16 | 3 | 1 | C3-391.EH-16 043 | 32.0 | 15.4 | 43.0 | 21.9 | 28.0 | 53° | 150 | 30.00 | 0.26 | 40000 |
| C4 | E10 | 3 | 1 | C4-391.EH-10 041 | 40.0 | 9.6 | 41.0 | 13.1 | 21.0 | 62° | 150 | 12.00 | 0.35 | 39000 |
| | E12 | 3 | 1 | C4-391.EH-12 044 | 40.0 | 11.6 | 44.0 | 16.4 | 24.0 | 61° | 150 | 15.00 | 0.36 | 39000 |
| | E16 | 3 | 1 | C4-391.EH-16 049 | 40.0 | 15.4 | 49.0 | 21.9 | 29.0 | 59° | 150 | 30.00 | 0.42 | 39000 |
| | E20 | 3 | 1 | C4-391.EH-20 046 | 40.0 | 19.2 | 46.0 | 19.4 | 26.0 | 57° | 150 | 50.00 | 0.43 | 39000 |
| | E25 | 3 | 1 | C4-391.EH-25 051 | 40.0 | 24.1 | 51.0 | 25.0 | 31.0 | 53° | 150 | 65.00 | 0.50 | 39000 |
| C5 | E10 | 3 | 1 | C5-391.EH-10 042 | 50.0 | 9.6 | 42.0 | 12.8 | 22.0 | 65° | 150 | 12.00 | 0.56 | 28000 |
| | E12 | 3 | 1 | C5-391.EH-12 045 | 50.0 | 11.6 | 45.0 | 16.0 | 25.0 | 64° | 150 | 15.00 | 0.57 | 28000 |
| | E16 | 3 | 1 | C5-391.EH-16 050 | 50.0 | 15.4 | 50.0 | 21.5 | 30.0 | 63° | 150 | 30.00 | 0.63 | 28000 |
| | E20 | 3 | 1 | C5-391.EH-20 047 | 50.0 | 19.2 | 47.0 | 19.0 | 27.0 | 62° | 150 | 50.00 | 0.64 | 28000 |
| | E25 | 3 | 1 | C5-391.EH-25 052 | 50.0 | 24.1 | 52.0 | 24.7 | 32.0 | 60° | 150 | 65.00 | 0.70 | 28000 |
| C6 | E10 | 3 | 1 | C6-391.EH-10 046 | 63.0 | 9.6 | 46.0 | 13.0 | 24.0 | 67° | 150 | 12.00 | 0.94 | 20000 |
| | E12 | 3 | 1 | C6-391.EH-12 049 | 63.0 | 11.6 | 49.0 | 16.3 | 27.0 | 67° | 150 | 15.00 | 0.95 | 20000 |
| | E16 | 3 | 1 | C6-391.EH-16 054 | 63.0 | 15.4 | 54.0 | 21.8 | 32.0 | 66° | 150 | 30.00 | 1.01 | 20000 |
| | E20 | 3 | 1 | C6-391.EH-20 051 | 63.0 | 19.2 | 51.0 | 19.3 | 29.0 | 66° | 150 | 50.00 | 1.02 | 20000 |
| | E25 | 3 | 1 | C6-391.EH-25 056 | 63.0 | 24.1 | 56.0 | 25.0 | 34.0 | 65° | 150 | 65.00 | 1.08 | 20000 |

Short design, for segment clamping only



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|------|-----------------|-----------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BHTA ₂ | BAR | NM | KG | RPMX |
| C3 | E10 | 3 | 1 | C3-391.EH-10 026 | 32.0 | 9.6 | 26.0 | 13.0 | 18.0 | 45° | 150 | 12.00 | 0.15 | 40000 |
| | E12 | 3 | 1 | C3-391.EH-12 029 | 32.0 | 11.6 | 29.0 | 16.0 | 21.0 | 45° | 150 | 15.00 | 0.17 | 40000 |
| | E16 | 3 | 1 | C3-391.EH-16 027 | 32.0 | 15.4 | 27.0 | 14.0 | 19.0 | 45° | 150 | 30.00 | 0.24 | 55000 |
| | E20 | 3 | 1 | C3-391.EH-20 031 | 32.0 | 19.2 | 31.0 | 18.0 | 23.0 | 45° | 150 | 50.00 | 0.27 | 55000 |
| C4 | E10 | 3 | 1 | C4-391.EH-10 026 | 40.0 | 9.6 | 26.0 | 13.0 | 18.0 | 45° | 150 | 12.00 | 0.24 | 39000 |
| | E12 | 3 | 1 | C4-391.EH-12 029 | 40.0 | 11.6 | 29.0 | 16.0 | 21.0 | 45° | 150 | 15.00 | 0.26 | 39000 |
| | E16 | 3 | 1 | C4-391.EH-16 035 | 40.0 | 15.4 | 35.0 | 22.0 | 27.0 | 45° | 150 | 30.00 | 0.31 | 39000 |
| | E20 | 3 | 1 | C4-391.EH-20 031 | 40.0 | 19.2 | 31.0 | 18.0 | 23.0 | 45° | 150 | 50.00 | 0.34 | 39000 |
| | E25 | 3 | 1 | C4-391.EH-25 038 | 40.0 | 24.1 | 38.0 | 25.0 | 30.0 | 45° | 150 | 65.00 | 0.28 | 39000 |
| C5 | E10 | 3 | 1 | C5-391.EH-10 026 | 50.0 | 9.6 | 26.0 | 13.0 | 18.0 | 45° | 150 | 12.00 | 0.38 | 28000 |
| | E12 | 3 | 1 | C5-391.EH-12 029 | 50.0 | 11.6 | 29.0 | 16.0 | 21.0 | 45° | 150 | 15.00 | 0.40 | 28000 |
| | E16 | 3 | 1 | C5-391.EH-16 035 | 50.0 | 15.4 | 35.0 | 22.0 | 27.0 | 45° | 150 | 30.00 | 0.45 | 28000 |
| | E20 | 3 | 1 | C5-391.EH-20 031 | 50.0 | 19.2 | 31.0 | 18.0 | 23.0 | 45° | 150 | 50.00 | 0.47 | 28000 |
| | E25 | 3 | 1 | C5-391.EH-25 038 | 50.0 | 24.1 | 38.0 | 25.0 | 30.0 | 45° | 150 | 65.00 | 0.53 | 28000 |

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



M1



N23



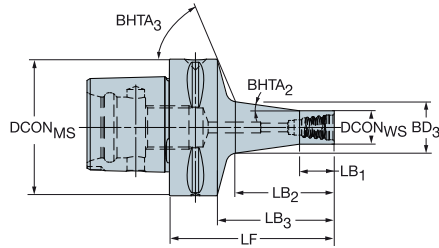
N15



N3

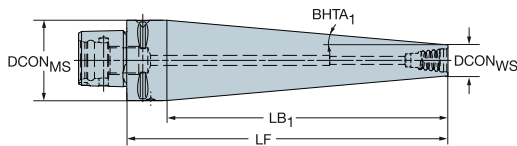
Coromant Capto® to Coromant EH adaptor

Long design



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₃ | BHTA ₂ | BHTA ₃ | BAR | NM | KG | RPMX |
| C3 | E10 | 3 | 1 | C3-391.EH-10 049 | 32.0 | 9.6 | 49.0 | 10.0 | 28.5 | 34.0 | 14.8 | 8° | 57° | 150 | 12.00 | 0.20 | 40000 |
| | E12 | 3 | 1 | C3-391.EH-12 054 | 32.0 | 11.6 | 54.0 | 12.0 | 33.9 | 39.0 | 17.8 | 8° | 54° | 150 | 15.00 | 0.25 | 40000 |
| | E16 | 3 | 1 | C3-391.EH-16 065 | 32.0 | 15.4 | 65.0 | 16.0 | 45.7 | 50.0 | 23.8 | 8° | 44° | 150 | 30.00 | 0.32 | 40000 |
| C4 | E10 | 3 | 1 | C4-391.EH-10 055 | 40.0 | 9.6 | 55.0 | 10.0 | 28.5 | 32.6 | 22.1 | 8° | 62° | 150 | 12.00 | 0.37 | 39000 |
| | E12 | 3 | 1 | C4-391.EH-12 060 | 40.0 | 11.6 | 60.0 | 12.0 | 33.9 | 40.0 | 17.7 | 8° | 61° | 150 | 15.00 | 0.39 | 39000 |
| | E16 | 3 | 1 | C4-391.EH-16 071 | 40.0 | 15.4 | 71.0 | 16.0 | 45.7 | 51.0 | 23.7 | 8° | 56° | 150 | 30.00 | 0.48 | 39000 |
| | E20 | 3 | 1 | C4-391.EH-20 084 | 40.0 | 19.2 | 84.0 | 20.0 | 59.6 | 64.0 | 30.3 | 8° | 47° | 150 | 50.00 | 0.59 | 39000 |
| | E25 | 3 | 1 | C4-391.EH-25 074 | 40.0 | 24.1 | 74.0 | 25.0 | 49.6 | 54.0 | 31.0 | 8° | 45° | 150 | 65.00 | 0.61 | 39000 |
| C5 | E10 | 3 | 1 | C5-391.EH-10 056 | 50.0 | 9.6 | 56.0 | 10.0 | 28.1 | 36.0 | 14.7 | 8° | 65° | 150 | 12.00 | 0.57 | 28000 |
| | E12 | 3 | 1 | C5-391.EH-12 061 | 50.0 | 11.6 | 61.0 | 12.0 | 33.5 | 41.0 | 17.6 | 8° | 65° | 150 | 15.00 | 0.60 | 28000 |
| | E16 | 3 | 1 | C5-391.EH-16 072 | 50.0 | 15.4 | 72.0 | 16.0 | 45.3 | 52.0 | 23.6 | 8° | 63° | 150 | 30.00 | 0.69 | 28000 |
| | E20 | 3 | 1 | C5-391.EH-20 085 | 50.0 | 19.2 | 85.0 | 20.0 | 59.2 | 65.0 | 30.2 | 8° | 59° | 150 | 50.00 | 0.79 | 28000 |
| | E25 | 3 | 1 | C5-391.EH-25 100 | 50.0 | 24.1 | 100.0 | 25.0 | 75.3 | 80.0 | 38.2 | 8° | 51° | 150 | 65.00 | 1.01 | 28000 |
| C6 | E10 | 3 | 1 | C6-391.EH-10 060 | 63.0 | 9.6 | 60.0 | 10.0 | 28.4 | 38.0 | 14.8 | 8° | 68° | 150 | 12.00 | 0.95 | 20000 |
| | E12 | 3 | 1 | C6-391.EH-12 065 | 63.0 | 11.6 | 65.0 | 12.0 | 33.8 | 43.0 | 17.7 | 8° | 67° | 150 | 15.00 | 0.97 | 20000 |
| | E16 | 3 | 1 | C6-391.EH-16 076 | 63.0 | 15.4 | 76.0 | 16.0 | 45.6 | 54.0 | 23.7 | 8° | 66° | 150 | 30.00 | 1.07 | 20000 |
| | E20 | 3 | 1 | C6-391.EH-20 088 | 63.0 | 19.2 | 88.0 | 20.0 | 58.4 | 66.0 | 30.0 | 8° | 65° | 150 | 50.00 | 1.16 | 20000 |
| | E25 | 3 | 1 | C6-391.EH-25 103 | 63.0 | 24.1 | 103.0 | 25.0 | 74.5 | 81.0 | 38.0 | 8° | 62° | 150 | 65.00 | 1.37 | 20000 |
| C8 | E20 | 3 | 1 | C8-391.EH-20 100 | 80.0 | 19.2 | 100.0 | 20.0 | 60.2 | 70.0 | 30.5 | 8° | 68° | 150 | 50.00 | 2.25 | 14000 |
| | E25 | 3 | 1 | C8-391.EH-25 114 | 80.0 | 24.1 | 114.0 | 25.0 | 75.3 | 84.0 | 38.2 | 8° | 68° | 150 | 65.00 | 2.45 | 14000 |

Long conical design



| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|-------|-----------------|-------------------|-----|-------|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BHTA ₁ | BAR | NM | KG | RPMX | | |
| C3 | E10 | 3 | 1 | C3-391.EH-10 143 | 32.0 | 9.6 | 143.0 | 128.0 | 5° | 150 | 12.00 | 0.55 | 40000 | | |
| | E12 | 3 | 1 | C3-391.EH-12 132 | 32.0 | 11.6 | 132.0 | 117.0 | 5° | 150 | 15.00 | 0.56 | 40000 | | |
| | E16 | 3 | 1 | C3-391.EH-16 110 | 32.0 | 15.4 | 110.0 | 95.0 | 5° | 150 | 30.00 | 0.57 | 40000 | | |
| C4 | E10 | 3 | 1 | C4-391.EH-10 128 | 40.0 | 9.6 | 128.0 | 108.0 | 8° | 150 | 12.00 | 0.78 | 39000 | | |
| | E12 | 3 | 1 | C4-391.EH-12 121 | 40.0 | 11.6 | 121.0 | 101.0 | 8° | 150 | 15.00 | 0.78 | 39000 | | |
| | E16 | 3 | 1 | C4-391.EH-16 160 | 40.0 | 15.4 | 160.0 | 140.0 | 5° | 150 | 30.00 | 1.06 | 39000 | | |
| | E20 | 3 | 1 | C4-391.EH-20 139 | 40.0 | 19.2 | 139.0 | 119.0 | 5° | 150 | 50.00 | 1.03 | 39000 | | |
| C5 | E16 | 3 | 1 | C5-391.EH-16 143 | 50.0 | 15.4 | 143.0 | 123.0 | 8° | 150 | 30.00 | 1.43 | 28000 | | |
| | E20 | 3 | 1 | C5-391.EH-20 130 | 50.0 | 19.2 | 130.0 | 110.0 | 8° | 150 | 50.00 | 1.40 | 28000 | | |

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

M1



N23

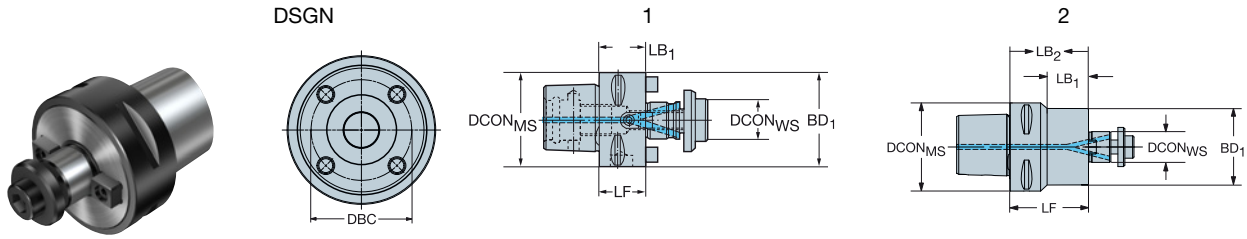


N15



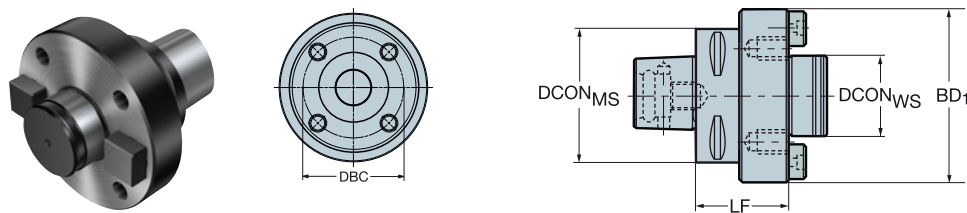
N3

Coromant Capto® to arbor adaptor



Coolant through arbor

| CZC _{MS} | CZC _{WS} | CNCS | CXSC | DSGN | Ordering code | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|---------------------|--------------------|------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|--------|------|-------|--|
| | | | | | | DCON _{MS} | DBC | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX | |
| C3 | 16 | 3 | 4 | 1 | C3-391.05C-16 030 | 32.0 | | 16.0 | 30.0 | 30.0 | | 32.0 | | 80 | 22.00 | 0.25 | 20000 | |
| C4 | 16 | 3 | 4 | 2 | C4-391.05C-16 032 | 40.0 | | 16.0 | 32.0 | 10.0 | 32.0 | 40.0 | 40.0 | 80 | 22.00 | 0.38 | 20000 | |
| | 16 | 3 | 4 | 2 | C4-391.05C-16 055 | 40.0 | | 16.0 | 55.0 | 33.0 | 55.0 | 32.0 | 40.0 | 80 | 22.00 | 0.40 | 20000 | |
| | 22 | 3 | 4 | 1 | C4-391.05C-22 025 | 40.0 | | 22.0 | 25.0 | 25.0 | | 40.0 | | 80 | 45.00 | 0.40 | 16000 | |
| | 22 | 3 | 4 | 1 | C4-391.05C-22 055 | 40.0 | | 22.0 | 55.0 | 55.0 | | 40.0 | | 80 | 45.00 | 0.60 | 16000 | |
| C5 | 16 | 3 | 4 | 2 | C5-391.05C-16 035 | 50.0 | | 16.0 | 35.0 | 10.0 | 35.0 | 32.0 | 50.0 | 80 | 22.00 | 0.60 | 20000 | |
| | 16 | 3 | 4 | 2 | C5-391.05C-16 070 | 50.0 | | 16.0 | 70.0 | 44.8 | 70.0 | 32.0 | 50.0 | 80 | 22.00 | 0.70 | 20000 | |
| | 22 | 3 | 4 | 1 | C5-391.05C-22 025M | 50.0 | | 22.0 | 25.0 | 25.0 | | 50.0 | | 80 | 45.00 | 0.62 | 16000 | |
| | 22 | 3 | 4 | 2 | C5-391.05C-22 070 | 50.0 | | 22.0 | 70.0 | 47.0 | 70.0 | 40.0 | 50.0 | 80 | 45.00 | 0.90 | 16000 | |
| | 27 | 3 | 4 | 1 | C5-391.05C-27 025M | 50.0 | | 27.0 | 25.0 | 25.0 | | 56.0 | | 80 | 80.00 | 0.68 | 17000 | |
| | 32 | 3 | 4 | 1 | C5-391.05C-32 040 | 50.0 | | 32.0 | 40.0 | 40.0 | | 63.0 | | 80 | 180.00 | 1.14 | 16000 | |
| C6 | 16 | 3 | 4 | 2 | C6-391.05C-16 040 | 63.0 | | 16.0 | 40.0 | 10.0 | 40.0 | 32.0 | 63.0 | 80 | 22.00 | 1.00 | 20000 | |
| | 22 | 3 | 4 | 1 | C6-391.05C-22 025M | 63.0 | | 22.0 | 25.0 | 25.0 | | 63.0 | | 80 | 45.00 | 0.96 | 16000 | |
| | 22 | 3 | 4 | 2 | C6-391.05C-22 080 | 63.0 | | 22.0 | 80.0 | 40.0 | 80.0 | 40.0 | 63.0 | 80 | 45.00 | 1.40 | 16000 | |
| | 27 | 3 | 4 | 1 | C6-391.05C-27 025M | 63.0 | | 27.0 | 25.0 | 25.0 | | 63.0 | | 80 | 80.00 | 1.01 | 17000 | |
| | 27 | 3 | 4 | 2 | C6-391.05C-27 080 | 63.0 | | 27.0 | 80.0 | 55.0 | 80.0 | 50.0 | 63.0 | 80 | 80.00 | 1.60 | 17000 | |
| | 32 | 3 | 4 | 1 | C6-391.05C-32 025M | 63.0 | | 32.0 | 25.0 | 25.0 | | 65.0 | | 80 | 180.00 | 1.09 | 16000 | |
| | 40S | 3 | 4 | 1 | C6-391.05C-40 050M | 63.0 | 66.7 | 40.0 | 50.0 | 50.0 | | 87.0 | | 80 | 300.00 | 2.40 | 17000 | |
| C8 | 16 | 3 | 4 | 2 | C8-391.05C-16 050 | 80.0 | | 16.0 | 50.0 | 10.0 | 50.0 | 32.0 | 80.0 | 80 | 22.00 | 2.10 | 14000 | |
| | 22 | 3 | 4 | 1 | C8-391.05C-22 030M | 80.0 | | 22.0 | 30.0 | 30.0 | | 80.0 | | 80 | 45.00 | 1.86 | 14000 | |
| | 22 | 3 | 4 | 2 | C8-391.05C-22 090 | 80.0 | | 22.0 | 90.0 | 45.0 | 90.0 | 40.0 | 80.0 | 80 | 45.00 | 2.40 | 14000 | |
| | 27 | 3 | 4 | 1 | C8-391.05C-27 030M | 80.0 | | 27.0 | 30.0 | 30.0 | | 80.0 | | 80 | 80.00 | 1.91 | 14000 | |
| | 27 | 3 | 4 | 2 | C8-391.05C-27 090 | 80.0 | | 27.0 | 90.0 | 50.0 | 90.0 | 50.0 | 80.0 | 80 | 80.00 | 2.70 | 14000 | |
| | 32 | 3 | 4 | 1 | C8-391.05C-32 030M | 80.0 | | 32.0 | 30.0 | 30.0 | | 80.0 | | 80 | 180.00 | 2.02 | 14000 | |
| | 40S | 3 | 4 | 1 | C8-391.05C-40 060M | 80.0 | 66.7 | 40.0 | 60.0 | 60.0 | | 87.0 | | 80 | 300.00 | 3.47 | 14000 | |
| C10 | 27 | 3 | 4 | 2 | C10-391.05C-27 075 | 100.0 | | 27.0 | 75.0 | 29.0 | 75.0 | 60.0 | 100.0 | 80 | 80.00 | 4.52 | 10000 | |
| | 32 | 3 | 4 | 2 | C10-391.05C-32 075 | 100.0 | | 32.0 | 75.0 | 33.0 | 75.0 | 78.0 | 100.0 | 80 | 180.00 | 5.04 | 10000 | |
| | 40S | 3 | 4 | 1 | C10-391.05C-40 040M | 100.0 | 66.7 | 40.0 | 40.0 | 40.0 | | 100.0 | | 80 | 300.00 | 3.95 | 10000 | |

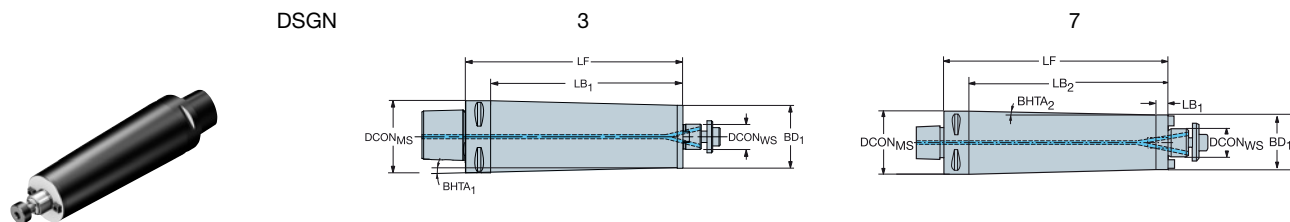


| CZC _{MS} | CZC _{WS} | Ordering code | Dimensions, mm | | | | | | | RPMX |
|-------------------|-------------------|-------------------|--------------------|-------|--------------------|------|-----------------|--------|------|-------|
| | | | DCON _{MS} | DBC | DCON _{WS} | LF | BD ₁ | NM | KG | |
| C8 | 60 | C8-391.05-60 060 | 80.0 | 101.6 | 60.0 | 60.0 | 130.0 | 180.00 | 6.03 | 14000 |
| C10 | 60 | C10-391.05-60 075 | 100.0 | 101.6 | 60.0 | 75.0 | 130.0 | 180.00 | 8.50 | 10000 |

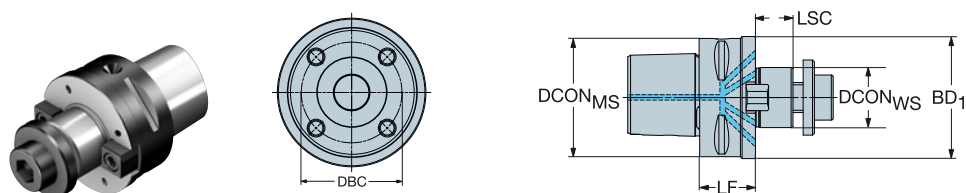
For spare parts, visit www.sandvik.coromant.com



Coromant Capto® to arbor adaptor



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BHTA ₂ | BAR | NM | KG | RPMX |
| C4 | 16 | 3 | 4 | 7 | C4-391.05C-16 120 | 40.0 | 16.0 | 120.0 | 22.0 | 100.0 | 120.0 | 32.0 | 32.0 | 40.0 | 0° | 2° | 80 | 22.00 | 0.99 | 18000 |
| C5 | 22 | 3 | 4 | 7 | C5-391.05C-22 150 | 50.0 | 22.0 | 150.0 | 12.0 | 130.0 | 150.0 | 40.0 | 40.0 | 50.0 | 0° | 2° | 80 | 45.00 | 2.04 | 16000 |
| C6 | 22 | 3 | 4 | 3 | C6-391.05C-22 120 | 63.0 | 22.0 | 120.0 | 98.0 | 120.0 | | 55.0 | 63.0 | | 2° | 0° | 80 | 45.00 | 2.82 | 16000 |
| | 22 | 3 | 4 | 3 | C6-391.05C-22 190 | 63.0 | 22.0 | 190.0 | 168.0 | 190.0 | | 55.0 | 63.0 | | 1° | 0° | 80 | 45.00 | 4.25 | 14000 |
| C8 | 27 | 3 | 4 | 3 | C8-391.05C-27 150 | 80.0 | 27.0 | 150.0 | 120.0 | 150.0 | | 65.0 | 80.0 | | 3° | 0° | 80 | 80.00 | 5.62 | 12000 |
| | 27 | 3 | 4 | 3 | C8-391.05C-27 240 | 80.0 | 27.0 | 240.0 | 210.0 | 240.0 | | 65.0 | 80.0 | | 2° | 0° | 80 | 80.00 | 8.42 | 10000 |



| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|------|--------------------|------|------|-----------------|--------|--------|-------|-------|--|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LSC | LF | BD ₁ | BAR | NM | KG | RPMX | | | | |
| C6 | 32 | 3 | 3 | C6-391.07C-32 030 | 63.0 | 32.0 | 20 | 25.0 | 65.0 | 80 | 180.00 | 1.23 | 12000 | | | | | |
| C8 | 40S | 3 | 3 | C8-391.07C-40 060 | 80.0 | 66.7 | 40.0 | 23 | 60.0 | 87.0 | 80 | 300.00 | 3.48 | 10000 | | | | |

Coolant supply for CoroMill QD with driving collars. For driving collars see page M27.

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



M1



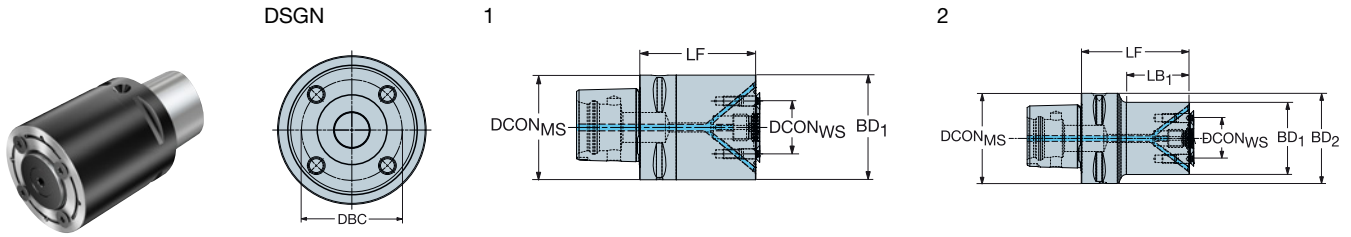
N23



N15

Coromant Capto® to arbor with driving screws adaptor

For CoroMill® QD with internal coolant supply



| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|----------------|--------------------|------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| C3 | X10 | 3 | 3 | 1 | C3-X10-032-040 | 32.0 | 22.0 | 10.0 | 2 | 40.0 | 40.0 | | 32.0 | 40.0 | 80 | 6.40 | 0.28 | 12000 |
| C4 | X10 | 3 | 3 | 2 | C4-X10-032-050 | 40.0 | 22.0 | 10.0 | 2 | 50.0 | 25.5 | 50.0 | 32.0 | 40.0 | 80 | 6.40 | 0.46 | 12000 |
| | X22 | 3 | 3 | 1 | C4-X22-040-050 | 40.0 | 32.0 | 22.0 | 2 | 50.0 | 50.0 | | 40.0 | | 80 | 3.90 | 0.56 | 11000 |
| C5 | X22 | 3 | 3 | 2 | C5-X22-040-060 | 50.0 | 32.0 | 22.0 | 2 | 60.0 | 35.0 | 60.0 | 40.0 | 50.0 | 80 | 3.90 | 0.85 | 11000 |
| | X32 | 3 | 3 | 1 | C5-X32-063-070 | 50.0 | 45.0 | 32.0 | 2 | 70.0 | 70.0 | | 63.0 | | 80 | 6.40 | 1.64 | 10000 |
| C6 | X32 | 3 | 3 | 1 | C6-X32-063-070 | 63.0 | 45.0 | 32.0 | 2 | 70.0 | 70.0 | | 63.0 | | 80 | 6.40 | 1.93 | 10000 |
| | X40 | 3 | 3 | 1 | C6-X40-080-090 | 63.0 | 63.0 | 40.0 | 2 | 90.0 | 90.0 | | 80.0 | | 80 | 70.00 | 3.46 | 8000 |
| C8 | X40 | 3 | 3 | 1 | C8-X40-080-095 | 80.0 | 63.0 | 40.0 | 2 | 95.0 | 95.0 | | 80.0 | | 80 | 70.00 | 4.34 | 8000 |

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



M1

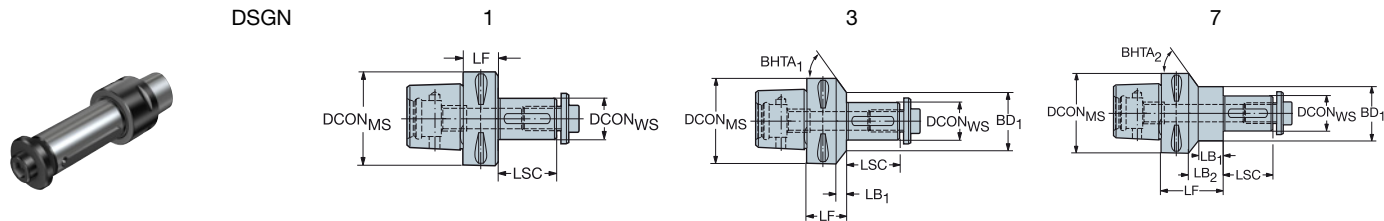


N23



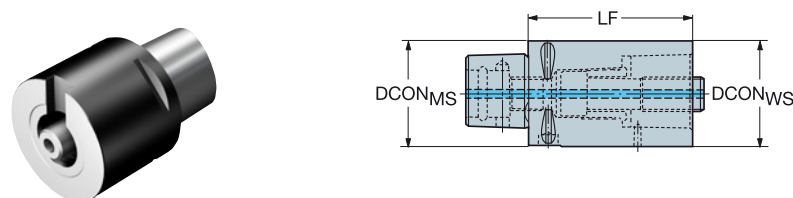
N15

Coromant Capto® to side and face mill arbor adaptor



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|--------------------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BHTA ₂ | BAR | NM | KG | RPMX |
| C3 | 16 | 3 | 1 | 3 | C3-391.10-16 020 | 32.0 | 16.0 | 30 | 20.0 | 5.0 | 20.0 | | 28.0 | 32.0 | | 21° | 0° | 80 | 22.00 | 0.22 | 8000 |
| C4 | 16 | 3 | 1 | 3 | C4-391.10-16 025 | 40.0 | 16.0 | 30 | 25.0 | 5.0 | 25.0 | | 28.0 | 40.0 | | 50° | 0° | 80 | 22.00 | 0.37 | 8000 |
| | 22 | 3 | 1 | 3 | C4-391.10-22 025 | 40.0 | 22.0 | 40 | 25.0 | 5.0 | 25.0 | | 36.0 | 40.0 | | 22° | 0° | 80 | 45.00 | 0.46 | 8000 |
| | 27 | 3 | 1 | 1 | C4-391.10-27 025 | 40.0 | 27.0 | 60 | 25.0 | 25.0 | | | 40.0 | | | | | 80 | 80.00 | 0.62 | 7000 |
| C5 | 22 | 3 | 1 | 3 | C5-391.10-22 025 | 50.0 | 22.0 | 40 | 25.0 | 5.1 | 25.0 | | 36.0 | 50.0 | | 54° | 0° | 80 | 45.00 | 0.72 | 8000 |
| | 27 | 3 | 1 | 3 | C5-391.10-27 025 | 50.0 | 27.0 | 60 | 25.0 | 5.0 | 25.0 | | 43.0 | 50.0 | | 35° | 0° | 80 | 80.00 | 0.83 | 7000 |
| | 32 | 3 | 1 | 1 | C5-391.10-32 025 | 50.0 | 32.0 | 60 | 25.0 | 25.0 | | | 50.0 | | | | | 80 | 180.00 | 0.96 | 6000 |
| C6 | 16 | 3 | 1 | 3 | C6-391.10-16 030 | 63.0 | 16.0 | 30 | 30.0 | 7.8 | 30.0 | | 28.0 | 63.0 | | 66° | 0° | 80 | 22.00 | 0.97 | 10000 |
| | 22 | 3 | 1 | 3 | C6-391.10-22 030 | 63.0 | 22.0 | 40 | 30.0 | 7.9 | 30.0 | | 36.0 | 63.0 | | 59° | 0° | 80 | 45.00 | 1.10 | 8000 |
| | 27 | 3 | 1 | 3 | C6-391.10-27 030 | 63.0 | 27.0 | 60 | 30.0 | 7.8 | 30.0 | | 43.0 | 63.0 | | 52° | 0° | 80 | 80.00 | 1.25 | 7000 |
| | 32 | 3 | 1 | 3 | C6-391.10-32 025 | 63.0 | 32.0 | 60 | 25.0 | 3.0 | 25.0 | | 48.0 | 63.0 | | 68° | 0° | 80 | 180.00 | 1.30 | 6000 |
| | 40 | 3 | 1 | 3 | C6-391.10-40 025 | 63.0 | 40.0 | 60 | 25.0 | 3.0 | 25.0 | | 56.0 | 63.0 | | 49° | 0° | 80 | 300.00 | 1.57 | 5000 |
| C8 | 22 | 3 | 1 | 3 | C8-391.10-22 040 | 80.0 | 22.0 | 40 | 40.0 | 10.2 | 40.0 | | 36.0 | 80.0 | | 65° | 0° | 80 | 45.00 | 2.26 | 8000 |
| | 27 | 3 | 1 | 3 | C8-391.10-27 030 | 80.0 | 27.0 | 60 | 30.0 | 7.8 | 30.0 | | 43.0 | 80.0 | | 67° | 0° | 80 | 80.00 | 2.00 | 7000 |
| | 32 | 3 | 1 | 3 | C8-391.10-32 030 | 80.0 | 32.0 | 60 | 30.0 | 7.6 | 30.0 | | 48.0 | 80.0 | | 64° | 0° | 80 | 180.00 | 2.12 | 6000 |
| | 40 | 3 | 1 | 3 | C8-391.10-40 030 | 80.0 | 40.0 | 60 | 30.0 | 7.9 | 30.0 | | 56.0 | 80.0 | | 56° | 0° | 80 | 300.00 | 2.38 | 5000 |
| | 50 | 3 | 1 | 3 | C8-391.10-50 030 | 80.0 | 50.0 | 60 | 30.0 | 3.0 | 30.0 | | 70.0 | 80.0 | | 58° | 0° | 80 | 120.00 | 2.90 | 4500 |
| | 60 | 3 | 1 | 1 | C8-391.10-60 030 | 80.0 | 60.0 | 60 | 30.0 | 30.0 | | | 80.0 | | | | | 80 | 180.00 | 3.51 | 4000 |
| C10 | 32 | 3 | 1 | 7 | C10-391.10-32 065 | 100.0 | 32.0 | 60 | 65.0 | 20.0 | 29.0 | 65.0 | 48.0 | 48.0 | 100.0 | 0° | 71° | 80 | 180.00 | 4.43 | 6000 |
| | 40 | 3 | 1 | 7 | C10-391.10-40 070 | 100.0 | 40.0 | 60 | 70.0 | 25.0 | 34.0 | 70.0 | 56.0 | 56.0 | 100.0 | 0° | 67° | 80 | 300.00 | 4.87 | 5000 |
| | 50 | 3 | 1 | 7 | C10-391.10-50 055 | 100.0 | 50.0 | 80 | 55.0 | 10.0 | 19.0 | 55.0 | 70.0 | 70.0 | 100.0 | 0° | 59° | 80 | 120.00 | 5.44 | 4500 |
| | 60 | 3 | 1 | 3 | C10-391.10-60 040 | 100.0 | 60.0 | 90 | 40.0 | 4.0 | 40.0 | | 84.0 | 100.0 | | 63° | 0° | 80 | 180.00 | 5.93 | 4000 |

Coromant Capto® to VL adaptor



| | | | | | Dimensions, mm | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | BAR | NM | KG |
| C8 | 80 | 3 | 1 | C8-391.01-V80 065 | 80.0 | 80.0 | 65.0 | 80 | 170.00 | 3.05 |

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

M1



N23



N15

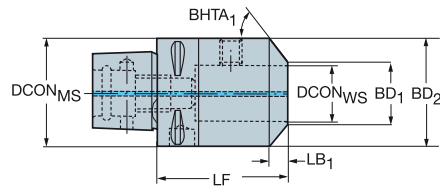
Coromant Capto® to Weldon adaptor

Workpiece side interface DIN 6535-HB and DIN 1835-B

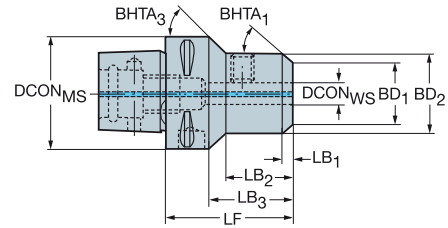


DSGN

3



14



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-------|-------|------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | BHTA ₃ | (BAR) | (NM) | (KG) | RPMX | |
| C3 | 6 | 3 | 1 | 14 | C3-391.20-06 045A | 32.0 | 6.0 | 46.0 | 4.0 | 27.5 | 29.5 | 46.0 | 17.0 | 25.0 | 25.0 | 32.0 | 45° | 60° | 20 | 3.00 | 0.24 | 32000 | |
| | 8 | 3 | 1 | 14 | C3-391.20-08 045A | 32.0 | 8.0 | 46.0 | 4.0 | 29.0 | 31.0 | 46.0 | 20.0 | 28.0 | 28.0 | 32.0 | 45° | | 20 | 7.00 | 0.26 | 32000 | |
| | 10 | 3 | 1 | 3 | C3-391.20-10 050 | 32.0 | 10.0 | 50.0 | 4.0 | 50.0 | | | 27.0 | 35.0 | | | 45° | | 20 | 10.00 | 0.40 | 32000 | |
| | 12 | 3 | 1 | 3 | C3-391.20-12 055 | 32.0 | 12.0 | 55.0 | 5.0 | 55.0 | | | 32.0 | 42.0 | | | 45° | | 20 | 12.00 | 0.51 | 32000 | |
| C4 | 6 | 3 | 1 | 14 | C4-391.20-06 050 | 40.0 | 6.0 | 50.0 | 4.0 | 25.5 | 29.8 | 50.0 | 17.0 | 25.0 | 25.0 | 40.0 | 45° | 60° | 20 | 3.00 | 0.40 | 30000 | |
| | 8 | 3 | 1 | 14 | C4-391.20-08 050 | 40.0 | 8.0 | 50.0 | 4.0 | 26.5 | 32.5 | 50.0 | 20.0 | 28.0 | 28.0 | 40.0 | 45° | 45° | 20 | 7.00 | 0.40 | 30000 | |
| | 10 | 3 | 1 | 14 | C4-391.20-10 050A | 40.0 | 10.0 | 51.0 | 4.0 | 29.6 | 31.0 | 51.0 | 27.0 | 35.0 | 35.0 | 40.0 | 45° | 60° | 20 | 10.00 | 0.50 | 30000 | |
| | 12 | 3 | 1 | 3 | C4-391.20-12 055A | 40.0 | 12.0 | 56.0 | 5.0 | 56.0 | | | 32.0 | 42.0 | | | 45° | | 20 | 12.00 | 0.61 | 30000 | |
| | 14 | 3 | 1 | 3 | C4-391.20-14 055 | 40.0 | 14.0 | 55.0 | 5.0 | 55.0 | | | 34.0 | 44.0 | | | 45° | | 20 | 12.00 | 0.62 | 30000 | |
| | 16 | 3 | 1 | 3 | C4-391.20-16 055 | 40.0 | 16.0 | 55.0 | 5.0 | 55.0 | | | 38.0 | 48.0 | | | 45° | | 20 | 15.00 | 0.70 | 30000 | |
| C5 | 6 | 3 | 1 | 14 | C5-391.20-06 050 | 50.0 | 6.0 | 50.0 | 4.0 | 25.5 | 30.0 | 50.0 | 17.0 | 25.0 | 25.0 | 50.0 | 45° | 70° | 20 | 3.00 | 0.62 | 28000 | |
| | 8 | 3 | 1 | 14 | C5-391.20-08 050 | 50.0 | 8.0 | 50.0 | 4.0 | 26.0 | 30.0 | 50.0 | 20.0 | 28.0 | 28.0 | 50.0 | 45° | 70° | 20 | 7.00 | 0.60 | 28000 | |
| | 10 | 3 | 1 | 14 | C5-391.20-10 055 | 50.0 | 10.0 | 55.0 | 4.0 | 27.5 | 35.0 | 55.0 | 27.0 | 35.0 | 35.0 | 50.0 | 45° | 45° | 20 | 10.00 | 0.72 | 28000 | |
| | 12 | 3 | 1 | 14 | C5-391.20-12 060 | 50.0 | 12.0 | 60.0 | 5.0 | 36.0 | 40.0 | 60.0 | 32.0 | 42.0 | 42.0 | 50.0 | 45° | 45° | 20 | 12.00 | 0.90 | 28000 | |
| | 14 | 3 | 1 | 14 | C5-391.20-14 060 | 50.0 | 14.0 | 60.0 | 5.0 | 37.0 | 40.0 | 60.0 | 34.0 | 44.0 | 44.0 | 50.0 | 45° | 45° | 20 | 12.00 | 0.90 | 28000 | |
| | 16 | 3 | 1 | 14 | C5-391.20-16 060 | 50.0 | 16.0 | 60.0 | 5.0 | 39.0 | 40.0 | 60.0 | 38.0 | 48.0 | 48.0 | 50.0 | 45° | 45° | 20 | 15.00 | 1.00 | 28000 | |
| | 18 | 3 | 1 | 3 | C5-391.20-18 060 | 50.0 | 18.0 | 60.0 | 5.0 | 60.0 | | | 40.0 | 50.0 | | | 45° | | 20 | 15.00 | 0.95 | 28000 | |
| | 20 | 3 | 1 | 3 | C5-391.20-20 060 | 50.0 | 20.0 | 60.0 | 5.0 | 60.0 | | | 42.0 | 52.0 | | | 45° | | 20 | 20.00 | 1.00 | 28000 | |
| | 25 | 3 | 1 | 3 | C5-391.20-25 080 | 50.0 | 25.0 | 80.0 | 8.0 | 80.0 | | | 49.0 | 65.0 | | | 45° | | 20 | 25.00 | 1.68 | 28000 | |
| C6 | 6 | 3 | 1 | 14 | C6-391.20-06 055 | 63.0 | 6.0 | 55.0 | 4.0 | 25.0 | 32.7 | 55.0 | 17.0 | 25.0 | 25.0 | 63.0 | 45° | 68° | 20 | 3.00 | 0.99 | 20000 | |
| | 8 | 3 | 1 | 14 | C6-391.20-08 055 | 63.0 | 8.0 | 55.0 | 4.0 | 26.0 | 33.1 | 55.0 | 20.0 | 28.0 | 28.0 | 63.0 | 45° | 68° | 20 | 7.00 | 1.00 | 20000 | |
| | 10 | 3 | 1 | 14 | C6-391.20-10 060 | 63.0 | 10.0 | 60.0 | 4.0 | 30.0 | 38.1 | 60.0 | 27.0 | 35.0 | 35.0 | 63.0 | 45° | 60° | 20 | 10.00 | 1.12 | 20000 | |
| | 12 | 3 | 1 | 14 | C6-391.20-12 060 | 63.0 | 12.0 | 60.0 | 5.0 | 33.0 | 37.9 | 60.0 | 32.0 | 42.0 | 42.0 | 63.0 | 45° | 65° | 20 | 12.00 | 1.20 | 20000 | |
| | 14 | 3 | 1 | 14 | C6-391.20-14 060 | 63.0 | 14.0 | 60.0 | 5.0 | 33.5 | 37.9 | 60.0 | 34.0 | 44.0 | 44.0 | 63.0 | 45° | 65° | 20 | 12.00 | 1.20 | 20000 | |
| | 16 | 3 | 1 | 14 | C6-391.20-16 065 | 63.0 | 16.0 | 65.0 | 5.0 | 35.5 | 43.0 | 65.0 | 38.0 | 48.0 | 48.0 | 63.0 | 45° | 45° | 20 | 15.00 | 1.36 | 20000 | |
| | 18 | 3 | 1 | 14 | C6-391.20-18 065 | 63.0 | 18.0 | 65.0 | 5.0 | 39.0 | 42.7 | 65.0 | 40.0 | 50.0 | 50.0 | 63.0 | 45° | 60° | 20 | 15.00 | 1.38 | 20000 | |
| | 20 | 3 | 1 | 14 | C6-391.20-20 065 | 63.0 | 20.0 | 65.0 | 5.0 | 37.5 | 43.0 | 65.0 | 42.0 | 52.0 | 52.0 | 63.0 | 45° | 45° | 20 | 20.00 | 1.30 | 20000 | |
| | 25 | 3 | 1 | 3 | C6-391.20-25 080 | 63.0 | 25.0 | 80.0 | 8.0 | 80.0 | | | 49.0 | 65.0 | | | 45° | | 20 | 25.00 | 2.00 | 20000 | |
| | 32 | 3 | 1 | 3 | C6-391.20-32 090 | 63.0 | 32.0 | 90.0 | 8.0 | 90.0 | | | 56.0 | 72.0 | | | 45° | | 20 | 45.00 | 2.48 | 20000 | |
| | 40 | 3 | 1 | 3 | C6-391.20-40 100 | 63.0 | 40.0 | 100.0 | 8.0 | 100.0 | | | 74.0 | 90.0 | | | 45° | | 20 | 45.00 | 3.88 | 20000 | |
| C8 | 6 | 3 | 1 | 14 | C8-391.20-06 070 | 80.0 | 6.0 | 70.0 | 4.0 | 27.0 | 40.0 | 70.0 | 17.0 | 25.0 | 25.0 | 80.0 | 45° | 65° | 20 | 3.00 | 2.18 | 14000 | |
| | 8 | 3 | 1 | 14 | C8-391.20-08 070 | 80.0 | 8.0 | 70.0 | 4.0 | 28.0 | 40.0 | 70.0 | 20.0 | 28.0 | 28.0 | 80.0 | 45° | 65° | 20 | 7.00 | 2.18 | 14000 | |
| | 10 | 3 | 1 | 14 | C8-391.20-10 070 | 80.0 | 10.0 | 70.0 | 4.0 | 29.5 | 40.0 | 70.0 | 27.0 | 35.0 | 35.0 | 80.0 | 45° | 65° | 20 | 10.00 | 2.22 | 14000 | |
| | 12 | 3 | 1 | 14 | C8-391.20-12 070 | 80.0 | 12.0 | 70.0 | 5.0 | 31.0 | 40.0 | 70.0 | 32.0 | 42.0 | 42.0 | 80.0 | 45° | 65° | 20 | 12.00 | 2.31 | 14000 | |
| | 14 | 3 | 1 | 14 | C8-391.20-14 070 | 80.0 | 14.0 | 70.0 | 5.0 | 31.6 | 40.0 | 70.0 | 34.0 | 44.0 | 44.0 | 80.0 | 45° | 65° | 20 | 12.00 | 2.38 | 14000 | |
| | 16 | 3 | 1 | 14 | C8-391.20-16 070 | 80.0 | 16.0 | 70.0 | 5.0 | 33.0 | 40.0 | 70.0 | 38.0 | 48.0 | 48.0 | 80.0 | 45° | 65° | 20 | 15.00 | 2.38 | 14000 | |
| | 18 | 3 | 1 | 14 | C8-391.20-18 070 | 80.0 | 18.0 | 70.0 | 5.0 | 33.0 | 40.0 | 70.0 | 40.0 | 50.0 | 50.0 | 80.0 | 45° | 65° | 20 | 15.00 | 2.40 | 14000 | |
| | 20 | 3 | 1 | 14 | C8-391.20-20 070 | 80.0 | 20.0 | 70.0 | 5.0 | 35.5 | 40.0 | 70.0 | 42.0 | 52.0 | 52.0 | 80.0 | 45° | 70° | 20 | 20.00 | 2.39 | 14000 | |
| | 25 | 3 | 1 | 14 | C8-391.20-25 080 | 80.0 | 25.0 | 80.0 | 8.0 | 53.7 | 58.0 | 80.0 | 49.0 | 65.0 | 65.0 | 80.0 | 45° | 60° | 20 | 25.00 | 2.73 | 14000 | |
| | 32 | 3 | 1 | 14 | C8-391.20-32 080 | 80.0 | 32.0 | 80.0 | 8.0 | 55.7 | 58.0 | 80.0 | 56.0 | 72.0 | 72.0 | 80.0 | 45° | 60° | 20 | 45.00 | 2.88 | 14000 | |
| | 40 | 3 | 1 | 3 | C8-391.20-40 110 | 80.0 | 40.0 | 110.0 | 8.0 | 110.0 | | | 74.0 | 90.0 | | | 45° | | 20 | 45.00 | 5.05 | 14000 | |
| | 50 | 3 | 1 | 3 | C8-391.20-50 120 | 80.0 | 50.0 | 120.0 | 8.0 | 120.0 | | | 84.0 | 100.0 | | | 45° | | 20 | 60.00 | 5.91 | 14000 | |

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M1

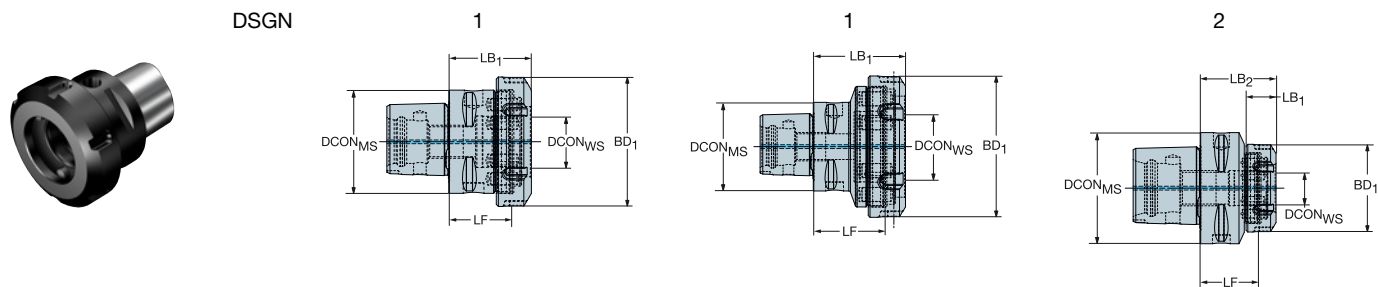


N23



N15

Coromant Capto® to MDI adaptor



| | | | | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|----------------|--------------------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| C3 | MDI-20 | 3 | 1 | 1 | C3-DM20-N-032 | 32.0 | 20.0 | 32.0 | 42.0 | | 49.7 | | 80 | 135.00 | 0.31 | 55000 |
| C4 | MDI-20 | 3 | 1 | 1 | C4-DM20-N-028 | 40.0 | 20.0 | 28.0 | 38.0 | | 49.7 | | 80 | 135.00 | 0.40 | 39000 |
| | MDI-25 | 3 | 1 | 1 | C4-DM25-N-035 | 40.0 | 25.0 | 35.0 | 45.0 | | 62.7 | | 80 | 170.00 | 0.58 | 39000 |
| C4 | MDI-32 | 3 | 1 | 1 | C4-DM32-N-042 | 40.0 | 32.0 | 42.0 | 52.0 | | 67.7 | | 80 | 200.00 | 0.71 | 39000 |
| | MDI-20 | 3 | 1 | 2 | C5-DM20-N-028 | 50.0 | 20.0 | 28.0 | 18.0 | 38.0 | 49.7 | 50.0 | 80 | 135.00 | 0.57 | 28000 |
| C5 | MDI-25 | 3 | 1 | 1 | C5-DM25-N-030 | 50.0 | 25.0 | 30.0 | 40.0 | | 62.7 | | 80 | 170.00 | 0.67 | 28000 |
| | MDI-32 | 3 | 1 | 1 | C5-DM32-N-035 | 50.0 | 32.0 | 35.0 | 45.0 | | 67.7 | | 80 | 200.00 | 0.77 | 28000 |
| C5 | MDI-40 | 3 | 1 | 1 | C5-DM40-N-040 | 50.0 | 40.0 | 40.0 | 52.0 | | 79.7 | | 80 | 230.00 | 1.00 | 28000 |
| | MDI-20 | 3 | 1 | 2 | C6-DM20-N-033 | 63.0 | 20.0 | 33.0 | 18.0 | 43.0 | 49.7 | 63.0 | 80 | 135.00 | 0.96 | 20000 |
| C6 | MDI-25 | 3 | 1 | 2 | C6-DM25-N-030 | 63.0 | 25.0 | 30.0 | 18.0 | 40.0 | 62.7 | 63.0 | 80 | 170.00 | 1.00 | 20000 |
| | MDI-32 | 3 | 1 | 1 | C6-DM32-N-030 | 63.0 | 32.0 | 30.0 | 40.0 | | 67.7 | | 80 | 200.00 | 0.99 | 20000 |
| C6 | MDI-40 | 3 | 1 | 1 | C6-DM40-N-040 | 63.0 | 40.0 | 40.0 | 52.0 | | 79.7 | | 80 | 230.00 | 1.34 | 20000 |
| | MDI-32 | 3 | 1 | 2 | C8-DM32-N-040 | 80.0 | 32.0 | 40.0 | 18.0 | 50.0 | 67.7 | 80.0 | 80 | 200.00 | 2.01 | 14000 |
| C8 | MDI-40 | 3 | 1 | 2 | C8-DM40-N-040 | 80.0 | 40.0 | 40.0 | 22.0 | 52.0 | 79.7 | 80.0 | 80 | 230.00 | 2.09 | 14000 |

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M1



N23



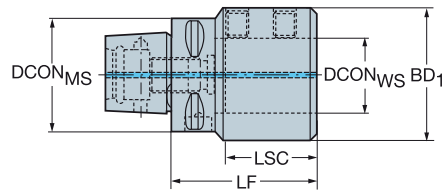
N15

Coromant Capto® to ISO 9766 adaptor

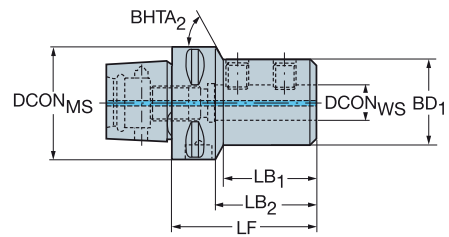


DSGN

1



7



| | | Dimensions, mm | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|------------------|-------------------|--------------------|--------------------|-------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------|-------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₂ | BAR | NM | KG | RPMX |
| C3 | 16 | 3 | 1 | 1 | C3-391.27-16 056 | 32.0 | 16.0 | 49 | 56.0 | 56.0 | | | 36.0 | | | | 20 | 10.00 | 0.40 | 32000 |
| | 20 | 3 | 1 | 1 | C3-391.27-20 060 | 32.0 | 20.0 | 51 | 60.0 | 60.0 | | | 40.0 | | | | 20 | 12.00 | 0.46 | 32000 |
| | 25 | 3 | 1 | 1 | C3-391.27-25 080 | 32.0 | 25.0 | 57 | 80.0 | 80.0 | | | 45.0 | | | | 20 | 20.00 | 0.70 | 32000 |
| C4 | 16 | 3 | 1 | 7 | C4-391.27-16 056 | 40.0 | 16.0 | 49 | 56.0 | 32.5 | 36.0 | 56.0 | 36.0 | 36.0 | 40.0 | 30° | 20 | 10.00 | 0.49 | 30000 |
| | 20 | 3 | 1 | 1 | C4-391.27-20 060 | 40.0 | 20.0 | 51 | 60.0 | 60.0 | | | 40.0 | | | | 20 | 12.00 | 0.55 | 30000 |
| | 25 | 3 | 1 | 1 | C4-391.27-25 077 | 40.0 | 25.0 | 57 | 77.0 | 77.0 | | | 45.0 | | | | 20 | 20.00 | 0.75 | 30000 |
| | 32 | 3 | 1 | 1 | C4-391.27-32 088 | 40.0 | 32.0 | 61 | 88.0 | 88.0 | | | 52.0 | | | | 20 | 30.00 | 0.99 | 30000 |
| C5 | 16 | 3 | 1 | 7 | C5-391.27-16 065 | 50.0 | 16.0 | 49 | 65.0 | 41.7 | 45.0 | 65.0 | 36.0 | 36.0 | 50.0 | 65° | 20 | 10.00 | 0.75 | 28000 |
| | 20 | 3 | 1 | 7 | C5-391.27-20 060 | 50.0 | 20.0 | 51 | 60.0 | 37.7 | 40.0 | 60.0 | 40.0 | 40.0 | 50.0 | 65° | 20 | 12.00 | 0.74 | 28000 |
| | 25 | 3 | 1 | 7 | C5-391.27-25 071 | 50.0 | 25.0 | 57 | 71.0 | 46.7 | 51.0 | 71.0 | 45.0 | 45.0 | 50.0 | 30° | 20 | 20.00 | 0.46 | 28000 |
| | 32 | 3 | 1 | 1 | C5-391.27-32 075 | 50.0 | 32.0 | 61 | 75.0 | 75.0 | | | 52.0 | | | | 20 | 30.00 | 0.97 | 28000 |
| | 40 | 3 | 1 | 1 | C5-391.27-40 100 | 50.0 | 40.0 | 71 | 100.0 | 100.0 | | | 65.0 | | | | 20 | 40.00 | 1.79 | 28000 |
| C6 | 16 | 3 | 1 | 7 | C6-391.27-16 070 | 63.0 | 16.0 | 49 | 70.0 | 43.0 | 47.9 | 70.0 | 36.0 | 36.0 | 63.0 | 70° | 20 | 10.00 | 1.14 | 20000 |
| | 20 | 3 | 1 | 7 | C6-391.27-20 070 | 63.0 | 20.0 | 51 | 70.0 | 43.8 | 48.0 | 70.0 | 40.0 | 40.0 | 63.0 | 70° | 20 | 12.00 | 1.18 | 20000 |
| | 25 | 3 | 1 | 7 | C6-391.27-25 070A | 63.0 | 25.0 | 57 | 72.0 | 45.8 | 50.0 | 72.0 | 45.0 | 45.0 | 63.0 | 65° | 20 | 20.00 | 1.23 | 20000 |
| | 32 | 3 | 1 | 7 | C6-391.27-32 075 | 63.0 | 32.0 | 61 | 75.0 | 49.8 | 53.0 | 75.0 | 52.0 | 52.0 | 63.0 | 60° | 20 | 30.00 | 1.30 | 20000 |
| | 40 | 3 | 1 | 1 | C6-391.27-40 085 | 63.0 | 40.0 | 71 | 85.0 | 85.0 | | | 65.0 | | | | 20 | 40.00 | 1.74 | 20000 |
| C8 | 16 | 3 | 1 | 7 | C8-391.27-16 080 | 80.0 | 16.0 | 49 | 80.0 | 42.0 | 50.0 | 80.0 | 36.0 | 36.0 | 80.0 | 70° | 20 | 10.00 | 2.25 | 14000 |
| | 20 | 3 | 1 | 7 | C8-391.27-20 080 | 80.0 | 20.0 | 51 | 80.0 | 43.8 | 49.9 | 80.0 | 40.0 | 40.0 | 80.0 | 73° | 20 | 12.00 | 2.26 | 14000 |
| | 25 | 3 | 1 | 7 | C8-391.27-25 085 | 80.0 | 25.0 | 57 | 85.0 | 49.8 | 55.1 | 85.0 | 45.0 | 45.0 | 80.0 | 73° | 20 | 20.00 | 2.32 | 14000 |
| | 32 | 3 | 1 | 7 | C8-391.27-32 090 | 80.0 | 32.0 | 61 | 90.0 | 53.8 | 60.0 | 90.0 | 52.0 | 52.0 | 80.0 | 66° | 20 | 30.00 | 2.46 | 14000 |
| | 40 | 3 | 1 | 7 | C8-391.27-40 095 | 80.0 | 40.0 | 71 | 95.0 | 62.8 | 65.1 | 95.0 | 65.0 | 65.0 | 80.0 | 73° | 20 | 40.00 | 2.78 | 14000 |
| 50 | 3 | 1 | 7 | C8-391.27-50 100 | 80.0 | 50.0 | 81 | 100.0 | 68.6 | 70.0 | 100.0 | 75.0 | 75.0 | 80.0 | 61° | 20 | 45.00 | 2.94 | 14000 | |

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



M1

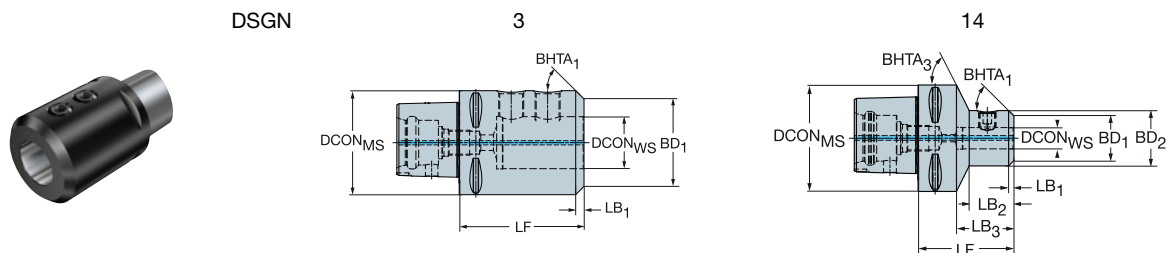


N23



N15

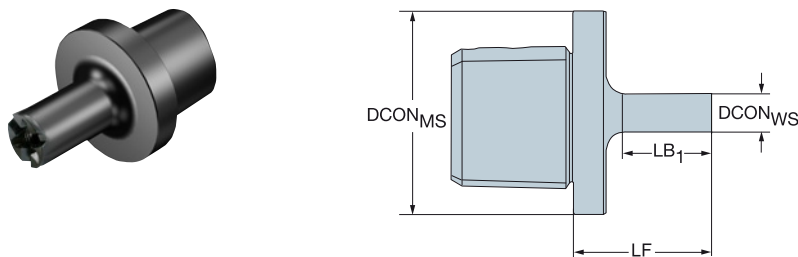
Coromant Capto® to Weldon / ISO 9766 adaptor



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | BHTA ₃ | BAR | NM | KG | RPMX |
| C10 | 20 | 3 | 1 | 14 | C10-391.23-20 090 | 100.0 | 20.0 | 90.0 | 5.0 | 42.0 | 54.0 | 90.0 | 42.0 | 52.0 | 52.0 | 100.0 | 45° | 63° | 20 | 20.00 | 4.00 | 10000 |
| | 25 | 3 | 1 | 14 | C10-391.23-25 105 | 100.0 | 25.0 | 105.0 | 8.0 | 61.0 | 69.0 | 105.0 | 49.0 | 65.0 | 65.0 | 100.0 | 45° | 65° | 20 | 25.00 | 5.09 | 10000 |
| | 32 | 3 | 1 | 14 | C10-391.23-32 110 | 100.0 | 32.0 | 110.0 | 8.0 | 66.0 | 74.0 | 110.0 | 56.0 | 72.0 | 72.0 | 100.0 | 45° | 60° | 20 | 45.00 | 5.41 | 10000 |
| | 40 | 3 | 1 | 14 | C10-391.23-40 115 | 100.0 | 40.0 | 115.0 | 8.0 | 76.0 | 79.0 | 115.0 | 74.0 | 90.0 | 90.0 | 100.0 | 45° | 59° | 20 | 45.00 | 6.58 | 10000 |
| | 50 | 3 | 1 | 3 | C10-391.23-50 120 | 100.0 | 50.0 | 120.0 | 8.0 | 120.0 | | | 84.0 | 100.0 | | | 45° | | 20 | 60.00 | 7.20 | 10000 |

Coromant Capto® to CoroMill® 327 adaptor

Short design, for segment clamping only



| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|-------------------|--|--|--------------------|--------------------|------|-----------------|------|------|-------|--|--|--|--|
| CZC _{MS} | CZC _{WS} | Ordering code | | | DCON _{MS} | DCON _{WS} | LF | LB ₁ | NM | KG | RPMX | | | | |
| C3 | 09 | C3-391.327-09 035 | | | 32.0 | 9.0 | 35.0 | 22.0 | 4.30 | 0.14 | 55000 | | | | |
| C4 | 09 | C4-391.327-09 035 | | | 40.0 | 9.0 | 35.0 | 22.0 | 4.30 | 0.21 | 39000 | | | | |
| | 12 | C4-391.327-12 043 | | | 40.0 | 12.0 | 43.0 | 30.0 | 6.50 | 0.29 | 39000 | | | | |
| C5 | 12 | C5-391.327-12 043 | | | 50.0 | 12.0 | 43.0 | 30.0 | 6.50 | 0.41 | 28000 | | | | |
| | 14 | C5-391.327-14 048 | | | 50.0 | 14.3 | 48.0 | 35.0 | 6.50 | 0.43 | 28000 | | | | |

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M1



N23



N15

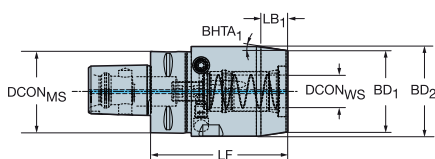
Coromant Capto® to CoroChuck™ 930

Heavy Duty design

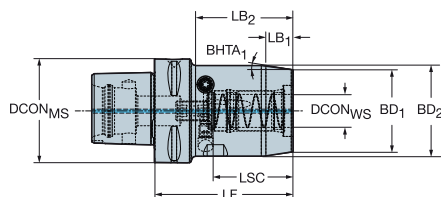


DSGN

3



6



| | | Dimensions, mm | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|------|-------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | RPMX |
| C4 | 20 | 3 | 1 | 3 | 930-C4-HD-20-084 | 40.0 | 20.0 | 51 | 84.0 | 17.8 | 84.0 | | 50.0 | 55.0 | | 8° | 80 | 10.00 | 1.25 | 39000 |
| C5 | 20 | 3 | 1 | 3 | 930-C5-HD-20-082 | 50.0 | 20.0 | 51 | 82.0 | 17.8 | 82.0 | | 50.0 | 55.0 | | 8° | 80 | 10.00 | 1.40 | 28000 |
| | 25 | 3 | 1 | 3 | 930-C5-HD-25-088 | 50.0 | 25.0 | 57 | 88.0 | 18.8 | 88.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 1.86 | 28000 |
| C6 | 20 | 3 | 1 | 6 | 930-C6-HD-20-084 | 63.0 | 20.0 | 51 | 84.0 | 17.8 | 59.0 | 84.0 | 50.0 | 55.0 | 63.0 | 8° | 80 | 10.00 | 1.76 | 20000 |
| | 25 | 3 | 1 | 3 | 930-C6-HD-25-087 | 63.0 | 25.0 | 57 | 87.0 | 18.8 | 87.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 2.16 | 20000 |
| | 25 | 3 | 1 | 3 | 930-C6-HD-25-150 | 63.0 | 25.0 | 57 | 150.0 | 18.8 | 150.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 3.63 | 20000 |
| C8 | 32 | 3 | 1 | 3 | 930-C6-HD-32-091 | 63.0 | 32.0 | 61 | 91.0 | 18.8 | 91.0 | | 68.0 | 76.0 | | 12° | 80 | 10.00 | 2.75 | 20000 |
| | 20 | 3 | 1 | 6 | 930-C8-HD-20-097 | 80.0 | 20.0 | 51 | 97.0 | 17.8 | 62.0 | 97.0 | 50.0 | 55.0 | 80.0 | 8° | 80 | 10.00 | 2.88 | 14000 |
| | 25 | 3 | 1 | 6 | 930-C8-HD-25-097 | 80.0 | 25.0 | 57 | 97.0 | 18.8 | 63.0 | 97.0 | 57.0 | 65.0 | 80.0 | 12° | 80 | 10.00 | 3.22 | 14000 |
| | 32 | 3 | 1 | 6 | 930-C8-HD-32-085 | 80.0 | 32.0 | 61 | 85.0 | 18.8 | 53.3 | 85.0 | 67.8 | 76.0 | 80.0 | 12° | 80 | 10.00 | 3.25 | 14000 |
| C10 | 32 | 3 | 1 | 6 | 930-C8-HD-32-180 | 80.0 | 32.0 | 61 | 180.0 | 18.8 | 148.0 | 180.0 | 68.0 | 76.0 | 80.0 | 12° | 80 | 10.00 | 6.54 | 14000 |
| | 20 | 3 | 1 | 6 | 930-C10-HD-20-102 | 100.0 | 20.0 | 51 | 102.0 | 17.8 | 59.0 | 102.0 | 50.0 | 55.0 | 100.0 | 8° | 80 | 10.00 | 4.49 | 10000 |
| | 25 | 3 | 1 | 6 | 930-C10-HD-25-105 | 100.0 | 25.0 | 57 | 105.0 | 18.8 | 63.0 | 105.0 | 57.0 | 65.0 | 100.0 | 12° | 80 | 10.00 | 4.89 | 10000 |
| | 32 | 3 | 1 | 6 | 930-C10-HD-32-098 | 100.0 | 32.0 | 61 | 98.0 | 18.8 | 56.2 | 98.0 | 67.8 | 76.0 | 100.0 | 12° | 80 | 10.00 | 5.14 | 10000 |

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M1



N23



N6



N15



N4

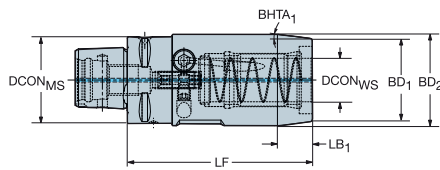
Coromant Capto® to CoroChuck™ 930

Slender design

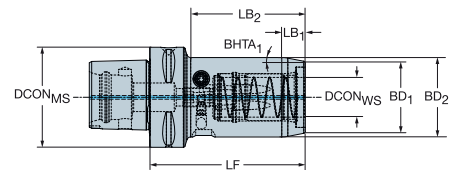


DSGN

3



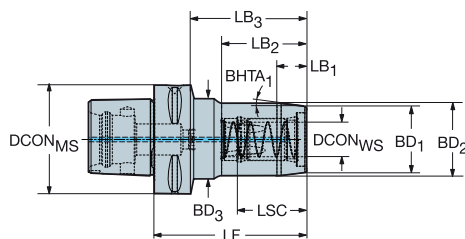
6



| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | RPMX | | | |
| C3 | 6 | 3 | 1 | 6 | 930-C3-S-06-064 | 32.0 | 6.0 | 37 | 64.0 | 11.3 | 33.2 | 64.0 | 22.0 | 26.0 | 32.0 | 10° | 80 | 8.00 | 0.32 | 55000 | | | |
| | 8 | 3 | 1 | 6 | 930-C3-S-08-065 | 32.0 | 8.0 | 37 | 65.0 | 11.3 | 35.3 | 65.0 | 24.0 | 28.0 | 32.0 | 10° | 80 | 8.00 | 0.36 | 55000 | | | |
| | 10 | 3 | 1 | 6 | 930-C3-S-10-070 | 32.0 | 10.0 | 41 | 70.0 | 11.3 | 39.6 | 70.0 | 26.0 | 30.0 | 32.0 | 10° | 80 | 8.00 | 0.38 | 55000 | | | |
| | 12 | 3 | 1 | 3 | 930-C3-S-12-074 | 32.0 | 12.0 | 46 | 74.0 | 11.3 | 74.0 | | 28.0 | 32.0 | | 10° | 80 | 8.00 | 0.45 | 55000 | | | |
| C4 | 6 | 3 | 1 | 6 | 930-C4-S-06-066 | 40.0 | 6.0 | 37 | 66.0 | 11.3 | 30.2 | 66.0 | 22.0 | 26.0 | 40.0 | 10° | 80 | 8.00 | 0.48 | 39000 | | | |
| | 8 | 3 | 1 | 6 | 930-C4-S-08-066 | 40.0 | 8.0 | 37 | 66.0 | 11.3 | 30.2 | 66.0 | 24.0 | 28.0 | 40.0 | 10° | 80 | 8.00 | 0.50 | 39000 | | | |
| | 10 | 3 | 1 | 6 | 930-C4-S-10-072 | 40.0 | 10.0 | 41 | 72.0 | 11.3 | 34.2 | 72.0 | 26.0 | 30.0 | 40.0 | 10° | 80 | 8.00 | 0.55 | 39000 | | | |
| | 12 | 3 | 1 | 6 | 930-C4-S-12-080A | 40.0 | 12.0 | 46 | 80.0 | 11.3 | 40.0 | 80.0 | 28.0 | 32.0 | 40.0 | 15° | 80 | 8.00 | 0.65 | 39000 | | | |
| | 20 | 3 | 1 | 3 | 930-C4-S-20-090A | 40.0 | 20.0 | 51 | 90.0 | 16.0 | 90.0 | | 38.0 | 42.0 | | 7° | 80 | 8.00 | 0.85 | 39000 | | | |
| C5 | 6 | 3 | 1 | 6 | 930-C5-S-06-068 | 50.0 | 6.0 | 37 | 68.0 | 11.3 | 30.2 | 68.0 | 22.0 | 26.0 | 50.0 | 10° | 80 | 8.00 | 0.75 | 28000 | | | |
| | 8 | 3 | 1 | 6 | 930-C5-S-08-070 | 50.0 | 8.0 | 37 | 70.0 | 11.3 | 32.2 | 70.0 | 24.0 | 28.0 | 50.0 | 10° | 80 | 8.00 | 0.77 | 28000 | | | |
| | 10 | 3 | 1 | 6 | 930-C5-S-10-072 | 50.0 | 10.0 | 41 | 72.0 | 11.3 | 34.2 | 72.0 | 26.0 | 30.0 | 50.0 | 10° | 80 | 8.00 | 0.80 | 20000 | | | |
| | 12 | 3 | 1 | 6 | 930-C5-S-12-075 | 50.0 | 12.0 | 46 | 75.0 | 11.3 | 38.2 | 75.0 | 28.0 | 32.0 | 50.0 | 10° | 80 | 8.00 | 0.85 | 28000 | | | |
| | 20 | 3 | 1 | 6 | 930-C5-S-20-085 | 50.0 | 20.0 | 51 | 85.0 | 16.0 | 49.2 | 85.0 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 1.04 | 28000 | | | |
| | 20 | 3 | 1 | 6 | 930-C5-S-20-125 | 50.0 | 20.0 | 51 | 125.0 | 16.0 | 49.2 | 125.0 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 1.63 | 28000 | | | |
| C6 | 25 | 3 | 1 | 3 | 930-C5-S-25-091 | 50.0 | 25.0 | 57 | 91.0 | 12.9 | 91.0 | | 45.0 | 50.0 | | 11° | 80 | 8.00 | 1.28 | 28000 | | | |
| | 25 | 3 | 1 | 6 | 930-C6-S-25-098 | 63.0 | 25.0 | 57 | 98.0 | 12.9 | 72.1 | 98.0 | 45.0 | 50.0 | 63.0 | 11° | 80 | 8.00 | 1.70 | 20000 | | | |
| C8 | 25 | 3 | 1 | 6 | 930-C8-S-25-108 | 80.0 | 25.0 | 57 | 108.0 | 12.9 | 72.0 | 108.0 | 45.0 | 50.0 | 80.0 | 11° | 80 | 8.00 | 2.74 | 14000 | | | |

DSGN

10



| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | RPMX | | | |
| C6 | 6 | 3 | 1 | 10 | 930-C6-S-06-074 | 63.0 | 6.0 | 37 | 74.0 | 11.3 | 30.2 | 48.1 | 22.0 | 26.0 | 50.0 | 10° | 80 | 8.00 | 1.15 | 20000 | | | |
| | 8 | 3 | 1 | 10 | 930-C6-S-08-076 | 63.0 | 8.0 | 37 | 76.0 | 11.3 | 32.2 | 50.1 | 24.0 | 28.0 | 50.0 | 10° | 80 | 8.00 | 1.17 | 20000 | | | |
| | 10 | 3 | 1 | 10 | 930-C6-S-10-078 | 63.0 | 10.0 | 41 | 78.0 | 11.3 | 34.2 | 52.1 | 26.0 | 30.0 | 50.0 | 10° | 80 | 8.00 | 1.20 | 20000 | | | |
| | 12 | 3 | 1 | 10 | 930-C6-S-12-082 | 63.0 | 12.0 | 46 | 82.0 | 11.3 | 38.2 | 56.0 | 28.0 | 32.0 | 50.0 | 10° | 80 | 8.00 | 1.26 | 20000 | | | |
| | 20 | 3 | 1 | 10 | 930-C6-S-20-091 | 63.0 | 20.0 | 51 | 91.0 | 16.0 | 49.2 | 65.1 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 1.45 | 20000 | | | |
| C8 | 20 | 3 | 1 | 10 | 930-C6-S-20-150 | 63.0 | 20.0 | 51 | 150.0 | 16.0 | 49.2 | 66.8 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 2.55 | 20000 | | | |
| | 12 | 3 | 1 | 10 | 930-C8-S-12-094 | 80.0 | 12.0 | 46 | 94.0 | 11.3 | 38.2 | 59.0 | 28.0 | 32.0 | 50.0 | 10° | 80 | 8.00 | 2.36 | 14000 | | | |
| | 20 | 3 | 1 | 10 | 930-C8-S-20-103 | 80.0 | 20.0 | 51 | 103.0 | 16.0 | 49.2 | 68.0 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 2.54 | 14000 | | | |
| | 20 | 3 | 1 | 10 | 930-C8-S-20-175 | 80.0 | 20.0 | 51 | 175.0 | 16.0 | 49.2 | 70.0 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 4.39 | 14000 | | | |

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M1



N23



N6



N15



N4



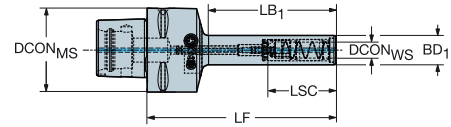
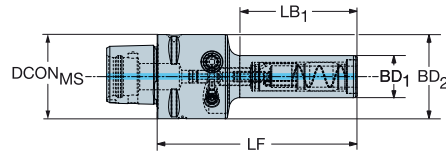
Coromant Capto® to CoroChuck™ 930

Pencil design

DSGN

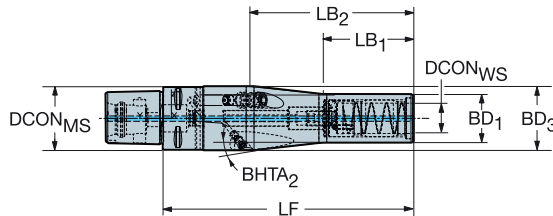
2

5



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----|------|------|-------|
| C4 | 6 | 3 | 1 | 2 | 930-C4-P-06-085 | 40.0 | 6.0 | 37 | 85.0 | 45.8 | 85.0 | | 14.5 | 40.0 | | 80 | 8.00 | 0.42 | 39000 |
| | 8 | 3 | 1 | 2 | 930-C4-P-08-085 | 40.0 | 8.0 | 37 | 85.0 | 45.8 | 85.0 | | 17.5 | 40.0 | | 80 | 8.00 | 0.45 | 39000 |
| | 10 | 3 | 1 | 2 | 930-C4-P-10-095 | 40.0 | 10.0 | 41 | 95.0 | 55.8 | 95.0 | | 20.0 | 40.0 | | 80 | 8.00 | 0.50 | 39000 |
| | 10 | 3 | 1 | 2 | 930-C4-P-10-135 | 40.0 | 10.0 | 41 | 135.0 | 95.8 | 135.0 | | 20.0 | 40.0 | | 80 | 8.00 | 0.59 | 39000 |
| | 12 | 3 | 1 | 2 | 930-C4-P-12-100 | 40.0 | 12.0 | 46 | 100.0 | 60.8 | 100.0 | | 22.0 | 40.0 | | 80 | 8.00 | 0.56 | 39000 |
| C5 | 12 | 3 | 1 | 2 | 930-C4-P-12-135 | 40.0 | 12.0 | 46 | 135.0 | 95.8 | 135.0 | | 22.0 | 40.0 | | 80 | 8.00 | 0.66 | 39000 |
| | 6 | 3 | 1 | 5 | 930-C5-P-06-088 | 50.0 | 6.0 | 37 | 88.0 | 47.9 | 65.0 | 88.0 | 14.5 | 40.0 | 50.0 | 80 | 8.00 | 0.67 | 28000 |
| | 8 | 3 | 1 | 5 | 930-C5-P-08-088 | 50.0 | 8.0 | 37 | 88.0 | 45.8 | 64.9 | 88.0 | 17.5 | 40.0 | 50.0 | 80 | 8.00 | 0.65 | 28000 |
| | 10 | 3 | 1 | 5 | 930-C5-P-10-098 | 50.0 | 10.0 | 41 | 98.0 | 55.8 | 74.9 | 98.0 | 20.0 | 40.0 | 50.0 | 80 | 8.00 | 0.70 | 28000 |
| | 10 | 3 | 1 | 5 | 930-C5-P-10-138 | 50.0 | 10.0 | 41 | 138.0 | 95.8 | 114.9 | 138.0 | 20.0 | 40.0 | 50.0 | 80 | 8.00 | 0.80 | 28000 |
| C6 | 12 | 3 | 1 | 5 | 930-C5-P-12-103 | 50.0 | 12.0 | 46 | 103.0 | 60.8 | 80.0 | 103.0 | 22.0 | 40.0 | 50.0 | 80 | 8.00 | 0.78 | 28000 |
| | 12 | 3 | 1 | 5 | 930-C5-P-12-138 | 50.0 | 12.0 | 46 | 138.0 | 95.8 | 115.0 | 138.0 | 22.0 | 40.0 | 50.0 | 80 | 8.00 | 0.88 | 28000 |
| | 6 | 3 | 1 | 5 | 930-C6-P-06-091 | 63.0 | 6.0 | 37 | 91.0 | 47.9 | 64.9 | 91.0 | 14.5 | 40.0 | 63.0 | 80 | 8.00 | 1.03 | 20000 |
| | 8 | 3 | 1 | 5 | 930-C6-P-08-091 | 63.0 | 8.0 | 37 | 91.0 | 45.8 | 64.9 | 91.0 | 17.5 | 40.0 | 63.0 | 80 | 8.00 | 1.00 | 20000 |
| | 10 | 3 | 1 | 5 | 930-C6-P-10-102 | 63.0 | 10.0 | 41 | 102.0 | 55.8 | 75.0 | 102.0 | 20.0 | 40.0 | 63.0 | 80 | 8.00 | 1.07 | 20000 |
| C8 | 10 | 3 | 1 | 5 | 930-C6-P-10-142 | 63.0 | 10.0 | 41 | 142.0 | 95.8 | 115.0 | 142.0 | 20.0 | 40.0 | 63.0 | 80 | 8.00 | 1.16 | 20000 |
| | 12 | 3 | 1 | 5 | 930-C6-P-12-107 | 63.0 | 12.0 | 46 | 107.0 | 60.8 | 80.0 | 107.0 | 22.0 | 40.0 | 63.0 | 80 | 8.00 | 1.14 | 20000 |
| | 12 | 3 | 1 | 5 | 930-C6-P-12-142 | 63.0 | 12.0 | 46 | 142.0 | 95.8 | 115.0 | 142.0 | 22.0 | 40.0 | 63.0 | 80 | 8.00 | 1.25 | 20000 |
| | 12 | 3 | 1 | 5 | 930-C8-P-12-120 | 80.0 | 12.0 | 46 | 120.0 | 60.8 | 83.0 | 120.0 | 22.0 | 40.0 | 80.0 | 80 | 8.00 | 2.23 | 14000 |
| | 12 | 3 | 1 | 5 | 930-C8-P-12-155 | 80.0 | 12.0 | 46 | 155.0 | 95.8 | 118.0 | 155.0 | 22.0 | 40.0 | 80.0 | 80 | 8.00 | 2.38 | 14000 |



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₃ | BHTA ₂ | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| C4 | 20 | 3 | 1 | 930-C4-P-20-160 | 40.0 | 20.0 | 51 | 160.0 | 60.0 | 108.0 | 32.0 | 42.0 | 5° | 80 | 8.00 | 1.22 | 39000 |

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M1



N23



N6



N15



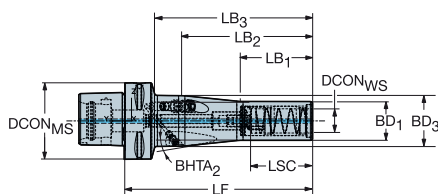
N4

Coromant Capto® to CoroChuck™ 930

Pencil design

DSGN

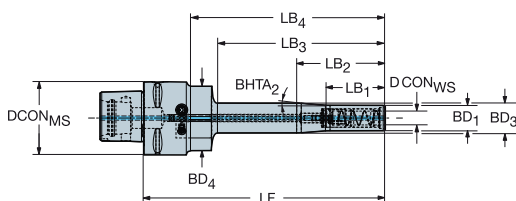
11



| | | | | | Dimensions, mm | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₃ | BHTA ₂ | BAR | NM | KG | RPMX |
| C4 | 12 | 3 | 1 | 11 | 930-C4-P-12-185 | 40.0 | 12.0 | 46 | 185.0 | 50.0 | 75.0 | 145.8 | 22.0 | 26.0 | 4° | 80 | 8.00 | 0.94 | 39000 |
| C5 | 20 | 3 | 1 | 11 | 930-C5-P-20-151 | 50.0 | 20.0 | 51 | 151.0 | 60.0 | 108.0 | 128.0 | 32.0 | 42.0 | 6° | 80 | 8.00 | 1.32 | 28000 |
| | | | | | 930-C5-P-20-231 | 50.0 | 20.0 | 51 | 231.0 | 60.0 | 188.0 | 208.0 | 32.0 | 42.0 | 2° | 80 | 8.00 | 2.00 | 28000 |
| C6 | 20 | 3 | 1 | 11 | 930-C6-P-20-155 | 63.0 | 20.0 | 51 | 155.0 | 60.0 | 108.0 | 128.1 | 32.0 | 42.0 | 6° | 80 | 8.00 | 1.68 | 20000 |
| | | | | | 930-C6-P-20-235 | 63.0 | 20.0 | 51 | 235.0 | 60.0 | 188.0 | 208.1 | 32.0 | 42.0 | 2° | 80 | 8.00 | 2.38 | 20000 |
| C8 | 20 | 3 | 1 | 11 | 930-C8-P-20-165 | 80.0 | 20.0 | 51 | 165.0 | 60.0 | 108.0 | 128.1 | 32.0 | 42.0 | 6° | 80 | 8.00 | 2.80 | 14000 |
| | | | | | 930-C8-P-20-245 | 80.0 | 20.0 | 51 | 245.0 | 60.0 | 188.0 | 208.1 | 32.0 | 42.0 | 2° | 80 | 8.00 | 3.44 | 14000 |

DSGN

17



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₃ | BD ₄ | BHTA ₂ | BAR | NM | KG | RPMX |
| C5 | 12 | 3 | 1 | 17 | 930-C5-P-12-188 | 50.0 | 12.0 | 46 | 188.0 | 50.0 | 75.0 | 145.8 | 167.0 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.00 | 1.18 | 28000 |
| C6 | 12 | 3 | 1 | 17 | 930-C6-P-12-192 | 63.0 | 12.0 | 46 | 192.0 | 50.0 | 75.0 | 145.8 | 167.0 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.00 | 1.57 | 20000 |
| C8 | 12 | 3 | 1 | 17 | 930-C8-P-12-205 | 80.0 | 12.0 | 46 | 205.0 | 50.0 | 75.0 | 145.8 | 170.0 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.00 | 2.63 | 14000 |

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M1



N23



N6



N15



N4

Coromant Capto® to CoroChuck™ 930

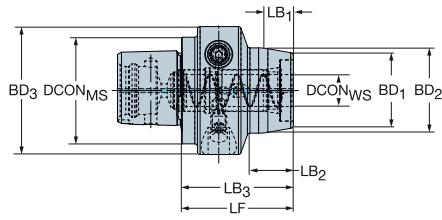
For driven tool holders

Segment clamping and manual tool change only

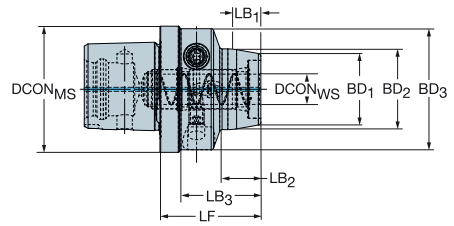


DSGN

6



10



| | | Dimensions, mm | | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|------|-----------------|--------------------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | (BAR) | (KG) | RPMX |
| C3 | 12 | 3 | 1 | 6 | 930-C3-T-12-046 | 32.0 | 12.0 | 46 | 46.0 | 11.3 | 22.8 | 46.0 | | 28.0 | 32.0 | 48.0 | | 10° | 80 | 0.39 | 10000 |
| C4 | 12 | 3 | 1 | 6 | 930-C4-T-12-042 | 40.0 | 12.0 | 46 | 42.0 | 11.3 | 17.0 | 42.0 | | 28.0 | 32.0 | 48.0 | | 10° | 80 | 0.46 | 10000 |
| | 20 | 3 | 1 | 6 | 930-C4-T-20-058 | 40.0 | 20.0 | 51 | 58.0 | 16.0 | 34.3 | 58.0 | | 38.1 | 42.0 | 57.0 | | 7° | 80 | 0.70 | 10000 |
| C5 | 12 | 3 | 1 | 10 | 930-C5-T-12-040 | 50.0 | 12.0 | 46 | 40.0 | 11.3 | 16.1 | 32.0 | 40.0 | 28.0 | 32.0 | 48.0 | 50.0 | 10° | 80 | 0.56 | 10000 |
| | 20 | 3 | 1 | 6 | 930-C5-T-20-046 | 50.0 | 20.0 | 51 | 46.0 | 11.3 | 22.1 | 46.0 | | 38.1 | 42.0 | 57.0 | | 10° | 80 | 0.68 | 10000 |

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



M1



N23



N6

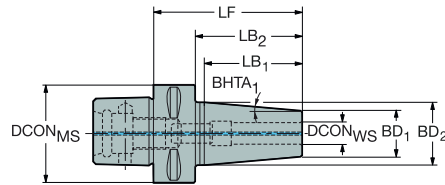


N15



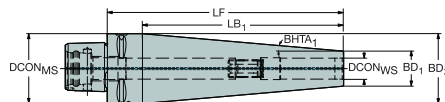
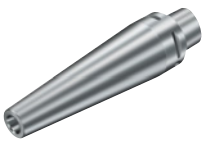
N4

Coromant Capto® to shrink fit chuck



Short design

| | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BHTA ₁ | BAR | KG | RPMX | | |
| C4 | 6 | 3 | 1 | C4-391.19-06 075 | 40.0 | 6.0 | 75.0 | 44.1 | 55.0 | 20.0 | 27.0 | 4° | 80 | 0.43 | 39000 | | |
| | 8 | 3 | 1 | C4-391.19-08 075 | 40.0 | 8.0 | 75.0 | 44.1 | 55.0 | 20.0 | 27.0 | 4° | 80 | 0.45 | 39000 | | |
| | 10 | 3 | 1 | C4-391.19-10 075 | 40.0 | 10.0 | 75.0 | 50.5 | 55.0 | 24.0 | 32.0 | 4° | 80 | 0.52 | 39000 | | |
| | 12 | 3 | 1 | C4-391.19-12 075 | 40.0 | 12.0 | 75.0 | 50.5 | 55.0 | 24.0 | 32.0 | 4° | 80 | 0.50 | 39000 | | |
| | 14 | 3 | 1 | C4-391.19-14 080 | 40.0 | 14.0 | 80.0 | 44.1 | 60.0 | 27.0 | 34.0 | 4° | 80 | 0.58 | 39000 | | |
| | 16 | 3 | 1 | C4-391.19-16 080 | 40.0 | 16.0 | 80.0 | 44.1 | 60.0 | 27.0 | 34.0 | 4° | 80 | 0.56 | 39000 | | |
| C5 | 6 | 3 | 1 | C5-391.19-06 075 | 50.0 | 6.0 | 75.0 | 44.1 | 55.0 | 20.0 | 27.0 | 4° | 80 | 0.64 | 28000 | | |
| | 8 | 3 | 1 | C5-391.19-08 075 | 50.0 | 8.0 | 75.0 | 43.9 | 55.0 | 20.0 | 27.0 | 4° | 80 | 0.63 | 28000 | | |
| | 10 | 3 | 1 | C5-391.19-10 075 | 50.0 | 10.0 | 75.0 | 50.2 | 55.0 | 24.0 | 32.0 | 4° | 80 | 0.70 | 28000 | | |
| | 12 | 3 | 1 | C5-391.19-12 075 | 50.0 | 12.0 | 75.0 | 50.2 | 55.0 | 24.0 | 32.0 | 4° | 80 | 0.68 | 28000 | | |
| | 14 | 3 | 1 | C5-391.19-14 080 | 50.0 | 14.0 | 80.0 | 44.1 | 60.0 | 27.0 | 34.0 | 4° | 80 | 0.76 | 28000 | | |
| | 16 | 3 | 1 | C5-391.19-16 080 | 50.0 | 16.0 | 80.0 | 44.1 | 60.0 | 27.0 | 34.0 | 4° | 80 | 0.73 | 28000 | | |
| | 18 | 3 | 1 | C5-391.19-18 080 | 50.0 | 18.0 | 80.0 | 56.9 | 60.0 | 33.0 | 42.0 | 4° | 80 | 0.90 | 28000 | | |
| | 20 | 3 | 1 | C5-391.19-20 085 | 50.0 | 20.0 | 85.0 | 56.9 | 65.0 | 33.0 | 42.0 | 4° | 80 | 0.90 | 28000 | | |
| C6 | 6 | 3 | 1 | C6-391.19-06 080 | 63.0 | 6.0 | 80.0 | 44.1 | 58.0 | 20.0 | 27.0 | 4° | 80 | 0.99 | 20000 | | |
| | 8 | 3 | 1 | C6-391.19-08 080 | 63.0 | 8.0 | 80.0 | 44.1 | 58.0 | 20.0 | 27.0 | 4° | 80 | 0.99 | 20000 | | |
| | 10 | 3 | 1 | C6-391.19-10 080 | 63.0 | 10.0 | 80.0 | 50.5 | 58.0 | 24.0 | 32.0 | 4° | 80 | 1.05 | 20000 | | |
| | 12 | 3 | 1 | C6-391.19-12 080 | 63.0 | 12.0 | 80.0 | 50.5 | 58.0 | 24.0 | 32.0 | 4° | 80 | 1.05 | 20000 | | |
| | 14 | 3 | 1 | C6-391.19-14 085 | 63.0 | 14.0 | 85.0 | 44.1 | 63.0 | 27.0 | 34.0 | 4° | 80 | 1.11 | 20000 | | |
| | 16 | 3 | 1 | C6-391.19-16 085 | 63.0 | 16.0 | 85.0 | 44.1 | 63.0 | 27.0 | 34.0 | 4° | 80 | 1.10 | 20000 | | |
| | 18 | 3 | 1 | C6-391.19-18 085 | 63.0 | 18.0 | 85.0 | 56.9 | 63.0 | 33.0 | 42.0 | 4° | 80 | 1.27 | 20000 | | |
| | 20 | 3 | 1 | C6-391.19-20 085 | 63.0 | 20.0 | 85.0 | 56.9 | 63.0 | 33.0 | 42.0 | 4° | 80 | 1.24 | 20000 | | |
| | 25 | 3 | 1 | C6-391.19-25 090 | 63.0 | 25.0 | 90.0 | 56.9 | 68.0 | 44.0 | 53.0 | 4° | 80 | 1.60 | 20000 | | |
| | 32 | 3 | 1 | C6-391.19-32 095 | 63.0 | 32.0 | 95.0 | 56.9 | 73.0 | 44.0 | 53.0 | 4° | 80 | 1.51 | 20000 | | |
| C8 | 10 | 3 | 1 | C8-391.19-10 090 | 80.0 | 10.0 | 90.0 | 50.2 | 60.0 | 24.0 | 32.0 | 4° | 80 | 2.07 | 14000 | | |
| | 12 | 3 | 1 | C8-391.19-12 090 | 80.0 | 12.0 | 90.0 | 50.2 | 60.0 | 24.0 | 32.0 | 4° | 80 | 2.06 | 14000 | | |
| | 16 | 3 | 1 | C8-391.19-16 095 | 80.0 | 16.0 | 95.0 | 43.8 | 65.0 | 27.0 | 34.0 | 4° | 80 | 2.09 | 14000 | | |
| | 20 | 3 | 1 | C8-391.19-20 095 | 80.0 | 20.0 | 95.0 | 56.5 | 65.0 | 33.0 | 42.0 | 4° | 80 | 2.21 | 14000 | | |
| | 25 | 3 | 1 | C8-391.19-25 100 | 80.0 | 25.0 | 100.0 | 56.5 | 70.0 | 44.0 | 53.0 | 4° | 80 | 2.58 | 14000 | | |
| C10 | 12 | 3 | 1 | C10-391.19-12 095 | 100.0 | 12.0 | 95.0 | 50.5 | 59.0 | 24.0 | 32.0 | 4° | 80 | 3.65 | 10000 | | |
| | 16 | 3 | 1 | C10-391.19-16 100 | 100.0 | 16.0 | 100.0 | 44.1 | 64.0 | 27.0 | 34.0 | 4° | 80 | 3.72 | 10000 | | |
| | 20 | 3 | 1 | C10-391.19-20 100 | 100.0 | 20.0 | 100.0 | 56.9 | 64.0 | 33.0 | 42.0 | 4° | 80 | 3.83 | 10000 | | |
| | 25 | 3 | 1 | C10-391.19-25 110 | 100.0 | 25.0 | 110.0 | 56.9 | 74.0 | 44.0 | 53.0 | 4° | 80 | 4.31 | 10000 | | |



Long conical design

| | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-------------------|-----|------|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BD ₁ | BD ₂ | BHTA ₁ | BAR | KG | RPMX | | | |
| C3 | 6 | 3 | 1 | C3-391.19-06 118 | 32.0 | 6.0 | 118.0 | 103.0 | 14.0 | 32.0 | 5° | 80 | 0.45 | 55000 | | | |
| | 8 | 3 | 1 | C3-391.19-08 107 | 32.0 | 8.0 | 107.0 | 92.0 | 16.0 | 32.0 | 5° | 80 | 0.44 | 55000 | | | |
| | 10 | 3 | 1 | C3-391.19-10 095 | 32.0 | 10.0 | 95.0 | 80.0 | 18.0 | 32.0 | 5° | 80 | 0.40 | 55000 | | | |
| | 12 | 3 | 1 | C3-391.19-12 084 | 32.0 | 12.0 | 84.0 | 69.0 | 20.0 | 32.0 | 5° | 80 | 0.38 | 55000 | | | |
| C4 | 12 | 3 | 1 | C4-391.19-12 135 | 40.0 | 12.0 | 135.0 | 115.0 | 20.0 | 40.0 | 5° | 80 | 0.84 | 39000 | | | |
| | 16 | 3 | 1 | C4-391.19-16 112 | 40.0 | 16.0 | 112.0 | 92.0 | 24.0 | 40.0 | 5° | 80 | 0.77 | 39000 | | | |
| | 18 | 3 | 1 | C4-391.19-18 080 | 40.0 | 18.0 | 80.0 | 56.9 | 33.0 | 42.0 | 4° | 80 | 0.69 | 39000 | | | |
| | 20 | 3 | 1 | C4-391.19-20 085 | 40.0 | 20.0 | 85.0 | 56.9 | 33.0 | 42.0 | 4° | 80 | 0.71 | 39000 | | | |
| C5 | 20 | 3 | 1 | C5-391.19-20 146 | 50.0 | 20.0 | 146.0 | 126.0 | 28.0 | 50.0 | 5° | 80 | 1.45 | 28000 | | | |
| | 25 | 3 | 1 | C5-391.19-25 090 | 50.0 | 25.0 | 90.0 | 56.9 | 44.0 | 53.0 | 4° | 80 | 1.26 | 28000 | | | |
| | 25 | 3 | 1 | C5-391.19-25 118 | 50.0 | 25.0 | 118.0 | 98.0 | 33.0 | 50.0 | 5° | 80 | 1.25 | 28000 | | | |

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

M1



N23

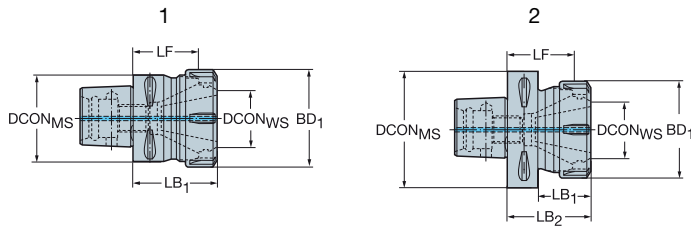


N15

Coromant Capto® to ER collet chuck

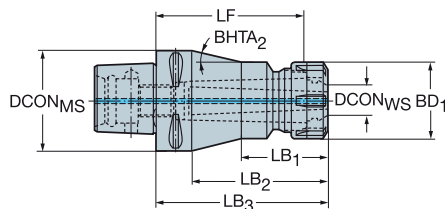
Workpiece side interface DIN 6499-B

DSGN



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX |
|-------------------|-------------------|------|------|------------------|------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|------|-------|-------|
| C3 | ER16 | 3 | 1 | 2 | C3-391.14-16 045 | 32.0 | 17.0 | 34.4 | 29.0 | 45.0 | 28.0 | 32.0 | 80 | 0.20 | 55000 |
| | ER20 | 3 | 1 | 1 | C3-391.14-20 045 | 32.0 | 21.0 | 33.5 | 45.0 | | 33.7 | | 80 | 0.22 | 55000 |
| C4 | ER20 | 3 | 1 | 2 | C4-391.14-20 052 | 40.0 | 21.0 | 40.5 | 30.8 | 52.0 | 33.7 | 40.0 | 80 | 0.37 | 39000 |
| | ER25 | 3 | 1 | 1 | C4-391.14-25 052 | 40.0 | 26.0 | 40.0 | 52.0 | | 42.0 | | 80 | 0.42 | 39000 |
| | ER32 | 3 | 1 | 1 | C4-391.14-32 054 | 40.0 | 33.0 | 41.0 | 54.0 | | 50.0 | | 80 | 0.46 | 39000 |
| C5 | ER20 | 3 | 1 | 2 | C5-391.14-20 055 | 50.0 | 21.0 | 43.5 | 31.1 | 55.0 | 33.7 | 50.0 | 80 | 0.62 | 28000 |
| | ER25 | 3 | 1 | 2 | C5-391.14-25 055 | 50.0 | 26.0 | 43.0 | 33.0 | 55.0 | 42.0 | 50.0 | 80 | 0.63 | 28000 |
| | ER32 | 3 | 1 | 1 | C5-391.14-32 057 | 50.0 | 33.0 | 44.0 | 57.0 | | 50.0 | | 80 | 0.68 | 28000 |
| | ER32 | 3 | 1 | 1 | C5-391.14-32 100 | 50.0 | 33.0 | 87.0 | 100.0 | | 50.0 | | 80 | 1.28 | 28000 |
| | ER40 | 3 | 1 | 1 | C5-391.14-40 060 | 50.0 | 41.0 | 45.0 | 60.0 | | 63.0 | | 80 | 0.81 | 28000 |
| C6 | ER25 | 3 | 1 | 2 | C6-391.14-25 060 | 63.0 | 26.0 | 48.0 | 32.9 | 60.0 | 42.0 | 63.0 | 80 | 1.04 | 20000 |
| | ER25 | 3 | 1 | 2 | C6-391.14-25 100 | 63.0 | 26.0 | 88.0 | 75.0 | 100.0 | 42.0 | 63.0 | 80 | 1.44 | 20000 |
| | ER32 | 3 | 1 | 2 | C6-391.14-32 060 | 63.0 | 33.0 | 47.0 | 35.3 | 60.0 | 50.0 | 63.0 | 80 | 1.06 | 20000 |
| | ER32 | 3 | 1 | 2 | C6-391.14-32 100 | 63.0 | 33.0 | 87.0 | 75.0 | 100.0 | 50.0 | 63.0 | 80 | 1.60 | 20000 |
| | ER40 | 3 | 1 | 1 | C6-391.14-40 065 | 63.0 | 41.0 | 50.0 | 65.0 | | 63.0 | | 80 | 1.22 | 20000 |
| | ER40 | 3 | 1 | 1 | C6-391.14-40 130 | 63.0 | 41.0 | 115.0 | 130.0 | | 63.0 | | 80 | 2.77 | 20000 |
| C8 | ER20 | 3 | 1 | 2 | C8-391.14-20 065 | 80.0 | 21.0 | 53.5 | 29.9 | 65.0 | 35.0 | 80.0 | 80 | 2.02 | 14000 |
| | ER25 | 3 | 1 | 2 | C8-391.14-25 070 | 80.0 | 26.0 | 58.0 | 32.4 | 70.0 | 42.0 | 80.0 | 80 | 2.10 | 14000 |
| | ER32 | 3 | 1 | 2 | C8-391.14-32 070 | 80.0 | 33.0 | 57.0 | 35.0 | 70.0 | 50.0 | 80.0 | 80 | 2.13 | 14000 |
| | ER40 | 3 | 1 | 2 | C8-391.14-40 070 | 80.0 | 41.0 | 55.0 | 38.0 | 70.0 | 63.0 | 80.0 | 80 | 2.19 | 14000 |
| ER50 | 3 | 1 | 2 | C8-391.14-50 080 | 80.0 | 52.0 | 59.0 | 50.0 | 80.0 | 78.0 | 80.0 | 80 | 2.46 | 14000 | |



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BHTA ₂ | BAR | KG | RPMX |
|-------------------|-------------------|------|------------------|-------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-------------------|------|-------|-------|
| C4 | ER16 | 3 | 1 | C4-391.14-16 070 | 40.0 | 17.0 | 59.4 | 44.0 | 50.0 | 70.0 | 28.0 | 45° | 80 | 0.42 | 39000 |
| C5 | ER16 | 3 | 1 | C5-391.14-16 100 | 50.0 | 17.0 | 89.4 | 60.0 | 80.0 | 100.0 | 28.0 | 29° | 80 | 0.90 | 28000 |
| | ER20 | 3 | 1 | C5-391.14-20 100 | 50.0 | 21.0 | 88.5 | 55.0 | 80.0 | 100.0 | 35.0 | 16° | 80 | 1.00 | 28000 |
| | ER20 | 3 | 1 | C5-391.14-20 130 | 50.0 | 21.0 | 118.5 | 55.0 | 109.9 | 130.0 | 35.0 | 7° | 80 | 1.31 | 28000 |
| ER25 | 3 | 1 | C5-391.14-25 100 | 50.0 | 26.0 | 88.0 | 65.0 | 80.0 | 100.0 | 42.0 | 14° | 80 | 1.13 | 28000 | |
| C6 | ER16 | 3 | 1 | C6-391.14-16 100 | 63.0 | 17.0 | 89.4 | 60.0 | 78.0 | 100.0 | 28.0 | 44° | 80 | 1.26 | 20000 |
| | ER20 | 3 | 1 | C6-391.14-20 060 | 63.0 | 21.0 | 48.5 | 31.1 | 38.0 | 60.0 | 33.7 | 65° | 80 | 1.00 | 20000 |
| | ER25 | 3 | 1 | C6-391.14-25 130 | 63.0 | 26.0 | 118.0 | 65.0 | 108.0 | 130.0 | 42.0 | 13° | 80 | 1.90 | 20000 |
| | ER25 | 3 | 1 | C6-391.14-25 160 | 63.0 | 26.0 | 148.0 | 65.0 | 138.0 | 160.0 | 42.0 | 8° | 80 | 2.50 | 20000 |
| | ER32 | 3 | 1 | C6-391.14-32 130 | 63.0 | 33.0 | 117.0 | 75.0 | 108.0 | 130.0 | 50.0 | 11° | 80 | 2.22 | 20000 |
| | ER32 | 3 | 1 | C8-391.14-32 160 | 80.0 | 33.0 | 147.0 | 75.0 | 130.0 | 160.0 | 50.0 | 15° | 80 | 0.30 | 14000 |
| C8 | ER40 | 3 | 1 | C8-391.14-40 160 | 80.0 | 41.0 | 145.0 | 95.0 | 130.0 | 160.0 | 63.0 | 13° | 80 | 4.58 | 14000 |
| | ER32 | 3 | 1 | C10-391.14-32 160 | 100.0 | 33.0 | 147.0 | 75.0 | 124.0 | 160.0 | 50.0 | 27° | 80 | 5.98 | 10000 |
| C10 | ER40 | 3 | 1 | C10-391.14-40 160 | 100.0 | 41.0 | 145.0 | 95.0 | 124.0 | 160.0 | 63.0 | 32° | 80 | 6.32 | 10000 |
| | ER50 | 3 | 1 | C10-391.14-50 160 | 100.0 | 52.0 | 139.0 | 100.0 | 124.0 | 160.0 | 80.0 | 22° | 80 | 7.21 | 10000 |

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



M1



N23

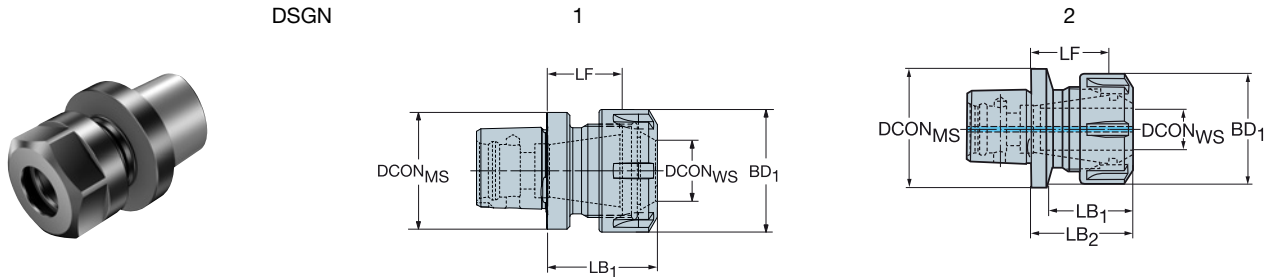


N15

Coromant Capto® to ER collet chuck

Workpiece side interface DIN 6499-B

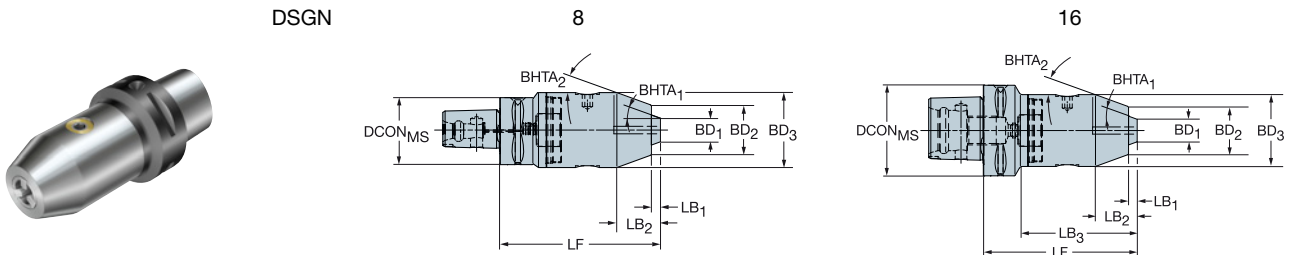
Short design, for segment clamping only



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|--------------------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX | | |
| C3 | ER16 | 3 | 1 | 2 | C3-391.14-16 035 | 32.0 | 17.0 | 24.0 | 26.6 | 34.6 | 28.0 | 32.0 | 80 | 0.10 | 55000 | | |
| | ER20 | 3 | 1 | 1 | C3-391.14-20 036 | 32.0 | 21.0 | 24.5 | 36.0 | | 33.7 | | 80 | 0.17 | 55000 | | |
| C4 | ER16 | 3 | 1 | 2 | C4-391.14-16 035 | 40.0 | 17.0 | 24.0 | 26.6 | 34.6 | 28.0 | 40.0 | 80 | 0.20 | 39000 | | |
| | ER20 | 3 | 1 | 2 | C4-391.14-20 035 | 40.0 | 21.0 | 23.5 | 27.0 | 35.0 | 33.7 | 40.0 | 80 | 0.25 | 39000 | | |
| | ER25 | 3 | 1 | 1 | C4-391.14-25 038 | 40.0 | 26.0 | 26.0 | 38.0 | | 42.0 | | 80 | 0.30 | 39000 | | |
| C5 | ER20 | 3 | 1 | 2 | C5-391.14-20 036 | 50.0 | 21.0 | 24.0 | 27.5 | 35.5 | 35.0 | 50.0 | 80 | 0.30 | 28000 | | |
| | ER25 | 3 | 1 | 2 | C5-391.14-25 037 | 50.0 | 26.0 | 25.0 | 29.0 | 37.0 | 42.0 | 50.0 | 80 | 0.30 | 28000 | | |
| | ER32 | 3 | 1 | 1 | C5-391.14-32 045 | 50.0 | 33.0 | 32.0 | 45.0 | | 50.0 | | 80 | 0.52 | 28000 | | |

Coromant Capto® to drill chuck

Internal and external coolant supply



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|-------|-------|------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | BHTA ₂ | BAR | NM | KG | RPMX | |
| C3 | 8-1 | 3 | 1 | 8 | C3-391.32-08 076 | 32.0 | 76.0 | 3.0 | 19.1 | 76.0 | | 9.9 | 24.1 | 36.0 | | 19° | 20° | 50 | 10.00 | 0.54 | 8000 | |
| | 1-13 | 3 | 1 | 8 | C3-391.32-13 102 | 32.0 | 96.0 | 6.0 | 22.2 | 102.0 | | 15.7 | 38.1 | 50.0 | | 19° | 20° | 50 | 20.00 | 1.14 | 8000 | |
| C4 | 8-1 | 3 | 1 | 16 | C4-391.32-08 077 | 40.0 | 77.0 | 3.0 | 19.1 | 55.8 | 77.0 | 9.9 | 24.1 | 36.0 | 40.0 | | 19° | 20° | 50 | 10.00 | 0.64 | 8000 |
| | 1-13 | 3 | 1 | 8 | C4-391.32-13 104 | 40.0 | 98.0 | 6.0 | 22.2 | 104.0 | | 15.7 | 38.1 | 50.0 | | 19° | 20° | 50 | 20.00 | 1.24 | 8000 | |
| C5 | 8-1 | 3 | 1 | 16 | C5-391.32-08 079 | 50.0 | 76.0 | 3.0 | 19.1 | 53.6 | 79.0 | 9.9 | 24.1 | 36.0 | 50.0 | | 19° | 20° | 50 | 10.00 | 0.85 | 8000 |
| | 1-13 | 3 | 1 | 8 | C5-391.32-13 103 | 50.0 | 97.0 | 6.0 | 22.2 | 103.0 | | 15.7 | 38.1 | 50.0 | | 19° | 20° | 50 | 20.00 | 1.41 | 8000 | |
| C6 | 1-13 | 3 | 1 | 16 | C6-391.32-13 107 | 63.0 | 101.0 | 6.0 | 22.2 | 79.8 | 107.0 | 15.7 | 38.1 | 50.0 | 63.0 | | 19° | 20° | 50 | 20.00 | 1.79 | 8000 |
| | 16-1 | 3 | 1 | 16 | C6-391.32-16 112 | 63.0 | 106.0 | 6.0 | 22.2 | 88.4 | 112.0 | 15.7 | 45.1 | 57.0 | 63.0 | | 19° | 20° | 50 | 20.00 | 2.02 | 8000 |
| C8 | 1-13 | 3 | 1 | 16 | C8-391.32-13 112 | 80.0 | 106.0 | 6.0 | 22.2 | 77.1 | 112.0 | 15.7 | 38.1 | 50.0 | 80.0 | | 19° | 20° | 50 | 20.00 | 2.78 | 8000 |
| | 16-1 | 3 | 1 | 16 | C8-391.32-16 117 | 80.0 | 111.0 | 6.0 | 31.2 | 84.2 | 117.0 | 15.7 | 38.1 | 57.0 | 80.0 | | 19° | 20° | 50 | 20.00 | 3.02 | 8000 |

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

M1



N23

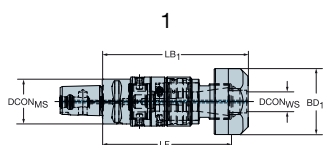


N15

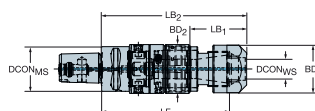
Coromant Capto® to CoroChuck™ 970

Workpiece side interface DIN 6499-B

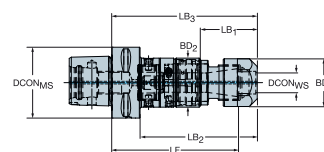
DSGN



2



5



Dimensions, mm

| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | (BAR) | (KG) | RPMX |
|-------------------|-------------------|-------|------|------|------|----------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------|------|------|
| C3 | ER11 | M5 | 3 | 1 | 5 | 970-C3-11-078 | 32.0 | 11.3 | 74.2 | 24.1 | 63.0 | 78.0 | 18.7 | 23.5 | 32.0 | 80 | 0.27 | 8000 |
| | ER20 | M12 | 3 | 1 | 2 | 970-C3-20-102 | 32.0 | 20.8 | 89.2 | 35.3 | 97.2 | | 33.7 | 35.0 | | 80 | 0.60 | 8000 |
| C4 | ER11 | M5 | 3 | 1 | 5 | 970-C4-11-080 | 40.0 | 11.3 | 76.2 | 24.1 | 60.0 | 80.0 | 18.7 | 23.5 | 40.0 | 80 | 0.40 | 8000 |
| | ER20 | M12 | 3 | 1 | 5 | 970-C4-20-102 | 40.0 | 20.8 | 89.2 | 35.3 | 76.9 | 97.2 | 33.7 | 35.0 | 40.0 | 80 | 0.68 | 8000 |
| | ER25 | M20 | 3 | 1 | 2 | 970-C4-25-122 | 40.0 | 25.8 | 108.1 | 37.1 | 116.6 | | 42.0 | 44.0 | | 80 | 1.04 | 8000 |
| C5 | ER20 | M12 | 3 | 1 | 5 | 970-C5-20-103 | 50.0 | 20.8 | 89.7 | 35.3 | 77.6 | 97.7 | 33.7 | 35.0 | 50.0 | 80 | 0.88 | 8000 |
| | ER25 | M20 | 3 | 1 | 5 | 970-C5-25-122 | 50.0 | 25.8 | 108.6 | 37.1 | 97.1 | 117.1 | 42.0 | 44.0 | 50.0 | 80 | 1.24 | 8000 |
| | ER40 | M30 | 3 | 1 | 1 | 970-C5-40-154 | 50.0 | 40.8 | 137.2 | 148.6 | | | 63.0 | | | 80 | 2.66 | 8000 |
| C6 | ER20 | M12 | 3 | 1 | 5 | 970-C6-20-105 | 63.0 | 20.8 | 91.7 | 35.3 | 77.6 | 99.7 | 33.7 | 35.0 | 63.0 | 80 | 1.21 | 8000 |
| | ER25 | M20 | 3 | 1 | 5 | 970-C6-25-124 | 63.0 | 25.8 | 110.6 | 37.1 | 97.1 | 119.1 | 42.0 | 44.0 | 63.0 | 80 | 1.57 | 8000 |
| | ER32 | M27 | 3 | 1 | 2 | 970-C6-32-128 | 63.0 | 32.8 | 118.3 | 105.8 | 127.8 | | 50.0 | 63.0 | | 80 | 1.53 | 8000 |
| | ER40 | M30 | 3 | 1 | 1 | 970-C6-40-154 | 63.0 | 40.8 | 136.7 | 148.1 | | | 63.0 | | | 80 | 2.95 | 8000 |
| | ER50 | M48 | 3 | 1 | 5 | 970-C6-50-210 | 63.0 | 52.0 | 187.5 | 76.5 | 134.5 | 208.0 | 77.7 | 80.0 | 86.0 | 80 | 4.90 | 8000 |
| C8 | ER20 | M12 | 3 | 1 | 5 | 970-C8-20-112 | 80.0 | 20.8 | 98.7 | 35.3 | 76.6 | 106.7 | 33.7 | 35.0 | 80.0 | 80 | 2.22 | 8000 |
| | ER25 | M20 | 3 | 1 | 5 | 970-C8-25-131 | 80.0 | 25.8 | 117.6 | 37.1 | 96.1 | 126.1 | 42.0 | 44.0 | 80.0 | 80 | 2.58 | 8000 |
| | ER32 | M27 | 3 | 1 | 2 | 970-C8-32-135 | 80.0 | 32.8 | 125.3 | 104.8 | 134.8 | | 50.0 | 80.0 | | 80 | 2.50 | 8000 |
| | ER40 | M30 | 3 | 1 | 2 | 970-C8-40-161 | 80.0 | 40.8 | 143.7 | 125.1 | 155.1 | | 63.0 | 80.0 | | 80 | 4.00 | 8000 |
| | ER50 | M48 | 3 | 1 | 5 | 970-C8-50-215 | 80.0 | 52.0 | 192.0 | 76.5 | 134.5 | 212.5 | 77.7 | 80.0 | 86.0 | 80 | 6.87 | 8000 |
| C10 | ER25 | M20 | 3 | 1 | 5 | 970-C10-25-143 | 100.0 | 25.8 | 129.6 | 37.1 | 102.1 | 138.1 | 42.0 | 44.0 | 100.0 | 80 | 4.29 | 8000 |
| | ER40 | M30 | 3 | 1 | 2 | 970-C10-40-173 | 100.0 | 40.8 | 155.7 | 131.1 | 167.1 | | 63.0 | 100.0 | | 80 | 5.76 | 8000 |

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M1



N23

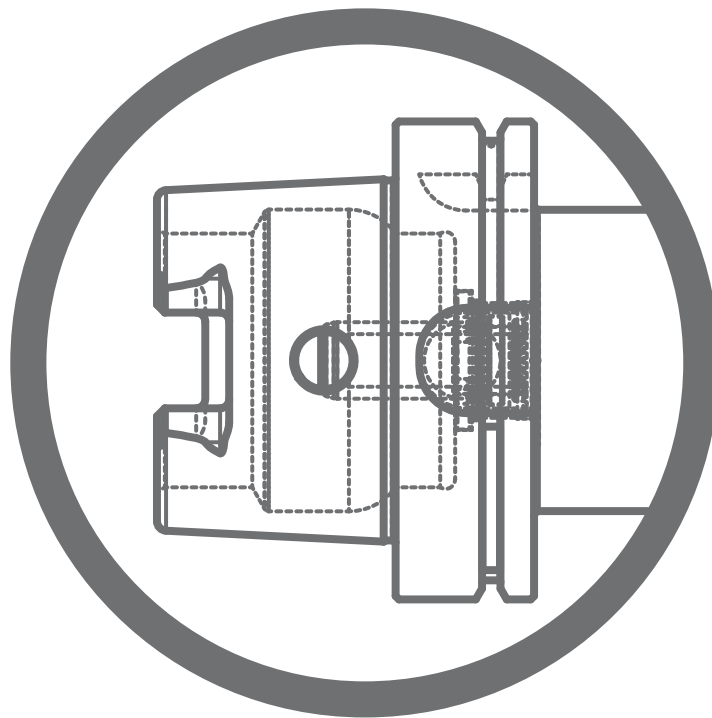


N15



N5

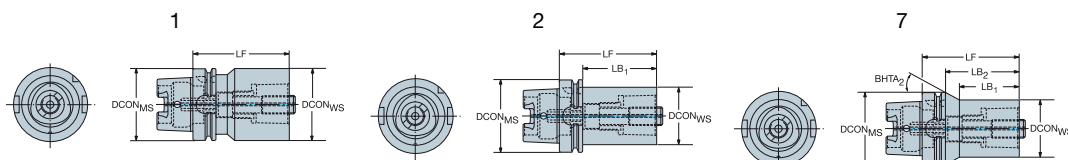
Machine side interface HSK



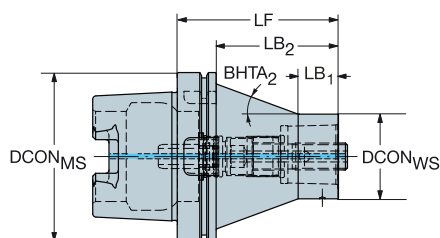
HSK to Coromant Capto® adaptor

Machine side interface HSK A/C

DSGN



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|---------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|--------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₂ | BD ₃ | BHTA ₂ | BAR | NM | KG |
| 50 | C3 | 1 | 1 | 2 | C3-390.410-50 075A | 50.0 | 32.0 | 75.0 | 49.0 | 75.0 | | 50.0 | | 0° | 100 | 45.00 | 0.67 |
| | C4 | 1 | 1 | 2 | C4-390.410-50 080A | 50.0 | 40.0 | 80.0 | 54.0 | 80.0 | | 50.0 | | 0° | 100 | 55.00 | 0.85 |
| 63 | C3 | 1 | 1 | 2 | C3-390.410-63 075C | 63.0 | 32.0 | 75.0 | 49.0 | 75.0 | | 63.0 | | 0° | 100 | 45.00 | 0.97 |
| | C4 | 1 | 1 | 2 | C4-390.410-63 080C | 63.0 | 40.0 | 80.0 | 54.0 | 80.0 | | 63.0 | | 0° | 100 | 55.00 | 1.14 |
| | C5 | 1 | 1 | 2 | C5-390.410-63 090C | 63.0 | 50.0 | 90.0 | 64.0 | 90.0 | | 63.0 | | 0° | 100 | 95.00 | 1.47 |
| 80 | C4 | 1 | 1 | 2 | C4-390.410-80 090 | 80.0 | 40.0 | 90.0 | 64.0 | 90.0 | | 80.0 | | 0° | 100 | 55.00 | 1.69 |
| | C5 | 1 | 1 | 2 | C5-390.410-80 095 | 80.0 | 50.0 | 95.0 | 69.0 | 95.0 | | 80.0 | | 0° | 100 | 95.00 | 2.02 |
| | C6 | 1 | 1 | 2 | C6-390.410-80 110 | 80.0 | 63.0 | 110.0 | 84.0 | 110.0 | | 80.0 | | 0° | 100 | 170.00 | 2.79 |
| 100 | C3 | 1 | 1 | 7 | C3-390.410-100 080A | 100.0 | 32.0 | 80.0 | 43.0 | 51.0 | 80.0 | 32.0 | 100.0 | 45° | 100 | 45.00 | 2.42 |
| | C4 | 1 | 1 | 2 | C4-390.410-100 090A | 100.0 | 40.0 | 90.0 | 61.0 | 90.0 | | 100.0 | | 0° | 100 | 55.00 | 2.63 |
| | C5 | 1 | 1 | 2 | C5-390.410-100 100A | 100.0 | 50.0 | 100.0 | 71.0 | 100.0 | | 100.0 | | 0° | 100 | 95.00 | 3.02 |
| | C6 | 1 | 1 | 2 | C6-390.410-100 110A | 100.0 | 63.0 | 110.0 | 81.0 | 110.0 | | 100.0 | | 0° | 100 | 170.00 | 3.70 |
| | C8 | 1 | 1 | 2 | C8-390.410-100 120A | 100.0 | 80.0 | 120.0 | 91.0 | 120.0 | | 100.0 | | 0° | 100 | 170.00 | 4.87 |
| | C10 | 1 | 1 | 1 | C10-390.410-100 155 | 100.0 | 100.0 | 155.0 | 155.0 | | | | | | 100 | 380.00 | 7.64 |
| 125 | C4 | 1 | 1 | 7 | C4-390.410-125 095 | 125.0 | 40.0 | 95.0 | 46.0 | 66.0 | 95.0 | 40.0 | 125.0 | 45° | 100 | 55.00 | 4.15 |
| | C5 | 1 | 1 | 7 | C5-390.410-125 105 | 125.0 | 50.0 | 105.0 | 66.0 | 76.0 | 105.0 | 50.0 | 125.0 | 45° | 100 | 95.00 | 4.46 |
| | C6 | 1 | 1 | 2 | C6-390.410-125 120 | 125.0 | 63.0 | 120.0 | 91.0 | 120.0 | | 125.0 | | 0° | 100 | 170.00 | 5.35 |
| | C8 | 1 | 1 | 2 | C8-390.410-125 130 | 125.0 | 80.0 | 130.0 | 101.0 | 130.0 | | 125.0 | | 0° | 100 | 170.00 | 6.70 |
| | C10 | 1 | 1 | 2 | C10-390.410-125 160 | 125.0 | 100.0 | 160.0 | 131.0 | 160.0 | | 125.0 | | 0° | 100 | 380.00 | 9.66 |
| 160 | C6 | 1 | 1 | 2 | C6-390.410-160 125 | 160.0 | 63.0 | 125.0 | 94.0 | 125.0 | | 160.0 | | 0° | 100 | 170.00 | 8.55 |
| | C8 | 1 | 1 | 2 | C8-390.410-160 135 | 160.0 | 80.0 | 135.0 | 104.0 | 135.0 | | 160.0 | | 0° | 100 | 170.00 | 10.16 |
| | C10 | 1 | 1 | 2 | C10-390.410-160 160 | 160.0 | 100.0 | 160.0 | 129.0 | 160.0 | | 160.0 | | 0° | 100 | 380.00 | 12.94 |



Heavy Duty design

| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|---------------------|--------------------|--------------------|-------|-----------------|-----------------|-------------------|-----|--------|------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BHTA ₂ | BAR | NM | KG | | |
| 100 | C3 | 1 | 1 | C3-390.410-100080HD | 100.0 | 32.0 | 80.0 | 20.0 | 51.0 | 41° | 100 | 45.00 | 2.93 | | |
| | C4 | 1 | 1 | C4-390.410-100090HD | 100.0 | 40.0 | 90.0 | 20.0 | 61.0 | 29° | 100 | 55.00 | 3.27 | | |
| | C5 | 1 | 1 | C5-390.410-100100HD | 100.0 | 50.0 | 100.0 | 30.0 | 71.0 | 23° | 100 | 95.00 | 3.58 | | |
| | C6 | 1 | 1 | C6-390.410-100110HD | 100.0 | 63.0 | 110.0 | 30.0 | 81.0 | 12° | 100 | 170.00 | 4.22 | | |
| 125 | C4 | 1 | 1 | C4-390.410-125095HD | 125.0 | 40.0 | 95.0 | 20.0 | 66.0 | 36° | 100 | 55.00 | 5.25 | | |
| | C5 | 1 | 1 | C5-390.410-125105HD | 125.0 | 50.0 | 105.0 | 20.0 | 76.0 | 27° | 100 | 95.00 | 5.82 | | |
| | C6 | 1 | 1 | C6-390.410-125120HD | 125.0 | 63.0 | 120.0 | 30.0 | 91.0 | 20° | 100 | 170.00 | 6.57 | | |
| | C8 | 1 | 1 | C8-390.410-125130HD | 125.0 | 80.0 | 130.0 | 30.0 | 101.0 | 11° | 100 | 170.00 | 7.76 | | |

A special coolant tube is delivered together with the HSK basic holders.

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



M1



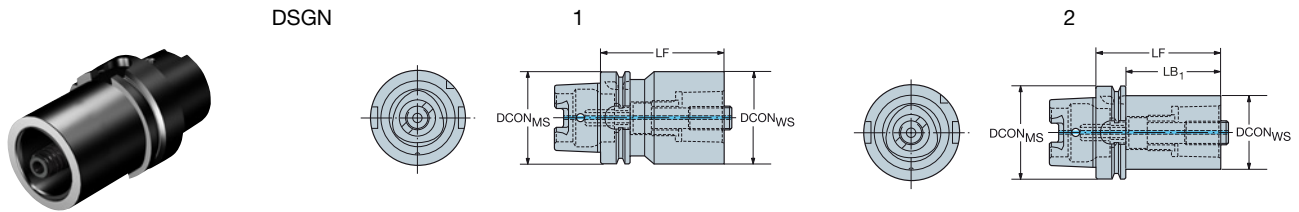
N23



N15

HSK to Coromant Capto® adaptor

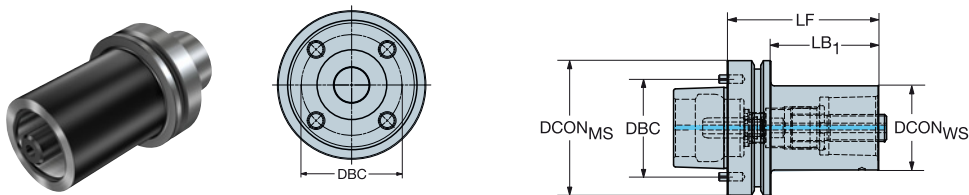
Machine side interface HSK A/C/T



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------|--------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₂ | BAR | NM | KG |
| 40 | C3 | 1 | 1 | 2 | C3-390.419-40 065 | 40.0 | 32.0 | 65.0 | 45.0 | 65.0 | 40.0 | 100 | 45.00 | 0.46 |
| | C4 | 1 | 1 | 1 | C4-390.419-40 075 | 40.0 | 40.0 | 75.0 | 75.0 | | | 100 | 55.00 | 0.60 |
| 63 | C5 | 1 | 1 | 2 | C5-390.419-63 090 | 63.0 | 50.0 | 90.0 | 64.0 | 90.0 | 63.0 | 100 | 95.00 | 1.46 |
| | C6 | 1 | 1 | 1 | C6-390.419-63 110 | 63.0 | 63.0 | 110.0 | 110.0 | | | 100 | 170.00 | 2.14 |
| 100 | C6 | 1 | 1 | 2 | C6-390.419-100 110 | 100.0 | 63.0 | 110.0 | 81.0 | 110.0 | 100.0 | 100 | 170.00 | 3.72 |
| | C8 | 1 | 1 | 2 | C8-390.419-100 120 | 100.0 | 80.0 | 120.0 | 91.0 | 120.0 | 100.0 | 100 | 170.00 | 4.88 |

Machine side interface HSK F with pins

For Makino MAG machine family



| | | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|------|--------------------|------|-----------------|-----|-------|------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LF | LB ₁ | BAR | NM | KG | |
| 80 | C5 | 1 | 1 | C5-390.612-80 090 | 80.0 | 58.0 | 50.0 | 90.0 | 64.0 | 100 | 95.00 | 1.92 | |

A special coolant tube is delivered together with the HSK basic holders.

HSK80F - Compatible with the Makino MAG machine family 1, 3, 4, 7 - for aerospace frame aluminium machining

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

M1



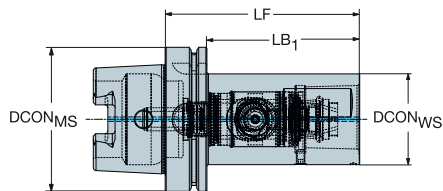
N23



N15

HSK to Coromant Capto® adaptor with Quick change

Machine side interface HSK A/C



| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|------|----------------|--------------------|--------------------|-------|-----------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BAR | NM | KG | RPMX |
| 63 | C5 | 1 | 1 | HA06-QC-C5-115 | 63.0 | 50.0 | 115.0 | 88.0 | 100 | 70.00 | 1.77 | 20500 |
| 100 | C6 | 1 | 1 | HA10-QC-C6-135 | 100.0 | 63.0 | 135.0 | 105.0 | 100 | 90.00 | 4.17 | 12500 |
| | C8 | 1 | 1 | HA10-QC-C8-165 | 100.0 | 80.0 | 165.0 | 135.0 | 100 | 130.00 | 6.32 | 12500 |

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



M1



N23



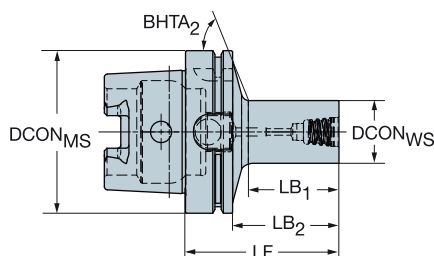
N6



N15

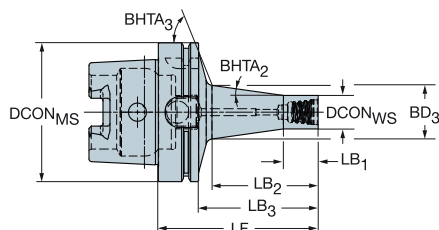
HSK to Coromant EH adaptor

Machine side interface HSK A/C



Short design

| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|---------------------|--------------------|--------------------|------|-----------------|-----------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BHTA ₂ | BAR | NM | KG | RPMX |
| 40 | E10 | 1 | 1 | 392.410EH-40 10 040 | 40.0 | 9.6 | 40.0 | 13.0 | 20.0 | 59° | 100 | 12.00 | 0.28 | 30000 |
| | E12 | 1 | 1 | 392.410EH-40 12 043 | 40.0 | 11.6 | 43.0 | 16.3 | 23.0 | 58° | 100 | 15.00 | 0.30 | 30000 |
| | E16 | 1 | 1 | 392.410EH-40 16 048 | 40.0 | 15.4 | 48.0 | 21.9 | 28.0 | 55° | 100 | 30.00 | 0.35 | 30000 |
| | E20 | 1 | 1 | 392.410EH-40 20 045 | 40.0 | 19.2 | 45.0 | 19.4 | 25.0 | 50° | 100 | 50.00 | 0.37 | 30000 |
| 50 | E10 | 1 | 1 | 392.410EH-50 10 047 | 50.0 | 9.6 | 47.0 | 13.0 | 21.0 | 63° | 100 | 12.00 | 0.49 | 25000 |
| | E12 | 1 | 1 | 392.410EH-50 12 050 | 50.0 | 11.6 | 50.0 | 16.3 | 24.0 | 62° | 100 | 15.00 | 0.51 | 25000 |
| | E16 | 1 | 1 | 392.410EH-50 16 055 | 50.0 | 15.4 | 55.0 | 21.8 | 29.0 | 60° | 100 | 30.00 | 0.57 | 25000 |
| | E20 | 1 | 1 | 392.410EH-50 20 052 | 50.0 | 19.2 | 52.0 | 19.3 | 26.0 | 58° | 100 | 50.00 | 0.58 | 25000 |
| | E25 | 1 | 1 | 392.410EH-50 25 057 | 50.0 | 24.1 | 57.0 | 24.9 | 31.0 | 54° | 100 | 65.00 | 0.63 | 25000 |
| 63 | E10 | 1 | 1 | 392.410EH-63 10 049 | 63.0 | 9.6 | 49.0 | 13.5 | 23.0 | 66° | 100 | 12.00 | 0.78 | 20500 |
| | E12 | 1 | 1 | 392.410EH-63 12 051 | 63.0 | 11.6 | 51.0 | 15.8 | 25.0 | 65° | 100 | 15.00 | 0.81 | 20500 |
| | E16 | 1 | 1 | 392.410EH-63 16 056 | 63.0 | 15.4 | 56.0 | 21.3 | 30.0 | 65° | 100 | 30.00 | 0.85 | 20500 |
| | E20 | 1 | 1 | 392.410EH-63 20 053 | 63.0 | 19.2 | 53.0 | 18.8 | 27.0 | 63° | 100 | 50.00 | 0.87 | 20500 |
| | E25 | 1 | 1 | 392.410EH-63 25 059 | 63.0 | 24.1 | 59.0 | 25.5 | 33.0 | 61° | 100 | 65.00 | 0.93 | 20500 |



Long design

| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|----------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₃ | BHTA ₂ | BHTA ₃ | BAR | NM | KG | RPMX |
| 63 | E10 | 1 | 1 | 392.410EH-63 10 062 | 63.0 | 9.6 | 62.0 | 10.0 | 27.9 | 36.0 | 14.6 | 8° | 66° | 100 | 12.00 | 0.80 | 20500 |
| | E12 | 1 | 1 | 392.410EH-63 12 068 | 63.0 | 11.6 | 68.0 | 12.0 | 34.3 | 42.0 | 17.9 | 8° | 65° | 100 | 15.00 | 0.83 | 20500 |
| | E16 | 1 | 1 | 392.410EH-63 16 078 | 63.0 | 15.4 | 78.0 | 16.0 | 45.1 | 52.0 | 23.6 | 8° | 64° | 100 | 30.00 | 0.92 | 20500 |
| | E20 | 1 | 1 | 392.410EH-63 20 091 | 63.0 | 19.2 | 91.0 | 20.0 | 59.0 | 65.0 | 30.1 | 8° | 61° | 100 | 50.00 | 1.01 | 20500 |
| 100 | E25 | 1 | 1 | 392.410EH-63 25 105 | 63.0 | 24.1 | 105.0 | 25.0 | 74.0 | 79.0 | 37.6 | 8° | 54° | 100 | 65.00 | 1.21 | 20500 |
| | E20 | 1 | 1 | 392.410EH-100 20 100 | 100.0 | 19.2 | 100.0 | 20.0 | 60.3 | 71.0 | 30.5 | 8° | 70° | 100 | 50.00 | 2.58 | 12500 |
| | E25 | 1 | 1 | 392.410EH-100 25 115 | 100.0 | 24.1 | 115.0 | 25.0 | 76.4 | 86.0 | 38.6 | 8° | 70° | 100 | 65.00 | 2.68 | 12500 |

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

M1



N23



N15



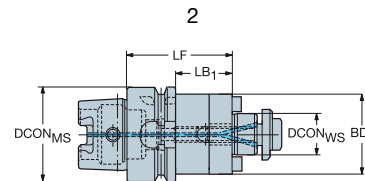
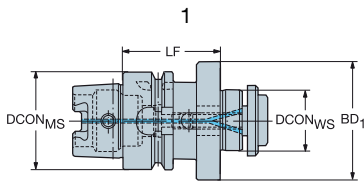
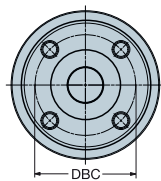
N3

HSK to arbor adaptor

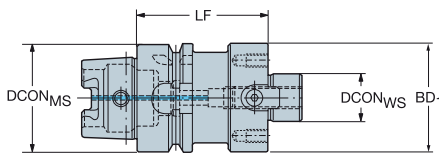
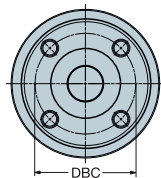
Machine side interface HSK A/C

Coolant through arbor

DSGN



| | | Dimensions, mm | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|--------------------|---------------------|--------------------|------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|--------|--------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 40 | 16 | 1 | 4 | 2 | 392.41005C-4016050 | 40.0 | 16.0 | 50.0 | 30.0 | 50.0 | 32.0 | 40.0 | 80 | 22.00 | 0.45 | 30000 | |
| | 22 | 1 | 4 | 1 | 392.41005C-4022050 | 40.0 | 22.0 | 50.0 | 50.0 | 48.0 | | 80 | 45.00 | 0.60 | 30000 | | |
| 50 | 16 | 1 | 4 | 2 | 392.41005C-5016050 | 50.0 | 16.0 | 50.0 | 24.0 | 50.0 | 32.0 | 50.0 | 80 | 22.00 | 0.62 | 25000 | |
| | 22 | 1 | 4 | 2 | 392.41005C-5022060 | 50.0 | 22.0 | 60.0 | 34.0 | 60.0 | 48.0 | 50.0 | 80 | 45.00 | 0.92 | 25000 | |
| 63 | 16 | 1 | 4 | 2 | 392.41005C6316050 | 63.0 | 16.0 | 50.0 | 24.0 | 50.0 | 32.0 | 63.0 | 80 | 22.00 | 0.87 | 20500 | |
| | 22 | 1 | 4 | 2 | 392.41005C6322050 | 63.0 | 22.0 | 50.0 | 24.0 | 50.0 | 50.0 | 63.0 | 80 | 45.00 | 1.12 | 20500 | |
| | 27 | 1 | 4 | 2 | 392.41005C6327060 | 63.0 | 27.0 | 60.0 | 24.0 | 60.0 | 60.0 | 63.0 | 80 | 80.00 | 1.45 | 20500 | |
| | 32 | 1 | 4 | 1 | 392.41005C6332060 | 63.0 | 32.0 | 60.0 | 60.0 | | 78.0 | | 80 | 180.00 | 1.80 | 20500 | |
| 40S | 1 | 4 | 1 | 392.41005C6340060M | 63.0 | 66.7 | 40.0 | 60.0 | 60.0 | | 87.0 | | 80 | 300.00 | 2.13 | 20500 | |
| 80 | 22 | 1 | 4 | 2 | 392.41005C8022050 | 80.0 | 22.0 | 50.0 | 24.0 | 50.0 | 50.0 | 80.0 | 80 | 45.00 | 1.59 | 14000 | |
| | 27 | 1 | 4 | 2 | 392.41005C8027050 | 80.0 | 27.0 | 50.0 | 24.0 | 50.0 | 60.0 | 80.0 | 80 | 80.00 | 1.78 | 14000 | |
| | 32 | 1 | 4 | 2 | 392.41005C8032060 | 80.0 | 32.0 | 60.0 | 34.0 | 60.0 | 78.0 | 80.0 | 80 | 180.00 | 2.42 | 14000 | |
| | 40 | 1 | 4 | 1 | 392.41005C8040060 | 80.0 | 40.0 | 60.0 | 60.0 | | 87.0 | | 80 | 300.00 | 2.74 | 14000 | |
| 100 | 22 | 1 | 4 | 2 | 392.41005C10022100 | 100.0 | 22.0 | 100.0 | 71.0 | 100.0 | 50.0 | 100.0 | 80 | 45.00 | 3.25 | 12500 | |
| | 27 | 1 | 4 | 2 | 392.41005C10027100 | 100.0 | 27.0 | 100.0 | 71.0 | 100.0 | 60.0 | 100.0 | 80 | 80.00 | 3.76 | 12500 | |
| | 32 | 1 | 4 | 2 | 392.41005C10032100 | 100.0 | 32.0 | 100.0 | 71.0 | 100.0 | 78.0 | 100.0 | 80 | 180.00 | 4.90 | 12500 | |
| | 40S | 1 | 4 | 2 | 392.41005C10040100M | 100.0 | 66.7 | 40.0 | 100.0 | 71.0 | 100.0 | 87.0 | 100.0 | 80 | 300.00 | 5.62 | 12500 |
| 125 | 32 | 1 | 4 | 2 | 392.41005C12532100 | 125.0 | 32.0 | 100.0 | 71.0 | 100.0 | 78.0 | 125.0 | 80 | 180.00 | 6.19 | 9500 | |
| | 40S | 1 | 4 | 2 | 392.41005C12540100M | 125.0 | 66.7 | 40.0 | 100.0 | 71.0 | 100.0 | 87.0 | 125.0 | 80 | 300.00 | 7.05 | 9500 |



| | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|----------------|--------------------|--------------------|-------|--------------------|------|-----------------|--------|------|-------|
| CZC _{MS} | CZC _{WS} | DSGN | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LF | BD ₁ | NM | KG | RPMX |
| 100 | 60 | 1 | 392.41005-10060075 | 100.0 | 101.6 | 60.0 | 75.0 | 130.0 | 180.00 | 6.30 | 12500 |
| 125 | 60 | 1 | 392.41005-12560085 | 125.0 | 101.6 | 60.0 | 85.0 | 130.0 | 180.00 | 9.70 | 9500 |

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M1



N23

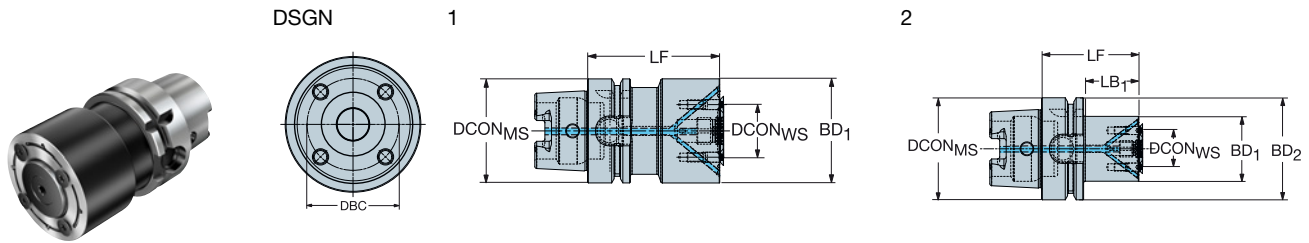


N15

HSK to arbor with driving screws adaptor

Machine side interface HSK A/C

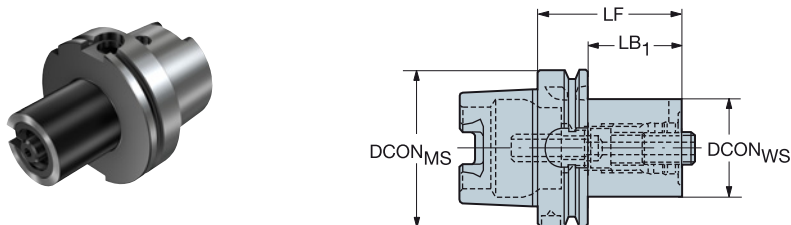
For CoroMill® QD with internal coolant supply



| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|--------------------|------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|------|------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 63 | X10 | 1 | 3 | 2 | HA06-X10-032-055 | 63.0 | 22.0 | 10.0 | 2 | 55.0 | 28.0 | 55.0 | 32.0 | 63.0 | 80 | 6.40 | 0.85 | 12000 |
| | X22 | 1 | 3 | 2 | HA06-X22-040-060 | 63.0 | 32.0 | 22.0 | 2 | 60.0 | 33.0 | 60.0 | 40.0 | 63.0 | 80 | 3.90 | 1.01 | 11000 |
| | X32 | 1 | 3 | 1 | HA06-X32-063-080 | 63.0 | 45.0 | 32.0 | 2 | 80.0 | 80.0 | | 63.0 | 80 | 6.40 | 1.82 | 10000 | |

HSK to VL adaptor

Machine side interface HSK A/C



| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|--------------------|--------------------|--------------------|------|-----------------|-----|--------|------|--|--|--|--|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BAR | NM | KG | | | | | | | |
| 100 | 80 | 1 | 1 | 390.410-100 80 090 | 100.0 | 80.0 | 90.0 | 61.0 | 100 | 170.00 | 4.39 | | | | | | | |

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M1



N23



N15

HSK to Weldon adaptor

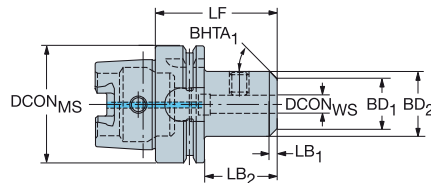
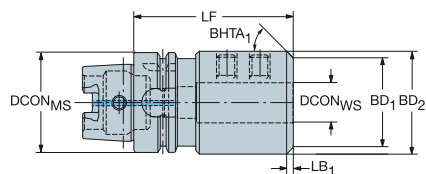
Machine side interface HSK A/C

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN

3

6



| | | | | | | Dimensions, mm | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------------|-----------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------|-------|-------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | RPMX | |
| 63 | 8 | 1 | 1 | 6 | 392.41020-63 08 065B | 63.0 | 8.0 | 65.0 | 2.0 | 39.0 | 65.0 | 24.0 | 28.0 | 63.0 | 45° | 20 | 7.00 | 0.83 | 20500 | |
| | 10 | 1 | 1 | 6 | 392.41020-63 10 065B | 63.0 | 10.0 | 65.0 | 2.0 | 39.0 | 65.0 | 31.0 | 35.0 | 63.0 | 45° | 20 | 10.00 | 1.02 | 20500 | |
| | 12 | 1 | 1 | 6 | 392.41020-63 12 080B | 63.0 | 12.0 | 80.0 | 2.0 | 54.0 | 80.0 | 38.0 | 42.0 | 63.0 | 45° | 20 | 12.00 | 1.18 | 20500 | |
| | 16 | 1 | 1 | 6 | 392.41020-63 16 080B | 63.0 | 16.0 | 80.0 | 2.0 | 54.0 | 80.0 | 44.0 | 48.0 | 63.0 | 45° | 20 | 15.00 | 1.32 | 20500 | |
| | 20 | 1 | 1 | 6 | 392.41020-63 20 080B | 63.0 | 20.0 | 80.0 | 4.0 | 54.0 | 80.0 | 44.0 | 52.0 | 63.0 | 45° | 20 | 20.00 | 1.39 | 20500 | |
| | 25 | 1 | 1 | 3 | 392.41020-63 25 110B | 63.0 | 25.0 | 110.0 | 5.0 | 110.0 | | | 55.0 | 65.0 | | 45° | 20 | 25.00 | 2.35 | 20500 |
| 100 | 32 | 1 | 1 | 3 | 392.41020-63 32 110B | 63.0 | 32.0 | 110.0 | 5.0 | 110.0 | | | 62.0 | 72.0 | | 45° | 20 | 45.00 | 2.60 | 20500 |
| | 12 | 1 | 1 | 6 | 392.41020-100 12 080A | 100.0 | 12.0 | 80.0 | 5.0 | 51.0 | 80.0 | 32.0 | 42.0 | 100.0 | 45° | 20 | 12.00 | 2.62 | 12500 | |
| | 16 | 1 | 1 | 6 | 392.41020-100 16 100A | 100.0 | 16.0 | 100.0 | 5.0 | 71.0 | 100.0 | 32.0 | 42.0 | 100.0 | 45° | 20 | 15.00 | 2.98 | 12500 | |
| | 20 | 1 | 1 | 6 | 392.41020-100 20 100A | 100.0 | 20.0 | 100.0 | 5.0 | 71.0 | 100.0 | 42.0 | 52.0 | 100.0 | 45° | 20 | 20.00 | 3.12 | 12500 | |
| | 25 | 1 | 1 | 6 | 392.41020-100 25 100A | 100.0 | 25.0 | 100.0 | 8.0 | 71.0 | 100.0 | 49.0 | 65.0 | 100.0 | 45° | 20 | 25.00 | 3.59 | 12500 | |
| | 32 | 1 | 1 | 6 | 392.41020-100 32 100A | 100.0 | 32.0 | 100.0 | 8.0 | 71.0 | 100.0 | 56.0 | 72.0 | 100.0 | 45° | 20 | 45.00 | 3.84 | 12500 | |
| 40 | 1 | 1 | 6 | 392.41020-100 40 120A | 100.0 | 40.0 | 120.0 | 8.0 | 91.0 | 120.0 | 74.0 | 90.0 | 100.0 | 45° | 20 | 45.00 | 5.64 | 12500 | | |

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M1



N23

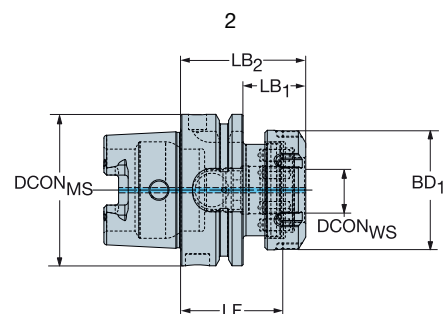
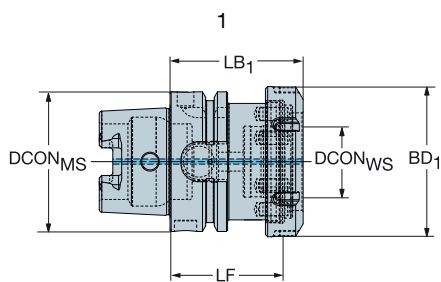


N15

HSK to MDI adaptor

Machine side interface HSK A/C/T

DSGN



| | | Dimensions, mm | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|------|-----------------|--------------------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 63 | MDI-20 | 1 | 1 | 2 | HT06-DM20-N-042 | 63.0 | 20.0 | 42.0 | 26.0 | 52.0 | 49.7 | 63.0 | 80 | 135.00 | 0.86 | 20000 |
| | MDI-25 | 1 | 1 | 2 | HT06-DM25-N-050 | 63.0 | 25.0 | 50.0 | 34.0 | 60.0 | 62.7 | 63.0 | 80 | 170.00 | 1.10 | 20000 |
| | MDI-32 | 1 | 1 | 1 | HT06-DM32-N-050 | 63.0 | 32.0 | 50.0 | 60.0 | | 67.7 | | 80 | 200.00 | 1.18 | 20000 |

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

M1



N23



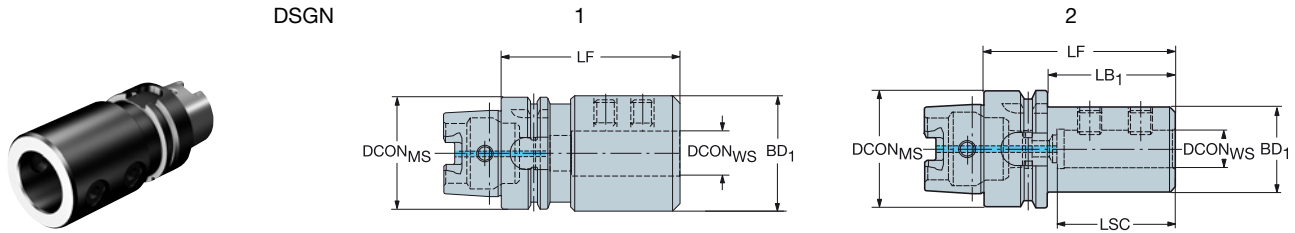
N15



N5

HSK to ISO 9766 adaptor

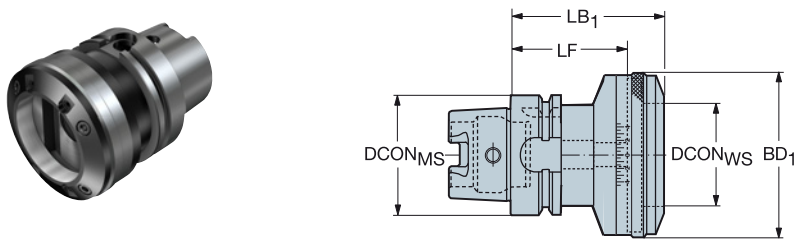
Machine side interface HSK A/C



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|----------------------|-----------------------|--------------------|--------------------|-------|-------|-----------------|-----------------|-----------------|-----------------|-------|-------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 63 | 16 | 1 | 1 | 2 | 392.41027-63 16 080B | 63.0 | 16.0 | 49 | 80.0 | 54.0 | 80.0 | 36.0 | 63.0 | 20 | 10.00 | 1.02 | 20500 |
| | 20 | 1 | 1 | 2 | 392.41027-63 20 080B | 63.0 | 20.0 | 51 | 80.0 | 54.0 | 80.0 | 40.0 | 63.0 | 20 | 12.00 | 1.06 | 20500 |
| | 25 | 1 | 1 | 2 | 392.41027-63 25 090B | 63.0 | 25.0 | 57 | 90.0 | 64.0 | 90.0 | 45.0 | 63.0 | 20 | 20.00 | 0.12 | 20500 |
| | 32 | 1 | 1 | 2 | 392.41027-63 32 090B | 63.0 | 32.0 | 61 | 90.0 | 64.0 | 90.0 | 52.0 | 63.0 | 20 | 30.00 | 1.32 | 20500 |
| | 40 | 1 | 1 | 2 | 392.41027-63 40 110 | 63.0 | 40.0 | 71 | 110.0 | 110.0 | | 65.0 | 20 | 40.00 | 1.93 | 20500 | |
| 80 | 20 | 1 | 1 | 2 | 392.41027-80 20 085 | 80.0 | 20.0 | 51 | 85.0 | 59.0 | 85.0 | 40.0 | 80.0 | 20 | 12.00 | 1.59 | 14000 |
| | 25 | 1 | 1 | 2 | 392.41027-80 25 090 | 80.0 | 25.0 | 57 | 90.0 | 64.0 | 90.0 | 45.0 | 80.0 | 20 | 20.00 | 1.70 | 14000 |
| | 32 | 1 | 1 | 2 | 392.41027-80 32 095 | 80.0 | 32.0 | 61 | 95.0 | 69.0 | 95.0 | 52.0 | 80.0 | 20 | 30.00 | 1.88 | 14000 |
| | 40 | 1 | 1 | 2 | 392.41027-80 40 110 | 80.0 | 40.0 | 71 | 110.0 | 84.0 | 110.0 | 65.0 | 80.0 | 20 | 40.00 | 2.58 | 14000 |
| 100 | 16 | 1 | 1 | 2 | 392.41027-100 16 090A | 100.0 | 16.0 | 49 | 90.0 | 61.0 | 90.0 | 36.0 | 100.0 | 20 | 10.00 | 2.52 | 12500 |
| | 20 | 1 | 1 | 2 | 392.41027-100 20 090A | 100.0 | 20.0 | 51 | 90.0 | 61.0 | 90.0 | 40.0 | 100.0 | 20 | 12.00 | 2.58 | 12500 |
| | 25 | 1 | 1 | 2 | 392.41027-100 25 100A | 100.0 | 25.0 | 57 | 100.0 | 71.0 | 100.0 | 45.0 | 100.0 | 20 | 20.00 | 2.73 | 12500 |
| | 32 | 1 | 1 | 2 | 392.41027-100 32 100A | 100.0 | 32.0 | 61 | 100.0 | 71.0 | 100.0 | 52.0 | 100.0 | 20 | 30.00 | 2.84 | 12500 |
| | 40 | 1 | 1 | 2 | 392.41027-100 40 110A | 100.0 | 40.0 | 71 | 110.0 | 81.0 | 110.0 | 65.0 | 100.0 | 20 | 40.00 | 3.43 | 12500 |
| 50 | 1 | 1 | 2 | 392.41027-100 50 120 | 100.0 | 50.0 | 81 | 120.0 | 91.0 | 120.0 | 75.0 | 100.0 | 20 | 45.00 | 3.95 | 12500 | |

HSK to ISO 9766 adjustable adaptor

Machine side interface HSK A/C



| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|------------------------|--------------------|--------------------|------|-----------------|-----------------|-----|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BD ₁ | BAR | KG | RPMX |
| 63 | 1 | 1 | 1 | 392.410277-63 01 060B | 63.0 | 78.0 | 60.0 | 84.6 | 86.0 | 20 | 2.09 | 12000 |
| 100 | 2 | 1 | 1 | 392.410277-100 02 065A | 100.0 | 98.0 | 65.0 | 89.6 | 106.0 | 20 | 4.64 | 9000 |
| | 3 | 1 | 1 | 392.410277-100 03 085A | 100.0 | 136.0 | 85.0 | 95.0 | 140.0 | 20 | 6.58 | 6000 |

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



M1



N23



N15

HSK to CoroChuck™ 930

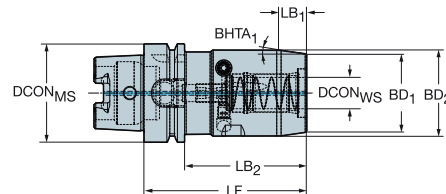
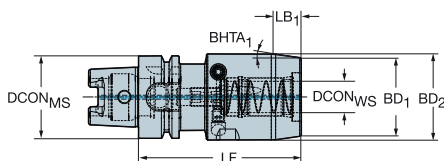
Heavy Duty design

Machine side interface HSK A/C

DSGN

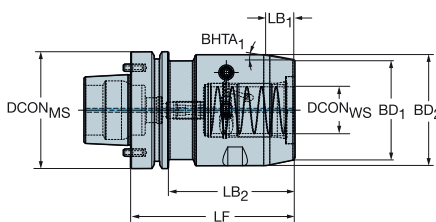
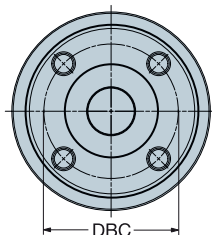
3

6



| | | | | | | Dimensions, mm | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|--------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | RPMX |
| 63 | 20 | 1 | 1 | 6 | 930-HA06-HD-20-104 | 63.0 | 20.0 | 51 | 104.0 | 17.8 | 78.0 | 104.0 | 50.0 | 55.0 | 62.9 | 8° | 80 | 10.00 | 1.89 | 20000 |
| | 25 | 1 | 1 | 3 | 930-HA06-HD-25-110 | 63.0 | 25.0 | 57 | 110.0 | 18.8 | 110.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 2.35 | 20000 |
| | 32 | 1 | 1 | 3 | 930-HA06-HD-32-112 | 63.0 | 32.0 | 61 | 112.0 | 18.8 | 112.0 | | 68.0 | 76.0 | | 12° | 80 | 10.00 | 2.90 | 20000 |
| | 32 | 1 | 1 | 6 | 930-HA08-HD-32-110 | 80.0 | 32.0 | 61 | 110.0 | 18.8 | 84.0 | 110.0 | 68.0 | 76.0 | 80.0 | 12° | 80 | 10.00 | 3.44 | 14000 |
| 100 | 20 | 1 | 1 | 6 | 930-HA10-HD-20-100 | 100.0 | 20.0 | 51 | 100.0 | 17.8 | 71.0 | 100.0 | 50.0 | 55.0 | 99.9 | 8° | 80 | 10.00 | 3.18 | 10000 |
| | 25 | 1 | 1 | 6 | 930-HA10-HD-25-106 | 100.0 | 25.0 | 57 | 106.0 | 18.8 | 77.0 | 106.0 | 57.0 | 65.0 | 99.9 | 12° | 80 | 10.00 | 3.72 | 10000 |
| | 32 | 1 | 1 | 6 | 930-HA10-HD-32-110 | 100.0 | 32.0 | 61 | 110.0 | 18.8 | 81.0 | 110.0 | 68.0 | 76.0 | 99.9 | 12° | 80 | 10.00 | 4.40 | 10000 |
| | 32 | 1 | 1 | 6 | 930-HA10-HD-32-180 | 100.0 | 32.0 | 61 | 180.0 | 18.8 | 151.0 | 180.0 | 68.0 | 76.0 | 100.0 | 12° | 80 | 10.00 | 6.84 | 10000 |

Machine side interface HSK F with pins for Makino



| | | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|--------------------|--------------------|----------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BHTA ₁ | BAR | NM | KG | RPMX | |
| 80 | 32 | 1 | 1 | 930-HF08-HD-32-112 | 80.0 | 58.0 | 32.0 | 61 | 112.0 | 18.8 | 86.0 | 68.0 | 76.0 | 12° | 80 | 10.00 | 3.48 | 24000 | |

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



M1



N23



N6



N15



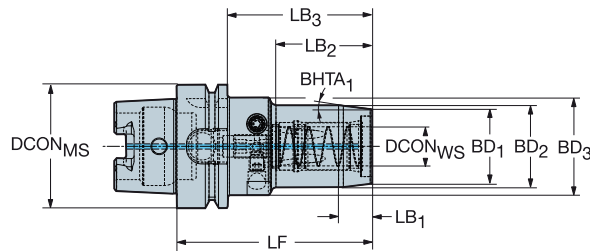
N4



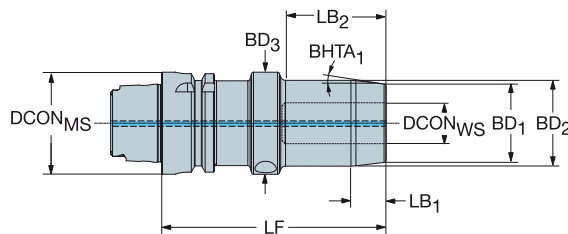
HSK to CoroChuck™ 930

Slender design

Machine side interface HSK A/C



| | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------|-------|------|------|-------------------|--------|--------|-----|-------|------|------|------|------|------|------|-------|-----|------|------|-------|--|--|
| CZCMS | CZCWS | CNSC | CXSC | Ordering code | DCONMS | DCONWS | LSC | LF | LB1 | LB2 | LB3 | BD1 | BD2 | BD3 | BHTA1 | BAR | NM | KG | RPMX | | |
| 40 | 6 | 1 | 1 | 930-HA04-S-06-070 | 40.0 | 6.0 | 37 | 70.0 | 11.3 | 33.2 | 50.0 | 22.0 | 26.0 | 32.0 | 10° | 80 | 8.00 | 0.40 | 30000 | | |
| | 8 | 1 | 1 | 930-HA04-S-08-070 | 40.0 | 8.0 | 37 | 70.0 | 11.3 | 35.3 | 50.0 | 24.0 | 28.0 | 32.0 | 10° | 80 | 8.00 | 0.42 | 30000 | | |
| | 10 | 1 | 1 | 930-HA04-S-10-075 | 40.0 | 10.0 | 41 | 75.0 | 11.3 | 39.6 | 55.0 | 26.0 | 30.0 | 32.0 | 10° | 80 | 8.00 | 0.46 | 30000 | | |
| | 12 | 1 | 1 | 930-HA04-S-12-080 | 40.0 | 12.0 | 46 | 80.0 | 11.3 | 41.0 | 60.0 | 28.0 | 32.0 | 33.5 | 10° | 80 | 8.00 | 0.51 | 30000 | | |
| 50 | 6 | 1 | 1 | 930-HA05-S-06-074 | 50.0 | 6.0 | 37 | 74.0 | 11.3 | 30.2 | 48.0 | 22.0 | 26.0 | 40.0 | 10° | 80 | 8.00 | 0.64 | 25000 | | |
| | 8 | 1 | 1 | 930-HA05-S-08-074 | 50.0 | 8.0 | 37 | 74.0 | 11.3 | 30.2 | 48.0 | 24.0 | 28.0 | 40.0 | 10° | 80 | 8.00 | 0.65 | 25000 | | |
| | 10 | 1 | 1 | 930-HA05-S-10-080 | 50.0 | 10.0 | 41 | 80.0 | 11.3 | 34.2 | 54.0 | 26.0 | 30.0 | 40.0 | 10° | 80 | 8.00 | 0.71 | 25000 | | |
| | 12 | 1 | 1 | 930-HA05-S-12-085 | 50.0 | 12.0 | 46 | 85.0 | 11.3 | 38.2 | 59.0 | 28.0 | 32.0 | 40.0 | 10° | 80 | 8.00 | 0.75 | 25000 | | |
| 63 | 6 | 1 | 1 | 930-HA06-S-06-074 | 63.0 | 6.0 | 37 | 74.0 | 11.3 | 30.2 | 48.0 | 22.0 | 26.0 | 40.0 | 10° | 80 | 8.00 | 0.90 | 20000 | | |
| | 8 | 1 | 1 | 930-HA06-S-08-074 | 63.0 | 8.0 | 37 | 74.0 | 11.3 | 30.2 | 48.0 | 24.0 | 28.0 | 40.0 | 10° | 80 | 8.00 | 0.91 | 20000 | | |
| | 10 | 1 | 1 | 930-HA06-S-10-080 | 63.0 | 10.0 | 41 | 80.0 | 11.3 | 34.2 | 54.0 | 26.0 | 30.0 | 40.0 | 10° | 80 | 8.00 | 0.99 | 20000 | | |
| | 12 | 1 | 1 | 930-HA06-S-12-090 | 63.0 | 12.0 | 46 | 90.0 | 11.3 | 38.2 | 64.0 | 28.0 | 32.0 | 50.0 | 10° | 80 | 8.00 | 1.21 | 20000 | | |
| 20 | 1 | 1 | 1 | 930-HA06-S-20-100 | 63.0 | 20.0 | 51 | 100.0 | 16.0 | 49.2 | 74.0 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 1.40 | 20000 | | |
| | 1 | 1 | 1 | 930-HA10-S-12-095 | 100.0 | 12.0 | 46 | 95.0 | 11.3 | 38.2 | 66.0 | 28.0 | 32.0 | 50.0 | 10° | 80 | 8.00 | 2.63 | 10000 | | |
| 20 | 1 | 1 | 1 | 930-HA10-S-20-100 | 100.0 | 20.0 | 51 | 100.0 | 16.0 | 49.2 | 71.0 | 38.0 | 42.0 | 50.0 | 7° | 80 | 8.00 | 2.74 | 10000 | | |



| | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------|-------|------|------|-------------------|--------|--------|-----|-------|------|------|------|------|-------|-----|------|------|-------|--|--|--|--|
| CZCMS | CZCWS | CNSC | CXSC | Ordering code | DCONMS | DCONWS | LSC | LF | LB1 | LB2 | BD1 | BD2 | BHTA1 | BAR | NM | KG | RPMX | | | | |
| 40 | 12 | 1 | 1 | 930-HA04-S-12-096 | 40.0 | 12.0 | 46 | 96.0 | 11.3 | 38.2 | 28.0 | 32.0 | 10° | 80 | 8.00 | 0.70 | 40000 | | | | |
| 50 | 20 | 1 | 1 | 930-HA05-S-20-090 | 50.0 | 20.0 | 51 | 90.0 | 16.0 | 64.0 | 37.6 | 41.5 | 7° | 80 | 8.00 | 0.89 | 25000 | | | | |
| | 20 | 1 | 1 | 930-HA05-S-20-110 | 50.0 | 20.0 | 51 | 110.0 | 16.0 | 49.2 | 38.0 | 42.0 | 7° | 80 | 8.00 | 1.19 | 36000 | | | | |
| 63 | 25 | 1 | 1 | 930-HA06-S-25-108 | 63.0 | 25.0 | 57 | 108.0 | 12.9 | 81.1 | 45.0 | 50.0 | 11° | 80 | 8.00 | 1.66 | 20000 | | | | |
| 80 | 25 | 1 | 1 | 930-HA08-S-25-110 | 80.0 | 25.0 | 57 | 110.0 | 12.9 | 83.1 | 45.0 | 50.0 | 11° | 80 | 8.00 | 2.13 | 14000 | | | | |
| 100 | 25 | 1 | 1 | 930-HA10-S-25-110 | 100.0 | 25.0 | 57 | 110.0 | 12.9 | 80.1 | 45.0 | 50.0 | 11° | 80 | 8.00 | 3.02 | 10000 | | | | |

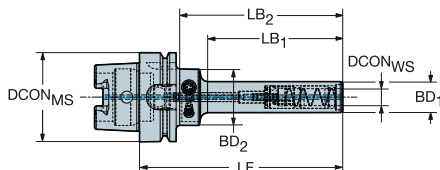
For spare parts, visit www.sandvik.coromant.com



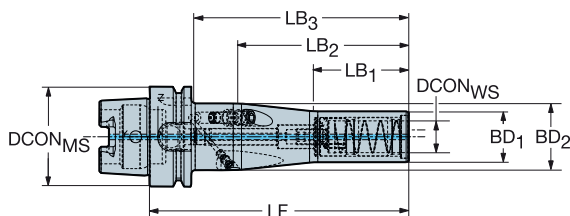
HSK to CoroChuck™ 930

Pencil design

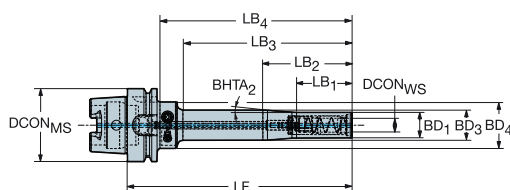
Machine side interface HSK A/C



| | | Dimensions, mm | | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|-------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₂ | BAR | NM | KG | RPMX |
| 63 | 6 | 1 | 1 | 930-HA06-P-06-094 | 63.0 | 6.0 | 37 | 94.0 | 45.8 | 52.1 | 68.0 | 94.0 | 14.5 | 14.5 | 40.0 | 63.0 | 62° | 80 | 8.00 | 0.89 | 20000 |
| | 8 | 1 | 1 | 930-HA06-P-08-094 | 63.0 | 8.0 | 37 | 94.0 | 45.8 | 65.5 | 94.0 | | 17.5 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 0.87 | 20000 |
| | 10 | 1 | 1 | 930-HA06-P-10-104 | 63.0 | 10.0 | 41 | 104.0 | 55.8 | 75.5 | 104.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 0.91 | 20000 |
| | 10 | 1 | 1 | 930-HA06-P-10-144 | 63.0 | 10.0 | 41 | 144.0 | 95.8 | 115.5 | 144.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.01 | 20000 |
| | 12 | 1 | 1 | 930-HA06-P-12-109 | 63.0 | 12.0 | 46 | 109.0 | 60.8 | 66.4 | 83.0 | 109.0 | 22.0 | 22.0 | 40.0 | 63.0 | 55° | 80 | 8.00 | 0.98 | 20000 |
| | 12 | 1 | 1 | 930-HA06-P-12-144 | 63.0 | 12.0 | 46 | 144.0 | 95.8 | 101.4 | 118.0 | 144.0 | 22.0 | 22.0 | 40.0 | 63.0 | 55° | 80 | 8.00 | 1.09 | 20000 |
| 100 | 12 | 1 | 1 | 930-HA10-P-12-115 | 100.0 | 12.0 | 46 | 115.0 | 60.8 | 66.4 | 86.0 | 115.0 | 22.0 | 22.0 | 40.0 | 100.0 | 55° | 80 | 8.00 | 2.40 | 10000 |
| | 12 | 1 | 1 | 930-HA10-P-12-150 | 100.0 | 12.0 | 46 | 150.0 | 95.8 | 101.4 | 121.0 | 150.0 | 22.0 | 22.0 | 40.0 | 100.0 | 55° | 80 | 8.00 | 2.51 | 10000 |



| | | Dimensions, mm | | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|-------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₃ | BHTA ₂ | BAR | NM | KG | RPMX |
| 63 | 20 | 1 | 1 | 930-HA06-P-20-163 | 63.0 | 20.0 | 51 | 163.0 | 60.0 | 108.0 | 137.0 | 32.0 | 42.0 | 6° | 80 | 8.00 | 1.59 | 20000 |
| 100 | 20 | 1 | 1 | 930-HA10-P-20-170 | 100.0 | 20.0 | 51 | 170.0 | 60.0 | 108.0 | 141.0 | 32.0 | 42.0 | 6° | 80 | 8.00 | 3.06 | 10000 |



| | | Dimensions, mm | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|-------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₃ | BD ₄ | BHTA ₂ | BAR | NM | KG | RPMX |
| 63 | 12 | 1 | 1 | 930-HA06-P-12-194 | 63.0 | 12.0 | 46 | 194.0 | 50.0 | 75.0 | 145.8 | 168.0 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.00 | 1.39 | 20000 |
| 100 | 12 | 1 | 1 | 930-HA10-P-12-200 | 100.0 | 12.0 | 46 | 200.0 | 50.0 | 75.0 | 145.8 | 171.0 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.00 | 2.79 | 10000 |

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

M1



N23



N6



N15

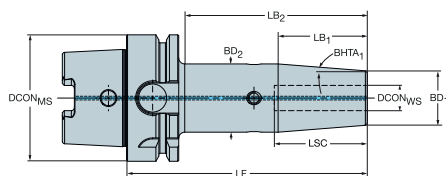


N4

HSK to shrink fit chuck

Machine side interface HSK A/C

Internal coolant supply



For MQL machining

| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-------------------|-------|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BHTA ₁ | (BAR) | (KG) | RPMX | | |
| 63 | 6 | 1 | 1 | HA06-SH06Q-S-080 | 63.0 | 6.0 | 22 | 80.0 | 38.1 | 54.0 | 21.0 | 27.0 | 4° | 10 | 0.83 | 20500 | | |
| | 6 | 1 | 1 | HA06-SH06Q-S-120 | 63.0 | 6.0 | 22 | 120.0 | 38.1 | 94.0 | 21.0 | 27.0 | 4° | 10 | 1.01 | 20500 | | |
| | 8 | 1 | 1 | HA06-SH08Q-S-080 | 63.0 | 8.0 | 26 | 80.0 | 38.1 | 54.0 | 21.0 | 27.0 | 4° | 10 | 0.82 | 20500 | | |
| | 8 | 1 | 1 | HA06-SH08Q-S-120 | 63.0 | 8.0 | 26 | 120.0 | 38.1 | 94.0 | 21.0 | 27.0 | 4° | 10 | 1.00 | 20500 | | |
| | 10 | 1 | 1 | HA06-SH10Q-S-085 | 63.0 | 10.0 | 31 | 85.0 | 50.8 | 59.0 | 24.0 | 32.0 | 4° | 10 | 0.90 | 20500 | | |
| | 10 | 1 | 1 | HA06-SH10Q-S-120 | 63.0 | 10.0 | 31 | 120.0 | 50.8 | 94.0 | 24.0 | 32.0 | 4° | 10 | 1.11 | 20500 | | |
| | 12 | 1 | 1 | HA06-SH12Q-S-090 | 63.0 | 12.0 | 34 | 90.0 | 50.8 | 64.0 | 24.0 | 32.0 | 4° | 10 | 0.91 | 20500 | | |
| | 12 | 1 | 1 | HA06-SH12Q-S-120 | 63.0 | 12.0 | 34 | 120.0 | 50.8 | 94.0 | 24.0 | 32.0 | 4° | 10 | 1.09 | 20500 | | |
| | 16 | 1 | 1 | HA06-SH16Q-S-095 | 63.0 | 16.0 | 39 | 95.0 | 44.4 | 69.0 | 27.0 | 34.0 | 4° | 10 | 0.97 | 20500 | | |
| | 16 | 1 | 1 | HA06-SH16Q-S-120 | 63.0 | 16.0 | 39 | 120.0 | 44.4 | 94.0 | 27.0 | 34.0 | 4° | 10 | 1.14 | 20500 | | |
| | 20 | 1 | 1 | HA06-SH20Q-S-100 | 63.0 | 20.0 | 41 | 100.0 | 57.2 | 74.0 | 33.0 | 42.0 | 4° | 10 | 1.17 | 20500 | | |
| | 20 | 1 | 1 | HA06-SH20Q-S-120 | 63.0 | 20.0 | 41 | 120.0 | 57.2 | 94.0 | 33.0 | 42.0 | 4° | 10 | 1.38 | 20500 | | |
| | 25 | 1 | 1 | HA06-SH25Q-S-115 | 63.0 | 25.0 | 47 | 115.0 | 57.2 | 89.0 | 44.0 | 53.0 | 4° | 10 | 1.75 | 20500 | | |
| | 32 | 1 | 1 | HA06-SH32Q-S-120 | 63.0 | 32.0 | 51 | 120.0 | 57.2 | 94.0 | 44.0 | 53.0 | 4° | 10 | 1.64 | 20500 | | |
| 100 | 6 | 1 | 1 | HA10-SH06Q-S-085 | 100.0 | 6.0 | 22 | 85.0 | 38.1 | 56.0 | 21.0 | 27.0 | 4° | 10 | 2.19 | 12500 | | |
| | 6 | 1 | 1 | HA10-SH06Q-S-120 | 100.0 | 6.0 | 22 | 120.0 | 38.1 | 91.0 | 21.0 | 27.0 | 4° | 10 | 2.34 | 12500 | | |
| | 8 | 1 | 1 | HA10-SH08Q-S-085 | 100.0 | 8.0 | 26 | 85.0 | 38.1 | 56.0 | 21.0 | 27.0 | 4° | 10 | 2.18 | 12500 | | |
| | 8 | 1 | 1 | HA10-SH08Q-S-120 | 100.0 | 8.0 | 26 | 120.0 | 38.1 | 91.0 | 21.0 | 27.0 | 4° | 10 | 2.33 | 12500 | | |
| | 10 | 1 | 1 | HA10-SH10Q-S-090 | 100.0 | 10.0 | 31 | 90.0 | 50.8 | 61.0 | 24.0 | 32.0 | 4° | 10 | 2.26 | 12500 | | |
| | 10 | 1 | 1 | HA10-SH10Q-S-120 | 100.0 | 10.0 | 31 | 120.0 | 50.8 | 91.0 | 24.0 | 32.0 | 4° | 10 | 2.44 | 12500 | | |
| | 12 | 1 | 1 | HA10-SH12Q-S-095 | 100.0 | 12.0 | 34 | 95.0 | 50.8 | 66.0 | 24.0 | 32.0 | 4° | 10 | 2.28 | 12500 | | |
| | 12 | 1 | 1 | HA10-SH12Q-S-120 | 100.0 | 12.0 | 34 | 120.0 | 50.8 | 91.0 | 24.0 | 32.0 | 4° | 10 | 2.42 | 12500 | | |
| | 16 | 1 | 1 | HA10-SH16Q-S-100 | 100.0 | 16.0 | 39 | 100.0 | 44.4 | 71.0 | 27.0 | 34.0 | 4° | 10 | 2.34 | 12500 | | |
| | 16 | 1 | 1 | HA10-SH16Q-S-130 | 100.0 | 16.0 | 39 | 130.0 | 44.4 | 101.0 | 27.0 | 34.0 | 4° | 10 | 2.54 | 12500 | | |
| | 20 | 1 | 1 | HA10-SH20Q-S-105 | 100.0 | 20.0 | 41 | 105.0 | 57.2 | 76.0 | 33.0 | 42.0 | 4° | 10 | 2.54 | 12500 | | |
| | 20 | 1 | 1 | HA10-SH20Q-S-130 | 100.0 | 20.0 | 41 | 130.0 | 57.2 | 101.0 | 33.0 | 42.0 | 4° | 10 | 2.80 | 12500 | | |
| | 25 | 1 | 1 | HA10-SH25Q-S-115 | 100.0 | 25.0 | 47 | 115.0 | 57.2 | 86.0 | 44.0 | 53.0 | 4° | 10 | 3.06 | 12500 | | |
| | 32 | 1 | 1 | HA10-SH32Q-S-120 | 100.0 | 32.0 | 51 | 120.0 | 57.2 | 91.0 | 44.0 | 53.0 | 4° | 10 | 2.95 | 12500 | | |

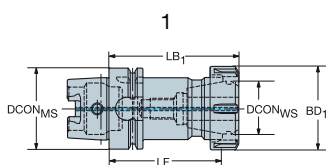
Balance: Fine adjustment possibility

HSK to ER collet chuck

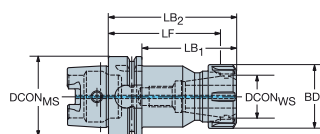
Workpiece side interface DIN 6499-B



DSGN



2



| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-------|------|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | (BAR) | (KG) | RPMX | | | |
| 40 | ER25 | 1 | 1 | 1 | 392.41014-4025062 | 40.0 | 26.0 | 50.0 | 62.0 | | 42.0 | | 80 | 0.42 | 30000 | | | |
| 50 | ER32 | 1 | 1 | 1 | 392.41014-5032072 | 50.0 | 33.0 | 59.0 | 72.0 | | 50.0 | | 80 | 0.70 | 25000 | | | |
| 63 | ER16 | 1 | 1 | 2 | 392.41014-63 16 100 | 63.0 | 17.0 | 89.4 | 71.0 | 100.0 | 28.0 | 63.0 | 80 | 0.96 | 20500 | | | |
| | ER25 | 1 | 1 | 2 | 392.41014-63 25 100 | 63.0 | 26.0 | 88.0 | 74.0 | 100.0 | 42.0 | 63.0 | 80 | 1.24 | 20500 | | | |
| | ER32 | 1 | 1 | 2 | 392.41014-63 32 100B | 63.0 | 33.0 | 87.0 | 74.0 | 100.0 | 50.0 | 63.0 | 80 | 1.37 | 20500 | | | |
| | ER40 | 1 | 1 | 1 | 392.41014-63 40 120B | 63.0 | 41.0 | 105.0 | 120.0 | | 63.0 | | 80 | 1.88 | 20500 | | | |
| 100 | ER32 | 1 | 1 | 2 | 392.41014-100 32 100A | 100.0 | 33.0 | 87.0 | 71.0 | 100.0 | 50.0 | 100.0 | 80 | 2.75 | 12500 | | | |
| | ER40 | 1 | 1 | 2 | 392.41014-100 40 120A | 100.0 | 41.0 | 105.0 | 91.0 | 120.0 | 63.0 | 100.0 | 80 | 3.48 | 12500 | | | |
| | ER50 | 1 | 1 | 2 | 392.41014-100 50 130A | 100.0 | 52.0 | 109.0 | 101.0 | 130.0 | 78.0 | 100.0 | 80 | 4.45 | 12500 | | | |

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M1



N23

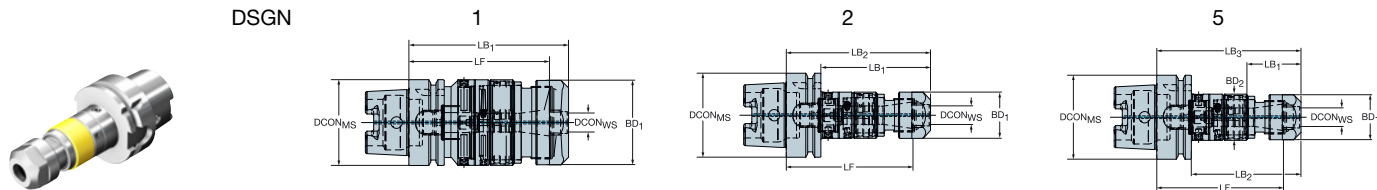


N15

HSK to CoroChuck™ 970

Machine side interface HSK A/C

Workpiece side interface DIN 6499-B



| | | | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|-------|------|------|------|-----------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----|------|------|--|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX | |
| 63 | ER32 | M27 | 1 | 1 | 2 | 970-HA06-32-131 | 63.0 | 32.8 | 121.7 | 105.2 | 131.2 | 50.0 | 63.0 | 80 | 1.41 | 8000 | |
| | ER40 | M30 | 1 | 1 | 1 | 970-HA06-40-160 | 63.0 | 41.0 | 143.1 | 154.5 | | 63.0 | | 80 | 2.91 | 8000 | |
| 100 | ER32 | M27 | 1 | 1 | 2 | 970-HA10-32-138 | 100.0 | 32.8 | 128.2 | 108.7 | 137.7 | 50.0 | 100.0 | 80 | 2.80 | 8000 | |
| | ER40 | M30 | 1 | 1 | 2 | 970-HA10-40-164 | 100.0 | 40.8 | 146.6 | 129.1 | 158.0 | 63.0 | 100.0 | 80 | 4.35 | 8000 | |

For MQL machining

| | | | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|-------|------|------|------|------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----|------|------|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BAR | KG | RPMX |
| 63 | ER20 | M12 | 1 | 1 | 5 | 970-HA06-20-108 | 63.0 | 20.8 | 95.1 | 35.3 | 77.1 | 103.1 | 33.7 | 35.0 | 80 | 1.09 | 8000 |
| | ER20 | M12 | 1 | 1 | 5 | 970-HA06Q-20-108 | 63.0 | 20.8 | 95.1 | 40.3 | 82.1 | 108.1 | 33.7 | 34.6 | 80 | 1.10 | 8000 |
| | ER25 | M20 | 1 | 1 | 5 | 970-HA06-25-128 | 63.0 | 25.8 | 114.0 | 37.1 | 96.5 | 122.5 | 42.0 | 44.0 | 80 | 1.44 | 8000 |
| | ER25 | M20 | 1 | 1 | 5 | 970-HA06Q-25-128 | 63.0 | 25.8 | 114.0 | 43.2 | 101.5 | 127.5 | 41.7 | 44.0 | 80 | 1.05 | 8000 |
| 100 | ER20 | M12 | 1 | 1 | 5 | 970-HA10-20-115 | 100.0 | 20.8 | 101.6 | 35.3 | 80.5 | 109.6 | 33.7 | 35.0 | 80 | 2.58 | 8000 |
| | ER20 | M12 | 1 | 1 | 5 | 970-HA10Q-20-115 | 100.0 | 20.8 | 101.6 | 40.7 | 85.6 | 114.6 | 33.7 | 34.6 | 80 | 2.53 | 8000 |
| | ER25 | M20 | 1 | 1 | 5 | 970-HA10-25-134 | 100.0 | 25.8 | 120.5 | 37.1 | 100.0 | 129.0 | 42.0 | 44.0 | 80 | 2.92 | 8000 |
| | ER25 | M20 | 1 | 1 | 5 | 970-HA10Q-25-134 | 100.0 | 25.8 | 120.5 | 42.1 | 105.0 | 134.0 | 41.7 | 44.0 | 80 | 2.89 | 8000 |

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M1



N23

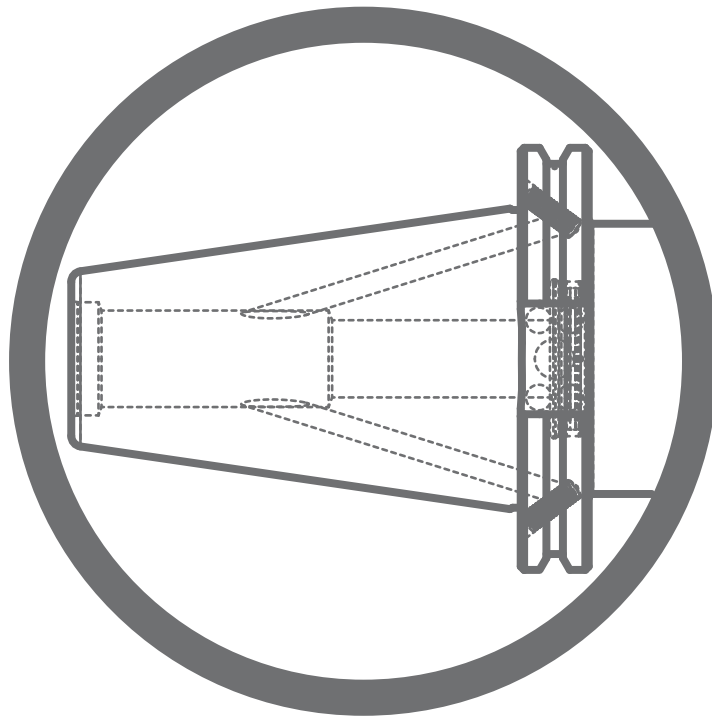


N15



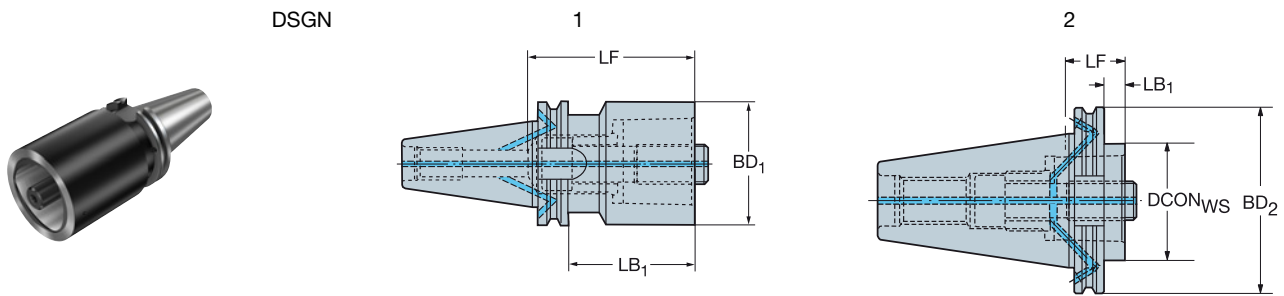
N5

Machine side interface BIG-PLUS® ISO



BIG-PLUS ISO to Coromant Capto® adaptor

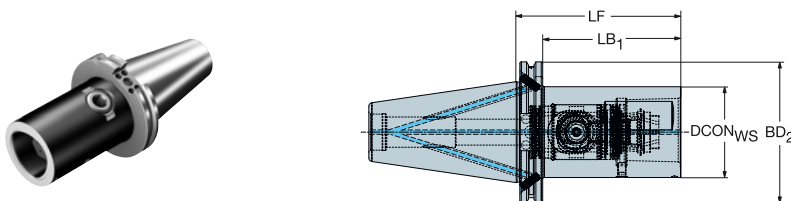
Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|--------------------|--------------------|-------|--------------------|-------|-----------------|-----------------|-----------------|--------|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₂ | BAR | NM | KG |
| 40 | C3 | 7 | 1 | 2 | C3-390B.540-40 030 | M16 | 32.0 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 45.00 | 0.89 |
| | C4 | 7 | 1 | 2 | C4-390B.540-40 040 | M16 | 40.0 | 40.0 | 20.9 | 40.0 | 63.5 | 80 | 55.00 | 0.96 |
| | C5 | 7 | 1 | 2 | C5-390B.540-40 050 | M16 | 50.0 | 50.0 | 30.9 | 50.0 | 63.5 | 80 | 95.00 | 1.12 |
| | C6 | 7 | 1 | 2 | C6-390B.540-40 085 | M16 | 63.0 | 85.0 | 30.9 | 50.0 | 63.5 | 80 | 170.00 | 1.81 |
| 50 | C3 | 7 | 1 | 2 | C3-390.540-50 030A | M24 | 32.0 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 45.00 | 2.80 |
| | C3 | 7 | 1 | 2 | C3-390.540-50 060 | M24 | 32.0 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 45.00 | 2.91 |
| | C4 | 7 | 1 | 2 | C4-390.540-50 030A | M24 | 40.0 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 55.00 | 2.80 |
| | C4 | 7 | 1 | 2 | C4-390.540-50 060 | M24 | 40.0 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 55.00 | 3.01 |
| | C5 | 7 | 1 | 2 | C5-390.540-50 030A | M24 | 50.0 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 95.00 | 2.75 |
| | C5 | 7 | 1 | 2 | C5-390.540-50 070 | M24 | 50.0 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 95.00 | 3.27 |
| | C6 | 7 | 1 | 2 | C6-390.540-50 050A | M24 | 63.0 | 50.0 | 30.9 | 50.0 | 97.5 | 80 | 170.00 | 3.10 |
| | C6 | 7 | 1 | 2 | C6-390.540-50 100 | M24 | 63.0 | 100.0 | 80.9 | 100.0 | 97.5 | 80 | 170.00 | 4.22 |
| | C8 | 7 | 1 | 2 | C8-390.540-50 070A | M24 | 80.0 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 170.00 | 3.90 |
| | C8 | 7 | 1 | 2 | C8-390.540-50 120 | M24 | 80.0 | 120.0 | 100.9 | 120.0 | 97.5 | 80 | 170.00 | 5.74 |
| C10 | 7 | 1 | 1 | C10-390.540-50 140 | M24 | 100.0 | 140.0 | 140.0 | | | 80 | 380.00 | 7.72 | |

BIG-PLUS ISO to Coromant Capto® adaptor with Quick change

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|----------------|----------------|--------------------|-------|-----------------|-----------------|-----|-------|------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG | | |
| 50 | C6 | 7 | 1 | IB50-QC-C6-115 | M24 | 63.0 | 115.0 | 95.0 | 97.4 | 80 | 90.00 | 4.48 | | |

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M1



N23

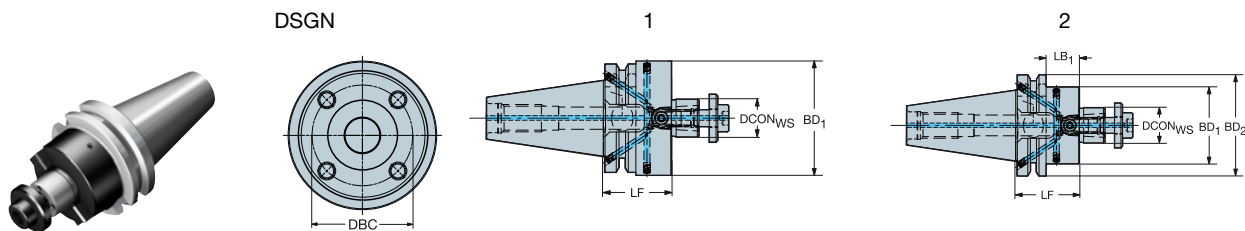


N15

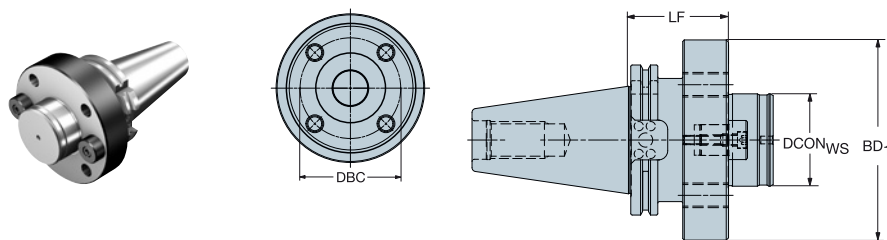
BIG-PLUS ISO to arbor adaptor

Coolant through arbor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



| | | Dimensions, mm | | | | | | | | | | | | | | | |
|--------------------|-------------------|----------------|------|--------------------|-------------------|------|------|--------------------|------|-----------------|-----------------|-----------------|-----------------|--------|--------|-------|-------|
| CZC _{MIS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DBC | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 40 | 16 | 7 | 4 | 2 | 392.54005C4016045 | M16 | 16.0 | 45.0 | 25.9 | 45.0 | 32.0 | 63.5 | 80 | 22.00 | 1.04 | 18000 | |
| | 22 | 7 | 4 | 2 | 392.54005C4022040 | M16 | 22.0 | 40.0 | 20.9 | 40.0 | 48.0 | 63.5 | 80 | 45.00 | 1.20 | 18000 | |
| | 27 | 7 | 4 | 2 | 392.54005C4027050 | M16 | 27.0 | 50.0 | 30.9 | 50.0 | 60.0 | 63.5 | 80 | 80.00 | 1.51 | 18000 | |
| | 32 | 7 | 4 | 1 | 392.54005C4032055 | M16 | 32.0 | 55.0 | 55.0 | | 78.0 | | 80 | 180.00 | 2.03 | 18000 | |
| 40S | 7 | 4 | 1 | 392.54005C4040055M | 66.7 | M16 | 40.0 | 55.0 | 55.0 | | 87.0 | | 80 | 300.00 | 2.37 | 18000 | |
| 50 | 22 | 7 | 4 | 2 | 392.54005C5022040 | M24 | 22.0 | 40.0 | 21.0 | 40.0 | 48.0 | 97.5 | 80 | 45.00 | 3.04 | 12000 | |
| | 27 | 7 | 4 | 2 | 392.54005C5027050 | M24 | 27.0 | 50.0 | 30.9 | 50.0 | 60.0 | 97.5 | 80 | 80.00 | 3.45 | 12000 | |
| | 32 | 7 | 4 | 2 | 392.54005C5032055 | M24 | 32.0 | 55.0 | 35.9 | 55.0 | 78.0 | 97.5 | 80 | 180.00 | 4.11 | 12000 | |
| | 40S | 7 | 4 | 2 | 392.54005C5040060 | 66.7 | M24 | 40.0 | 60.0 | 40.9 | 60.0 | 87.0 | 97.0 | 80 | 300.00 | 4.65 | 12000 |



| | | Dimensions, mm | | | | | | | | | |
|--------------------|-------------------|-------------------|-------|------|--------------------|------|-----------------|--------|------|-------|--|
| CZC _{MIS} | CZC _{WS} | Ordering code | DBC | CRKS | DCON _{WS} | LF | BD ₁ | NM | KG | RPMX | |
| 50 | 60 | 392.54005-5060065 | 101.6 | M24 | 60.0 | 65.0 | 130.0 | 180.00 | 7.70 | 12000 | |

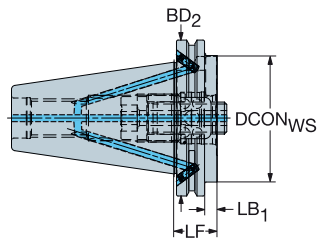
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BIG-PLUS ISO to VL adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

Workpiece side interface DIN 6499-B



| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|--------------------|------|--------------------|------|-----------------|-----------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 50 | 80 | 7 | 1 | 390B.540-50 80 027 | M24 | 80.0 | 27.0 | 7.9 | 97.5 | 80 | 170.00 | 2.87 | 12000 |

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M1



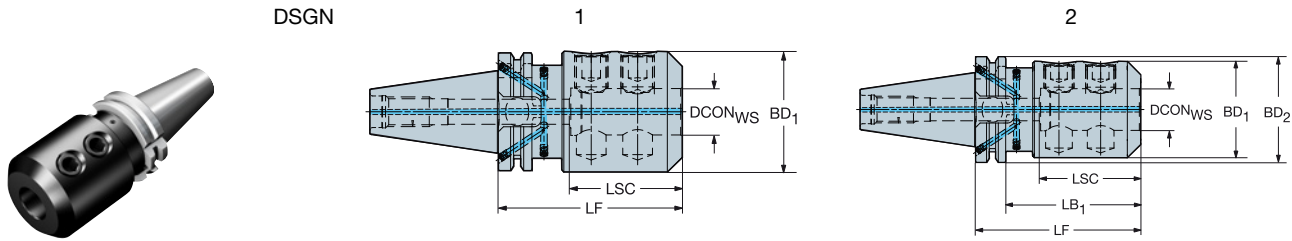
N23



N15

BIG-PLUS ISO to Weldon / ISO 9766 adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



| | | Dimensions, mm | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|------|-------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 40 | 16 | 7 | 1 | 2 | 392.54023-4016060 | M16 | 16.0 | | 60.0 | 40.9 | 60.0 | 48.0 | 63.5 | 20 | 25.00 | 1.32 | 18000 |
| | 20 | 7 | 1 | 2 | 392.54023-4020070 | M16 | 20.0 | | 70.0 | 50.9 | 70.0 | 52.0 | 63.5 | 20 | 25.00 | 1.52 | 18000 |
| | 25 | 7 | 1 | 1 | 392.54023-4025100 | M16 | 25.0 | | 100.0 | 100.0 | | 65.0 | | 20 | 25.00 | 2.43 | 18000 |
| | 32 | 7 | 1 | 1 | 392.54023-4032105 | M16 | 32.0 | | 105.0 | 105.0 | | 72.0 | | 20 | 45.00 | 2.80 | 18000 |
| | 40 | 7 | 1 | 1 | 392.54023-4040115 | M16 | 40.0 | | 115.0 | 115.0 | | 90.0 | | 20 | 45.00 | 4.28 | 18000 |
| 50 | 25 | 7 | 1 | 2 | 392.54023-5025085 | M24 | 25.0 | 60 | 85.0 | 65.9 | 85.0 | 65.0 | 97.5 | 20 | 25.00 | 4.05 | 12000 |
| | 32 | 7 | 1 | 2 | 392.54023-5032090 | M24 | 32.0 | 64 | 90.0 | 69.9 | 90.0 | 72.0 | 97.5 | 20 | 45.00 | 4.42 | 12000 |
| | 40 | 7 | 1 | 2 | 392.54023-5040115 | M24 | 40.0 | 74 | 115.0 | 95.9 | 115.0 | 90.0 | 97.0 | 20 | 45.00 | 6.35 | 12000 |

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M1



N23



N15

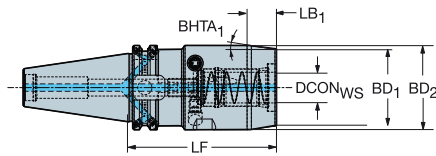
BIG-PLUS ISO to CoroChuck™ 930

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

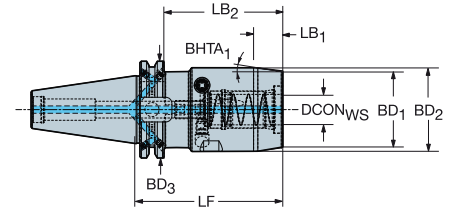


DSGN

3



6

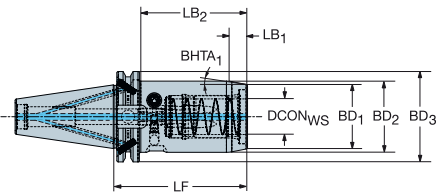


Heavy Duty design

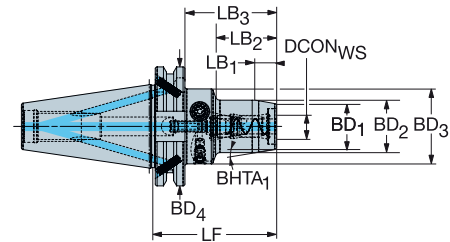
| CZC _{MS} | CZC _{WS} | CNCS | CXSC | DSGN | Ordering code | Dimensions, mm | | | | | | | | | | | | | | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|------|--------------------|----------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|----|-------|------|-------|----|----|------|
| | | | | | | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | | | | | | | |
| 40 | 20 | 7 | 1 | 6 | 930-IB40-HD-20-097 | M16 | 20.0 | 51 | 97.0 | 17.8 | 77.9 | 97.0 | 50.0 | 55.0 | 63.5 | 8° | 80 | 10.00 | 2.03 | 18000 | | | |
| | 25 | 7 | 1 | 3 | 930-IB40-HD-25-103 | M16 | 25.0 | 57 | 103.0 | 18.8 | 103.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 2.50 | 18000 | | | |
| 50 | 20 | 7 | 1 | 6 | 930-IB50-HD-20-083 | M24 | 20.0 | 51 | 83.0 | 17.8 | 63.9 | 83.0 | 50.0 | 55.0 | 97.4 | 8° | 80 | 10.00 | 3.72 | 12000 | | | |
| | 25 | 7 | 1 | 6 | 930-IB50-HD-25-087 | M24 | 25.0 | 57 | 87.0 | 18.8 | 67.9 | 87.0 | 57.0 | 65.0 | 97.4 | 12° | 80 | 10.00 | 4.17 | 12000 | | | |
| | 32 | 7 | 1 | 6 | 930-IB50-HD-32-077 | M24 | 32.0 | 61 | 77.0 | 18.8 | 57.9 | 77.0 | 68.0 | 76.0 | 97.4 | 12° | 80 | 10.00 | 4.27 | 12000 | | | |

DSGN

6



10



Slender design

| CZC _{MS} | CZC _{WS} | CNCS | CXSC | DSGN | Ordering code | Dimensions, mm | | | | | | | | | | | | | | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|------|-------------------|----------------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|----|------|------|-------|------|
| | | | | | | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | | | | | |
| 40 | 6 | 7 | 1 | 10 | 930-IB40-S-06-068 | M16 | 6.0 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 68.0 | 22.0 | 26.0 | 40.0 | 63.5 | 10° | 80 | 8.00 | 1.08 | 18000 | |
| | 8 | 7 | 1 | 10 | 930-IB40-S-08-068 | M16 | 8.0 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 68.0 | 24.0 | 28.0 | 40.0 | 63.5 | 10° | 80 | 8.00 | 1.10 | 18000 | |
| | 10 | 7 | 1 | 10 | 930-IB40-S-10-072 | M16 | 10.0 | 41 | 72.0 | 11.3 | 34.2 | 52.9 | 72.0 | 26.0 | 30.0 | 40.0 | 63.5 | 10° | 80 | 8.00 | 1.13 | 18000 | |
| | 12 | 7 | 1 | 10 | 930-IB40-S-12-080 | M16 | 12.0 | 46 | 80.0 | 11.3 | 38.2 | 60.9 | 80.0 | 28.0 | 32.0 | 50.0 | 63.5 | 10° | 80 | 8.00 | 1.33 | 18000 | |
| | 20 | 7 | 1 | 10 | 930-IB40-S-20-090 | M16 | 20.0 | 51 | 90.0 | 16.0 | 49.2 | 70.9 | 90.0 | 38.0 | 42.0 | 50.0 | 63.5 | 7° | 80 | 8.00 | 1.52 | 18000 | |
| 50 | 25 | 7 | 1 | 6 | 930-IB40-S-25-095 | M16 | 25.0 | 57 | 95.0 | 12.9 | 75.0 | 95.0 | | 45.0 | 50.0 | 63.5 | | 11° | 80 | 8.00 | 1.74 | 18000 | |
| | 20 | 7 | 1 | 10 | 930-IB50-S-20-089 | M24 | 20.0 | 51 | 89.0 | 16.0 | 49.2 | 69.9 | 89.0 | 38.0 | 42.0 | 50.0 | 97.4 | 7° | 80 | 8.00 | 3.40 | 12000 | |
| | 25 | 7 | 1 | 6 | 930-IB50-S-25-095 | M24 | 25.0 | 57 | 95.0 | 12.9 | 73.5 | 95.0 | | 45.0 | 50.0 | 97.4 | | 11° | 80 | 8.00 | 3.61 | 12000 | |

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M1



N23



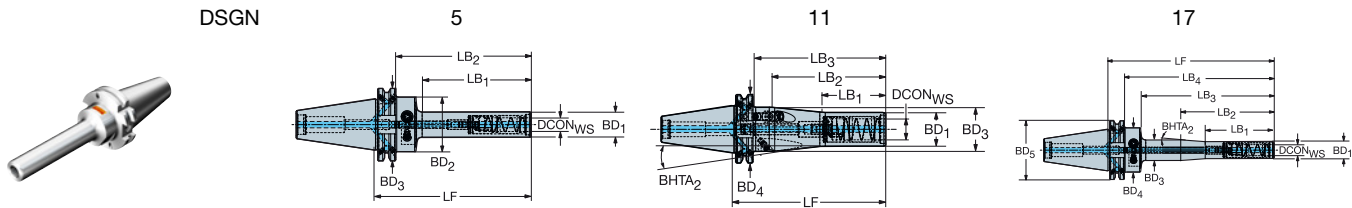
N15



N4

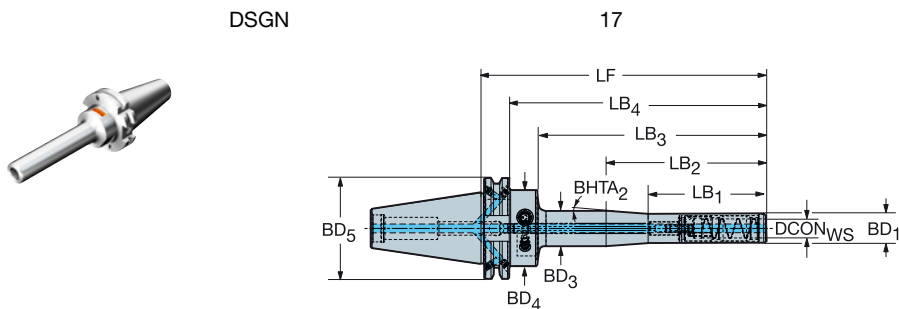
BIG-PLUS ISO to CoroChuck™ 930

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



Pencil design

| | | Dimensions, mm | | | | | | | | | | | | | | | | | BAR | NM | KG | RPMX | | |
|-------------------|-------------------|----------------|------|------|-------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | LB ₅ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | | | | |
| 40 | 8 | 7 | 1 | 5 | 930-IB40-P-08-088 | M16 | 8.0 | 37 | 88.0 | 45.8 | 66.5 | 88.0 | | | 17.5 | 40.0 | 63.5 | | | 0° | 80 | 8.00 | 1.06 | 18000 |
| | 10 | 7 | 1 | 5 | 930-IB40-P-10-098 | M16 | 10.0 | 41 | 98.0 | 55.8 | 76.5 | 98.0 | | | 20.0 | 40.0 | 63.5 | | | 0° | 80 | 8.00 | 1.10 | 18000 |
| | 10 | 7 | 1 | 5 | 930-IB40-P-10-138 | M16 | 10.0 | 41 | 138.0 | 95.8 | 116.5 | 138.0 | | | 20.0 | 40.0 | 63.5 | | | 0° | 80 | 8.00 | 1.20 | 18000 |
| | 12 | 7 | 1 | 5 | 930-IB40-P-12-103 | M16 | 12.0 | 46 | 103.0 | 65.0 | 83.9 | 103.0 | | | 22.0 | 40.0 | 63.5 | | | 0° | 80 | 8.00 | 1.19 | 18000 |
| | 12 | 7 | 1 | 5 | 930-IB40-P-12-138 | M16 | 12.0 | 46 | 138.0 | 100.0 | 118.9 | 138.0 | | | 22.0 | 40.0 | 63.5 | | | 0° | 80 | 8.00 | 1.29 | 18000 |
| | 12 | 7 | 1 | 17 | 930-IB40-P-12-188 | M16 | 12.0 | 46 | 188.0 | 50.0 | 75.0 | 150.0 | 168.9 | 188 | 22.0 | 22.0 | 26.0 | 40.0 | 63 | 4° | 80 | 8.00 | 1.58 | 18000 |
| | 20 | 7 | 1 | 11 | 930-IB40-P-20-145 | M16 | 20.0 | 51 | 145.0 | 60.0 | 108.0 | 125.9 | 145.0 | | 32.0 | 32.0 | 42.0 | 63.5 | | 5° | 80 | 8.00 | 1.66 | 18000 |



| | | Dimensions, mm | | | | | | | | | | | | | | | | | BAR | NM | KG | RPMX | | |
|-------------------|-------------------|----------------|------|------|-------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|------|------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | LB ₅ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | | | | |
| 40 | 12 | 7 | 1 | 17 | 930-IB40-P-12-188 | M16 | 12.0 | 46 | 188.0 | 50.0 | 75.0 | 150.0 | 168.9 | 188 | 22.0 | 26.0 | 40.0 | 63 | 4° | 80 | 8.00 | 1.58 | 18000 | |

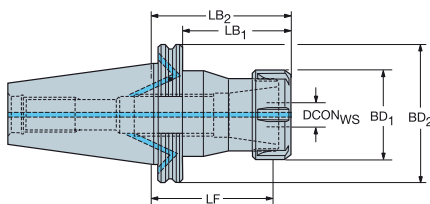
BIG-PLUS® SYSTEM licensed by BIG Daishowa
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BIG-PLUS ISO to ER collet chuck

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

Workpiece side interface DIN 6499-B



| | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX |
| 40 | ER25 | 7 | 1 | 392.54014-4025070 | M16 | 26.0 | 58.0 | 30.9 | 70.0 | 42.0 | 63.5 | 80 | 1.17 | 18000 |
| | ER40 | 7 | 1 | 392.54014-4040075 | M16 | 41.0 | 60.0 | 55.9 | 75.0 | 63.0 | 63.5 | 80 | 1.43 | 18000 |

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M1



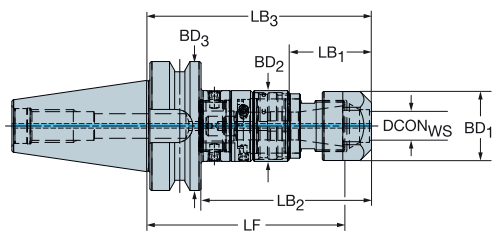
N23



N15

BIG-PLUS ISO to CoroChuck™ 970

Workpiece side interface DIN 6499-B

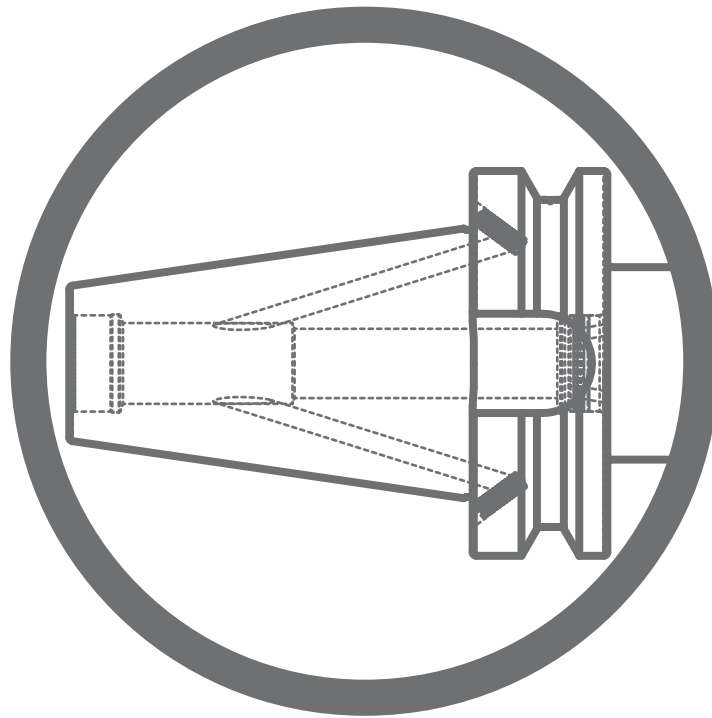


| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|-------|------|------|-----------------|------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----|------|------|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BAR | KG | RPMX |
| 50 | ER20 | M12 | 7 | 1 | 970-IB50-20-106 | M24 | 20.8 | 93.2 | 35.3 | 82.1 | 101.2 | 33.7 | 35.0 | 97.5 | 80 | 3.00 | 8000 |
| | ER25 | M20 | 7 | 1 | 970-IB50-25-126 | M24 | 25.8 | 112.1 | 37.1 | 101.5 | 120.6 | 42.0 | 44.0 | 97.5 | 80 | 3.50 | 8000 |

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Machine side interface BIG-PLUS® MAS-BT

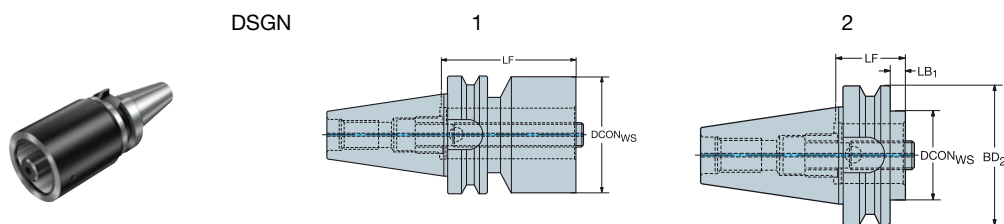


BIG-PLUS MAS-BT to Coromant Capto® adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

ENG

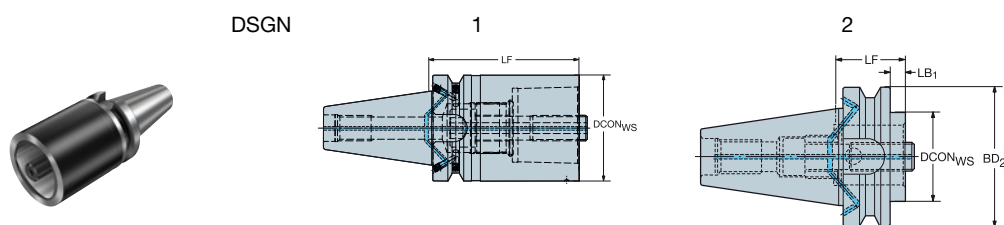
J



K

| | | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|----------------|--------------------|------|-----------------|-----------------|-----------------|-----|-------|------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₂ | BAR | NM | KG | |
| 30 | C3 | 1 | 1 | 2 | C3-390.555-30 040 | M12 | 32.0 | 40.0 | 18.0 | 40.0 | 46.0 | 80 | 45.00 | 0.48 | |
| | C4 | 1 | 1 | 2 | C4-390.555-30 060 | M12 | 40.0 | 60.0 | 38.0 | 60.0 | 46.0 | 80 | 55.00 | 0.67 | |
| | C5 | 1 | 1 | 1 | C5-390.555-30 080 | M12 | 50.0 | 80.0 | 80.0 | | | 80 | 95.00 | 1.08 | |

L



| | | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------|---------------------|----------------|--------------------|-------|-----------------|-----------------|-----------------|-----|--------|------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₂ | BAR | NM | KG | |
| 40 | C3 | 7 | 1 | 2 | C3-390B.555-40 030 | M16 | 32.0 | 30.0 | 3.0 | 30.0 | 63.0 | 80 | 45.00 | 1.00 | |
| | C4 | 7 | 1 | 2 | C4-390B.555-40 040 | M16 | 40.0 | 40.0 | 13.0 | 40.0 | 63.0 | 80 | 55.00 | 1.04 | |
| | C4 | 7 | 1 | 2 | C4-390B.555-40 070 | M16 | 40.0 | 70.0 | 43.0 | 70.0 | 63.0 | 80 | 55.00 | 1.32 | |
| | C5 | 7 | 1 | 2 | C5-390B.555-40 050 | M16 | 50.0 | 50.0 | 23.0 | 50.0 | 63.0 | 80 | 95.00 | 1.16 | |
| | C5 | 7 | 1 | 2 | C5-390B.555-40 090 | M16 | 50.0 | 90.0 | 63.0 | 90.0 | 63.0 | 80 | 95.00 | 1.73 | |
| | C6 | 7 | 1 | 1 | C6-390B.555-40 075 | M16 | 63.0 | 75.0 | 75.0 | | | 80 | 170.00 | 1.75 | |
| 50 | C3 | 7 | 1 | 2 | C3-390B.558-50 040 | M24 | 32.0 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 45.00 | 3.72 | |
| | C3 | 7 | 1 | 2 | C3-390B.558-50 070 | M24 | 32.0 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 45.00 | 3.82 | |
| | C4 | 7 | 1 | 2 | C4-390B.558-50 040 | M24 | 40.0 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 55.00 | 3.72 | |
| | C4 | 7 | 1 | 2 | C4-390B.558-50 070 | M24 | 40.0 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 55.00 | 3.90 | |
| | C5 | 7 | 1 | 2 | C5-390B.558-50 040 | M24 | 50.0 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 95.00 | 3.59 | |
| | C5 | 7 | 1 | 2 | C5-390B.558-50 080 | M24 | 50.0 | 80.0 | 42.0 | 80.0 | 100.0 | 80 | 95.00 | 4.13 | |
| | C6 | 7 | 1 | 2 | C6-390B.558-50 050 | M24 | 63.0 | 50.0 | 12.0 | 50.0 | 100.0 | 80 | 170.00 | 3.64 | |
| | C6 | 7 | 1 | 2 | C6-390B.558-50 100 | M24 | 63.0 | 100.0 | 62.0 | 100.0 | 100.0 | 80 | 170.00 | 4.75 | |
| | C8 | 7 | 1 | 2 | C8-390B.558-50 070 | M24 | 80.0 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 170.00 | 4.16 | |
| | C8 | 7 | 1 | 2 | C8-390B.558-50 120 | M24 | 80.0 | 120.0 | 82.0 | 120.0 | 100.0 | 80 | 170.00 | 6.02 | |
| | C10 | 7 | 1 | 1 | C10-390B.558-50 140 | M24 | 100.0 | 140.0 | 140.0 | | | 80 | 380.00 | 8.01 | |

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M

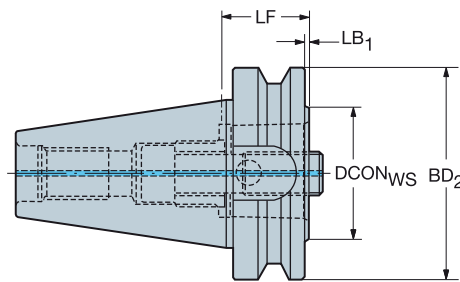
N



BIG-PLUS MAS-BT to Coromant Capto® adaptor

90° rotated polygon for precision tool tip control

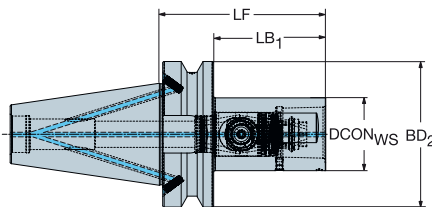
Designed for Mazak™ e-machine and Mori Seiki NT™ -Series



| | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|------|--------------------|------|-----------------|-----------------|-----|-------|------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG | | |
| 40 | C5 | 1 | 1 | C5-390.562-40 050 | M16 | 50.0 | 50.0 | 23.0 | 63.0 | 80 | 45.00 | 1.16 | | |
| 50 | C6 | 1 | 1 | C6-390.562-50 050 | M24 | 63.0 | 50.0 | 12.0 | 100.0 | 80 | 65.00 | 3.66 | | |
| | C8 | 1 | 1 | C8-390.562-50 070 | M24 | 80.0 | 70.0 | 32.0 | 100.0 | 80 | 65.00 | 4.18 | | |

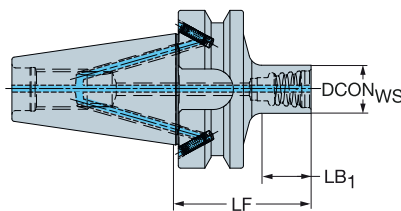
BIG-PLUS MAS-BT to Coromant Capto® adaptor with Quick change

Machine side interface compatible with MAS-BT 403 and JIS B 6339



| | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|----------------|------|--------------------|-------|-----------------|-----------------|-----|-------|------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG | | |
| 50 | C6 | 7 | 1 | BB50-QC-C6-135 | M24 | 63.0 | 135.0 | 96.0 | 135.0 | 80 | 90.00 | 5.52 | | |

BIG-PLUS MAS-BT to Coromant EH adaptor



| | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|----------------|------|--------------------|------|-----------------|-----------------|-----|-------|------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG | RPMX | |
| 30 | E12 | 1 | 1 | EH-BB30-12-044 | M12 | 11.6 | 44.0 | 15.4 | 46.0 | 80 | 15.00 | 0.41 | 25000 | |
| | E16 | 1 | 1 | EH-BB30-16-050 | M12 | 15.4 | 50.0 | 22.0 | 46.0 | 80 | 30.00 | 0.43 | 25000 | |
| | E20 | 1 | 1 | EH-BB30-20-047 | M12 | 19.2 | 47.0 | 19.4 | 46.0 | 80 | 50.00 | 0.43 | 25000 | |
| | E25 | 1 | 1 | EH-BB30-25-052 | M12 | 24.1 | 52.0 | 25.1 | 46.0 | 80 | 65.00 | 0.46 | 25000 | |

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M1



N23



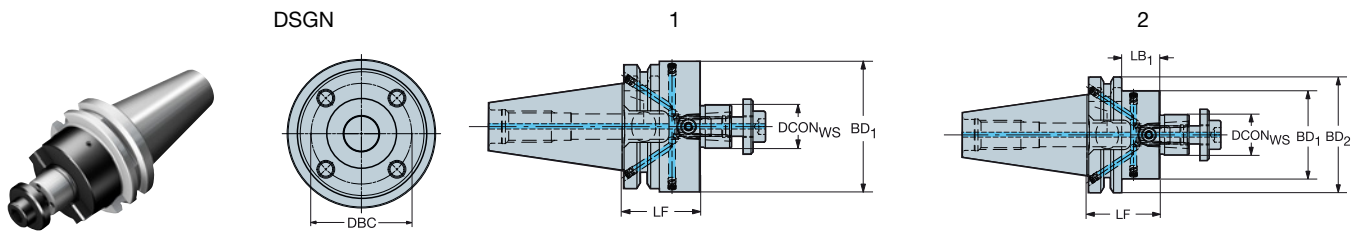
N15



N3

BIG-PLUS MAS-BT to arbor adaptor

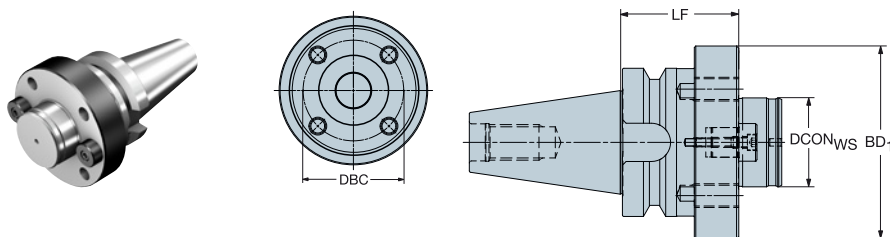
Machine side interface compatible with MAS-BT 403 and JIS B 6339



| | | Dimensions, mm | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|------|--------------------|------|------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DBC | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 30 | 16 | 1 | 4 | 2 | 392.55505C3016040 | | M12 | 16.0 | 40.0 | 18.0 | 40.0 | 32.0 | 46.0 | 80 | 22.00 | 0.55 | 25000 |
| | 22 | 1 | 4 | 1 | 392.55505C3022040 | | M12 | 22.0 | 40.0 | 40.0 | | 48.0 | | 80 | 45.00 | 0.73 | 25000 |
| | 27 | 1 | 4 | 1 | 392.55505C3027040 | | M12 | 27.0 | 40.0 | 40.0 | | 60.0 | | 80 | 80.00 | 0.91 | 25000 |
| | 32 | 1 | 4 | 1 | 392.55505C3032045 | | M12 | 32.0 | 45.0 | 45.0 | | 78.0 | | 80 | 180.00 | 1.40 | 25000 |
| 40 | 16 | 7 | 4 | 2 | 392.55505C4016050 | | M16 | 16.0 | 50.0 | 23.0 | 50.0 | 32.0 | 63.0 | 80 | 22.00 | 1.18 | 18000 |
| | 22 | 7 | 4 | 2 | 392.55505C4022045 | | M16 | 22.0 | 45.0 | 18.0 | 45.0 | 48.0 | 63.0 | 80 | 45.00 | 1.32 | 18000 |
| | 27 | 7 | 4 | 2 | 392.55505C4027045 | | M16 | 27.0 | 45.0 | 18.0 | 45.0 | 60.0 | 63.0 | 80 | 80.00 | 1.50 | 18000 |
| | 32 | 7 | 4 | 1 | 392.55505C4032050 | | M16 | 32.0 | 50.0 | 50.0 | | 78.0 | | 80 | 180.00 | 2.01 | 18000 |
| | 40S | 7 | 4 | 1 | 392.55505C4040055M | 66.7 | M16 | 40.0 | 55.0 | 55.0 | | 87.0 | | 80 | 300.00 | 2.58 | 18000 |
| 50 | 22 | 7 | 4 | 2 | 392.55805C5022055 | | M24 | 22.0 | 55.0 | 17.0 | 55.0 | 48.0 | 100.0 | 80 | 45.00 | 3.96 | 12000 |
| | 27 | 7 | 4 | 2 | 392.55805C5027055 | | M24 | 27.0 | 55.0 | 17.0 | 55.0 | 60.0 | 100.0 | 80 | 80.00 | 4.14 | 12000 |
| | 32 | 7 | 4 | 2 | 392.55805C5032055 | | M24 | 32.0 | 55.0 | 17.0 | 55.0 | 78.0 | 100.0 | 80 | 180.00 | 4.43 | 12000 |
| | 40S | 7 | 4 | 2 | 392.55805C5040055 | 66.7 | M24 | 40.0 | 55.0 | 17.0 | 55.0 | 87.0 | 100.0 | 80 | 300.00 | 4.69 | 12000 |

BIG-PLUS MAS-BT to arbor adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



| | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|-------------------|-------|------|--------------------|------|-----------------|--------|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | Ordering code | DBC | CRKS | DCON _{WS} | LF | BD ₁ | NM | KG | RPMX | | |
| 50 | 60 | 392.55805-5060080 | 101.6 | M24 | 60.0 | 80.0 | 130.0 | 180.00 | 8.82 | 12000 | | |

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M1



N23

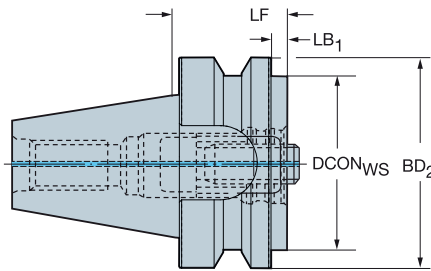


N15

BIG-PLUS MAS-BT to VL adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

Coolant through centre



| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|----------------|--------------------|------|-----------------|-----------------|-----|--------|------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG | | | |
| 50 | 80 | 1 | 1 | 390.558-50 80 040 | M24 | 80.0 | 40.0 | 2.0 | 100.0 | 80 | 180.00 | 3.50 | | | |

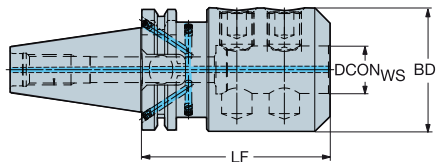
BIG-PLUS MAS-BT to Weldon / ISO 9766 adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

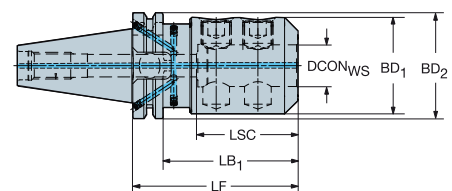


DSGN

1



2



| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|-------------------|------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-------|-------|-------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX | | |
| 30 | 16 | 1 | 1 | 1 | 392.55523-3016060 | M12 | 16.0 | 60.0 | 60.0 | | 48.0 | | 20 | 20.00 | 0.86 | 25000 | | |
| | 20 | 1 | 1 | 1 | 392.55523-3020065 | M12 | 20.0 | 65.0 | 65.0 | | 52.0 | | 20 | 20.00 | 0.97 | 25000 | | |
| | 25 | 1 | 1 | 1 | 392.55523-3025090 | M12 | 25.0 | 90.0 | 90.0 | | 65.0 | | 20 | 65.00 | 1.80 | 25000 | | |
| | 32 | 1 | 1 | 1 | 392.55523-3032095 | M12 | 32.0 | 95.0 | 95.0 | | 72.0 | | 20 | 45.00 | 2.16 | 25000 | | |
| 40 | 16 | 7 | 1 | 2 | 392.55523-4016065 | M16 | 16.0 | 65.0 | 38.0 | 65.0 | 48.0 | 63.0 | 20 | 20.00 | 1.43 | 18000 | | |
| | 20 | 7 | 1 | 2 | 392.55523-4020065 | M16 | 20.0 | 65.0 | 38.0 | 65.0 | 52.0 | 63.0 | 20 | 20.00 | 1.49 | 18000 | | |
| | 25 | 7 | 1 | 1 | 392.55523-4025090 | M16 | 25.0 | 90.0 | 90.0 | | 65.0 | | 20 | 25.00 | 2.30 | 18000 | | |
| | 32 | 7 | 1 | 1 | 392.55523-4032100 | M16 | 32.0 | 100.0 | 100.0 | | 72.0 | | 20 | 45.00 | 2.80 | 18000 | | |
| 50 | 40 | 7 | 1 | 1 | 392.55523-4040110 | M16 | 40.0 | 110.0 | 110.0 | | 90.0 | | 20 | 45.00 | 4.28 | 18000 | | |
| | 25 | 7 | 1 | 2 | 392.55823-5025100 | M24 | 25.0 | 100.0 | 62.0 | 100.0 | 65.0 | 100.0 | 20 | 25.00 | 4.94 | 12000 | | |
| | 32 | 7 | 1 | 2 | 392.55823-5032105 | M24 | 32.0 | 105.0 | 67.0 | 105.0 | 72.0 | 100.0 | 20 | 45.00 | 5.26 | 12000 | | |
| | 40 | 7 | 1 | 2 | 392.55823-5040115 | M24 | 40.0 | 115.0 | 77.0 | 115.0 | 90.0 | 100.0 | 20 | 45.00 | 6.60 | 12000 | | |
| 50 | 7 | 1 | 1 | 392.55823-5050130 | M24 | 50.0 | 130.0 | 100.0 | | 100.0 | | 20 | 60.00 | 7.81 | 12000 | | | |

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M1



N23



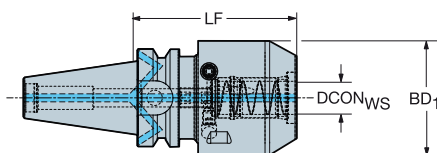
N15

BIG-PLUS MAS-BT to CoroChuck™ 930

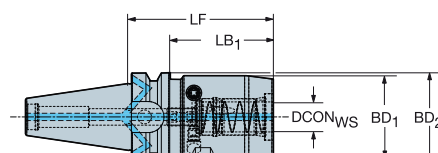
Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN

3



6

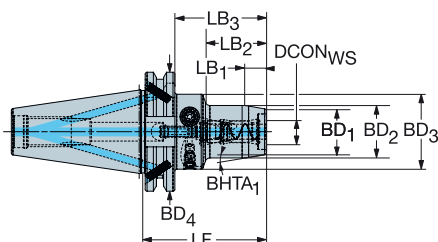


Heavy Duty design

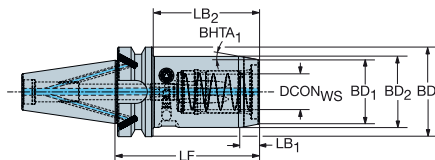
| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|--------------------|----------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | RPMX | | | |
| 40 | 20 | 7 | 1 | 6 | 930-BB40-HD-20-088 | M16 | 20.0 | 51 | 88.0 | 17.8 | 61.0 | 88.0 | 50.0 | 55.0 | 63.0 | 8° | 80 | 10.00 | 1.95 | 18000 | | | |
| | 25 | 7 | 1 | 3 | 930-BB40-HD-25-094 | M16 | 25.0 | 57 | 94.0 | 18.8 | 94.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 2.40 | 18000 | | | |
| 50 | 20 | 7 | 1 | 6 | 930-BB50-HD-20-102 | M24 | 20.0 | 51 | 102.0 | 17.8 | 64.0 | 102.0 | 50.0 | 55.0 | 100.0 | 8° | 80 | 10.00 | 4.75 | 12000 | | | |
| | 25 | 7 | 1 | 6 | 930-BB50-HD-25-106 | M24 | 25.0 | 57 | 106.0 | 18.8 | 68.0 | 106.0 | 57.0 | 65.0 | 100.0 | 12° | 80 | 10.00 | 5.16 | 12000 | | | |
| | 32 | 7 | 1 | 6 | 930-BB50-HD-32-096 | M24 | 32.0 | 61 | 96.0 | 18.8 | 58.0 | 96.0 | 68.0 | 76.0 | 100.0 | 12° | 80 | 10.00 | 5.25 | 12000 | | | |

DSGN

10



6



Slender design

| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|----------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | BAR | NM | KG | RPMX | |
| 30 | 6 | 1 | 1 | 6 | 930-BB30-S-06-048 | M12 | 6.0 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 22.0 | 26.0 | 46.0 | | 12° | 80 | 8.00 | 0.56 | 25000 | |
| | 8 | 1 | 1 | 6 | 930-BB30-S-08-048 | M12 | 8.0 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 24.0 | 28.0 | 46.0 | | 12° | 80 | 8.00 | 0.57 | 25000 | |
| | 10 | 1 | 1 | 6 | 930-BB30-S-10-048 | M12 | 10.0 | 41 | 48.0 | 9.3 | 13.8 | 48.0 | | 26.0 | 30.0 | 46.0 | | 12° | 80 | 8.00 | 0.56 | 25000 | |
| | 12 | 1 | 1 | 10 | 930-BB30-S-12-082 | M12 | 12.0 | 46 | 82.0 | 11.3 | 38.2 | 60.0 | 82.0 | 28.0 | 32.0 | 40.0 | 46.0 | 10° | 80 | 8.00 | 0.76 | 25000 | |
| | 20 | 1 | 1 | 6 | 930-BB30-S-20-088 | M12 | 20.0 | 51 | 88.0 | 16.0 | 66.0 | 88.0 | | 38.0 | 42.0 | 46.0 | | 7° | 80 | 8.00 | 0.94 | 25000 | |
| 40 | 6 | 7 | 1 | 10 | 930-BB40-S-06-075 | M16 | 6.0 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 22.0 | 26.0 | 40.0 | 63.0 | 10° | 80 | 8.00 | 1.23 | 18000 | |
| | 8 | 7 | 1 | 10 | 930-BB40-S-08-075 | M16 | 8.0 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 24.0 | 28.0 | 40.0 | 63.0 | 10° | 80 | 8.00 | 1.25 | 18000 | |
| | 10 | 7 | 1 | 10 | 930-BB40-S-10-080 | M16 | 10.0 | 41 | 80.0 | 11.3 | 34.2 | 53.0 | 80.0 | 26.0 | 30.0 | 40.0 | 63.0 | 10° | 80 | 8.00 | 1.29 | 18000 | |
| | 12 | 7 | 1 | 10 | 930-BB40-S-12-085 | M16 | 12.0 | 46 | 85.0 | 11.3 | 40.0 | 58.0 | 85.0 | 26.0 | 32.0 | 50.0 | 63.0 | 10° | 80 | 8.00 | 1.40 | 18000 | |
| | 20 | 7 | 1 | 10 | 930-BB40-S-20-094 | M16 | 20.0 | 51 | 94.0 | 16.0 | 49.2 | 67.0 | 94.0 | 37.9 | 42.0 | 50.0 | 63.0 | 7° | 80 | 8.00 | 1.62 | 18000 | |
| 50 | 25 | 7 | 1 | 6 | 930-BB40-S-25-102 | M16 | 25.0 | 57 | 102.0 | 12.9 | 74.0 | 102.0 | | 45.0 | 50.0 | 63.0 | | 11° | 80 | 10.00 | 1.87 | 18000 | |
| | 20 | 7 | 1 | 10 | 930-BB50-S-20-108 | M24 | 20.0 | 51 | 108.0 | 16.0 | 49.2 | 70.0 | 108.0 | 37.9 | 42.0 | 50.0 | 100.0 | 7° | 80 | 8.00 | 4.41 | 12000 | |
| | 25 | 7 | 1 | 6 | 930-BB50-S-25-114 | M24 | 25.0 | 57 | 114.0 | 12.9 | 73.5 | 114.0 | | 45.0 | 50.0 | 100.0 | | 11° | 80 | 10.00 | 4.62 | 12000 | |

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M1



N23



N15



N4

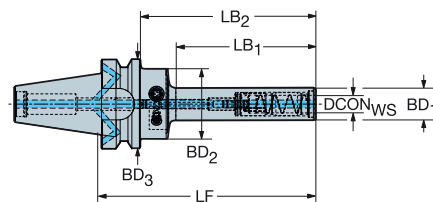
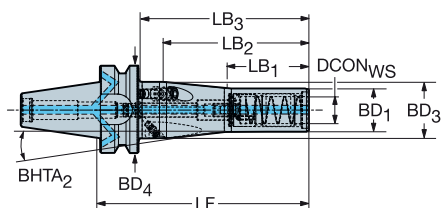
BIG-PLUS MAS-BT to CoroChuck™ 930

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN

11

5

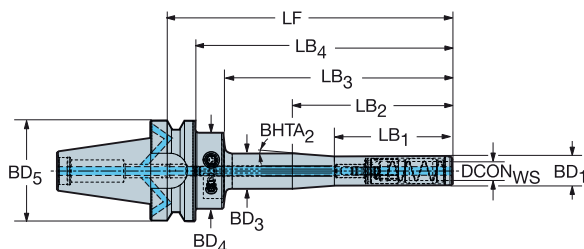


Pencil design

| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₂ | BAR | NM | KG | RPMX |
| 30 | 6 | 1 | 1 | 5 | 930-BB30-P-06-088 | M12 | 6.0 | 37 | 88.0 | 50.0 | 66.0 | 88.0 | | 14.5 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.62 | 25000 |
| | 8 | 1 | 1 | 5 | 930-BB30-P-08-088 | M12 | 8.0 | 37 | 88.0 | 45.8 | 66.0 | 88.0 | | 17.5 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.60 | 25000 |
| | 10 | 1 | 1 | 5 | 930-BB30-P-10-098 | M12 | 10.0 | 41 | 98.0 | 55.8 | 76.0 | 98.0 | | 20.0 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.64 | 25000 |
| | 10 | 1 | 1 | 5 | 930-BB30-P-10-138 | M12 | 10.0 | 41 | 138.0 | 95.8 | 116.0 | 138.0 | | 20.0 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.74 | 25000 |
| | 12 | 1 | 1 | 5 | 930-BB30-P-12-103 | M12 | 12.0 | 46 | 103.0 | 65.0 | 81.0 | 103.0 | | 22.0 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.71 | 25000 |
| 40 | 12 | 1 | 1 | 5 | 930-BB30-P-12-138 | M12 | 12.0 | 46 | 138.0 | 100.0 | 116.0 | 138.0 | | 22.0 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.80 | 25000 |
| | 8 | 7 | 1 | 5 | 930-BB40-P-08-095 | M16 | 8.0 | 37 | 95.0 | 45.8 | 65.5 | 95.0 | | 17.5 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.21 | 18000 |
| | 10 | 7 | 1 | 5 | 930-BB40-P-10-105 | M16 | 10.0 | 41 | 105.0 | 55.8 | 75.5 | 105.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.25 | 18000 |
| | 10 | 7 | 1 | 5 | 930-BB40-P-10-145 | M16 | 10.0 | 41 | 145.0 | 95.8 | 115.5 | 145.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.35 | 18000 |
| | 12 | 7 | 1 | 5 | 930-BB40-P-12-110 | M16 | 12.0 | 46 | 110.0 | 65.0 | 83.0 | 110.0 | | 22.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.33 | 18000 |
| | 12 | 7 | 1 | 5 | 930-BB40-P-12-145 | M16 | 12.0 | 46 | 145.0 | 100.0 | 118.0 | 145.0 | | 22.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.47 | 18000 |
| | 20 | 7 | 1 | 11 | 930-BB40-P-20-153 | M16 | 20.0 | 51 | 153.0 | 60.0 | 108.0 | 126.0 | 153.0 | | 32.0 | 32.0 | 42.0 | 63.0 | 5° | 80 | 8.00 | 1.85 |

DSGN

17



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | BAR | NM | KG | RPMX |
| 30 | 12 | 1 | 1 | 17 | 930-BB30-P-12-188 | M12 | 12.0 | 46 | 188.0 | 50.0 | 75.0 | 150.0 | 166.0 | 22.0 | 26.0 | 40.0 | 46 | 4° | 80 | 8.00 | 1.08 | 25000 |
| 40 | 12 | 7 | 1 | 17 | 930-BB40-P-12-195 | M16 | 12.0 | 46 | 195.0 | 50.0 | 75.0 | 150.0 | 168.0 | 22.0 | 26.0 | 40.0 | 63 | 4° | 80 | 8.00 | 1.68 | 18000 |

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M1



N23



N15

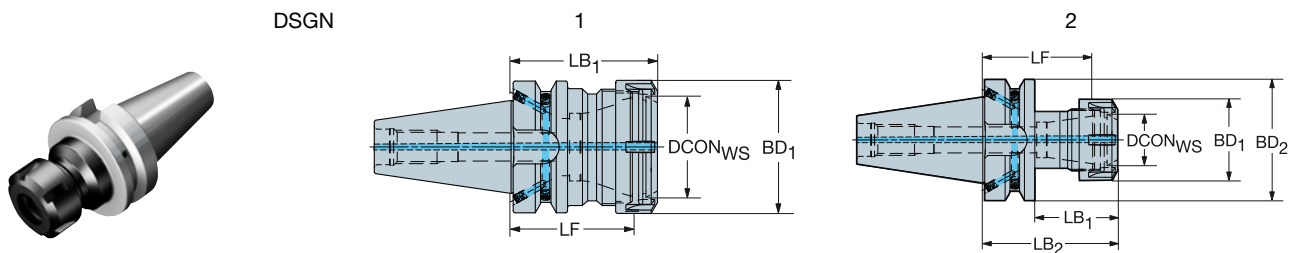


N4



BIG-PLUS MAS-BT to ER collet chuck

Machine side interface compatible with MAS-BT 403 and JIS B 6339



Workpiece side interface DIN 6499-B

| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX |
| 30 | ER11 | 1 | 1 | 2 | 392.55514-3011050 | M12 | 11.4 | 43.4 | 28.0 | 50.0 | 18.7 | 46.0 | 80 | 0.45 | 25000 |
| | ER16 | 1 | 1 | 2 | 392.55514-3016050 | M12 | 17.0 | 39.4 | 28.0 | 50.0 | 28.0 | 46.0 | 80 | 0.47 | 25000 |
| | ER20 | 1 | 1 | 2 | 392.55514-3020052 | M12 | 21.0 | 40.5 | 30.0 | 52.0 | 33.7 | 46.0 | 80 | 0.49 | 25000 |
| | ER25 | 1 | 1 | 2 | 392.55514-3025060 | M12 | 26.0 | 48.0 | 38.0 | 60.0 | 42.0 | 46.0 | 80 | 0.60 | 25000 |
| | ER32 | 1 | 1 | 1 | 392.55514-3032060 | M12 | 33.0 | 47.0 | 60.0 | | 50.0 | | 80 | 0.64 | 25000 |
| 40 | ER25 | 7 | 1 | 2 | 392.55514-4025070 | M16 | 26.0 | 58.0 | 43.0 | 70.0 | 42.0 | 63.0 | 80 | 1.24 | 18000 |
| | ER40 | 7 | 1 | 1 | 392.55514-4040070 | M16 | 41.0 | 55.0 | 70.0 | | 63.0 | | 80 | 1.39 | 18000 |

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M1



N23



N15

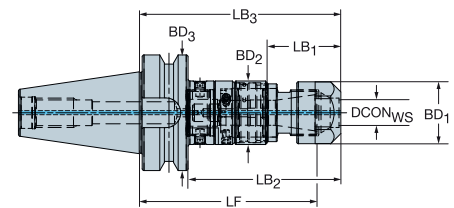
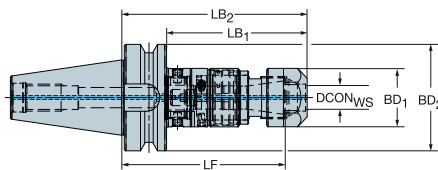
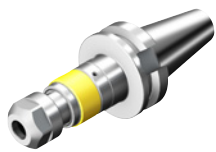
BIG-PLUS MAS-BT to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN

2

5



| | | | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|-------|------|------|------|-----------------|----------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|------|------|------|--|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BAR | KG | RPMX | |
| 30 | ER11 | M5 | 1 | 1 | 5 | 970-BB30-11-082 | M12 | 11.3 | 78.2 | 24.1 | 60.0 | 82.0 | 18.7 | 23.5 | 46.0 | 80 | 0.52 | 8000 | |
| | ER20 | M12 | 1 | 1 | 5 | 970-BB30-20-105 | M12 | 20.8 | 92.2 | 40.3 | 83.1 | 105.2 | 33.7 | 35.0 | 46.0 | 80 | 0.84 | 8000 | |
| | ER25 | M20 | 1 | 1 | 5 | 970-BB30-25-125 | M12 | 25.8 | 111.1 | 42.1 | 102.6 | 124.6 | 42.0 | 44.0 | 46.0 | 80 | 1.20 | 8000 | |
| 40 | ER20 | M12 | 7 | 1 | 5 | 970-BB40-20-110 | M16 | 20.8 | 97.2 | 40.3 | 83.1 | 110.2 | 33.7 | 35.0 | 63.0 | 80 | 1.43 | 8000 | |
| | ER25 | M20 | 7 | 1 | 5 | 970-BB40-25-130 | M16 | 25.8 | 116.1 | 42.1 | 102.6 | 129.6 | 42.0 | 44.0 | 63.0 | 80 | 1.79 | 8000 | |
| 50 | ER20 | M12 | 7 | 1 | 5 | 970-BB50-20-125 | M24 | 20.8 | 112.2 | 40.3 | 87.1 | 125.2 | 33.7 | 35.0 | 100.0 | 80 | 4.11 | 8000 | |
| | ER25 | M20 | 7 | 1 | 5 | 970-BB50-25-145 | M24 | 25.8 | 131.1 | 42.1 | 106.6 | 144.6 | 42.0 | 44.0 | 100.0 | 80 | 4.50 | 8000 | |
| | ER40 | M30 | 7 | 1 | 2 | 970-BB50-40-174 | M24 | 40.8 | 157.2 | 136.0 | 174.0 | | 63.0 | 100.0 | 80 | 5.66 | 8000 | | |

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M1



N23

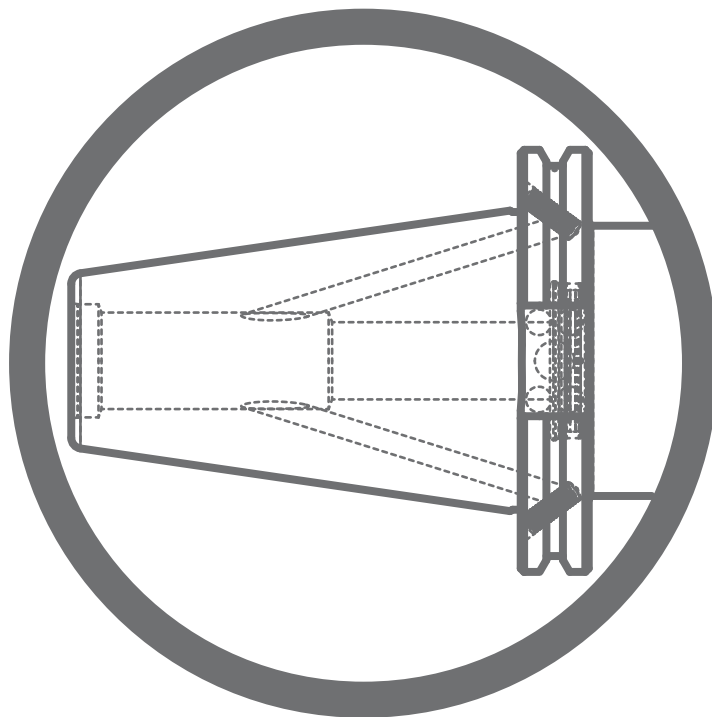


N15



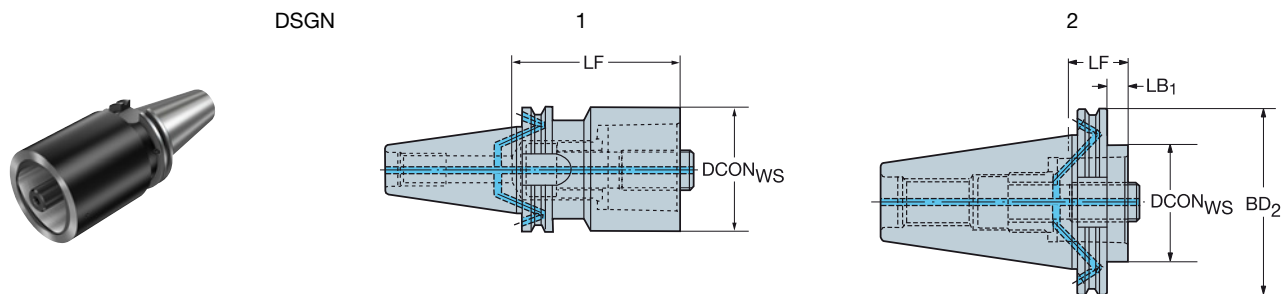
N5

Machine side interface ISO 7388-1



ISO 7388-1 to Coromant Capto® adaptor

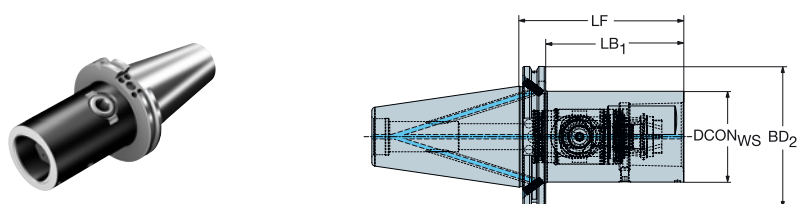
Machine side interface compatible with DIN 69871-ADB



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------|---------------------|------|--------------------|-------|-----------------|-----------------|-----------------|-----|--------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₂ | BAR | NM | KG |
| 40 | C3 | 7 | 1 | 2 | C3-390B.140-40 030 | M16 | 32.0 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 45.00 | 0.87 |
| | C3 | 7 | 1 | 2 | C3-390B.140-40 060 | M16 | 32.0 | 60.0 | 40.9 | 60.0 | 63.5 | 80 | 45.00 | 1.02 |
| | C4 | 7 | 1 | 2 | C4-390B.140-40 030 | M16 | 40.0 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 55.00 | 0.86 |
| | C4 | 7 | 1 | 2 | C4-390B.140-40 060 | M16 | 40.0 | 60.0 | 40.9 | 60.0 | 63.5 | 80 | 55.00 | 1.12 |
| | C5 | 7 | 1 | 2 | C5-390B.140-40 040 | M16 | 50.0 | 40.0 | 20.9 | 40.0 | 63.5 | 80 | 95.00 | 0.96 |
| | C5 | 7 | 1 | 2 | C5-390B.140-40 080 | M16 | 50.0 | 80.0 | 60.9 | 80.0 | 63.5 | 80 | 95.00 | 1.52 |
| | C6 | 7 | 1 | 2 | C6-390B.140-40 085 | M16 | 63.0 | 85.0 | 65.9 | 85.0 | 63.5 | 80 | 170.00 | 1.84 |
| 50 | C3 | 7 | 1 | 2 | C3-390B.140-50 030 | M24 | 32.0 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 45.00 | 2.73 |
| | C3 | 7 | 1 | 2 | C3-390B.140-50 060 | M24 | 32.0 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 45.00 | 2.86 |
| | C4 | 7 | 1 | 2 | C4-390B.140-50 030 | M24 | 40.0 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 55.00 | 2.74 |
| | C4 | 7 | 1 | 2 | C4-390B.140-50 060 | M24 | 40.0 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 55.00 | 2.96 |
| | C5 | 7 | 1 | 2 | C5-390B.140-50 030 | M24 | 50.0 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 95.00 | 2.70 |
| | C5 | 7 | 1 | 2 | C5-390B.140-50 070 | M24 | 50.0 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 95.00 | 3.21 |
| | C6 | 7 | 1 | 2 | C6-390B.140-50 030 | M24 | 63.0 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 170.00 | 2.62 |
| | C6 | 7 | 1 | 2 | C6-390B.140-50 080 | M24 | 63.0 | 80.0 | 60.9 | 80.0 | 97.5 | 80 | 170.00 | 3.71 |
| | C8 | 7 | 1 | 2 | C8-390B.140-50 070 | M24 | 80.0 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 170.00 | 3.83 |
| | C8 | 7 | 1 | 2 | C8-390B.140-50 120 | M24 | 80.0 | 120.0 | 100.9 | 120.0 | 97.5 | 80 | 170.00 | 5.69 |
| | C10 | 7 | 1 | 1 | C10-390B.140-50 140 | M24 | 100.0 | 140.0 | 140.0 | | | 80 | 380.00 | 7.66 |
| 60 | C8 | 1 | 1 | 2 | C8-390.140-60 120 | M30 | 80.0 | 120.0 | 100.9 | 120.0 | 155.0 | 80 | 170.00 | 12.57 |
| | C10 | 1 | 1 | 2 | C10-390.140-60 050 | M30 | 100.0 | 50.0 | 30.9 | 50.0 | 155.0 | 80 | 380.00 | 9.35 |

ISO 7388-1 to Coromant Capto® adaptor with Quick change

Machine side interface compatible with DIN 69871-ADB



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|---------------|----------------|--------------------|-------|-----------------|-----------------|-----|--------|------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG | | |
| 50 | C5 | 7 | 1 | I50-QC-C5-095 | M24 | 50.0 | 95.0 | 75.0 | 97.4 | 80 | 70.00 | 3.54 | | |
| | C6 | 7 | 1 | I50-QC-C6-115 | M24 | 63.0 | 115.0 | 95.0 | 97.4 | 80 | 90.00 | 4.43 | | |
| | C8 | 7 | 1 | I50-QC-C8-135 | M24 | 80.0 | 135.0 | 115.0 | 97.4 | 80 | 130.00 | 6.06 | | |

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M1



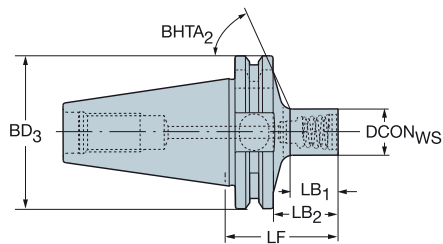
N23



N15

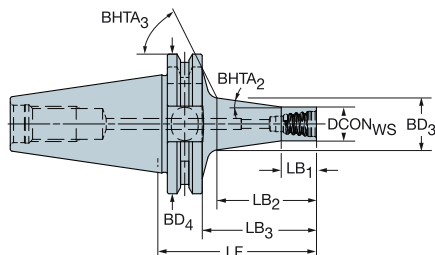
ISO 7388-1 to Coromant EH adaptor

Machine side interface compatible with DIN 69871-AD



Short design

| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|---------------------|----------------|--------------------|------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₃ | BHTA ₂ | BAR | NM | KG | RPMX |
| 40 | E10 | 1 | 1 | 392.140EH-40 10 041 | M16 | 9.6 | 41.0 | 12.7 | 21.9 | 63.5 | 65° | 80 | 12.00 | 0.96 | 18000 |
| | E12 | 1 | 1 | 392.140EH-40 12 044 | M16 | 11.6 | 44.0 | 16.0 | 24.9 | 63.5 | 65° | 80 | 15.00 | 0.97 | 18000 |
| | E16 | 1 | 1 | 392.140EH-40 16 049 | M16 | 15.4 | 49.0 | 21.5 | 29.9 | 63.5 | 65° | 80 | 30.00 | 1.03 | 18000 |
| | E20 | 1 | 1 | 392.140EH-40 20 046 | M16 | 19.2 | 46.0 | 19.0 | 27.0 | 63.5 | 63° | 80 | 50.00 | 1.05 | 18000 |
| | E25 | 1 | 1 | 392.140EH-40 25 051 | M16 | 24.1 | 51.0 | 24.6 | 31.9 | 63.5 | 61° | 80 | 65.00 | 1.09 | 18000 |



Long design

| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|---------------------|----------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₃ | BD ₄ | BHTA ₂ | BHTA ₃ | BAR | NM | KG | RPMX |
| 40 | E10 | 1 | 1 | 392.140EH-40 10 055 | M16 | 9.6 | 55.0 | 10.0 | 28.1 | 35.9 | 14.7 | 63.5 | 8° | 65° | 80 | 12.00 | 0.97 | 18000 |
| | E12 | 1 | 1 | 392.140EH-40 12 060 | M16 | 11.6 | 60.0 | 12.0 | 33.5 | 40.9 | 17.6 | 63.5 | 8° | 65° | 80 | 15.00 | 1.00 | 18000 |
| | E16 | 1 | 1 | 392.140EH-40 16 071 | M16 | 15.4 | 71.0 | 16.0 | 45.3 | 51.9 | 23.6 | 63.5 | 8° | 63° | 80 | 30.00 | 1.09 | 18000 |
| | E20 | 1 | 1 | 392.140EH-40 20 084 | M16 | 19.2 | 84.0 | 20.0 | 59.1 | 64.9 | 30.2 | 63.5 | 8° | 61° | 80 | 50.00 | 1.19 | 18000 |
| | E25 | 1 | 1 | 392.140EH-40 25 100 | M16 | 24.1 | 100.0 | 25.0 | 76.2 | 80.9 | 38.5 | 63.5 | 8° | 51° | 80 | 65.00 | 1.40 | 18000 |

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



M1



N23



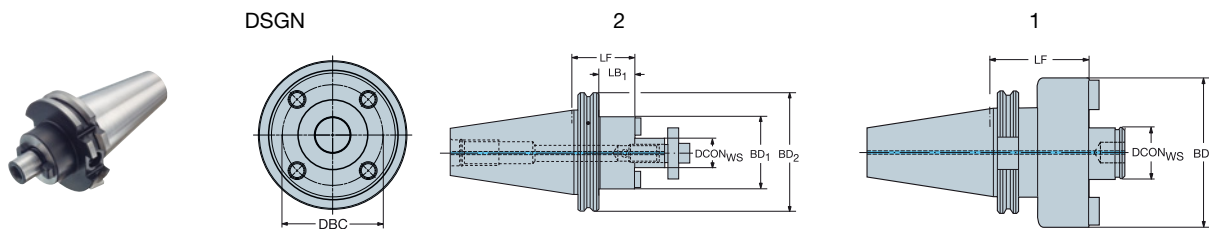
N15



N3

ISO 7388-1 to arbor adaptor

Machine side interface compatible with DIN 69871-ADB



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|-----------------|------|------|--------------------|------|-----------------|-----------------|-----------------|-----------------|--------|--------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DBC | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 40 | 16 | 7 | 1 | 2 | A1B05-40 16 035 | M16 | 16.0 | 35.0 | 15.9 | 35.0 | 36.0 | 63.5 | 80 | 22.00 | 1.04 | 18000 | |
| | 16 | 7 | 1 | 2 | A1B05-40 16 100 | M16 | 16.0 | 100.0 | 78.9 | 100.0 | 36.0 | 63.5 | 80 | 22.00 | 1.47 | 18000 | |
| | 22 | 7 | 1 | 2 | A1B05-40 22 035 | M16 | 22.0 | 35.0 | 13.9 | 35.0 | 48.0 | 63.5 | 80 | 45.00 | 1.15 | 18000 | |
| | 22 | 7 | 1 | 2 | A1B05-40 22 100 | M16 | 22.0 | 100.0 | 78.9 | 100.0 | 48.0 | 63.5 | 80 | 45.00 | 2.02 | 18000 | |
| | 27 | 7 | 1 | 2 | A1B05-40 27 035 | M16 | 27.0 | 35.0 | 15.0 | 35.0 | 48.0 | 63.5 | 80 | 80.00 | 1.08 | 18000 | |
| | 27 | 7 | 1 | 2 | A1B05-40 27 100 | M16 | 27.0 | 100.0 | 80.9 | 100.0 | 60.0 | 63.5 | 80 | 80.00 | 2.59 | 18000 | |
| 50 | 32 | 7 | 1 | 1 | A1B05-40 32 050 | M16 | 32.0 | 50.0 | 50.0 | | | 78.0 | | 80 | 180.00 | 1.82 | 18000 |
| | 22 | 7 | 1 | 2 | A1B05-50 22 035 | M24 | 22.0 | 35.0 | 15.9 | 35.0 | 48.0 | 97.5 | 80 | 45.00 | 3.00 | 12000 | |
| | 22 | 7 | 1 | 2 | A1B05-50 22 100 | M24 | 22.0 | 100.0 | 77.9 | 100.0 | 48.0 | 97.5 | 80 | 45.00 | 4.03 | 12000 | |
| | 27 | 7 | 1 | 2 | A1B05-50 27 035 | M24 | 27.0 | 35.0 | 12.9 | 35.0 | 60.0 | 97.5 | 80 | 80.00 | 3.26 | 12000 | |
| | 27 | 7 | 1 | 2 | A1B05-50 27 100 | M24 | 27.0 | 100.0 | 77.9 | 100.0 | 60.0 | 97.5 | 80 | 80.00 | 4.68 | 12000 | |
| | 32 | 7 | 1 | 2 | A1B05-50 32 035 | M24 | 32.0 | 35.0 | 12.9 | 35.0 | 78.0 | 97.5 | 80 | 180.00 | 3.54 | 12000 | |
| | 32 | 7 | 1 | 2 | A1B05-50 32 100 | M24 | 32.0 | 100.0 | 77.9 | 100.0 | 78.0 | 97.5 | 80 | 180.00 | 5.78 | 12000 | |
| | 40S | 7 | 1 | 2 | A1B05-50 40 050 | 66.7 | M24 | 40.0 | 50.0 | 30.9 | 50.0 | 89.0 | 97.5 | 80 | 300.00 | 4.48 | 12000 |
| 60 | 7 | 1 | 1 | A1F05-50 60 070 | 101.6 | M24 | 60.0 | 70.0 | 70.0 | | | 127.0 | | 80 | 180.00 | 7.76 | |

All holders are delivered with a standard screw without hole for coolant.

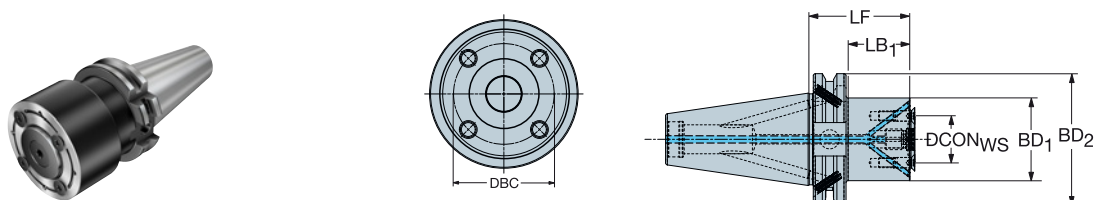
For cutters with coolant channels a new screw with radial coolant holes is necessary and can be ordered separately.

See page M13

ISO 7388-1 to arbor with driving screws adaptor

Machine side interface compatible with DIN 69871-ADB

For CoroMill® QD with internal coolant supply



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|----------------|------|--------------------|-----|------|-----------------|-----------------|-----------------|-----|------|------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DBC | CRKS | DCON _{WS} | LSC | LF | LB ₁ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX | |
| 40 | X10 | 7 | 3 | I40-X10-032-045 | 22.0 | M16 | 10.0 | 2 | 45.0 | 24.5 | 32.0 | 63.5 | 80 | 6.40 | 1.00 | 12000 | |
| | X22 | 7 | 3 | I40-X22-040-050 | 32.0 | M16 | 22.0 | 2 | 50.0 | 29.5 | 40.0 | 63.5 | 80 | 3.90 | 1.14 | 11000 | |
| | X32 | 7 | 3 | I40-X32-063-070 | 45.0 | M16 | 32.0 | 2 | 70.0 | 50.5 | 63.0 | 63.5 | 80 | 6.40 | 1.89 | 10000 | |

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M1



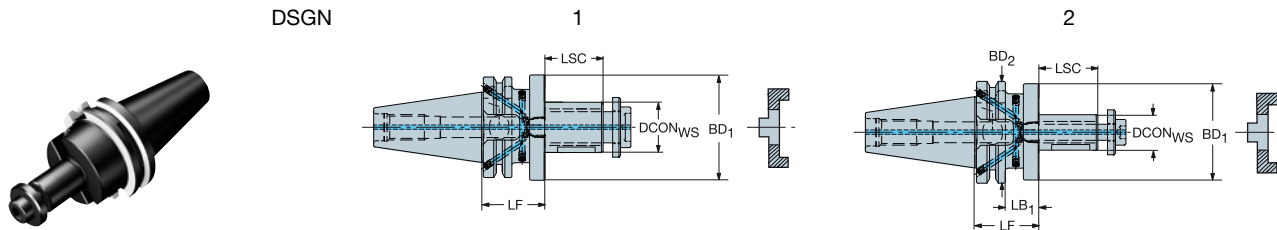
N23



N15

ISO 7388-1 to side and face mill arbor adaptor

Machine side interface compatible with DIN 69871-ADB



| | | | | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|--------|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG |
| 40 | 22 | 7 | 1 | 2 | A1B08-40 22 055 | M16 | 22.0 | 31 | 43.0 | 19.9 | 43.0 | 40.0 | 63.5 | 80 | 45.00 | 1.26 |
| | 27 | 7 | 1 | 2 | A1B08-40 27 055 | M16 | 27.0 | 33 | 43.0 | 22.9 | 43.0 | 48.0 | 63.5 | 80 | 80.00 | 1.45 |
| | 32 | 7 | 1 | 2 | A1B08-40 32 060 | M16 | 32.0 | 37 | 46.0 | 26.9 | 46.0 | 58.0 | 63.5 | 80 | 180.00 | 1.76 |
| | 40 | 7 | 1 | 1 | A1B08-40 40 060 | M16 | 40.0 | 41 | 46.0 | 60.0 | | 70.0 | 80 | 300.00 | 2.38 | |

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



M1

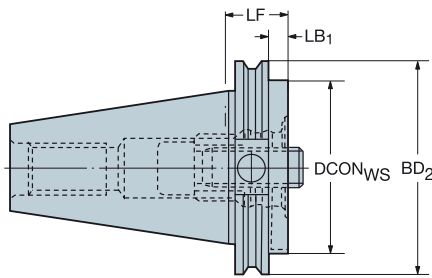


N23



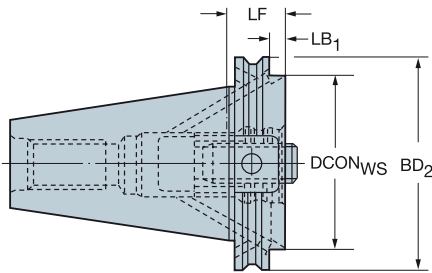
N15

ISO 7388-1 to VL adaptor



Machine side interface compatible with DIN 69871-AD

| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|------|--------------------|------|-----------------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{VS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG |
| 50 | 80 | 1 | 1 | 390.140-50 80 027 | M24 | 80.0 | 27.0 | 7.9 | 97.5 | 20 | 180.00 | 2.88 |



Machine side interface compatible with DIN 69871-B

| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|------|--------------------|------|-----------------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{VS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG |
| 50 | 80 | 6 | 1 | 390.272-50 80 027 | M24 | 80.0 | 27.0 | 7.9 | 97.5 | 20 | 180.00 | 2.86 |

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



M1



N23



N15

ISO 7388-1 to Weldon adaptor

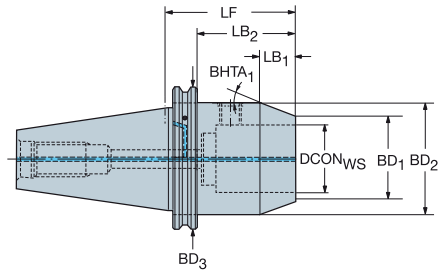
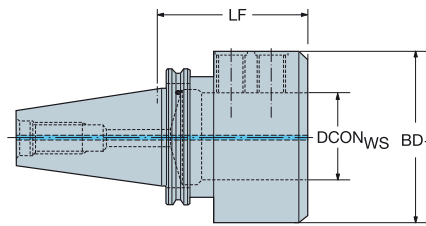
Machine side interface compatible with DIN 69871-ADB

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN

3

6



| | | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|----------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG |
| 40 | 6 | 7 | 1 | 6 | A1B20-40 06 050 | M16 | 6.0 | 50.0 | 11.0 | 28.9 | 50.0 | 12.3 | 25.0 | 63.5 | 30° | 20 | 3.00 | 0.91 |
| | 6 | 7 | 1 | 6 | A1B20-40 06 100 | M16 | 6.0 | 100.0 | 11.0 | 78.9 | 100.0 | 12.3 | 25.0 | 63.5 | 30° | 20 | 3.00 | 1.06 |
| | 8 | 7 | 1 | 6 | A1B20-40 08 050 | M16 | 8.0 | 50.0 | 11.0 | 28.9 | 50.0 | 15.3 | 28.0 | 63.5 | 30° | 20 | 7.00 | 0.82 |
| | 8 | 7 | 1 | 6 | A1B20-40 08 100 | M16 | 8.0 | 100.0 | 11.0 | 78.9 | 100.0 | 15.3 | 28.0 | 63.5 | 30° | 20 | 7.00 | 1.14 |
| | 10 | 7 | 1 | 6 | A1B20-40 10 050 | M16 | 10.0 | 50.0 | 13.0 | 28.9 | 50.0 | 20.0 | 35.0 | 63.5 | 30° | 20 | 10.00 | 0.92 |
| | 10 | 7 | 1 | 6 | A1B20-40 10 100 | M16 | 10.0 | 100.0 | 13.0 | 78.9 | 100.0 | 20.0 | 35.0 | 63.5 | 30° | 20 | 10.00 | 1.34 |
| | 12 | 7 | 1 | 6 | A1B20-40 12 050 | M16 | 12.0 | 50.0 | 13.0 | 28.9 | 50.0 | 27.0 | 42.0 | 63.5 | 30° | 20 | 12.00 | 1.07 |
| | 12 | 7 | 1 | 6 | A1B20-40 12 100 | M16 | 12.0 | 100.0 | 13.0 | 78.9 | 100.0 | 27.0 | 42.0 | 63.5 | 30° | 20 | 12.00 | 1.57 |
| | 16 | 7 | 1 | 6 | A1B20-40 16 063 | M16 | 16.0 | 63.0 | 13.0 | 41.9 | 63.0 | 33.0 | 48.0 | 63.5 | 30° | 20 | 15.00 | 1.30 |
| | 16 | 7 | 1 | 6 | A1B20-40 16 100 | M16 | 16.0 | 100.0 | 13.0 | 78.9 | 100.0 | 33.0 | 48.0 | 63.5 | 30° | 20 | 15.00 | 1.79 |
| | 20 | 7 | 1 | 6 | A1B20-40 20 063 | M16 | 20.0 | 63.0 | 13.0 | 41.9 | 63.0 | 37.0 | 52.0 | 63.5 | 30° | 20 | 20.00 | 1.26 |
| | 20 | 7 | 1 | 6 | A1B20-40 20 100 | M16 | 20.0 | 100.0 | 13.0 | 78.9 | 100.0 | 37.0 | 52.0 | 63.5 | 30° | 20 | 20.00 | 1.89 |
| | 25 | 7 | 1 | 3 | A1B20-40 25 100 | M16 | 25.0 | 100.0 | 13.0 | 100.0 | | 50.0 | 65.0 | | 30° | 20 | 25.00 | 2.24 |
| | 32 | 7 | 1 | 3 | A1B20-40 32 100 | M16 | 32.0 | 100.0 | 12.0 | 100.0 | | 58.1 | 72.0 | | 30° | 20 | 45.00 | 2.54 |
| 50 | 12 | 7 | 1 | 6 | A1B20-50 12 063 | M24 | 12.0 | 63.0 | 13.0 | 40.9 | 63.0 | 27.0 | 42.0 | 97.4 | 30° | 20 | 12.00 | 3.00 |
| | 16 | 7 | 1 | 6 | A1B20-50 16 063 | M24 | 16.0 | 63.0 | 13.0 | 40.9 | 63.0 | 33.0 | 48.0 | 97.4 | 30° | 20 | 15.00 | 3.20 |
| | 20 | 7 | 1 | 6 | A1B20-50 20 063 | M24 | 20.0 | 63.0 | 13.0 | 40.9 | 63.0 | 37.0 | 52.0 | 97.4 | 30° | 20 | 20.00 | 3.26 |
| | 20 | 7 | 1 | 6 | A1B20-50 20 100 | M24 | 20.0 | 100.0 | 13.0 | 77.9 | 100.0 | 37.0 | 52.0 | 97.4 | 30° | 20 | 20.00 | 3.87 |
| | 25 | 7 | 1 | 6 | A1B20-50 25 080 | M24 | 25.0 | 80.0 | 13.0 | 57.9 | 80.0 | 50.0 | 65.0 | 97.4 | 30° | 20 | 25.00 | 3.92 |
| | 25 | 7 | 1 | 6 | A1B20-50 25 100 | M24 | 25.0 | 100.0 | 13.0 | 77.9 | 100.0 | 50.0 | 65.0 | 97.4 | 30° | 20 | 25.00 | 4.45 |
| | 32 | 7 | 1 | 6 | A1B20-50 32 100 | M24 | 32.0 | 100.0 | 12.0 | 77.9 | 100.0 | 58.1 | 72.0 | 97.4 | 30° | 20 | 45.00 | 4.60 |
| | 32 | 7 | 1 | 6 | A1B20-50 32 160 | M24 | 32.0 | 160.0 | 12.0 | 137.9 | 160.0 | 58.1 | 72.0 | 97.4 | 30° | 20 | 45.00 | 6.60 |
| | 40 | 7 | 1 | 6 | A1B20-50 40 120 | M24 | 40.0 | 120.0 | 15.0 | 97.9 | 120.0 | 60.7 | 78.0 | 97.4 | 30° | 20 | 45.00 | 5.50 |

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M1



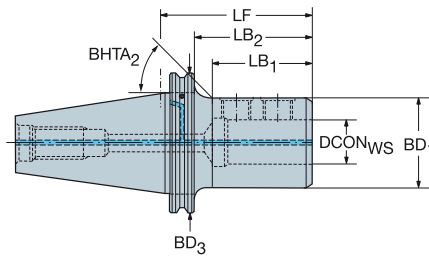
N23



N15

ISO 7388-1 to ISO 9766 adaptor

Machine side interface compatible with DIN 69871-ADB



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|----------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----|-------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | BD ₁ | BD ₂ | BAR | NM | KG |
| 40 | 16 | 7 | 1 | A1B27-40 16 080 | M16 | 16.0 | 49 | 80.0 | 55.9 | 36.0 | 63.5 | 20 | 10.00 | 1.21 |
| | 20 | 7 | 1 | A1B27-40 20 080 | M16 | 20.0 | 51 | 80.0 | 55.9 | 40.0 | 63.5 | 20 | 12.00 | 1.27 |
| | 25 | 7 | 1 | A1B27-40 25 085 | M16 | 25.0 | 57 | 85.0 | 64.9 | 45.0 | 63.5 | 20 | 20.00 | 1.38 |
| | 32 | 7 | 1 | A1B27-40 32 090 | M16 | 32.0 | 61 | 90.0 | 69.9 | 52.0 | 63.5 | 20 | 30.00 | 1.50 |
| 50 | 16 | 7 | 1 | A1B27-50 16 080 | M24 | 16.0 | 49 | 80.0 | 59.9 | 36.0 | 97.5 | 20 | 10.00 | 3.16 |
| | 20 | 7 | 1 | A1B27-50 20 080 | M24 | 20.0 | 51 | 80.0 | 59.9 | 40.0 | 97.5 | 20 | 12.00 | 3.20 |
| | 25 | 7 | 1 | A1B27-50 25 085 | M24 | 25.0 | 57 | 85.0 | 64.9 | 45.0 | 97.5 | 20 | 20.00 | 3.36 |
| | 32 | 7 | 1 | A1B27-50 32 090 | M24 | 32.0 | 61 | 90.0 | 69.9 | 52.0 | 97.5 | 20 | 30.00 | 3.52 |
| | 40 | 7 | 1 | A1B27-50 40 090 | M24 | 40.0 | 71 | 90.0 | 69.9 | 75.0 | 97.5 | 20 | 40.00 | 4.40 |
| | 50 | 7 | 1 | A1B27-50 50 100 | M24 | 50.0 | 81 | 100.0 | 79.9 | 75.0 | 97.5 | 20 | 45.00 | 4.22 |

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



M1



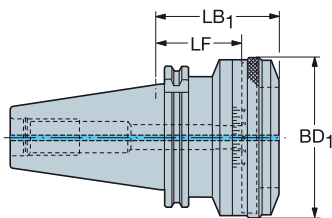
N23



N15

ISO 7388-1 to ISO 9766 adjustable adaptor

Machine side interface compatible with DIN 69871-AD



| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|------|-----------------------|------|--------------------|------|-----------------|-----------------|-----|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₁ | BAR | KG | RPMX |
| 40 | 1 | 1 | 1 | 392.140277-40 01 055A | M16 | 78.0 | 55.0 | 79.6 | 86.0 | 20 | 2.26 | 12000 |
| 50 | 2 | 1 | 1 | 392.140277-50 02 055A | M24 | 98.0 | 55.0 | 79.6 | 106.0 | 20 | 5.16 | 9000 |
| | 3 | 1 | 1 | 392.140277-50 03 075A | M24 | 136.0 | 75.0 | 85.0 | 140.0 | 20 | 7.03 | 6000 |

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



M1



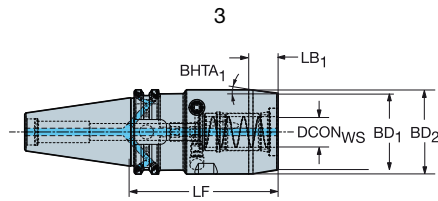
N23

ISO 7388-1 to CoroChuck™ 930

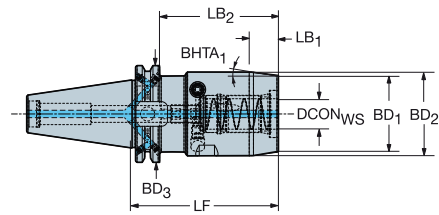
Machine side interface compatible with DIN 69871-ADB



DSGN



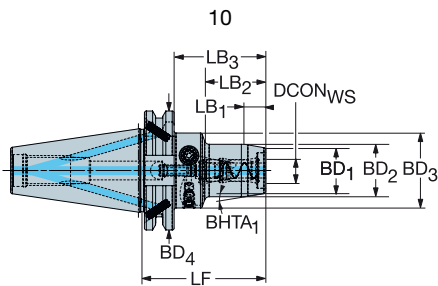
6



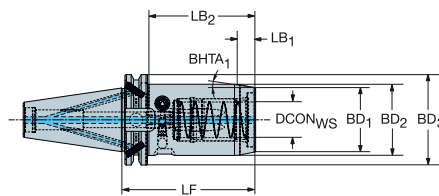
Heavy Duty design

| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|----------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | RPMX | | |
| 40 | 20 | 7 | 1 | 6 | 930-140-HD-20-097 | M16 | 20.0 | 51 | 97.0 | 17.8 | 77.9 | 97.0 | 50.0 | 55.0 | 63.5 | 8° | 80 | 10.00 | 2.03 | 18000 | | |
| | 25 | 7 | 1 | 3 | 930-140-HD-25-103 | M16 | 25.0 | 57 | 103.0 | 18.8 | 103.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 2.48 | 18000 | | |
| 50 | 20 | 7 | 1 | 6 | 930-150-HD-20-083 | M24 | 20.0 | 51 | 83.0 | 17.8 | 63.9 | 83.0 | 50.0 | 55.0 | 97.4 | 8° | 80 | 10.00 | 3.68 | 12000 | | |
| | 25 | 7 | 1 | 6 | 930-150-HD-25-087 | M24 | 25.0 | 57 | 87.0 | 18.8 | 67.9 | 87.0 | 57.0 | 65.0 | 97.4 | 12° | 80 | 10.00 | 4.13 | 12000 | | |
| | 32 | 7 | 1 | 6 | 930-150-HD-32-077 | M24 | 32.0 | 61 | 77.0 | 18.8 | 57.9 | 77.0 | 68.0 | 76.0 | 97.4 | 12° | 80 | 10.00 | 4.24 | 12000 | | |
| | 32 | 7 | 1 | 6 | 930-150-HD-32-170 | M24 | 32.0 | 61 | 170.0 | 18.8 | 150.9 | 170.0 | 68.0 | 76.0 | 97.4 | 12° | 80 | 10.00 | 7.43 | 12000 | | |

DSGN



6



Slender design

| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|----------------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | BHTA ₃ | BAR | NM | KG | RPMX |
| 40 | 6 | 7 | 1 | 10 | 930-140-S-06-068 | M16 | 6.0 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 22.0 | 26.0 | 40.0 | 63.5 | 10° | 0° | 80 | 8.00 | 1.06 | 18000 |
| | 8 | 7 | 1 | 10 | 930-140-S-08-068 | M16 | 8.0 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 24.0 | 28.0 | 40.0 | 63.5 | 10° | 0° | 80 | 8.00 | 1.07 | 18000 |
| | 10 | 7 | 1 | 10 | 930-140-S-10-072 | M16 | 10.0 | 41 | 72.0 | 11.3 | 34.2 | 52.9 | 26.0 | 30.0 | 40.0 | 63.5 | 10° | 0° | 80 | 8.00 | 1.11 | 18000 |
| | 12 | 7 | 1 | 10 | 930-140-S-12-080 | M16 | 12.0 | 46 | 80.0 | 11.3 | 38.2 | 60.9 | 28.0 | 32.0 | 50.0 | 63.5 | 10° | 0° | 80 | 8.00 | 1.32 | 18000 |
| | 20 | 7 | 1 | 10 | 930-140-S-20-090 | M16 | 20.0 | 51 | 90.0 | 16.0 | 49.2 | 70.9 | 38.0 | 42.0 | 50.0 | 63.5 | 7° | 0° | 80 | 8.00 | 1.50 | 18000 |
| | 25 | 7 | 1 | 6 | 930-140-S-25-095 | M16 | 25.0 | 57 | 95.0 | 12.9 | 75.0 | 76.0 | 45.0 | 50.0 | 50.0 | 63.5 | 11° | 82° | 80 | 8.00 | 1.71 | 18000 |
| 50 | 20 | 7 | 1 | 10 | 930-150-S-20-089 | M24 | 20.0 | 51 | 89.0 | 16.0 | 49.2 | 69.9 | 38.0 | 42.0 | 50.0 | 97.4 | 7° | 0° | 80 | 8.00 | 3.34 | 12000 |
| | 25 | 7 | 1 | 6 | 930-150-S-25-095 | M24 | 25.0 | 57 | 95.0 | 12.9 | 73.5 | 76.0 | 45.0 | 50.0 | 50.0 | 97.4 | 11° | 84° | 80 | 8.00 | 3.57 | 12000 |

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



M1



N23



N6



N15



N4

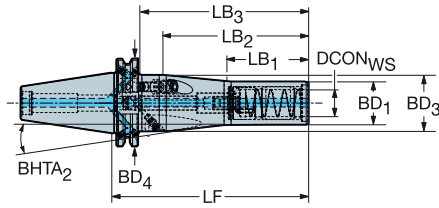


ISO 7388-1 to CoroChuck™ 930

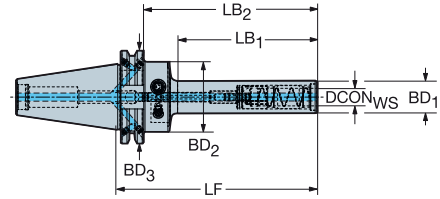
Machine side interface compatible with DIN 69871-ADB

DSGN

11



5



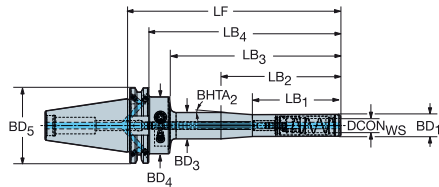
Pencil design

Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₂ | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|------|------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| 40 | 8 | 7 | 1 | 5 | 930-140-P-08-088 | M16 | 8.0 | 37 | 88.0 | 45.8 | 66.5 | 88.0 | | 17.5 | 40.0 | 63.5 | | 0° | 80 | 8.00 | 1.04 | 18000 |
| | 10 | 7 | 1 | 5 | 930-140-P-10-098 | M16 | 10.0 | 41 | 98.0 | 55.8 | 76.5 | 98.0 | | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.00 | 1.09 | 18000 |
| | 10 | 7 | 1 | 5 | 930-140-P-10-138 | M16 | 10.0 | 41 | 138.0 | 95.8 | 116.5 | 138.0 | | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.00 | 1.18 | 18000 |
| | 12 | 7 | 1 | 5 | 930-140-P-12-103 | M16 | 12.0 | 46 | 103.0 | 60.8 | 83.9 | 103.0 | | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.00 | 1.17 | 18000 |
| | 12 | 7 | 1 | 5 | 930-140-P-12-138 | M16 | 12.0 | 46 | 138.0 | 95.8 | 118.9 | 138.0 | | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.00 | 1.27 | 18000 |
| | 20 | 7 | 1 | 11 | 930-140-P-20-145 | M16 | 20.0 | 51 | 145.0 | 60.0 | 108.0 | 125.9 | 145.0 | 32.0 | 32.0 | 42.0 | 63.5 | 6° | 80 | 8.00 | 1.68 | 18000 |

DSGN

17



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|------|------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|
| 40 | 12 | 7 | 1 | 17 | 930-140-P-12-188 | M16 | 12.0 | 46 | 188.0 | 50.0 | 75.0 | 145.8 | 168.9 | 22.0 | 26.0 | 40.0 | 63 | 4° | 80 | 8.00 | 1.57 | 18000 |

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



M1



N23



N6



N15

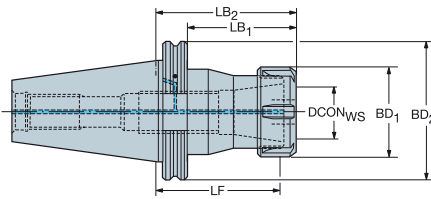


N4

ISO 7388-1 to ER collet chuck

Machine side interface compatible with DIN 69871-ADB

Workpiece side interface DIN 6499-B



| | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX |
| 40 | ER16 | 7 | 1 | A1B14-40 16 070 | M16 | 17.0 | 59.7 | 50.9 | 70.0 | 28.0 | 63.5 | 80 | 0.97 | 18000 |
| | | | | A1B14-40 16 100 | M16 | 17.0 | 89.7 | 80.9 | 100.0 | 28.0 | 63.5 | 80 | 1.12 | 18000 |
| | ER20 | 7 | 1 | A1B14-40 20 070 | M16 | 21.0 | 58.8 | 50.9 | 70.0 | 34.0 | 63.5 | 80 | 1.02 | 18000 |
| | | | | A1B14-40 20 100 | M16 | 21.0 | 88.8 | 80.9 | 100.0 | 34.0 | 63.5 | 80 | 1.25 | 18000 |
| | ER25 | 7 | 1 | A1B14-40 25 070 | M16 | 26.0 | 58.3 | 50.9 | 70.0 | 42.0 | 63.5 | 80 | 1.13 | 18000 |
| | | | | A1B14-40 25 100 | M16 | 26.0 | 88.3 | 80.9 | 100.0 | 42.0 | 63.5 | 80 | 1.44 | 18000 |
| | ER32 | 7 | 1 | A1B14-40 32 070 | M16 | 33.0 | 57.3 | 50.9 | 70.0 | 50.0 | 63.5 | 80 | 1.18 | 18000 |
| | | | | A1B14-40 40 070 | M16 | 41.0 | 55.3 | 50.9 | 70.0 | 63.0 | 63.5 | 80 | 1.25 | 18000 |
| 50 | ER20 | 7 | 1 | A1B14-50 20 070 | M24 | 21.0 | 58.8 | 50.9 | 70.0 | 34.0 | 97.5 | 80 | 2.96 | 12000 |
| | | | | A1B14-50 20 100 | M24 | 21.0 | 88.8 | 80.9 | 100.0 | 34.0 | 97.5 | 80 | 3.23 | 12000 |
| | ER25 | 7 | 1 | A1B14-50 25 070 | M24 | 26.0 | 58.3 | 50.9 | 70.0 | 42.0 | 97.5 | 80 | 3.02 | 12000 |
| | | | | A1B14-50 25 100 | M24 | 26.0 | 88.3 | 80.9 | 100.0 | 42.0 | 97.5 | 80 | 3.45 | 12000 |
| | ER32 | 7 | 1 | A1B14-50 32 070 | M24 | 33.0 | 57.3 | 50.9 | 70.0 | 50.0 | 97.5 | 80 | 3.08 | 12000 |
| | | | | A1B14-50 32 100 | M24 | 33.0 | 87.3 | 80.9 | 100.0 | 50.0 | 97.5 | 80 | 3.58 | 12000 |
| | ER40 | 7 | 1 | A1B14-50 40 070 | M24 | 41.0 | 55.3 | 50.9 | 70.0 | 63.0 | 97.5 | 80 | 3.20 | 12000 |

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



M1



N23



N15

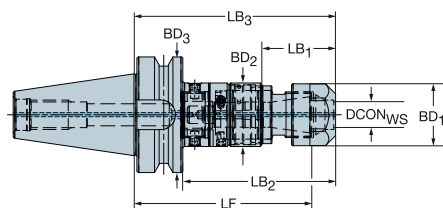
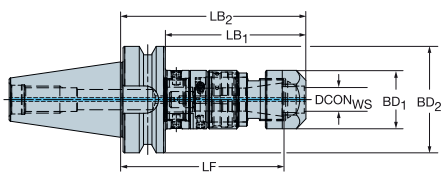
ISO 7388-1 to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN

2

5



Dimensions, mm

| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BAR | KG | RPMX |
|-------------------|-------------------|-------|------|------|------|----------------|------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----|------|------|
| 40 | ER20 | M12 | 1 | 1 | 5 | 970-I40-20-102 | M16 | 20.8 | 89.2 | 35.3 | 78.1 | 97.2 | 33.7 | 35.0 | 63.5 | 80 | 1.26 | 8000 |
| | ER25 | M20 | 1 | 1 | 5 | 970-I40-25-122 | M16 | 25.8 | 108.1 | 37.1 | 97.5 | 116.6 | 42.0 | 44.0 | 63.5 | 80 | 1.63 | 8000 |
| | ER32 | M27 | 1 | 1 | 2 | 970-I40-32-125 | M16 | 32.8 | 115.8 | 106.2 | 125.3 | | 50.0 | 63.5 | | 80 | 1.58 | 8000 |
| 50 | ER20 | M12 | 1 | 1 | 5 | 970-I50-20-106 | M24 | 20.8 | 93.2 | 35.3 | 82.1 | 101.2 | 33.7 | 35.0 | 97.5 | 80 | 3.12 | 8000 |
| | ER25 | M20 | 1 | 1 | 5 | 970-I50-25-126 | M24 | 25.8 | 112.1 | 37.1 | 101.5 | 120.6 | 42.0 | 44.0 | 97.5 | 80 | 3.75 | 8000 |
| | ER32 | M27 | 1 | 1 | 2 | 970-I50-32-129 | M24 | 32.8 | 119.8 | 110.2 | 129.3 | | 50.0 | 97.5 | | 80 | 3.36 | 8000 |
| | ER40 | M30 | 1 | 1 | 2 | 970-I50-40-155 | M24 | 40.8 | 138.2 | 130.6 | 149.6 | | 63.0 | 97.5 | | 80 | 4.94 | 8000 |

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M1



N23

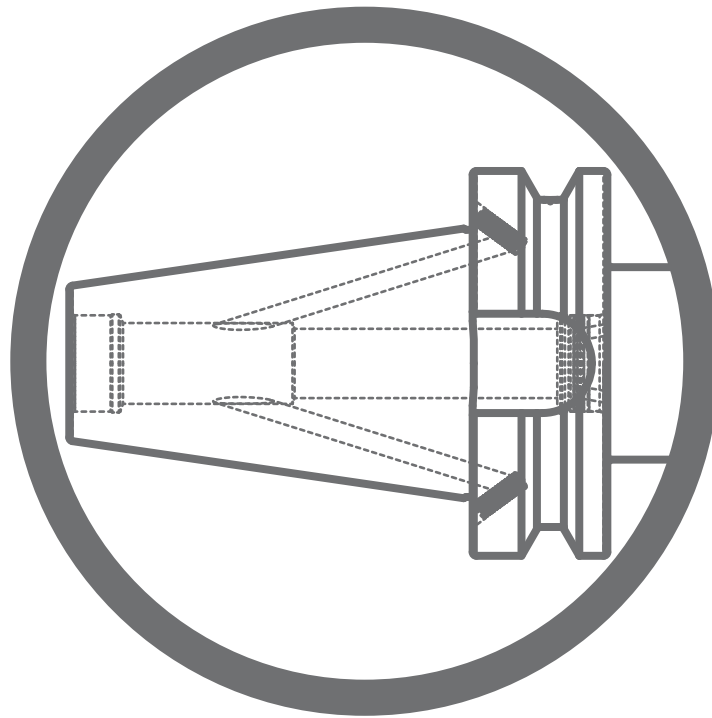


N15



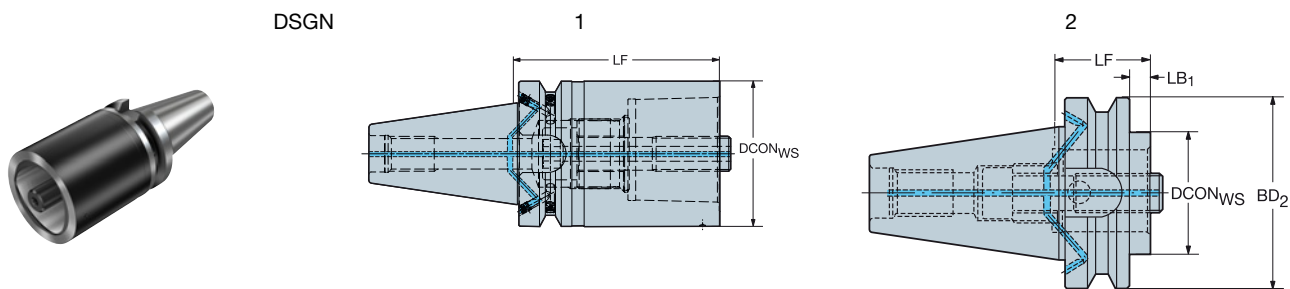
N5

Machine side interface MAS-BT



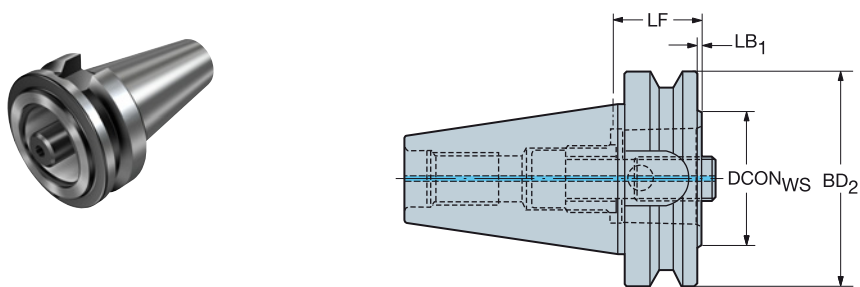
MAS-BT 403 to Coromant Capto® adaptor

Machine side interface compatible with JIS B 6339



| | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|--------------------|-------------------|-------|--------------------|-------|-----------------|-----------------|-----------------|--------|--------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₂ | BAR | NM | KG |
| 30 | C3 | 1 | 1 | 2 | C3-390.55-30 030 | M12 | 32.0 | 30.0 | 8.0 | 30.0 | 46.0 | 80 | 45.00 | 0.42 |
| | C3 | 1 | 1 | 2 | C3-390.55-30 060 | M12 | 32.0 | 60.0 | 38.0 | 60.0 | 46.0 | 80 | 45.00 | 0.58 |
| | C4 | 1 | 1 | 2 | C4-390.55-30 060 | M12 | 40.0 | 60.0 | 38.0 | 60.0 | 46.0 | 80 | 55.00 | 0.67 |
| | C5 | 1 | 1 | 1 | C5-390.55-30 080 | M12 | 50.0 | 80.0 | 80.0 | | | 80 | 95.00 | 1.07 |
| 40 | C3 | 7 | 1 | 2 | C3-390B.55-40 030 | M16 | 32.0 | 30.0 | 3.0 | 30.0 | 63.0 | 80 | 45.00 | 0.99 |
| | C3 | 7 | 1 | 2 | C3-390B.55-40 060 | M16 | 32.0 | 60.0 | 33.0 | 60.0 | 63.0 | 80 | 45.00 | 1.14 |
| | C4 | 7 | 1 | 2 | C4-390B.55-40 030 | M16 | 40.0 | 30.0 | 3.0 | 30.0 | 63.0 | 80 | 55.00 | 0.95 |
| | C4 | 7 | 1 | 2 | C4-390B.55-40 060 | M16 | 40.0 | 60.0 | 33.0 | 60.0 | 63.0 | 80 | 55.00 | 1.21 |
| | C5 | 7 | 1 | 2 | C5-390B.55-40 050 | M16 | 50.0 | 50.0 | 23.0 | 50.0 | 63.0 | 80 | 95.00 | 1.15 |
| | C5 | 7 | 1 | 2 | C5-390B.55-40 090 | M16 | 50.0 | 90.0 | 63.0 | 90.0 | 63.0 | 80 | 95.00 | 1.72 |
| | C6 | 7 | 1 | 1 | C6-390B.55-40 075 | M16 | 63.0 | 75.0 | 75.0 | | | 80 | 170.00 | 1.74 |
| 50 | C3 | 7 | 1 | 2 | C3-390B.58-50 040 | M24 | 32.0 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 45.00 | 3.68 |
| | C3 | 7 | 1 | 2 | C3-390B.58-50 070 | M24 | 32.0 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 45.00 | 3.80 |
| | C4 | 7 | 1 | 2 | C4-390B.58-50 040 | M24 | 40.0 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 55.00 | 3.65 |
| | C4 | 7 | 1 | 2 | C4-390B.58-50 070 | M24 | 40.0 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 55.00 | 3.88 |
| | C5 | 7 | 1 | 2 | C5-390B.58-50 040 | M24 | 50.0 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 95.00 | 3.56 |
| | C5 | 7 | 1 | 2 | C5-390B.58-50 080 | M24 | 50.0 | 80.0 | 42.0 | 80.0 | 100.0 | 80 | 95.00 | 4.09 |
| | C6 | 7 | 1 | 2 | C6-390B.58-50 050 | M24 | 63.0 | 50.0 | 12.0 | 50.0 | 100.0 | 80 | 170.00 | 3.61 |
| | C6 | 7 | 1 | 2 | C6-390B.58-50 100 | M24 | 63.0 | 100.0 | 62.0 | 100.0 | 100.0 | 80 | 170.00 | 4.71 |
| | C8 | 7 | 1 | 2 | C8-390B.58-50 070 | M24 | 80.0 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 170.00 | 4.12 |
| | C8 | 7 | 1 | 2 | C8-390B.58-50 120 | M24 | 80.0 | 120.0 | 72.0 | 120.0 | 100.0 | 80 | 170.00 | 5.98 |
| C10 | 7 | 1 | 1 | C10-390B.58-50 140 | M24 | 100.0 | 140.0 | 140.0 | | | 80 | 380.00 | 8.00 | |
| 60 | C8 | 1 | 1 | 2 | C8-390.58-60 120 | M30 | 80.0 | 120.0 | 72.0 | 120.0 | 155.0 | 80 | 170.00 | 15.14 |
| | C10 | 1 | 1 | 2 | C10-390.58-60 080 | M30 | 100.0 | 80.0 | 32.0 | 80.0 | 155.0 | 80 | 380.00 | 13.30 |

90° rotated polygon for precision tool tip control Designed for Mazak™ e-machine and Mori Seiki NT™ -Series



| | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|----------------|------|-------------------|------|--------------------|------|-----------------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG |
| 40 | C5 | 1 | 1 | C5-390.605-40 030 | M16 | 50.0 | 30.0 | 3.0 | 63.0 | 80 | 95.00 | 0.88 |
| 50 | C6 | 1 | 1 | C6-390.605-50 040 | M24 | 63.0 | 40.0 | 2.0 | 100.0 | 80 | 170.00 | 3.26 |
| | C8 | 1 | 1 | C8-390.605-50 070 | M24 | 80.0 | 70.0 | 32.0 | 100.0 | 80 | 170.00 | 4.14 |

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M1



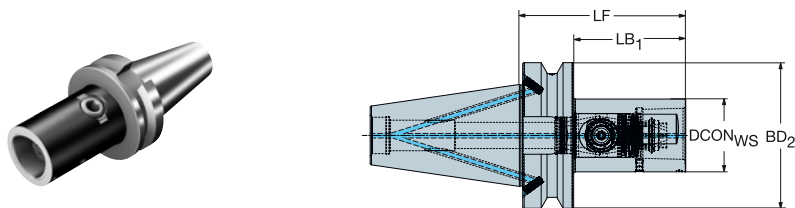
N23



N15

MAS-BT 403 to Coromant Capto® adaptor with Quick change

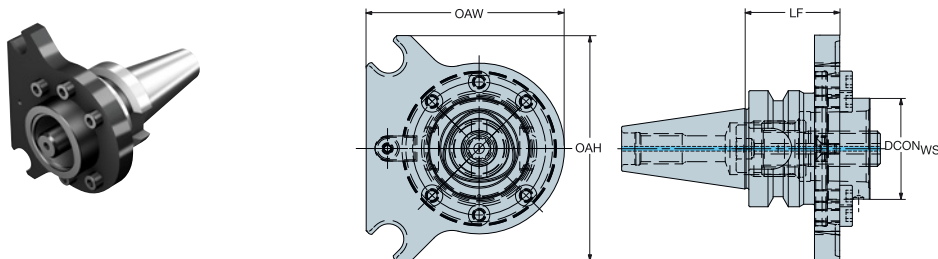
Machine side interface compatible with JIS B 6339



| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|---------------|----------------|--------------------|-------|-----------------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG |
| 50 | C5 | 7 | 1 | B50-QC-C5-115 | M24 | 50.0 | 115.0 | 76.0 | 100.0 | 80 | 70.00 | 4.55 |
| | C6 | 7 | 1 | B50-QC-C6-135 | M24 | 63.0 | 135.0 | 96.0 | 100.0 | 80 | 90.00 | 5.49 |
| | C8 | 7 | 1 | B50-QC-C8-150 | M24 | 80.0 | 150.0 | 111.0 | 100.0 | 80 | 130.00 | 6.91 |

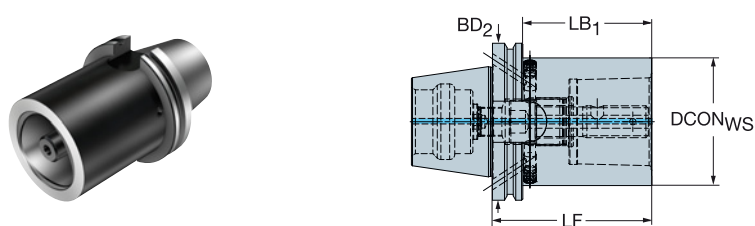
MAS-BT 403 to Coromant Capto® turning adaptor

For Brother Speedio mill-turn



| | | | | | Dimensions, mm | | | | | | |
|-------------------|-------------------|------|------|--------------------|--------------------|------|------|------|-----|----|-----|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{WS} | LF | OAW | OAH | BAR | NM | KG |
| 30 | C4 | 1 | 1 | C4-390.680-30 050Y | 40.0 | 50.0 | 77.0 | 90.0 | 80 | 55 | 1.0 |

MAS-BT short cone to Coromant Capto® adaptor



| | | | | | Dimensions, mm | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|-------|-----------------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG |
| 50 | C8 | 6 | 1 | C8-390.670-50 100 | 80.0 | 100.0 | 62.0 | 100.0 | 150 | 170.00 | 4.43 |

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

M1



N23



N23



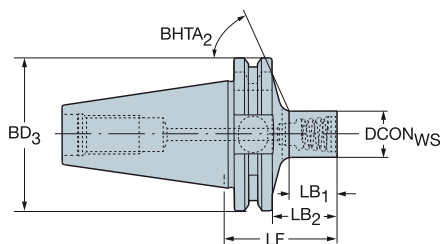
N15

MAS-BT 403 to Coromant EH adaptor

Machine side interface compatible with JIS B 6339

DSGN

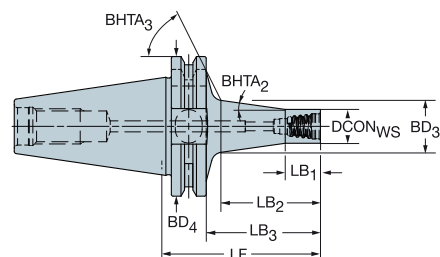
7



| | | | | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|--------------------|------|--------------------|------|-----------------|-----------------|-----------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₃ | BHTA ₂ | BAR | NM | KG | RPMX |
| 30 | E10 | 1 | 1 | 7 | 392.55EH-30 10 044 | M12 | 9.6 | 44.0 | 13.3 | 22.0 | 46.0 | 65° | 80 | 12.00 | 0.51 | 25000 |
| | E12 | 1 | 1 | 7 | 392.55EH-30 12 046 | M12 | 11.6 | 46.0 | 15.6 | 24.0 | 46.0 | 64° | 80 | 15.00 | 0.52 | 25000 |
| | E16 | 1 | 1 | 7 | 392.55EH-30 16 041 | M12 | 15.4 | 41.3 | 8.0 | 19.3 | 46.0 | 49° | 80 | 30.00 | 0.57 | 25000 |
| | E16 | 1 | 1 | 7 | 392.55EH-30 16 052 | M12 | 15.4 | 52.0 | 22.1 | 30.0 | 46.0 | 63° | 80 | 30.00 | 0.58 | 25000 |
| | E16 | 1 | 1 | 7 | 392.55EH-30 16 056 | M12 | 15.4 | 56.3 | 16.0 | 34.3 | 46.0 | 35° | 80 | 30.00 | 0.61 | 25000 |
| 40 | E20 | 1 | 1 | 7 | 392.55EH-30 20 049 | M12 | 19.2 | 49.0 | 19.6 | 27.0 | 46.0 | 61° | 80 | 50.00 | 0.59 | 25000 |
| | E20 | 1 | 1 | 7 | 392.55EH-30 20 069 | M12 | 19.2 | 68.7 | 25.0 | 34.7 | 46.0 | 27° | 80 | 50.00 | 0.66 | 25000 |
| | E25 | 1 | 1 | 7 | 392.55EH-30 25 054 | M12 | 24.1 | 54.0 | 25.2 | 32.0 | 46.0 | 58° | 80 | 65.00 | 0.65 | 25000 |
| | E10 | 1 | 1 | 7 | 392.55EH-40 10 051 | M16 | 9.6 | 51.0 | 13.0 | 24.0 | 63.0 | 67° | 80 | 12.00 | 1.16 | 18000 |
| | E12 | 1 | 1 | 7 | 392.55EH-40 12 054 | M16 | 11.6 | 54.0 | 16.3 | 27.0 | 63.0 | 67° | 80 | 15.00 | 1.18 | 18000 |
| 40 | E16 | 1 | 1 | 7 | 392.55EH-40 16 060 | M16 | 15.4 | 60.0 | 22.8 | 33.0 | 63.0 | 66° | 80 | 30.00 | 1.23 | 18000 |
| | E20 | 1 | 1 | 7 | 392.55EH-40 20 056 | M16 | 19.2 | 56.0 | 19.3 | 29.0 | 63.0 | 66° | 80 | 50.00 | 1.25 | 18000 |
| | E25 | 1 | 1 | 7 | 392.55EH-40 25 062 | M16 | 24.1 | 62.0 | 26.0 | 35.0 | 63.0 | 65° | 80 | 65.00 | 1.30 | 18000 |

DSGN

15



| | | | | | Dimensions, mm | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|--------------------|------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₃ | BD ₄ | BHTA ₂ | BHTA ₃ | BAR | NM | KG | RPMX |
| 30 | E10 | 1 | 1 | 15 | 392.55EH-30 10 057 | M12 | 9.6 | 57.0 | 10.0 | 27.6 | 35.0 | 14.6 | 46.0 | 7° | 65° | 80 | 12.00 | 0.51 | 25000 |
| | E12 | 1 | 1 | 15 | 392.55EH-30 12 063 | M12 | 11.6 | 63.0 | 12.0 | 34.1 | 41.0 | 17.8 | 46.0 | 8° | 64° | 80 | 15.00 | 0.54 | 25000 |
| | E16 | 1 | 1 | 15 | 392.55EH-30 16 074 | M12 | 15.4 | 74.0 | 16.0 | 45.9 | 52.0 | 23.8 | 46.0 | 8° | 61° | 80 | 30.00 | 0.64 | 25000 |
| | E20 | 1 | 1 | 15 | 392.55EH-30 20 086 | M12 | 19.2 | 86.0 | 20.0 | 58.7 | 64.0 | 30.1 | 46.0 | 8° | 56° | 80 | 50.00 | 0.73 | 25000 |
| | E25 | 1 | 1 | 15 | 392.55EH-30 25 077 | M12 | 24.1 | 77.0 | 25.0 | 49.9 | 55.0 | 31.1 | 46.0 | 8° | 55° | 80 | 65.00 | 0.75 | 25000 |
| 40 | E10 | 1 | 1 | 15 | 392.55EH-40 10 065 | M16 | 9.6 | 65.0 | 10.0 | 28.4 | 38.0 | 14.8 | 63.0 | 8° | 68° | 80 | 12.00 | 1.18 | 18000 |
| | E12 | 1 | 1 | 15 | 392.55EH-40 12 070 | M16 | 11.6 | 70.0 | 12.0 | 33.8 | 43.0 | 17.7 | 63.0 | 8° | 67° | 80 | 15.00 | 1.20 | 18000 |
| | E16 | 1 | 1 | 15 | 392.55EH-40 16 081 | M16 | 15.4 | 81.0 | 16.0 | 45.6 | 54.0 | 23.7 | 63.0 | 8° | 66° | 80 | 30.00 | 1.29 | 18000 |
| | E20 | 1 | 1 | 15 | 392.55EH-40 20 094 | M16 | 19.2 | 94.0 | 20.0 | 59.5 | 67.0 | 30.3 | 63.0 | 8° | 65° | 80 | 50.00 | 1.39 | 18000 |
| | E25 | 1 | 1 | 15 | 392.55EH-40 25 108 | M16 | 24.1 | 108.0 | 25.0 | 74.5 | 81.0 | 38.0 | 63.0 | 8° | 62° | 80 | 65.00 | 1.59 | 18000 |

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



N23



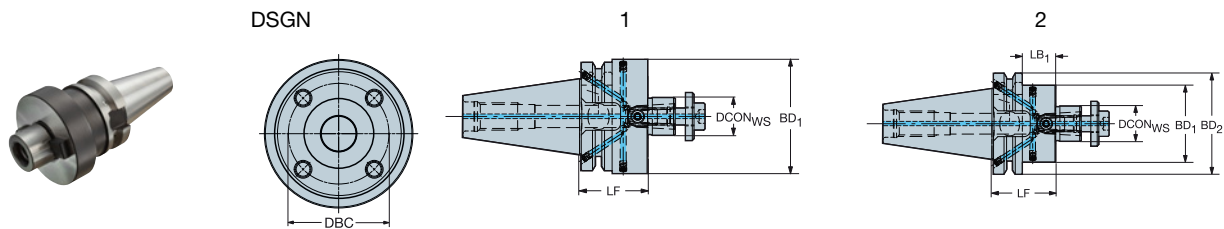
N15



N3

MAS-BT 403 to arbor adaptor

Machine side interface compatible with JIS B 6339



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|-------|------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----|--------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DBC | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 30 | 16 | 1 | 1 | 2 | A205-30 16 035 | | M12 | 16.0 | 35.0 | 13.0 | 35.0 | 36.0 | 46.0 | 80 | 22.00 | 0.54 | 25000 |
| | 22 | 1 | 1 | 2 | A205-30 22 035 | | M12 | 22.0 | 35.0 | 11.9 | 35.0 | 42.0 | 46.0 | 80 | 45.00 | 0.63 | 25000 |
| | 27 | 1 | 1 | 2 | A205-30 27 035 | | M12 | 27.0 | 35.0 | 13.0 | 35.0 | 42.0 | 46.0 | 80 | 80.00 | 0.67 | 25000 |
| | 32 | 1 | 1 | 1 | A205-30 32 050 | | M12 | 32.0 | 50.0 | 50.0 | | 78.0 | | 80 | 180.00 | 1.40 | 25000 |
| 40 | 16 | 7 | 1 | 2 | A2B05-40 16 035 | | M16 | 16.0 | 35.0 | 8.0 | 35.0 | 36.0 | 63.0 | 80 | 22.00 | 0.96 | 18000 |
| | 16 | 7 | 1 | 2 | A2B05-40 16 100 | | M16 | 16.0 | 100.0 | 71.0 | 100.0 | 36.0 | 63.0 | 80 | 22.00 | 1.58 | 18000 |
| | 22 | 7 | 1 | 2 | A2B05-40 22 035 | | M16 | 22.0 | 35.0 | 6.0 | 35.0 | 48.0 | 63.0 | 80 | 45.00 | 1.20 | 18000 |
| | 22 | 7 | 1 | 2 | A2B05-40 22 100 | | M16 | 22.0 | 100.0 | 71.0 | 100.0 | 48.0 | 63.0 | 80 | 45.00 | 2.07 | 18000 |
| | 27 | 7 | 1 | 2 | A2B05-40 27 035 | | M16 | 27.0 | 35.0 | 6.0 | 35.0 | 48.0 | 63.0 | 80 | 80.00 | 1.26 | 18000 |
| | 27 | 7 | 1 | 2 | A2B05-40 27 100 | | M16 | 27.0 | 100.0 | 71.0 | 100.0 | 59.0 | 63.0 | 80 | 80.00 | 2.66 | 18000 |
| | 32 | 7 | 1 | 1 | A2B05-40 32 065 | | M16 | 32.0 | 65.0 | 65.0 | | 78.0 | | 80 | 180.00 | 2.35 | 18000 |
| | 40S | 7 | 1 | 1 | A2B05-40 40 070 | 66.7 | M16 | 40.0 | 70.0 | 70.0 | | 87.0 | | 80 | 300.00 | 3.08 | 18000 |
| 50 | 22 | 7 | 4 | 2 | A2B05-50 22 055 | | M24 | 22.0 | 55.0 | 14.0 | 55.0 | 48.0 | 100.0 | 80 | 45.00 | 4.06 | 12000 |
| | 22 | 7 | 1 | 2 | A2B05-50 22 100 | | M24 | 22.0 | 100.0 | 59.0 | 100.0 | 48.0 | 100.0 | 80 | 45.00 | 4.79 | 12000 |
| | 27 | 7 | 1 | 2 | A2B05-50 27 055 | | M24 | 27.0 | 55.0 | 14.0 | 55.0 | 60.0 | 100.0 | 80 | 80.00 | 4.26 | 12000 |
| | 27 | 7 | 1 | 2 | A2B05-50 27 100 | | M24 | 27.0 | 100.0 | 59.0 | 100.0 | 60.0 | 100.0 | 80 | 80.00 | 5.28 | 12000 |
| | 32 | 7 | 1 | 2 | A2B05-50 32 055 | | M24 | 32.0 | 55.0 | 14.0 | 55.0 | 78.0 | 100.0 | 80 | 180.00 | 4.62 | 12000 |
| | 32 | 7 | 1 | 2 | A2B05-50 32 100 | | M24 | 32.0 | 100.0 | 59.0 | 100.0 | 78.0 | 100.0 | 80 | 180.00 | 6.31 | 12000 |
| | 40S | 7 | 1 | 2 | A2B05-50 40 055 | 66.7 | M24 | 40.0 | 55.0 | 14.0 | 55.0 | 89.0 | 100.0 | 80 | 300.00 | 5.04 | 12000 |
| | 60 | 7 | 1 | 1 | A2F05-50 60 080 | 101.6 | M24 | 60.0 | 80.0 | 80.0 | | 127.0 | | 80 | 180.00 | 7.78 | 12000 |

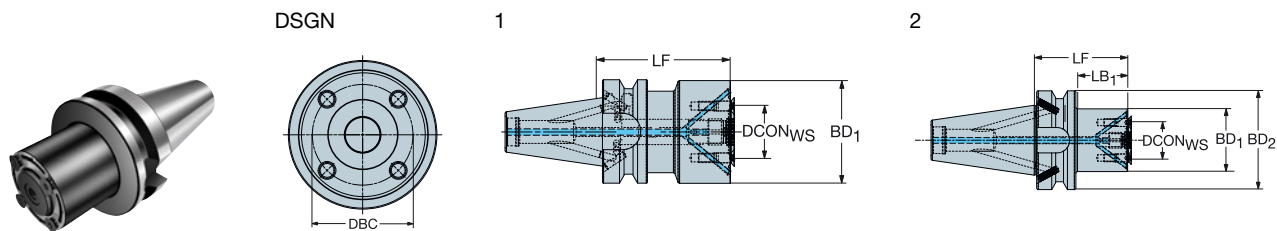
All holders are delivered with a standard screw without hole for coolant.

For cutters with coolant channels a new screw with radial coolant holes is necessary and can be ordered separately.

See page M13

MAS-BT to arbor with driving screws adaptor

Machine side interface compatible with JIS B 6339



| | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|------|------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DBC | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 30 | X10 | 1 | 3 | 2 | B30-X10-032-050 | 22.0 | M12 | 10.0 | 2 | 50.0 | 27.0 | 50.0 | 32.0 | 46.0 | 80 | 6.40 | 0.60 | 12000 |
| | X22 | 1 | 3 | 2 | B30-X22-040-055 | 32.0 | M12 | 22.0 | 2 | 55.0 | 32.0 | 55.0 | 40.0 | 46.0 | 80 | 3.90 | 0.73 | 11000 |
| 40 | X10 | 7 | 3 | 2 | B40-X10-032-055 | 22.0 | M16 | 10.0 | 2 | 55.0 | 27.0 | 55.0 | 32.0 | 63.0 | 80 | 6.40 | 1.18 | 12000 |
| | X22 | 7 | 3 | 2 | B40-X22-040-060 | 32.0 | M16 | 22.0 | 2 | 60.0 | 32.0 | 60.0 | 40.0 | 63.0 | 80 | 3.90 | 1.33 | 11000 |
| | X32 | 7 | 3 | 1 | B40-X32-063-080 | 45.0 | M16 | 32.0 | 2 | 80.0 | 80.0 | | 63.0 | | 80 | 6.40 | 2.28 | 10000 |

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

M1



N23



N15

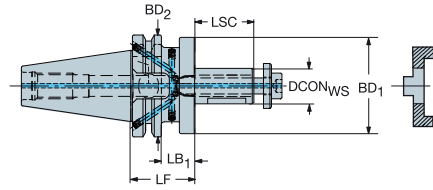
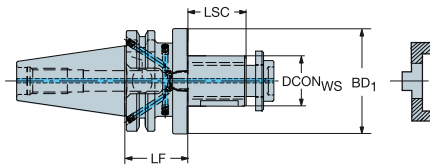
MAS-BT 403 to side and face mill arbor adaptor

Machine side interface compatible with JIS B 6339

DSGN

1

2



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|------|-----------------|------|--------------------|-----|------|-----------------|-----------------|-----------------|-----------------|-----|--------|------|-------|
| 30 | 22 | 1 | 1 | 2 | A208-30 22 047 | M12 | 22.0 | 31 | 35.0 | 13.0 | 35.0 | 40.0 | 46.0 | 80 | 45.00 | 0.71 | 25000 |
| | 27 | 1 | 1 | 1 | A208-30 27 050 | M12 | 27.0 | 33 | 38.0 | 38.0 | | 48.0 | | 80 | 80.00 | 0.87 | 25000 |
| 40 | 22 | 7 | 1 | 2 | A2B08-40 22 055 | M16 | 22.0 | 31 | 43.0 | 12.0 | 43.0 | 40.0 | 63.0 | 80 | 45.00 | 1.35 | 18000 |
| | 27 | 7 | 1 | 2 | A2B08-40 27 055 | M16 | 27.0 | 33 | 43.0 | 15.0 | 43.0 | 48.0 | 63.0 | 80 | 80.00 | 1.51 | 18000 |
| | 32 | 7 | 1 | 2 | A2B08-40 32 060 | M16 | 32.0 | 38 | 46.0 | 18.0 | 46.0 | 58.0 | 63.0 | 80 | 180.00 | 1.86 | 18000 |
| | 40 | 7 | 1 | 1 | A2B08-40 40 070 | M16 | 40.0 | 41 | 56.0 | 56.0 | | 70.0 | | 80 | 300.00 | 2.70 | 18000 |

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M1



N23



N15

MAS-BT 403 to Weldon adaptor

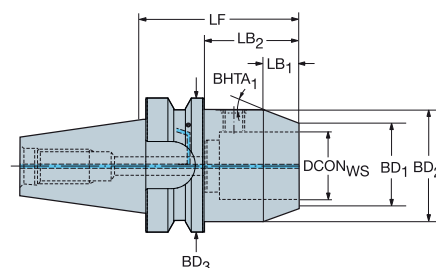
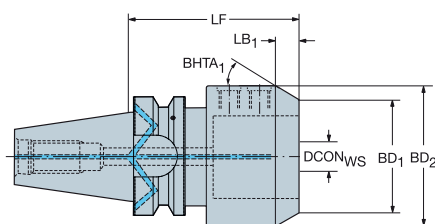
Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN

3

6



| | | | | | | Dimensions, mm | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|-----------------|----------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------|-------|------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | BAR | NM | KG | |
| 30 | 12 | 1 | 1 | 6 | A2B20-30 12 052 | M12 | 12.0 | 52.0 | 12.6 | 28.9 | 52.0 | 27.0 | 41.5 | 46.0 | 30° | 20 | 12.00 | 0.63 | |
| | 16 | 1 | 1 | 3 | A2B20-30 16 063 | M12 | 16.0 | 63.0 | 12.6 | 63.0 | | 33.0 | 47.5 | | 30° | 20 | 15.00 | 0.83 | |
| | 20 | 1 | 1 | 3 | A2B20-30 20 063 | M12 | 20.0 | 63.0 | 12.6 | 63.0 | | 37.0 | 51.5 | | 30° | 20 | 20.00 | 0.87 | |
| 40 | 6 | 7 | 1 | 6 | A2B20-40 06 100 | M16 | 6.0 | 100.0 | 11.0 | 71.0 | 100.0 | 12.3 | 25.0 | 63.0 | 30° | 20 | 3.00 | 1.21 | |
| | 8 | 7 | 1 | 6 | A2B20-40 08 100 | M16 | 8.0 | 100.0 | 11.0 | 71.0 | 100.0 | 15.3 | 28.0 | 63.0 | 30° | 20 | 7.00 | 1.27 | |
| | 10 | 7 | 1 | 6 | A2B20-40 10 100 | M16 | 10.0 | 100.0 | 13.0 | 71.0 | 100.0 | 20.0 | 35.0 | 63.0 | 30° | 20 | 10.00 | 1.44 | |
| | 12 | 7 | 1 | 6 | A2B20-40 12 063 | M16 | 12.0 | 63.0 | 13.0 | 34.0 | 63.0 | 27.0 | 42.0 | 63.0 | 30° | 20 | 12.00 | 1.12 | |
| | 12 | 7 | 1 | 6 | A2B20-40 12 100 | M16 | 12.0 | 100.0 | 13.0 | 71.0 | 100.0 | 27.0 | 42.0 | 63.0 | 30° | 20 | 12.00 | 1.66 | |
| | 16 | 7 | 1 | 6 | A2B20-40 16 063 | M16 | 16.0 | 63.0 | 13.0 | 34.0 | 63.0 | 33.0 | 48.0 | 63.0 | 30° | 20 | 15.00 | 1.35 | |
| | 16 | 7 | 1 | 6 | A2B20-40 16 100 | M16 | 16.0 | 100.0 | 13.0 | 71.0 | 100.0 | 33.0 | 48.0 | 63.0 | 30° | 20 | 15.00 | 1.84 | |
| | 20 | 7 | 1 | 6 | A2B20-40 20 063 | M16 | 20.0 | 63.0 | 13.0 | 34.0 | 63.0 | 37.0 | 52.0 | 63.0 | 30° | 20 | 20.00 | 1.37 | |
| | 20 | 7 | 1 | 6 | A2B20-40 20 100 | M16 | 20.0 | 100.0 | 13.0 | 71.0 | 100.0 | 37.0 | 52.0 | 63.0 | 30° | 20 | 20.00 | 1.96 | |
| | 25 | 7 | 1 | 6 | A2B20-40 25 090 | M16 | 25.0 | 90.0 | 13.0 | 61.0 | 90.0 | 44.0 | 59.0 | 63.0 | 30° | 20 | 25.00 | 1.73 | |
| | 32 | 7 | 1 | 3 | A2B20-40 32 100 | M16 | 32.0 | 100.0 | 13.0 | 100.0 | | 57.0 | 72.0 | | 30° | 20 | 45.00 | 2.40 | |
| 50 | 6 | 7 | 1 | 6 | A2B20-50 06 063 | M24 | 6.0 | 63.0 | 11.0 | 22.0 | 63.0 | 12.3 | 25.0 | 100.0 | 30° | 20 | 3.00 | 3.81 | |
| | 8 | 7 | 1 | 6 | A2B20-50 08 063 | M24 | 8.0 | 63.0 | 11.0 | 22.0 | 63.0 | 15.3 | 28.0 | 100.0 | 30° | 20 | 7.00 | 3.84 | |
| | 10 | 7 | 1 | 6 | A2B20-50 10 070 | M24 | 10.0 | 70.0 | 13.0 | 29.0 | 70.0 | 20.0 | 35.0 | 100.0 | 30° | 20 | 10.00 | 3.90 | |
| | 12 | 7 | 1 | 6 | A2B20-50 12 080 | M24 | 12.0 | 80.0 | 13.0 | 36.0 | 80.0 | 26.8 | 42.0 | 100.0 | 30° | 20 | 12.00 | 4.04 | |
| | 16 | 7 | 1 | 6 | A2B20-50 16 080 | M24 | 16.0 | 80.0 | 13.0 | 39.0 | 80.0 | 33.0 | 48.0 | 100.0 | 30° | 20 | 15.00 | 4.16 | |
| | 20 | 7 | 1 | 6 | A2B20-50 20 080 | M24 | 20.0 | 80.0 | 13.0 | 39.0 | 80.0 | 37.0 | 52.0 | 100.0 | 30° | 20 | 20.00 | 4.18 | |
| | 20 | 7 | 1 | 6 | A2B20-50 20 100 | M24 | 20.0 | 100.0 | 13.0 | 59.0 | 100.0 | 37.0 | 52.0 | 100.0 | 30° | 20 | 20.00 | 4.58 | |
| | 25 | 7 | 1 | 6 | A2B20-50 25 100 | M24 | 25.0 | 100.0 | 13.0 | 59.0 | 100.0 | 50.0 | 65.0 | 100.0 | 30° | 20 | 25.00 | 4.90 | |
| | 25 | 7 | 1 | 6 | A2B20-50 25 160 | M24 | 25.0 | 160.0 | 13.0 | 119.0 | 160.0 | 50.0 | 65.0 | 100.0 | 30° | 20 | 25.00 | 6.62 | |
| | 32 | 7 | 1 | 6 | A2B20-50 32 105 | M24 | 32.0 | 105.0 | 12.0 | 64.0 | 105.0 | 58.1 | 72.0 | 100.0 | 30° | 20 | 45.00 | 5.30 | |
| 32 | 7 | 1 | 6 | A2B20-50 32 160 | M24 | 32.0 | 160.0 | 12.0 | 119.0 | 160.0 | 58.1 | 72.0 | 100.0 | 30° | 20 | 45.00 | 7.20 | | |
| 40 | 7 | 1 | 6 | A2B20-50 40 115 | M24 | 40.0 | 115.0 | 15.0 | 74.0 | 115.0 | 60.7 | 78.0 | 100.0 | 30° | 20 | 45.00 | 5.60 | | |

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M1



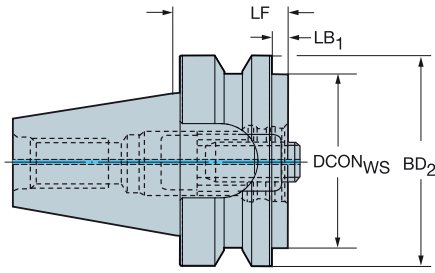
N23



N15

MAS-BT 403 to VL adaptor

Machine side interface compatible with JIS B 6339



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG |
|-------------------|-------------------|------|------|------------------|------|--------------------|------|-----------------|-----------------|-----|--------|------|
| 50 | 80 | 1 | 1 | 390.58-50 80 040 | M24 | 80.0 | 40.0 | 2.0 | 100.0 | 20 | 180.00 | 3.63 |

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



M1



N23



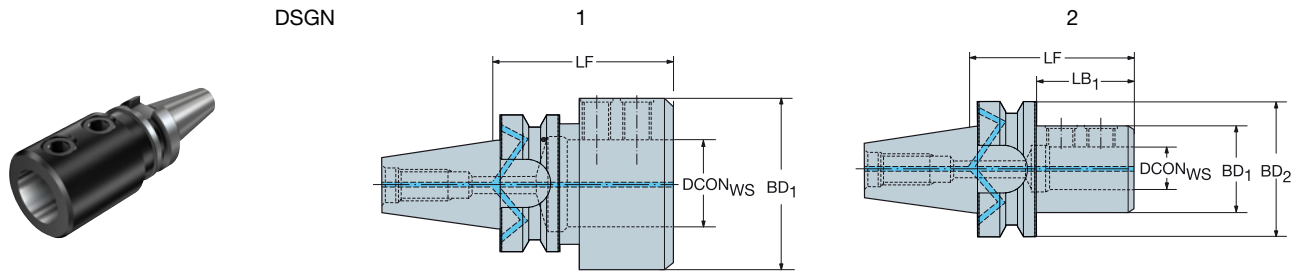
N15

L 80



MAS-BT 403 to ISO 9766 adaptor

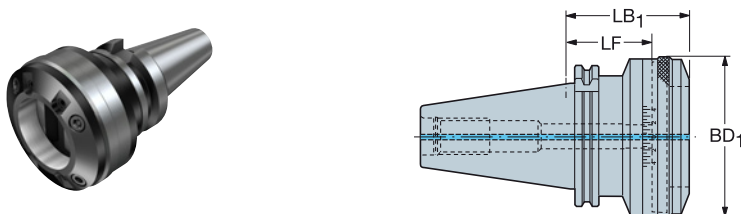
Machine side interface compatible with JIS B 6339



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|-----------------|------|--------------------|-------|-------|-----------------|-----------------|-----------------|-----------------|-------|-------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| 30 | 16 | 1 | 1 | 2 | A227-30 16 080 | M12 | 16.0 | 49 | 80.0 | 58.0 | 80.0 | 36.0 | 46.0 | 20 | 10.00 | 0.76 | 25000 |
| | 20 | 1 | 1 | 2 | A227-30 20 080 | M12 | 20.0 | 51 | 80.0 | 56.9 | 80.0 | 40.0 | 46.0 | 20 | 12.00 | 0.82 | 25000 |
| | 25 | 1 | 1 | 2 | A227-30 25 085 | M12 | 25.0 | 57 | 85.0 | 62.9 | 85.0 | 45.0 | 46.0 | 20 | 20.00 | 0.92 | 25000 |
| | 32 | 1 | 1 | 1 | A227-30 32 090 | M12 | 32.0 | 61 | 90.0 | 90.0 | | 52.0 | | 20 | 30.00 | 1.03 | 25000 |
| 40 | 16 | 7 | 1 | 2 | A2B27-40 16 070 | M16 | 16.0 | 49 | 70.0 | 42.0 | 70.0 | 36.0 | 63.0 | 20 | 10.00 | 1.24 | 18000 |
| | 20 | 7 | 1 | 2 | A2B27-40 20 075 | M16 | 20.0 | 51 | 75.0 | 48.0 | 75.0 | 40.0 | 63.0 | 20 | 12.00 | 1.32 | 18000 |
| | 25 | 7 | 1 | 2 | A2B27-40 25 080 | M16 | 25.0 | 57 | 80.0 | 52.0 | 80.0 | 45.0 | 63.0 | 20 | 20.00 | 1.40 | 18000 |
| | 32 | 7 | 1 | 2 | A2B27-40 32 085 | M16 | 32.0 | 61 | 85.0 | 57.0 | 85.0 | 52.0 | 63.0 | 20 | 30.00 | 1.51 | 18000 |
| 50 | 16 | 7 | 1 | 2 | A2B27-50 16 080 | M24 | 16.0 | 49 | 80.0 | 41.5 | 80.0 | 36.0 | 100.0 | 20 | 10.00 | 3.98 | 12000 |
| | 20 | 7 | 1 | 2 | A2B27-50 20 085 | M24 | 20.0 | 51 | 85.0 | 46.0 | 85.0 | 40.0 | 100.0 | 20 | 12.00 | 3.98 | 12000 |
| | 25 | 7 | 1 | 2 | A2B27-50 25 090 | M24 | 25.0 | 57 | 90.0 | 51.0 | 90.0 | 45.0 | 100.0 | 20 | 20.00 | 4.08 | 12000 |
| | 32 | 7 | 1 | 2 | A2B27-50 32 095 | M24 | 32.0 | 61 | 95.0 | 56.0 | 95.0 | 52.0 | 100.0 | 20 | 30.00 | 4.24 | 12000 |
| | 40 | 7 | 1 | 2 | A2B27-50 40 105 | M24 | 40.0 | 71 | 105.0 | 66.0 | 105.0 | 75.0 | 100.0 | 20 | 40.00 | 5.32 | 12000 |
| 50 | 7 | 1 | 2 | A2B27-50 50 113 | M24 | 50.0 | 81 | 113.0 | 74.0 | 113.0 | 75.0 | 100.0 | 20 | 45.00 | 4.96 | 12000 | |

MAS-BT 403 to ISO 9766 adjustable adaptor

Machine side interface compatible with JIS B 6339



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|----------------------|----------------|--------------------|------|-----------------|-----------------|-----|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₁ | BAR | KG | RPMX | | |
| 40 | 1 | 1 | 1 | 392.55277-40 01 055A | M16 | 78.0 | 55.0 | 79.6 | 86.0 | 20 | 2.38 | 12000 | | |
| 50 | 2 | 1 | 1 | 392.58277-50 02 063A | M24 | 98.0 | 63.0 | 87.6 | 106.0 | 20 | 5.79 | 9000 | | |
| | 3 | 1 | 1 | 392.58277-50 03 080B | M24 | 136.0 | 80.0 | 90.0 | 140.0 | 20 | 7.36 | 6000 | | |

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

M1



N23



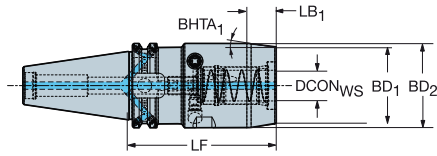
N15

MAS-BT 403 to CoroChuck™ 930

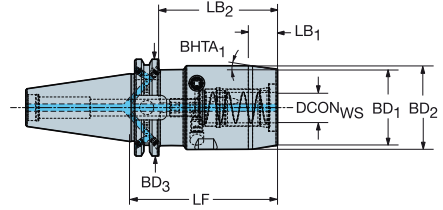
Machine side interface compatible with JIS B 6339

DSGN

3



6

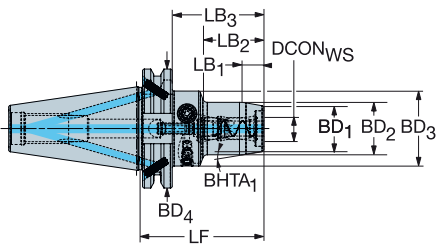


Heavy Duty design

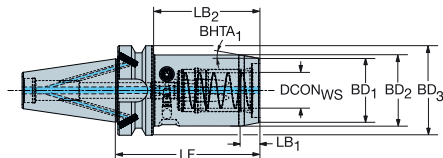
| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-------------------|----------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------|-------|------|-------|--|--|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BHTA ₁ | (BAR) | (NM) | (KG) | RPMX | | | | | |
| 40 | 20 | 7 | 1 | 6 | 930-B40-HD-20-088 | M16 | 20.0 | 51 | 88.0 | 17.8 | 61.0 | 88.0 | 50.0 | 55.0 | 63.0 | 8° | 80 | 10.00 | 1.93 | 18000 | | | | | |
| | 25 | 7 | 1 | 3 | 930-B40-HD-25-094 | M16 | 25.0 | 57 | 94.0 | 18.8 | 94.0 | | 57.0 | 65.0 | | 12° | 80 | 10.00 | 2.39 | 18000 | | | | | |
| 50 | 20 | 7 | 1 | 6 | 930-B50-HD-20-102 | M24 | 20.0 | 51 | 102.0 | 17.8 | 64.0 | 102.0 | 50.0 | 55.0 | 100.0 | 8° | 80 | 10.00 | 4.68 | 12000 | | | | | |
| | 25 | 7 | 1 | 6 | 930-B50-HD-25-106 | M24 | 25.0 | 57 | 106.0 | 18.8 | 68.0 | 106.0 | 57.0 | 65.0 | 100.0 | 12° | 80 | 10.00 | 5.15 | 12000 | | | | | |
| | 32 | 7 | 1 | 6 | 930-B50-HD-32-096 | M24 | 32.0 | 61 | 96.0 | 18.8 | 58.0 | 96.0 | 68.0 | 76.0 | 100.0 | 12° | 80 | 10.00 | 5.23 | 12000 | | | | | |
| | 32 | 7 | 1 | 6 | 930-B50-HD-32-185 | M24 | 32.0 | 61 | 185.0 | 18.8 | 147.0 | 185.0 | 68.0 | 76.0 | 100.0 | 12° | 80 | 10.00 | 8.34 | 12000 | | | | | |

DSGN

10



6



Slender design

| | | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|------------------|--------------------|------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------|------|------|-------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₁ | (BAR) | (NM) | (KG) | RPMX | | | |
| 30 | 6 | 1 | 1 | 6 | 930-B30-S-06-048 | M12 | 6.0 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 22.0 | 26.0 | 46.0 | | 12° | 80 | 8.00 | 0.55 | 25000 | | | |
| | 8 | 1 | 1 | 6 | 930-B30-S-08-048 | M12 | 8.0 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 24.0 | 28.0 | 46.0 | | 12° | 80 | 8.00 | 0.56 | 25000 | | | |
| | 10 | 1 | 1 | 6 | 930-B30-S-10-048 | M12 | 10.0 | 41 | 48.0 | 9.3 | 13.8 | 48.0 | | 26.0 | 30.0 | 46.0 | | 12° | 80 | 8.00 | 0.55 | 25000 | | | |
| | 12 | 1 | 1 | 10 | 930-B30-S-12-082 | M12 | 12.0 | 46 | 82.0 | 11.3 | 38.2 | 60.0 | 82.0 | 28.0 | 32.0 | 40.0 | 46.0 | 10° | 80 | 8.00 | 0.75 | 25000 | | | |
| 40 | 20 | 1 | 1 | 6 | 930-B30-S-20-088 | M12 | 20.0 | 51 | 88.0 | 16.0 | 66.0 | 88.0 | | 38.0 | 42.0 | 46.0 | | 7° | 80 | 8.00 | 0.93 | 25000 | | | |
| | 6 | 7 | 1 | 10 | 930-B40-S-06-075 | M16 | 6.0 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 22.0 | 26.0 | 40.0 | 63.0 | 10° | 80 | 8.00 | 1.21 | 18000 | | | |
| | 8 | 7 | 1 | 10 | 930-B40-S-08-075 | M16 | 8.0 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 24.0 | 28.0 | 40.0 | 63.0 | 10° | 80 | 8.00 | 1.23 | 18000 | | | |
| | 10 | 7 | 1 | 10 | 930-B40-S-10-080 | M16 | 10.0 | 41 | 80.0 | 11.3 | 34.2 | 53.0 | 80.0 | 26.0 | 30.0 | 40.0 | 63.0 | 10° | 80 | 8.00 | 1.27 | 18000 | | | |
| | 12 | 7 | 1 | 10 | 930-B40-S-12-085 | M16 | 12.0 | 46 | 85.0 | 11.3 | 38.2 | 58.0 | 85.0 | 27.9 | 32.0 | 50.0 | 63.0 | 10° | 80 | 8.00 | 1.45 | 18000 | | | |
| | 20 | 7 | 1 | 10 | 930-B40-S-20-094 | M16 | 20.0 | 51 | 94.0 | 16.0 | 49.2 | 67.0 | 94.0 | 37.9 | 42.0 | 50.0 | 63.0 | 7° | 80 | 8.00 | 1.62 | 18000 | | | |
| | 25 | 7 | 1 | 6 | 930-B40-S-25-102 | M16 | 25.0 | 57 | 102.0 | 12.9 | 74.0 | | 102.0 | 45.0 | 50.0 | | 63.0 | 11° | 80 | 8.00 | 1.86 | 18000 | | | |
| | 50 | 20 | 7 | 1 | 10 | 930-B50-S-20-108 | M24 | 20.0 | 51 | 108.0 | 16.0 | 49.2 | 70.0 | 108.0 | 37.9 | 42.0 | 50.0 | 100.0 | 7° | 80 | 8.00 | 4.35 | 12000 | | |
| | | 25 | 7 | 1 | 6 | 930-B50-S-25-114 | M24 | 25.0 | 57 | 114.0 | 12.9 | 73.5 | | 114.0 | 45.0 | 50.0 | | 100.0 | 11° | 80 | 8.00 | 4.59 | 12000 | | |

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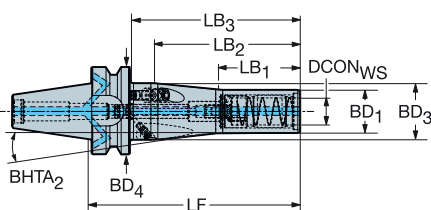
MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

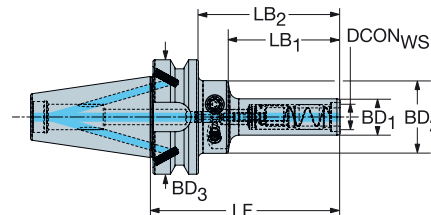
Pencil design

DSGN

11



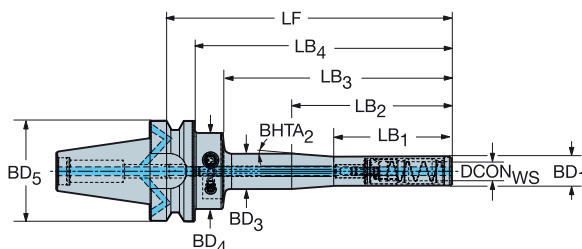
5



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₂ | BD ₃ | BD ₄ | BHTA ₂ | BAR | NM | KG | RPMX | | | |
| 30 | 6 | 1 | 1 | 11 | 930-B30-P-08-088 | M12 | 6.0 | 37 | 88.0 | 45.8 | 52.1 | 66.0 | 88.0 | 14.5 | 14.5 | 40.0 | 46.0 | 0° | 80 | 8.00 | 0.62 | 25000 | | | |
| | 8 | 1 | 1 | 5 | 930-B30-P-08-088 | M12 | 8.0 | 37 | 88.0 | 45.8 | 66.0 | 88.0 | | 17.5 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.59 | 25000 | | | |
| | 10 | 1 | 1 | 5 | 930-B30-P-10-098 | M12 | 10.0 | 41 | 98.0 | 55.8 | 76.0 | 98.0 | | 20.0 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.63 | 25000 | | | |
| | 10 | 1 | 1 | 5 | 930-B30-P-10-138 | M12 | 10.0 | 41 | 138.0 | 95.8 | 116.0 | 138.0 | | 20.0 | 40.0 | 46.0 | | 0° | 80 | 8.00 | 0.73 | 25000 | | | |
| | 12 | 1 | 1 | 11 | 930-B30-P-12-103 | M12 | 12.0 | 46 | 103.0 | 60.8 | 66.4 | 81.0 | 103.0 | 22.0 | 22.0 | 40.0 | 46.0 | 0° | 80 | 8.00 | 0.71 | 25000 | | | |
| | 12 | 1 | 1 | 11 | 930-B30-P-12-138 | M12 | 12.0 | 46 | 138.0 | 95.8 | 101.4 | 116.0 | 138.0 | 22.0 | 22.0 | 40.0 | 46.0 | 0° | 80 | 8.00 | 0.81 | 25000 | | | |
| 40 | 8 | 7 | 1 | 5 | 930-B40-P-08-095 | M16 | 8.0 | 37 | 95.0 | 45.8 | 65.5 | 95.0 | | 17.5 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.20 | 18000 | | | |
| | 10 | 7 | 1 | 5 | 930-B40-P-10-105 | M16 | 10.0 | 41 | 105.0 | 55.8 | 75.5 | 105.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.24 | 18000 | | | |
| | 10 | 7 | 1 | 5 | 930-B40-P-10-145 | M16 | 10.0 | 41 | 145.0 | 95.8 | 115.5 | 145.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.00 | 1.34 | 18000 | | | |
| | 12 | 7 | 1 | 11 | 930-B40-P-12-110 | M16 | 12.0 | 46 | 110.0 | 60.8 | 66.4 | 83.0 | 110.0 | 22.0 | 22.0 | 40.0 | 63.0 | 0° | 80 | 8.00 | 1.32 | 18000 | | | |
| | 12 | 7 | 1 | 11 | 930-B40-P-12-145 | M16 | 12.0 | 46 | 145.0 | 95.8 | 101.4 | 118.0 | 145.0 | 22.0 | 22.0 | 40.0 | 63.0 | 0° | 80 | 8.00 | 1.47 | 18000 | | | |
| | 20 | 7 | 1 | 11 | 930-B40-P-20-153 | M16 | 20.0 | 51 | 153.0 | 60.0 | 108.0 | 126.0 | 153.0 | 32.0 | 32.0 | 42.0 | 63.0 | 6° | 80 | 8.00 | 1.84 | 18000 | | | |

DSGN

17



| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | BAR | NM | KG | RPMX | | | |
| 30 | 12 | 1 | 1 | 17 | 930-B30-P-12-188 | M12 | 12.0 | 46 | 188.0 | 50.0 | 75.0 | 151.1 | 166.0 | 22.0 | 26.0 | 40.0 | 46 | 4° | 80 | 8.00 | 1.10 | 25000 | | | |
| 40 | 12 | 7 | 1 | 17 | 930-B40-P-12-195 | M16 | 12.0 | 46 | 195.0 | 50.0 | 75.0 | 151.1 | 168.0 | 22.0 | 26.0 | 40.0 | 46 | 4° | 80 | 8.00 | 1.72 | 18000 | | | |

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M1



N23



N6



N15



N4

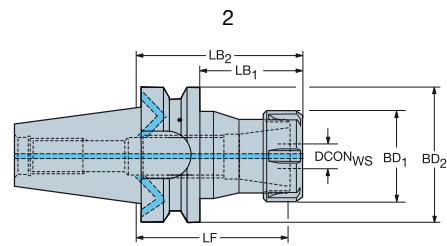
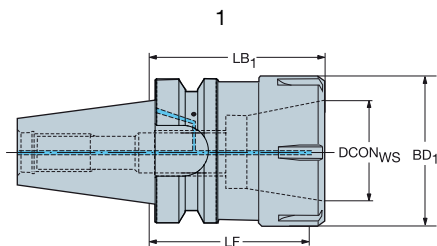


MAS-BT 403 to ER collet chuck

Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6499-B

DSGN



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|-----------------|-----------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|------|------|-------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX | | |
| 30 | ER11 | 1 | 1 | 2 | A2B14-30 11 050 | M12 | 11.4 | 43.7 | 26.9 | 50.0 | 19.0 | 46.0 | 80 | 0.43 | 25000 | | |
| | ER16 | 1 | 1 | 2 | A214-30 16 080 | M12 | 17.0 | 69.7 | 56.9 | 80.0 | 28.0 | 46.0 | 80 | 0.59 | 25000 | | |
| | ER16 | 1 | 1 | 2 | A214-30 16 100 | M12 | 17.0 | 89.7 | 76.9 | 100.0 | 28.0 | 46.0 | 80 | 0.68 | 25000 | | |
| | ER16 | 1 | 1 | 2 | A214-30 16 130 | M12 | 17.0 | 119.7 | 106.9 | 130.0 | 28.0 | 46.0 | 80 | 0.81 | 25000 | | |
| | ER16 | 1 | 1 | 2 | A2B14-30 16 050 | M12 | 17.0 | 39.7 | 26.9 | 50.0 | 27.7 | 46.0 | 80 | 0.46 | 25000 | | |
| | ER20 | 1 | 1 | 2 | A214-30 20 090 | M12 | 21.0 | 78.8 | 66.9 | 90.0 | 34.0 | 46.0 | 80 | 0.73 | 25000 | | |
| | ER20 | 1 | 1 | 2 | A214-30 20 130 | M12 | 21.0 | 118.8 | 106.9 | 130.0 | 34.0 | 46.0 | 80 | 0.99 | 25000 | | |
| | ER20 | 1 | 1 | 2 | A2B14-30 20 050 | M12 | 21.0 | 38.8 | 26.9 | 50.0 | 34.0 | 46.0 | 80 | 0.48 | 25000 | | |
| | ER25 | 1 | 1 | 2 | A214-30 25 100 | M12 | 26.0 | 88.3 | 76.9 | 100.0 | 42.0 | 46.0 | 80 | 0.99 | 25000 | | |
| | ER25 | 1 | 1 | 2 | A214-30 25 130 | M12 | 26.0 | 118.3 | 108.0 | 130.0 | 42.0 | 46.0 | 80 | 1.30 | 25000 | | |
| | ER25 | 1 | 1 | 2 | A2B14-30 25 062 | M12 | 26.0 | 50.3 | 38.9 | 62.0 | 42.0 | 46.0 | 80 | 0.58 | 25000 | | |
| | ER32 | 1 | 1 | 1 | A214-30 32 070 | M12 | 33.0 | 57.3 | 70.0 | | 50.0 | | 80 | 0.70 | 25000 | | |
| | ER32 | 1 | 1 | 1 | A214-30 32 130 | M12 | 33.0 | 117.3 | 130.0 | | 50.0 | | 80 | 1.25 | 25000 | | |
| | 40 | ER16 | 7 | 1 | 2 | A2B14-40 16 070 | M16 | 17.0 | 59.7 | 41.0 | 70.0 | 28.0 | 63.0 | 80 | 1.10 | 18000 | |
| ER16 | | 7 | 1 | 2 | A2B14-40 16 100 | M16 | 17.0 | 89.7 | 71.0 | 100.0 | 28.0 | 63.0 | 80 | 1.25 | 18000 | | |
| ER20 | | 7 | 1 | 2 | A2B14-40 20 070 | M16 | 21.0 | 58.8 | 41.0 | 70.0 | 34.0 | 63.0 | 80 | 1.15 | 18000 | | |
| ER20 | | 7 | 1 | 2 | A2B14-40 20 100 | M16 | 21.0 | 88.8 | 71.0 | 100.0 | 34.0 | 63.0 | 80 | 1.33 | 18000 | | |
| ER25 | | 7 | 1 | 2 | A2B14-40 25 070 | M16 | 26.0 | 58.3 | 41.0 | 70.0 | 42.0 | 63.0 | 80 | 1.22 | 18000 | | |
| ER25 | | 7 | 1 | 2 | A2B14-40 25 100 | M16 | 26.0 | 88.3 | 71.0 | 100.0 | 42.0 | 63.0 | 80 | 1.50 | 18000 | | |
| ER32 | | 7 | 1 | 2 | A2B14-40 32 070 | M16 | 33.0 | 57.3 | 41.0 | 70.0 | 50.0 | 63.0 | 80 | 1.24 | 18000 | | |
| ER40 | | 7 | 1 | 1 | A2B14-40 40 070 | M16 | 41.0 | 55.3 | 70.0 | | 63.0 | | 80 | 1.35 | 18000 | | |
| 50 | ER20 | 7 | 1 | 2 | A2B14-50 20 070 | M24 | 21.0 | 58.8 | 29.0 | 70.0 | 34.0 | 100.0 | 80 | 3.80 | 12000 | | |
| | ER20 | 7 | 1 | 2 | A2B14-50 20 100 | M24 | 21.0 | 88.8 | 59.0 | 100.0 | 34.0 | 100.0 | 80 | 4.11 | 12000 | | |
| | ER25 | 7 | 1 | 2 | A2B14-50 25 070 | M24 | 26.0 | 58.3 | 29.0 | 70.0 | 42.0 | 100.0 | 80 | 3.88 | 12000 | | |
| | ER25 | 7 | 1 | 2 | A2B14-50 25 100 | M24 | 26.0 | 88.3 | 59.0 | 100.0 | 42.0 | 100.0 | 80 | 4.26 | 12000 | | |
| | ER32 | 7 | 1 | 2 | A2B14-50 32 070 | M24 | 33.0 | 57.3 | 28.6 | 70.0 | 50.0 | 100.0 | 80 | 3.84 | 12000 | | |
| | ER32 | 7 | 1 | 2 | A2B14-50 32 100 | M24 | 33.0 | 87.3 | 59.0 | 100.0 | 50.0 | 100.0 | 80 | 4.26 | 12000 | | |
| | ER40 | 7 | 1 | 2 | A2B14-50 40 080 | M24 | 41.0 | 65.3 | 39.0 | 80.0 | 63.0 | 100.0 | 80 | 4.04 | 12000 | | |

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M1



N23

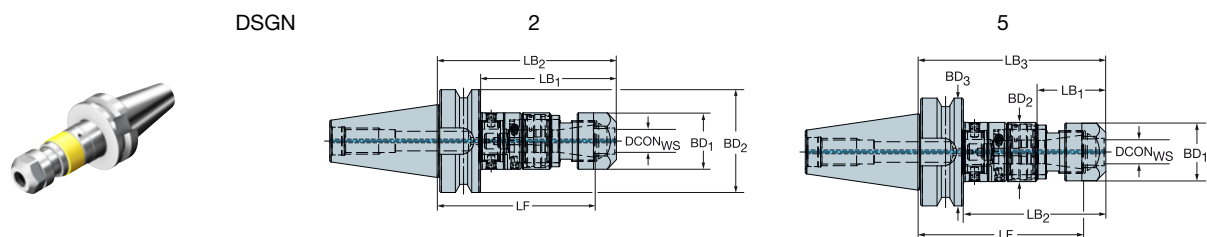


N15

MAS-BT 403 to CoroChuck™ 970

Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6499-B



| | | | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|-------|------|------|------|----------------|----------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|---|--|------|--|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BAR | KG | RPMX | |
| 30 | ER11 | M5 | 1 | 1 | 5 | 970-B30-11-082 | M12 | 11.3 | 78.2 | 24.1 | 60.0 | 82.0 | 18.7 | 23.5 | 46.0 | 80 | 0.55 | 8000 | |
| | ER20 | M12 | 1 | 1 | 5 | 970-B30-20-105 | M12 | 20.8 | 92.2 | 35.3 | 78.1 | 100.2 | 33.7 | 35.0 | 46.0 | 80 | 0.83 | 8000 | |
| | ER25 | M20 | 1 | 1 | 5 | 970-B30-25-125 | M12 | 25.8 | 111.1 | 37.1 | 97.6 | 119.6 | 42.0 | 44.0 | 46.0 | 80 | 1.19 | 8000 | |
| 40 | ER20 | M12 | 1 | 1 | 5 | 970-B40-20-110 | M16 | 20.8 | 97.2 | 35.3 | 78.1 | 105.2 | 33.7 | 35.0 | 63.0 | 80 | 1.42 | 8000 | |
| | ER25 | M20 | 1 | 1 | 5 | 970-B40-25-130 | M16 | 25.8 | 116.1 | 37.1 | 97.6 | 124.6 | 42.0 | 44.0 | 63.0 | 80 | 1.78 | 8000 | |
| | ER32 | M27 | 1 | 1 | 2 | 970-B40-32-133 | M16 | 32.8 | 123.8 | 106.3 | 133.3 | | 50.0 | 63.0 | | 80 | 1.74 | 8000 | |
| 50 | ER20 | M12 | 1 | 1 | 5 | 970-B50-20-125 | M24 | 20.8 | 112.2 | 35.3 | 82.1 | 120.2 | 33.7 | 35.0 | 100.0 | 80 | 4.09 | 8000 | |
| | ER25 | M20 | 1 | 1 | 5 | 970-B50-25-145 | M24 | 25.8 | 131.1 | 37.1 | 101.6 | 139.6 | 42.0 | 44.0 | 100.0 | 80 | 4.47 | 8000 | |
| | ER32 | M27 | 1 | 1 | 2 | 970-B50-32-148 | M24 | 32.8 | 138.8 | 110.3 | 148.3 | | 50.0 | 100.0 | | 80 | 4.33 | 8000 | |
| | ER40 | M30 | 1 | 1 | 2 | 970-B50-40-174 | M24 | 40.8 | 157.2 | 130.6 | 168.6 | | 63.0 | 100.0 | | 80 | 5.90 | 8000 | |

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M1



N23

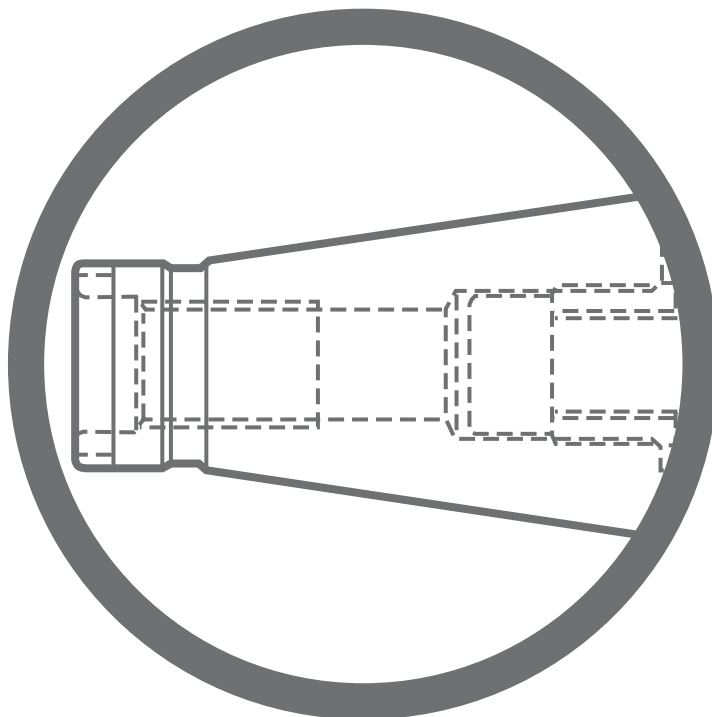


N15

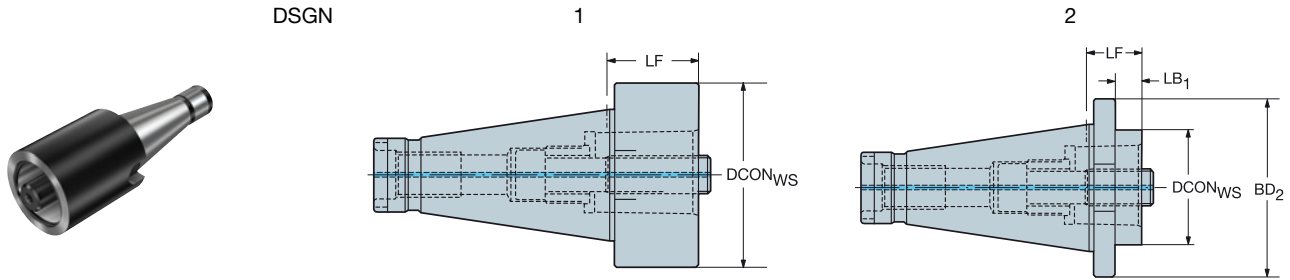


N5

Machine side interface DIN 2080



DIN 2080 to Coromant Capto® adaptor



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|------------------|--------------------|-------|-----------------|-----------------|-----------------|------|--------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | LB ₂ | BD ₂ | BAR | NM | KG |
| 40 | C3 | 1 | 1 | 2 | C3-390.00-40 030 | M16 | 32.0 | 30.0 | 18.4 | 30.0 | 63.0 | 80 | 45.00 | 0.86 |
| | C4 | 1 | 1 | 2 | C4-390.00-40 030 | M16 | 40.0 | 30.0 | 18.4 | 30.0 | 63.0 | 80 | 55.00 | 0.09 |
| | C4 | 1 | 1 | 2 | C4-390.00-40 060 | M16 | 40.0 | 60.0 | 48.4 | 60.0 | 63.0 | 80 | 55.00 | 1.13 |
| | C5 | 1 | 1 | 2 | C5-390.00-40 030 | M16 | 50.0 | 30.0 | 18.4 | 30.0 | 63.0 | 80 | 95.00 | 0.90 |
| | C6 | 1 | 1 | 1 | C6-390.00-40 075 | M16 | 63.0 | 75.0 | 75.0 | | | 80 | 170.00 | 1.87 |
| | 50 | C3 | 1 | 1 | 2 | C3-390.00-50 030 | M24 | 32.0 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 45.00 |
| C3 | | 1 | 1 | 2 | C3-390.00-50 060 | M24 | 32.0 | 60.0 | 44.8 | 60.0 | 97.5 | 80 | 45.00 | 2.89 |
| C4 | | 1 | 1 | 2 | C4-390.00-50 030 | M24 | 40.0 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 55.00 | 2.79 |
| C4 | | 1 | 1 | 2 | C4-390.00-50 060 | M24 | 40.0 | 60.0 | 44.8 | 60.0 | 97.5 | 80 | 55.00 | 3.01 |
| C5 | | 1 | 1 | 2 | C5-390.00-50 030 | M24 | 50.0 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 95.00 | 2.76 |
| C5 | | 1 | 1 | 2 | C5-390.00-50 070 | M24 | 50.0 | 70.0 | 54.8 | 70.0 | 97.5 | 80 | 95.00 | 3.28 |
| C6 | | 1 | 1 | 2 | C6-390.00-50 030 | M24 | 63.0 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 170.00 | 2.72 |
| C6 | | 1 | 1 | 2 | C6-390.00-50 080 | M24 | 63.0 | 80.0 | 64.8 | 80.0 | 97.5 | 80 | 170.00 | 3.82 |
| C8 | | 1 | 1 | 2 | C8-390.00-50 070 | M24 | 80.0 | 70.0 | 54.8 | 70.0 | 97.5 | 80 | 170.00 | 3.98 |
| C8 | | 1 | 1 | 2 | C8-390.00-50 120 | M24 | 80.0 | 120.0 | 104.8 | 120.0 | 97.5 | 80 | 170.00 | 5.84 |

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

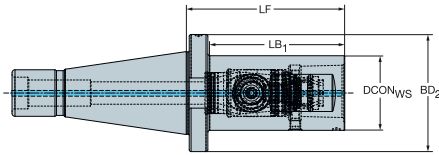
N23



N15

DIN 2080 to Coromant Capto® adaptor with Quick change

ENG

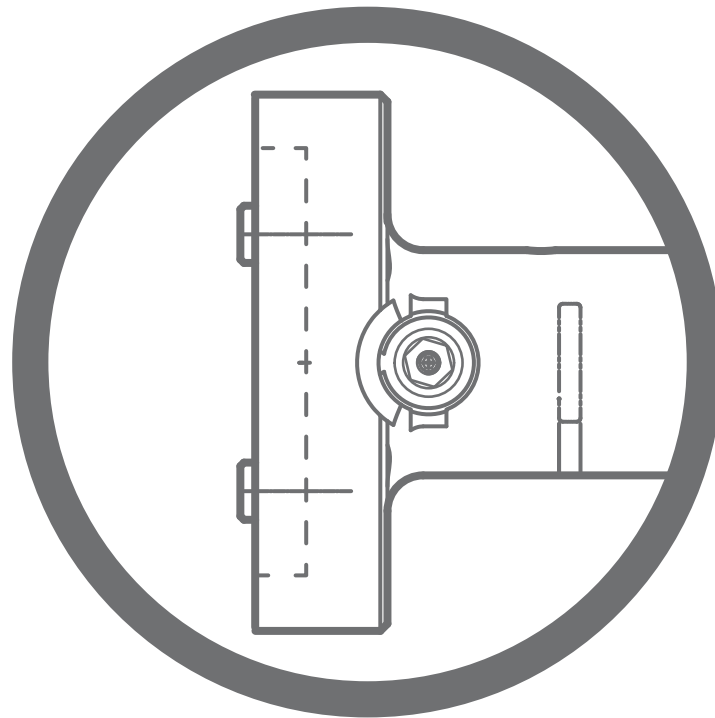


| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|----------------|----------------|--------------------|-------|-----------------|-----------------|-----|--------|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | CRKS | DCON _{WS} | LF | LB ₁ | BD ₂ | BAR | NM | KG |
| 40 | C5 | 1 | 1 | DN40-QC-C5-095 | M16 | 50.0 | 95.0 | 83.4 | 62.8 | 80 | 70.00 | 1.70 |
| 50 | C8 | 1 | 1 | DN50-QC-C8-140 | M24 | 80.0 | 140.0 | 124.8 | 97.3 | 80 | 130.00 | 6.30 |

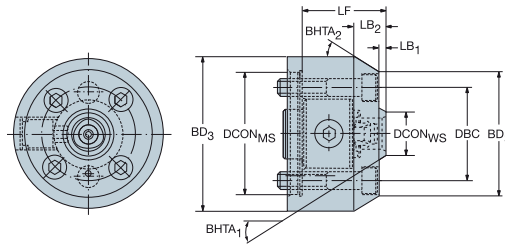
For spare parts, visit www.sandvik.coromant.com



Machine side interface DIN 2079

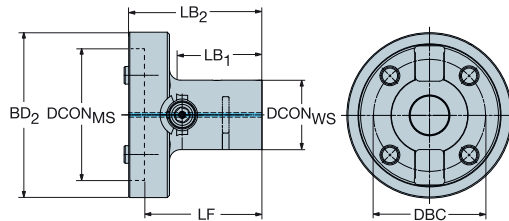


DIN 2079 to Coromant Capto® adaptor



| | | Dimensions, mm | | | | | | | | | | | | |
|-------|-------|---------------------|--------|------|--------|------|-----|------|------|-------|-------|-------|-------|------|
| CZCMS | CZCWS | Ordering code | DCONMS | DBC | DCONWS | LF | LB1 | LB2 | BD2 | BD3 | BHTA1 | BHTA2 | NM | KG |
| 40 | C3 | C3-390.34705-40 060 | 88.8 | 66.7 | 32.0 | 60.0 | 5.0 | 22.3 | 90.0 | 110.0 | 30° | 30° | 35.00 | 3.99 |
| | C4 | C4-390.34705-40 070 | 88.8 | 66.7 | 40.0 | 70.0 | 5.0 | 22.3 | 90.0 | 110.0 | 30° | 30° | 15.00 | 5.00 |

DIN 2079 to Coromant Capto® adaptor with Quick change

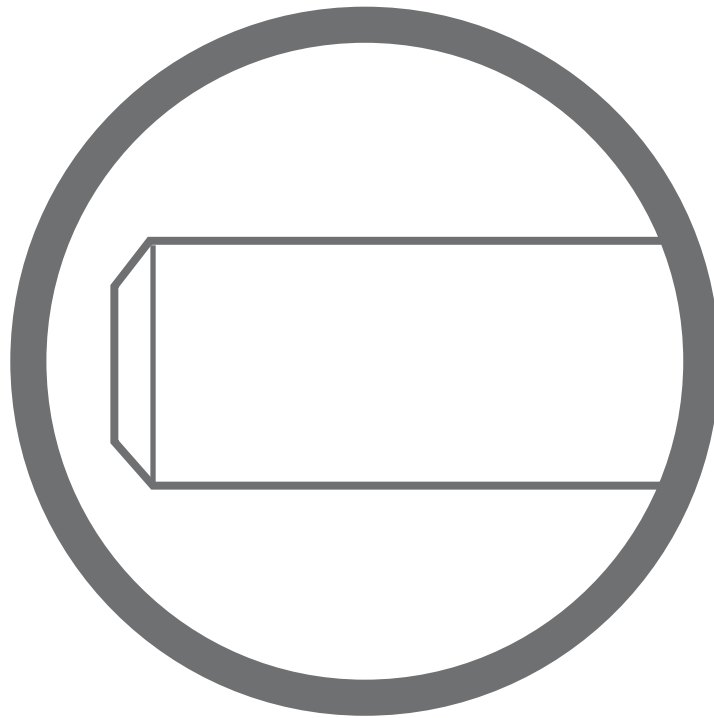


| | | Dimensions, mm | | | | | | | | | | | | | |
|-------|-------|----------------|------|----------------|--------|-------|--------|-------|-------|-------|-------|-----|--------|------|--|
| CZCMS | CZCWS | CNSC | CXSC | Ordering code | DCONMS | DBC | DCONWS | LF | LB1 | LB2 | BD2 | BAR | NM | KG | |
| 40 | C5 | 1 | 1 | SI40-QC-C5-090 | 88.8 | 66.7 | 50.0 | 90.0 | 70.0 | 102.0 | 110.0 | 80 | 70.00 | 2.30 | |
| 50 | C6 | 1 | 1 | SI50-QC-C6-105 | 128.5 | 101.6 | 63.0 | 105.0 | 74.0 | 121.0 | 150.0 | 80 | 90.00 | 5.00 | |
| | C8 | 3 | 1 | SI50-QC-C8-135 | 128.5 | 101.6 | 80.0 | 135.0 | 104.0 | 151.0 | 150.0 | 80 | 130.00 | 6.89 | |

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

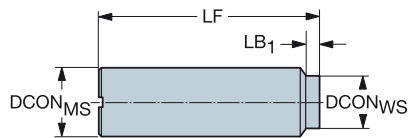


Machine side interface Cylindrical shank



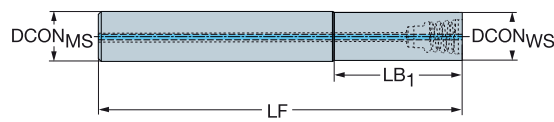
Cylindrical shank to Coromant EH adaptor

Straight design



Steel shank

| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|----------------|--------------------|--------------------|-----|-------|-----------------|-----|-------|------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BAR | NM | KG | RPMX | |
| 10 | E10 | 1 | 1 | E10-A10-SS-075 | 10.0 | 9.6 | 54 | 75.0 | 20.0 | 80 | 12.00 | 0.09 | 40000 | |
| 12 | E12 | 1 | 1 | E12-A12-SS-100 | 12.0 | 11.6 | 77 | 100.0 | 22.0 | 80 | 15.00 | 0.14 | 31000 | |
| 16 | E10 | 1 | 1 | E10-A16-SS-065 | 16.0 | 9.6 | 57 | 65.0 | 5.0 | 80 | 12.00 | 0.14 | 40000 | |
| | E12 | 1 | 1 | E12-A16-SS-065 | 16.0 | 11.6 | 58 | 65.0 | 5.0 | 80 | 15.00 | 0.15 | 40000 | |
| 20 | E16 | 1 | 1 | E16-A20-SS-070 | 20.0 | 15.4 | 63 | 70.0 | 5.0 | 80 | 30.00 | 0.26 | 40000 | |
| | E16 | 1 | 1 | E16-A20-SS-110 | 20.0 | 15.4 | 83 | 110.0 | 25.0 | 80 | 30.00 | 0.33 | 40000 | |
| | E20 | 1 | 1 | E20-A20-SS-120 | 20.0 | 19.2 | 89 | 120.0 | 30.0 | 80 | 50.00 | 0.38 | 34000 | |
| 25 | E20 | 1 | 1 | E20-A25-SS-080 | 25.0 | 19.2 | 73 | 80.0 | 5.0 | 80 | 50.00 | 0.39 | 40000 | |
| | E25 | 1 | 1 | E25-A25-SS-140 | 25.0 | 24.1 | 99 | 140.0 | 40.0 | 80 | 65.00 | 0.63 | 25000 | |
| 32 | E25 | 1 | 1 | E25-A32-SS-080 | 32.0 | 24.1 | 73 | 80.0 | 5.0 | 80 | 65.00 | 0.62 | 40000 | |



Heavy metal shank

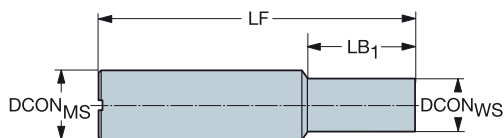
| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BAR | KG | RPMX | | |
| 10 | E10 | 1 | 1 | EH10-A10-SH-100 | 10.0 | 9.6 | 79 | 100.0 | 20.0 | 80 | 0.18 | 26000 | | |
| 12 | E12 | 1 | 1 | EH12-A12-SH-110 | 12.0 | 11.6 | 84 | 110.0 | 25.0 | 80 | 0.26 | 25000 | | |
| 16 | E16 | 1 | 1 | EH16-A16-SH-130 | 16.0 | 15.4 | 94 | 130.0 | 35.0 | 80 | 0.52 | 22000 | | |
| 20 | E20 | 1 | 1 | EH20-A20-SH-160 | 20.0 | 19.2 | 114 | 160.0 | 45.0 | 80 | 0.92 | 17000 | | |
| 25 | E25 | 1 | 1 | EH25-A25-SH-185 | 25.0 | 24.1 | 119 | 185.0 | 65.0 | 80 | 1.58 | 16000 | | |

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



Cylindrical shank to Coromant EH adaptor

Straight design



Cemented carbide shank

| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|----------------|--------------------|--------------------|-----|-------|-----------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BAR | NM | KG | RPMX |
| 10 | E10 | 1 | 1 | E10-A10-SE-100 | 10.0 | 9.6 | 49 | 100.0 | 50.0 | 80 | 12.00 | 0.15 | 35000 |
| 12 | E12 | 1 | 1 | E12-A12-SE-100 | 12.0 | 11.6 | 51 | 100.0 | 48.0 | 80 | 15.00 | 0.20 | 40000 |
| 16 | E16 | 1 | 1 | E16-A16-SE-135 | 16.0 | 15.4 | 54 | 135.0 | 80.0 | 80 | 30.00 | 0.44 | 27000 |
| 20 | E20 | 1 | 1 | E20-A20-SE-095 | 20.0 | 19.2 | 56 | 95.0 | 38.0 | 80 | 50.00 | 0.46 | 40000 |
| | E20 | 1 | 1 | E20-A20-SE-180 | 20.0 | 19.2 | 69 | 180.0 | 110.0 | 80 | 50.00 | 0.82 | 20000 |
| 25 | E25 | 1 | 1 | E25-A25-SE-200 | 25.0 | 24.1 | 79 | 200.0 | 120.0 | 80 | 65.00 | 1.36 | 19000 |

Note!

Cemented carbide shank to be used for Finishing/Semi finishing only

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



N23



N6



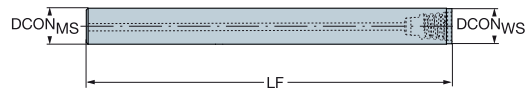
N15



N3

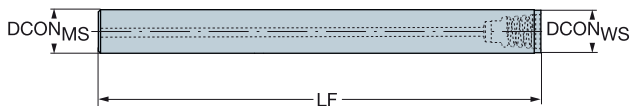
Cylindrical shank to Coromant EH adaptor

Straight design



G-undersized steel shank

| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-----|-------|-----|------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | BAR | KG | RPMX | | |
| 9 | E10 | 1 | 1 | EH10-A09.7-SS-080 | 9.7 | 9.6 | 78 | 80.0 | 80 | 0.10 | 40000 | | |
| 11 | E12 | 1 | 1 | EH12-A11.7-SS-085 | 11.7 | 11.6 | 83 | 85.0 | 80 | 0.12 | 40000 | | |
| 15 | E16 | 1 | 1 | EH16-A15.7-SS-100 | 15.7 | 15.4 | 97 | 100.0 | 80 | 0.24 | 40000 | | |
| 19 | E20 | 1 | 1 | EH20-A19.7-SS-120 | 19.7 | 19.2 | 117 | 120.0 | 80 | 0.38 | 40000 | | |
| 24 | E25 | 1 | 1 | EH25-A24.7-SS-135 | 24.7 | 24.1 | 132 | 135.0 | 80 | 0.56 | 40000 | | |



G-undersized heavy metal shank

| | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-----|-------|-----|-------|-------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | BAR | NM | KG | RPMX | |
| 9 | E10 | 1 | 1 | EH10-A09.7-SH-120 | 9.7 | 9.6 | 117 | 120.0 | 80 | 0.20 | 19000 | | |
| | E10 | 1 | 1 | EH10-A09.7-SH-100 | 9.7 | 9.6 | 97 | 100.0 | 80 | 12.00 | 0.17 | 23000 | |
| 11 | E12 | 1 | 1 | EH12-A11.7-SH-135 | 11.7 | 11.6 | 132 | 135.0 | 80 | 0.29 | 17000 | | |
| | E12 | 1 | 1 | EH12-A11.7-SH-110 | 11.7 | 11.6 | 107 | 110.0 | 80 | 15.00 | 0.25 | 23000 | |
| 15 | E16 | 1 | 1 | EH16-A15.7-SH-160 | 15.7 | 15.4 | 156 | 160.0 | 80 | 0.61 | 15000 | | |
| | E16 | 1 | 1 | EH16-A15.7-SH-130 | 15.7 | 15.4 | 126 | 130.0 | 80 | 30.00 | 0.51 | 19000 | |
| 19 | E20 | 1 | 1 | EH20-A19.7-SH-200 | 19.7 | 19.2 | 196 | 200.0 | 80 | 1.15 | 12000 | | |
| | E20 | 1 | 1 | EH20-A19.7-SH-160 | 19.7 | 19.2 | 156 | 160.0 | 80 | 50.00 | 0.91 | 19000 | |
| 24 | E25 | 1 | 1 | EH25-A24.7-SH-235 | 24.7 | 24.1 | 231 | 235.0 | 80 | 1.99 | 10500 | | |
| | E25 | 1 | 1 | EH25-A24.7-SH-185 | 24.7 | 24.1 | 181 | 185.0 | 80 | 65.00 | 1.58 | 14000 | |

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



N23



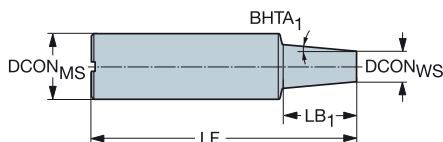
N15



N3

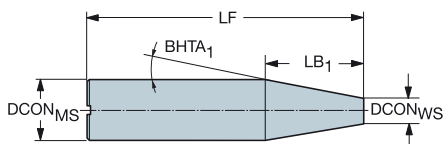
Cylindrical shank to Coromant EH adaptor

Conical design



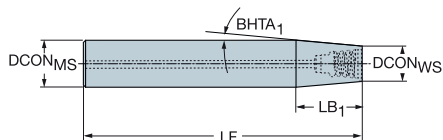
Steel shank

| | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|----------------|----------------|----------------|--------------------|--------------------|-------|-------|-----------------|-------------------|-------|-------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BHTA ₁ | BAR | NM | KG | RPMX |
| 16 | E10 | 1 | 1 | E10-A16-CS-140 | 16.0 | 9.6 | 103 | 140.0 | 36.6 | 5° | 80 | 12.00 | 0.24 | 16000 |
| | E10 | 1 | 1 | E10-A16-CS-160 | 16.0 | 9.6 | 108 | 160.0 | 50.0 | 1° | 80 | 12.00 | 0.24 | 12000 |
| | E12 | 1 | 1 | E12-A16-CS-140 | 16.0 | 11.6 | 115 | 140.0 | 25.1 | 5° | 80 | 15.00 | 0.25 | 16000 |
| 20 | E12 | 1 | 1 | E12-A16-CS-170 | 16.0 | 11.6 | 108 | 170.0 | 60.0 | 1° | 80 | 15.00 | 0.30 | 12000 |
| | E16 | 1 | 1 | E16-A20-CS-190 | 20.0 | 15.4 | 112 | 190.0 | 75.0 | 1° | 80 | 30.00 | 0.49 | 13000 |
| 25 | E16 | 1 | 1 | E16-A25-CS-170 | 25.0 | 15.4 | 115 | 170.0 | 54.9 | 5° | 80 | 30.00 | 0.66 | 18000 |
| 32 | E10 | 1 | 1 | E10-A32-CS-250 | 32.0 | 9.6 | 186 | 250.0 | 63.5 | 10° | 80 | 12.00 | 1.39 | 10000 |
| | E12 | 1 | 1 | E12-A32-CS-250 | 32.0 | 11.6 | 192 | 250.0 | 57.8 | 10° | 80 | 15.00 | 1.50 | 10000 |
| | E20 | 1 | 1 | E20-A32-CS-180 | 32.0 | 19.2 | 107 | 180.0 | 73.2 | 5° | 80 | 50.00 | 1.06 | 20000 |
| E25 | 1 | 1 | E25-A32-CS-200 | 32.0 | 24.1 | 154 | 200.0 | 45.1 | 5° | 80 | 65.00 | 1.29 | 15000 | |



Steel shank

| | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-------------------|-----|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BHTA ₁ | BAR | KG | RPMX |
| 20 | E16 | 1 | 1 | EH16-A20-CS-165 | 20.0 | 15.4 | 138 | 165.0 | 26.3 | 5° | 80 | 0.44 | 27000 |
| 25 | E20 | 1 | 1 | EH20-A25-CS-200 | 25.0 | 19.2 | 120 | 200.0 | 80.0 | 1° | 80 | 0.70 | 19000 |



Cemented carbide shank

| | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|----------------|-----------------|-----------------|--------------------|--------------------|-------|-------|-----------------|-------------------|-------|-------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BHTA ₁ | BAR | NM | KG | RPMX |
| 16 | E10 | 1 | 1 | EH10-A16-CE-140 | 16.0 | 9.6 | 103 | 140.0 | 36.6 | 5° | 80 | | 0.41 | 36000 |
| | E12 | 1 | 1 | EH12-A16-CE-165 | 16.0 | 11.6 | 139 | 165.0 | 25.1 | 5° | 80 | | 0.50 | 23000 |
| | E10 | 1 | 1 | E10-A16-CE-155 | 16.0 | 9.6 | 52 | 155.0 | 100.0 | 1° | 80 | 12.00 | 0.34 | 22000 |
| 20 | E12 | 1 | 1 | E12-A16-CE-150 | 16.0 | 11.6 | 58 | 150.0 | 90.0 | 1° | 80 | 15.00 | 0.39 | 23000 |
| | E16 | 1 | 1 | EH16-A20-CE-165 | 20.0 | 15.4 | 138 | 165.0 | 26.3 | 5° | 80 | | 0.78 | 27000 |
| 25 | E16 | 1 | 1 | E16-A20-CE-175 | 20.0 | 15.4 | 55 | 175.0 | 118.0 | 1° | 80 | 30.00 | 0.72 | 22000 |
| | E20 | 1 | 1 | EH20-A25-CE-150 | 25.0 | 19.2 | 116 | 150.0 | 33.1 | 5° | 80 | 50.00 | 1.05 | 23000 |
| 32 | E20 | 1 | 1 | EH20-A25-CE-200 | 25.0 | 19.2 | 117 | 200.0 | 83.0 | 2° | 80 | 50.00 | 1.08 | 19000 |
| | E20 | 1 | 1 | EH20-A32-CE-175 | 32.0 | 19.2 | 101 | 175.0 | 73.2 | 5° | 80 | 50.00 | 1.78 | 21000 |
| | E25 | 1 | 1 | EH25-A32-CE-190 | 32.0 | 24.1 | 144 | 190.0 | 45.1 | 5° | 80 | 65.00 | 2.07 | 20000 |
| E25 | 1 | 1 | EH25-A32-CE-215 | 32.0 | 24.1 | 169 | 215.0 | 45.1 | 5° | 80 | 65.00 | 2.41 | 18000 | |

Note!

Cemented carbide shank to be used for Finishing/Semi finishing only

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



N23



N6



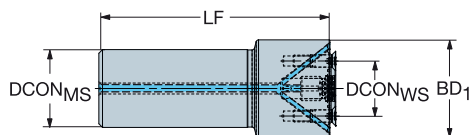
N15



N3

Cylindrical shank to arbor with driving screws adaptor

For CoroMill® QD with internal coolant supply



| | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|------|--------------------|-----|------|-----------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LSC | LF | BD ₁ | BAR | NM | KG | RPMX |
| 25 | X10 | 1 | 3 | CY25-X10-032-090 | 25.0 | 22.0 | 10.0 | 57 | 90.0 | 32.0 | 80 | 6.40 | 0.42 | 12000 |
| | X22 | 1 | 3 | CY25-X22-040-090 | 25.0 | 32.0 | 22.0 | 57 | 90.0 | 40.0 | 80 | 3.90 | 0.53 | 11000 |
| 32 | X22 | 1 | 3 | CY32-X22-040-095 | 32.0 | 32.0 | 22.0 | 61 | 95.0 | 40.0 | 80 | 3.90 | 0.71 | 11000 |



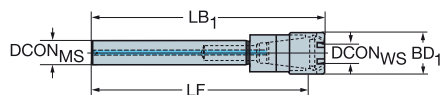
N23



N15

Cylindrical shank to ER collet chuck

Workpiece side interface DIN 6499-B



| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----|------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BD ₁ | BAR | KG |
| 8 | ER11 | 1 | 1 | 393.14-08 11 056 | 8.0 | 11.4 | 52 | 75.0 | 82.5 | 16.0 | 20 | 0.05 |
| 12 | ER16 | 1 | 1 | 393.14-12 16 080 | 12.0 | 17.0 | 77 | 107.0 | 118.5 | 22.0 | 20 | 0.13 |
| 16 | ER11 | 1 | 1 | 393.14-16 11 150 | 16.0 | 11.4 | 149 | 163.5 | 171.0 | 16.0 | 20 | 0.21 |
| 20 | ER16 | 1 | 1 | 393.14-20 16 155 | 20.0 | 17.0 | 155 | 170.0 | 181.5 | 22.0 | 20 | 0.31 |
| 25 | ER20 | 1 | 1 | 393.14-25 20 170A | 25.0 | 21.0 | 141 | 170.5 | 182.0 | 28.0 | 20 | 0.51 |

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



M1



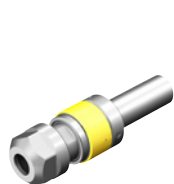
N23



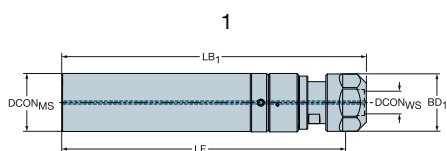
N15

Cylindrical shank to CoroChuck™ 970

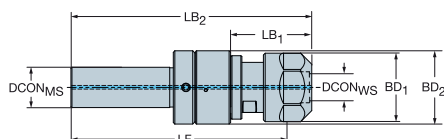
Workpiece side interface DIN 6499-B



DSGN



2



| | | | | | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|-------|------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----|------|------|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | KG | RPMX |
| 12 | ER8 | M3 | 1 | 1 | 1 | 970-CY12-8-052 | 12.0 | 8.5 | 70 | 94.0 | 100.0 | | 12.0 | | 60 | 0.12 | 8000 |
| 16 | ER11 | M5 | 1 | 1 | 2 | 970-CY16-11-052 | 16.0 | 11.3 | 44 | 91.5 | 25.2 | 96.4 | 18.7 | 23.5 | 80 | 0.16 | 8000 |
| 20 | ER20 | M12 | 1 | 1 | 2 | 970-CY20-20-069 | 20.0 | 20.8 | 50 | 106.5 | 40.2 | 119.5 | 34.0 | 34.6 | 80 | 0.44 | 8000 |

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



M1



N23

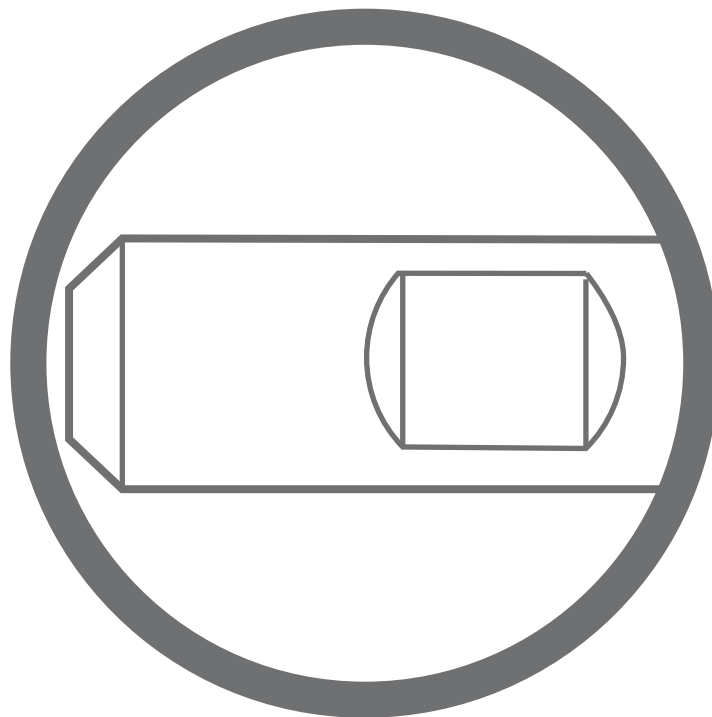


N15

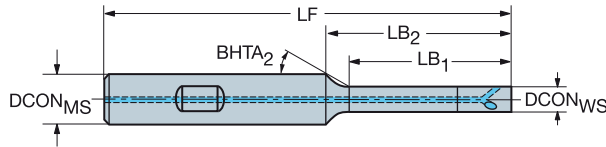


N5

Machine side interface Weldon shank



Weldon to CoroMill® 327 adaptor



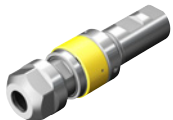
| | | Dimensions, mm | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-------------------|-------|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BHTA ₂ | (BAR) | (NM) | (KG) | RPMX |
| 12 | 06 | 1 | 1 | 327-12B15SC-06 | 12.0 | 6.0 | 46 | 70.5 | 11.5 | 17.2 | 6.0 | 30° | 20 | 1.80 | 0.07 | 40000 |
| | 06 | 1 | 1 | 327-12B21EC-06 | 12.0 | 6.0 | 46 | 76.5 | 17.5 | 23.2 | 6.0 | 30° | 20 | 1.80 | 0.13 | 40000 |
| | 06 | 1 | 1 | 327-12B30EC-06 | 12.0 | 6.0 | 46 | 86.5 | 26.5 | 32.2 | 6.0 | 30° | 20 | 1.80 | 0.13 | 40000 |
| | 06 | 1 | 1 | 327-12B42EC-06 | 12.0 | 6.0 | 46 | 96.5 | 38.5 | 44.2 | 6.0 | 30° | 20 | 1.80 | 0.13 | 40000 |
| 16 | 09 | 1 | 1 | 327-16B18SC-09 | 16.0 | 9.0 | 49 | 74.3 | 12.2 | 18.8 | 9.0 | 30° | 20 | 4.30 | 0.19 | 40000 |
| | 12 | 1 | 1 | 327-16B24SC-12 | 16.0 | 12.0 | 49 | 74.3 | 18.3 | 22.3 | 12.0 | 30° | 20 | 6.50 | 0.10 | 40000 |
| | 09 | 1 | 1 | 327-16B32EC-09 | 16.0 | 9.0 | 49 | 94.3 | 26.2 | 32.8 | 9.0 | 30° | 20 | 4.30 | 0.27 | 40000 |
| | 09 | 1 | 1 | 327-16B45EC-09 | 16.0 | 9.0 | 49 | 104.3 | 39.2 | 45.8 | 9.0 | 30° | 20 | 4.30 | 0.20 | 40000 |
| | 09 | 1 | 1 | 327-16B64EC-09 | 16.0 | 9.0 | 49 | 124.3 | 58.2 | 64.8 | 9.0 | 30° | 20 | 4.30 | 0.30 | 40000 |
| | 12 | 1 | 1 | 327-16B42EC-12 | 16.0 | 12.0 | 49 | 94.3 | 36.3 | 40.3 | 12.0 | 30° | 20 | 6.50 | 0.28 | 40000 |
| | 12 | 1 | 1 | 327-16B60EC-12 | 16.0 | 12.0 | 49 | 124.3 | 54.3 | 58.3 | 12.0 | 30° | 20 | 6.50 | 0.34 | 35000 |
| | 12 | 1 | 1 | 327-16B85EC-12 | 16.0 | 12.0 | 49 | 154.3 | 79.3 | 83.3 | 12.0 | 30° | 20 | 6.50 | 0.39 | 30000 |
| | 14 | 1 | 1 | 327-16B42EC-14 | 16.0 | 14.3 | 49 | 93.5 | 35.5 | 37.5 | 14.3 | 30° | 20 | 6.50 | 0.30 | 40000 |
| | 14 | 1 | 1 | 327-16B60EC-14 | 16.0 | 14.3 | 49 | 123.5 | 53.5 | 55.5 | 14.3 | 30° | 20 | 6.50 | 0.37 | 35000 |
| | 14 | 1 | 1 | 327-16B85EC-14 | 16.0 | 14.3 | 49 | 153.5 | 78.5 | 80.5 | 14.3 | 30° | 20 | 6.50 | 0.47 | 27000 |
| 20 | 14 | 1 | 1 | 327-20B35SC-14 | 20.0 | 14.3 | 51 | 93.5 | 28.5 | 33.2 | 14.0 | 30° | 20 | 6.50 | 0.28 | 40000 |

S = Steel shank

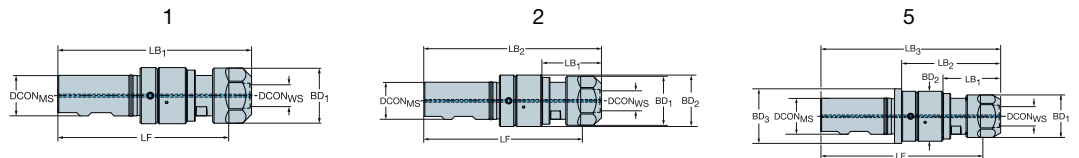
E = Cemented carbide shank

Weldon to CoroChuck™ 970

Workpiece side interface DIN 6499-B



DSGN

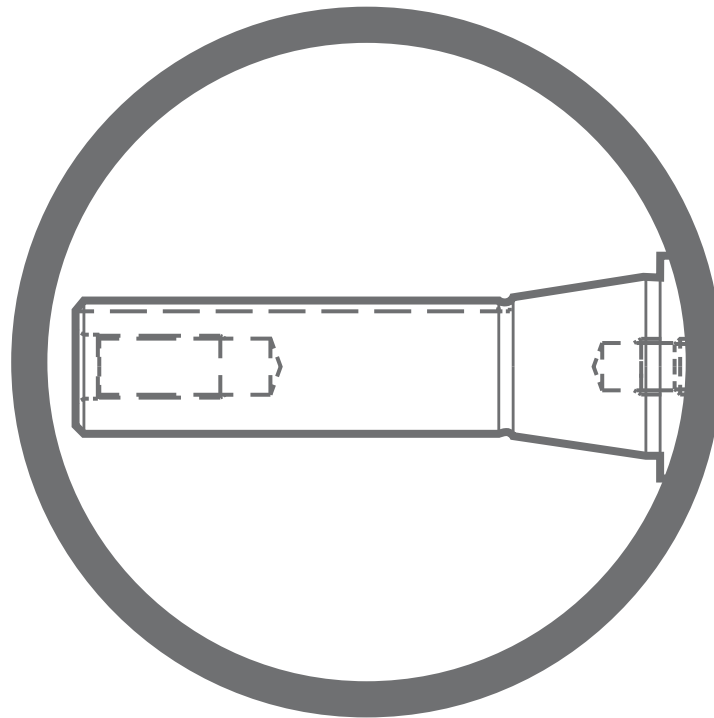


| | | Dimensions, mm | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|----------------|------|------|------|-----------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------|------|------|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | (BAR) | (KG) | RPMX |
| 16 | ER11 | M5 | 1 | 1 | 2 | 970-WE16-11-052 | 16.0 | 11.3 | 44 | 91.5 | 25.2 | 96.4 | | 18.7 | 23.5 | | 80 | 0.18 | 8000 |
| 20 | ER11 | M5 | 1 | 1 | 5 | 970-WE20-11-052 | 20.0 | 11.3 | 50 | 97.8 | 25.2 | 48.6 | 102.7 | 18.7 | 23.5 | 28.5 | 80 | 0.22 | 8000 |
| | ER20 | M12 | 1 | 1 | 2 | 970-WE20-20-069 | 20.0 | 20.8 | 50 | 106.5 | 40.3 | 119.5 | | 33.7 | 34.6 | | 80 | 0.44 | 8000 |
| 25 | ER11 | M5 | 1 | 1 | 5 | 970-WE25-11-052 | 25.0 | 11.3 | 50 | 97.8 | 25.2 | 48.6 | 102.7 | 18.7 | 23.5 | 28.5 | 80 | 0.30 | 8000 |
| | ER20 | M12 | 1 | 1 | 2 | 970-WE25-20-069 | 25.0 | 20.8 | 50 | 106.5 | 40.1 | 119.5 | | 33.7 | 34.6 | | 80 | 0.47 | 8000 |
| | ER25 | M20 | 1 | 1 | 2 | 970-WE25-25-088 | 25.0 | 25.8 | 50 | 125.4 | 42.2 | 138.9 | | 41.7 | 44.0 | | 80 | 0.84 | 8000 |
| | ER40 | M30 | 1 | 1 | 1 | 970-WE25-40-117 | 25.0 | 40.8 | 50 | 151.4 | 167.9 | | | 63.0 | | | 80 | 2.10 | 8000 |
| 40 | ER50 | M48 | 1 | 1 | 5 | 970-WE40-50-164 | 40.0 | 52.0 | 70 | 211.8 | 78.5 | 134.8 | 234.3 | 78.0 | 80.0 | 86.0 | 80 | 5.20 | 8000 |

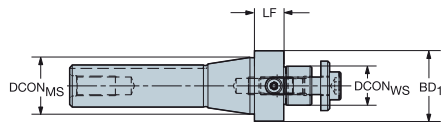
For spare parts, visit www.sandvik.coromant.com



Machine side interface Bridgeport



R8 (Bridgeport) to arbor adaptor



| | | Dimensions, mm | | | | | | |
|-------------------|-------------------|------------------|--------------------|------|-----------------|-------|------|-------|
| CZC _{MS} | CZC _{WS} | Ordering code | DCON _{WS} | LF | BD ₁ | NM | KG | RPMX |
| R8 | 22 | 392.R8.05-22 020 | 22.0 | 20.0 | 40.0 | 45.00 | 0.67 | 10000 |

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



M1

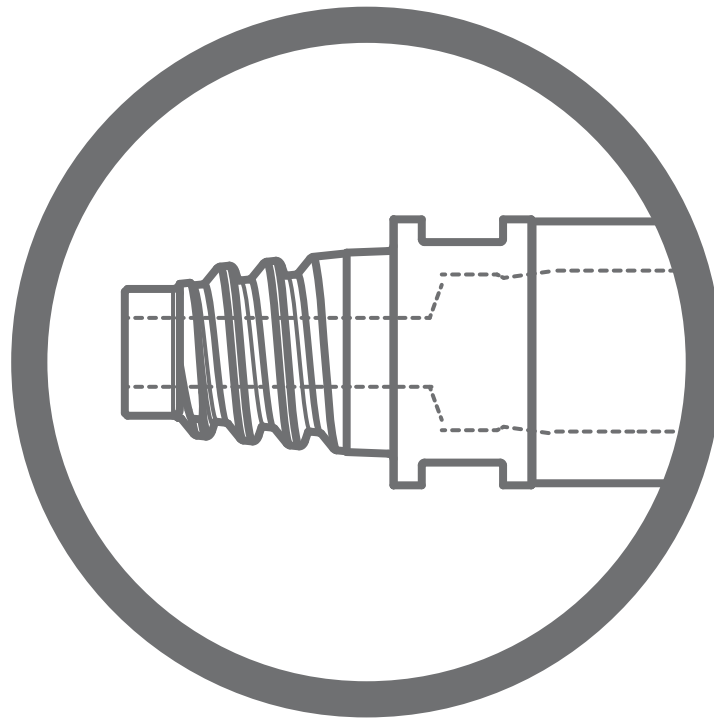


N23

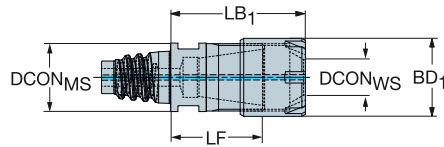


N15

Machine side interface Coromant EH

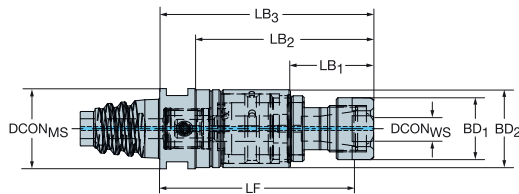
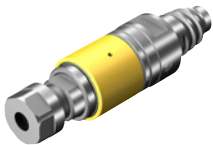


Coromant EH to ER adaptor



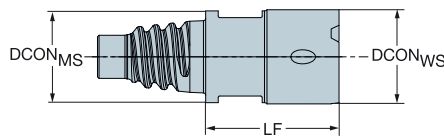
| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|----------------|--------------------|--------------------|------|-----------------|-----------------|-----|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BD ₁ | BAR | KG | RPMX |
| E12 | ER8 | 1 | 1 | ER-EH12-08-024 | 11.7 | 8.5 | 18.0 | 24.0 | 12.0 | 80 | 0.03 | 40000 |
| E16 | ER11 | 1 | 1 | ER-EH16-11-028 | 15.5 | 11.4 | 20.5 | 28.0 | 16.0 | 80 | 0.04 | 40000 |
| E20 | ER16 | 1 | 1 | ER-EH20-16-038 | 19.3 | 17.0 | 26.5 | 38.0 | 22.0 | 80 | 0.08 | 40000 |
| E25 | ER20 | 1 | 1 | ER-EH25-20-042 | 24.2 | 21.0 | 30.5 | 42.0 | 28.0 | 80 | 0.12 | 32000 |

Coromant EH to CoroChuck™ 970



| | | | | | Dimensions, mm | | | | | | | | | | | |
|-------------------|-------------------|-------|------|------|-----------------|--------------------|--------------------|------|-----------------|-----------------|-----------------|-----------------|-----------------|-----|------|------|
| CZC _{MS} | CZC _{WS} | TRMAX | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BAR | KG | RPMX |
| E25 | ER11 | M5 | 1 | 1 | 970-EH25-11-065 | 24.2 | 11.3 | 59.8 | 25.1 | 53.6 | 64.6 | 18.7 | 23.5 | 80 | 0.16 | 8000 |

Coromant EH to CoroMill® 327 adaptor

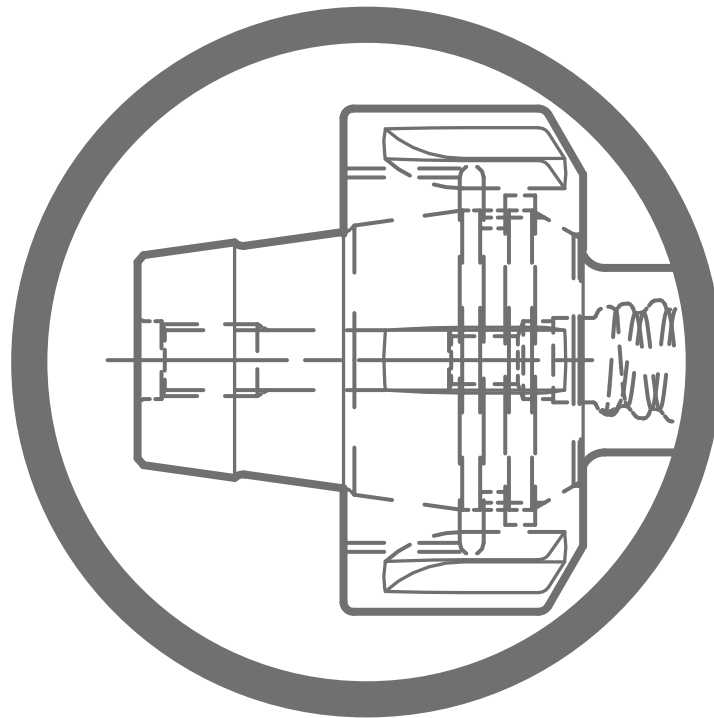


| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|-----------------|--------------------|--------------------|------|-----------------|-----|------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | BD ₁ | BAR | NM | KG | RPMX |
| E10 | 09 | 1 | 3 | 327-EH10-09-015 | 9.7 | 9.0 | 15.0 | 10.0 | 20 | 4.30 | 0.02 | 40000 |
| E12 | 12 | 1 | 3 | 327-EH12-12-017 | 11.7 | 12.0 | 17.0 | 12.0 | 20 | 6.50 | 0.02 | 40000 |
| | 14 | 1 | 3 | 327-EH12-14-017 | 11.7 | 14.3 | 17.0 | 14.3 | 20 | 6.50 | 0.01 | 40000 |

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

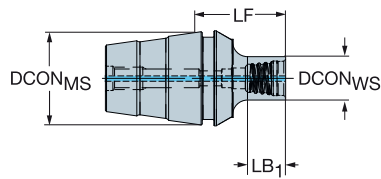


Machine side interface ER

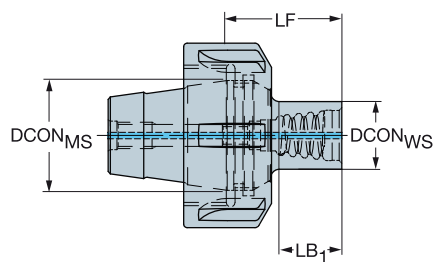


ER to Coromant EH adaptor

Machine side interface DIN 6499-B



| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|----------------|--------------------|--------------------|------|-----------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BAR | NM | KG | RPMX |
| ER16 | E10 | 1 | 1 | EH-ER16-10-008 | 17.0 | 9.6 | 14.9 | 7.2 | 80 | 12.00 | 0.09 | 40000 |
| ER20 | E10 | 1 | 1 | EH-ER20-10-008 | 21.0 | 9.6 | 15.8 | 7.2 | 80 | 12.00 | 0.11 | 40000 |
| | E12 | 1 | 1 | EH-ER20-12-010 | 21.0 | 11.6 | 17.8 | 9.2 | 80 | 15.00 | 0.13 | 40000 |
| ER25 | E10 | 1 | 1 | EH-ER25-10-012 | 26.0 | 9.6 | 20.3 | 7.2 | 80 | 12.00 | 0.16 | 32000 |
| | E12 | 1 | 1 | EH-ER25-12-014 | 26.0 | 11.6 | 22.3 | 10.2 | 80 | 15.00 | 0.17 | 32000 |
| | E16 | 1 | 1 | EH-ER25-16-016 | 26.0 | 15.4 | 24.3 | 14.2 | 80 | 30.00 | 0.22 | 32000 |
| ER32 | E10 | 1 | 1 | EH-ER32-10-012 | 33.0 | 9.6 | 21.5 | 7.4 | 80 | 12.00 | 0.25 | 25000 |
| | E12 | 1 | 1 | EH-ER32-12-014 | 33.0 | 11.6 | 23.5 | 9.4 | 80 | 15.00 | 0.27 | 25000 |
| | E16 | 1 | 1 | EH-ER32-16-018 | 33.0 | 15.4 | 27.5 | 13.4 | 80 | 30.00 | 0.35 | 25000 |
| | E20 | 1 | 1 | EH-ER32-20-022 | 33.0 | 19.2 | 31.5 | 18.9 | 80 | 50.00 | 0.34 | 25000 |
| | E25 | 1 | 1 | EH-ER32-25-025 | 33.0 | 24.1 | 34.5 | 25.0 | 80 | 65.00 | 0.41 | 25000 |
| ER40 | E16 | 1 | 1 | EH-ER40-16-022 | 41.0 | 15.4 | 33.1 | 15.0 | 20 | | 0.51 | 20000 |
| | E20 | 1 | 1 | EH-ER40-20-025 | 41.0 | 19.2 | 36.1 | 19.0 | 20 | | 0.53 | 20000 |
| | E25 | 1 | 1 | EH-ER40-25-028 | 41.0 | 24.1 | 39.1 | 24.0 | 20 | | 0.58 | 20000 |



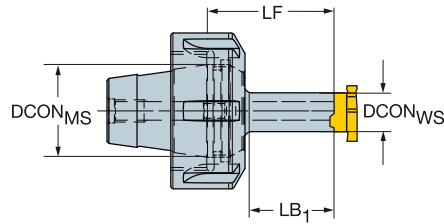
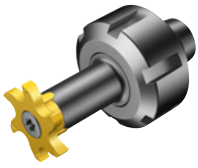
| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|--------------------|--------------------|--------------------|------|-----------------|-----|-------|------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BAR | NM | KG | RPMX |
| ER11 | E10 | 1 | 1 | 392.EREH-11 10 008 | 11.4 | 9.6 | 16.8 | 8.0 | 80 | 12.00 | 0.09 | 40000 |
| ER16 | E12 | 1 | 1 | 392.EREH-16 12 010 | 17.0 | 11.6 | 20.5 | 10.0 | 80 | 15.00 | 0.16 | 40000 |
| ER20 | E16 | 1 | 1 | 392.EREH-20 16 014 | 21.0 | 15.4 | 24.1 | 14.0 | 80 | 30.00 | 0.27 | 40000 |
| ER25 | E20 | 1 | 1 | 392.EREH-25 20 019 | 26.0 | 19.2 | 29.1 | 19.0 | 80 | 50.00 | 0.36 | 40000 |

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



ER to CoroMill® 327 adaptor

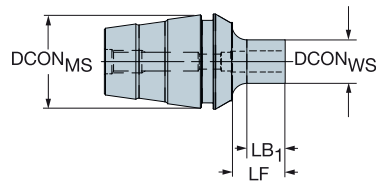
Machine side interface DIN 6499-B



| | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|---------------------|--------------------|--------------------|------|-----------------|-----------------|-------------|-------------|-------|--|
| CZC _{MS} | CZC _{WS} | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BD ₁ | NM | KG | RPMX | |
| ER11 | 09 | 392.ER327-11 09 022 | 11.4 | 9.0 | 25.0 | 16.0 | 9.0 | 4.30 | 0.07 | 40000 | |
| ER16 | 09 | 392.ER327-16 09 022 | 17.0 | 9.0 | 26.8 | 16.2 | 9.0 | 4.30 | 0.15 | 40000 | |
| | 12 | 392.ER327-16 12 030 | 17.0 | 12.0 | 34.8 | 24.3 | 12.0 | 6.50 | 0.22 | 40000 | |
| ER20 | 12 | 392.ER327-20 12 030 | 21.0 | 12.0 | 34.7 | 24.8 | 12.0 | 6.50 | 0.25 | 40000 | |
| | 14 | 392.ER327-20 14 035 | 21.0 | 14.3 | 38.9 | 28.8 | 14.0 | 6.50 | 0.27 | 40000 | |
| ER32 | 14 | 392.ER327-32 14 035 | 33.0 | 14.3 | 41.3 | 28.8 | 14.0 | 6.50 | 0.50 | 25000 | |

Note!

The nut is not a standard ER nut and therefore not exchangeable with the spare part series 5533 050-0X. The nut is always included in the package!



| | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|-----------------|--------------------|--------------------|------|-----------------|-----------------|-------------|-------------|-------|--|
| CZC _{MS} | CZC _{WS} | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BD ₁ | NM | KG | RPMX | |
| ER11 | 06 | 327-ER11-06-016 | 11.4 | 6.0 | 17.5 | 12.8 | 6.0 | 1.80 | 0.03 | 40000 | |
| ER20 | 09 | 327-ER20-09-022 | 21.0 | 9.0 | 24.7 | 16.5 | 9.0 | 4.30 | 0.09 | 40000 | |
| ER25 | 09 | 327-ER25-09-022 | 26.0 | 9.0 | 25.2 | 16.5 | 9.0 | 4.30 | 0.13 | 32000 | |
| | 12 | 327-ER25-12-030 | 26.0 | 12.0 | 33.2 | 24.6 | 12.0 | 6.50 | 0.22 | 32000 | |
| | 14 | 327-ER25-14-019 | 26.0 | 14.3 | 22.9 | 14.3 | 14.0 | 6.50 | 0.21 | 32000 | |
| ER32 | 14 | 327-ER25-14-035 | 26.0 | 14.3 | 37.4 | 28.8 | 14.0 | 6.50 | 0.23 | 32000 | |
| | 12 | 327-ER32-12-030 | 33.0 | 12.0 | 34.2 | 24.6 | 12.0 | 6.50 | 0.31 | 25000 | |
| | 14 | 327-ER32-14-019 | 33.0 | 14.3 | 23.9 | 14.3 | 14.0 | 6.50 | 0.30 | 25000 | |

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



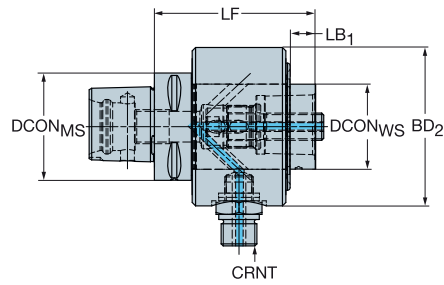
M1



N23

Coromant Capto® reduction adaptor

Coolant inducer

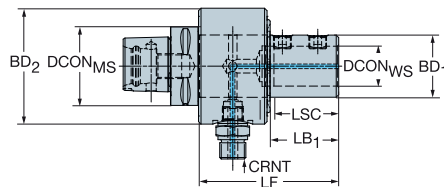


Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | BD ₂ | CRNT | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|---------------------|--------------------|--------------------|-------|-----------------|-----------------|--------|-----|--------|------|------|
| C5 | C4 | 2 | 1 | C5-391.02CCH-40 090 | 50.0 | 40.0 | 90.0 | 16.5 | 78.0 | G 3/8" | 18 | 55.00 | 1.96 | 6300 |
| C6 | C5 | 2 | 1 | C6-391.02CCH-50 095 | 63.0 | 50.0 | 95.0 | 15.0 | 93.0 | G 1/2" | 18 | 95.00 | 1.60 | 4300 |
| C8 | C6 | 2 | 1 | C8-391.02CCH-63 110 | 80.0 | 63.0 | 110.0 | 15.0 | 108.0 | G 1/2" | 18 | 170.00 | 4.77 | 3300 |

Coromant Capto® to ISO 9766 adaptor

Coolant inducer



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BD ₁ | BD ₂ | CRNT | BAR | NM | KG | RPMX |
|-------------------|-------------------|------|------|---------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|--------|-----|-------|------|------|
| C5 | 20 | 2 | 1 | C5-391.27CCH-20 120 | 50.0 | 20.0 | 51 | 120.0 | 46.5 | 40.0 | 78.0 | G 3/8" | 18 | 12.00 | 2.27 | 6300 |
| | 25 | 2 | 1 | C5-391.27CCH-25 135 | 50.0 | 25.0 | 57 | 135.0 | 49.7 | 45.0 | 93.0 | G 1/2" | 18 | 20 | 3.16 | 5300 |
| C6 | 32 | 2 | 1 | C6-391.27CCH-32 135 | 63.0 | 32.0 | 61 | 135.0 | 55.0 | 50.0 | 93.0 | G 1/2" | 18 | 30 | 3.41 | 5300 |
| C8 | 40 | 2 | 1 | C8-391.27CCH-40 155 | 80.0 | 40.0 | 71 | 155.0 | 63.5 | 65.0 | 108.0 | G 1/2" | 18 | 40 | 5.75 | 4000 |

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



M1



N23



N15

Silent Tools®

Adaptors with a dampening mechanism

Application

- In operations with long overhangs
- Productivity increases and surface quality improvements in short overhangs

Minimizing vibration at long overhangs over 3×D

Silent Tools adaptors minimize vibration through a dampener inside the tool maintaining good productivity and close tolerances even at long overhangs



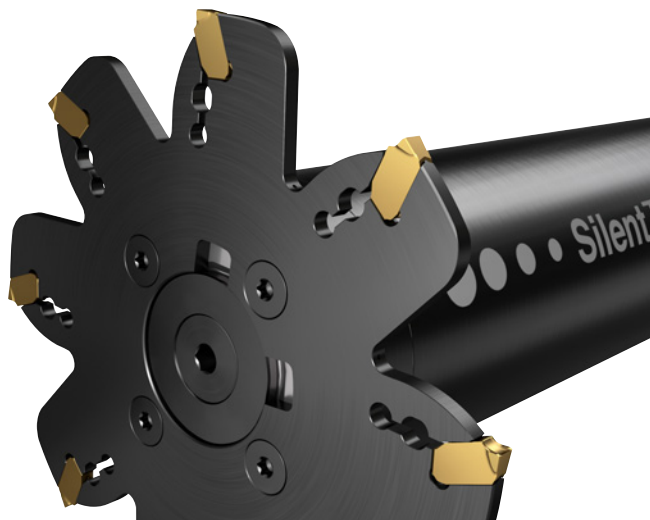
● ● ● ● SilentTools®

Boring

Problems that originate from vibrations are frequently encountered in boring and other operations, especially when machining with long overhangs. The vibrations may cause bad surface texture, insufficient accuracy and loss of productivity, increased insert and machine tool wear, as well as noise. Solving vibration problems will therefore always give you a productivity boost.

Milling

In many machining centers, the components and machine tools require long tool assemblies to reach down in large components. Vibration risk is high, and the typical remedy is either slow machining or damped tools. With Silent Tools milling adapters, chatter and vibrations are eliminated, allowing the machining rate to be increased and improving process security. Silent Tools for milling are productivity boosters.



www.sandvik.coromant.com/silenttools



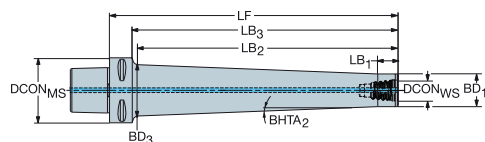
The dampening system consists of a heavy mass, supported on rubber spring elements

Coromant Capto® to Coromant EH damped adaptor

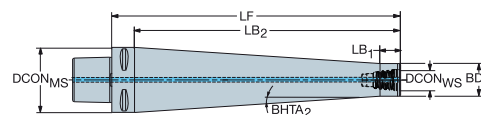


DSGN

12



7



●●● SilentTools®

| | | | | | Dimensions, mm | | | | | | | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|----------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-------------------|-------------------|-------|-------|-------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | LB ₄ | BD ₁ | BD ₃ | BD ₄ | BHTA ₂ | BHTA ₃ | (BAR) | (NM) | (KG) | RPMX | | |
| C4 | E16 | 3 | 1 | 12 | C4-EH16D-175 | 40.0 | 15.4 | 175.0 | 3.0 | 150.0 | 155.0 | 175.0 | 19.5 | 29.7 | 40.0 | 2° | 45° | 70 | 30.00 | 1.05 | 15000 | | |
| C5 | E20 | 3 | 1 | 12 | C5-EH20D-185 | 50.0 | 19.2 | 185.0 | 3.0 | 159.0 | 165.0 | 185.0 | 24.0 | 33.8 | 50.0 | 1° | 53° | 70 | 50.00 | 1.53 | 15000 | | |
| | | | | | C5-EH25D-280 | 50.0 | 24.1 | 280.0 | 20.0 | 260.0 | 280.0 | 31.7 | 50.0 | 2° | 0° | 70 | 65.00 | 5.29 | 10000 | | | | |
| C6 | E25 | 3 | 1 | 12 | C6-EH25D-280 | 63.0 | 24.1 | 280.0 | 20.0 | 252.0 | 258.0 | 280.0 | 31.7 | 49.7 | 63.0 | 2° | 67° | 70 | 65.00 | 5.68 | 10000 | | |
| | | | | | C6-EH25D-340 | 63.0 | 24.1 | 340.0 | 20.0 | 313.0 | 317.8 | 340.0 | 31.7 | 54.7 | 63.0 | 2° | 61° | 70 | 65.00 | 7.00 | 8000 | | |
| C8 | E25 | 3 | 1 | 12 | C8-EH25D-420 | 80.0 | 24.1 | 420.0 | 8.0 | 384.0 | 390.0 | 420.0 | 31.7 | 61.7 | 80.0 | 2° | 71° | 70 | 65.00 | 10.61 | 6000 | | |

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



N23



N15

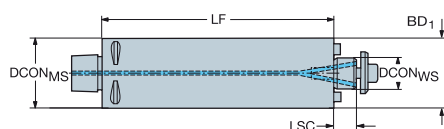


N3

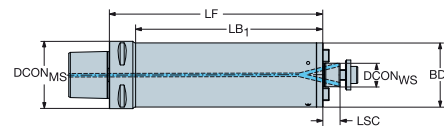
Coromant Capto® to arbor damped adaptor



DSGN 1

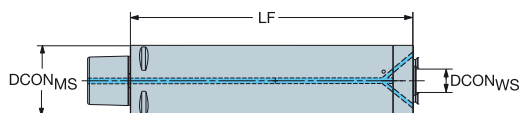
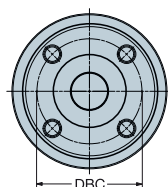


2



| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-------------------|-------------------|------|------|------|------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----------------|-----------------|--------|--------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | DSGN | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | LB ₂ | BD ₁ | BD ₂ | BAR | NM | KG | RPMX |
| C4 | 16 | 3 | 4 | 2 | C4-Q16D-038-130 | 40.0 | 16.0 | 11 | 130.0 | 107.8 | 130.0 | 38.0 | 40.0 | 70 | 22.00 | 1.62 | 16000 |
| | 16 | 3 | 4 | 2 | C4-Q16D-038-200 | 40.0 | 16.0 | 11 | 200.0 | 177.8 | 200.0 | 38.0 | 40.0 | 70 | 22.00 | 2.32 | 8000 |
| C5 | 22 | 3 | 4 | 2 | C5-Q22D-048-180 | 50.0 | 22.0 | 16 | 180.0 | 157.6 | 180.0 | 47.5 | 50.0 | 70 | 45.00 | 3.22 | 14000 |
| | 22 | 3 | 4 | 2 | C5-Q22D-048-220 | 50.0 | 22.0 | 16 | 220.0 | 197.6 | 220.0 | 47.5 | 50.0 | 70 | 45.00 | 6.04 | 11000 |
| | 22 | 3 | 4 | 2 | C5-Q22D-048-270 | 50.0 | 22.0 | 16 | 270.0 | 247.6 | 270.0 | 47.5 | 50.0 | 70 | 45.00 | 6.85 | 7000 |
| C6 | 22 | 3 | 4 | 2 | C6-Q22D-060-200 | 63.0 | 22.0 | 16 | 200.0 | 175.4 | 200.0 | 60.0 | 63.0 | 70 | 45.00 | 8.05 | 15000 |
| | 22 | 3 | 4 | 2 | C6-Q22D-060-260 | 63.0 | 22.0 | 16 | 260.0 | 235.4 | 260.0 | 60.0 | 63.0 | 70 | 45.00 | 9.29 | 11000 |
| | 22 | 3 | 4 | 2 | C6-Q22D-060-310 | 63.0 | 22.0 | 16 | 310.0 | 285.4 | 310.0 | 60.0 | 63.0 | 70 | 45.00 | 10.86 | 6000 |
| | 27 | 3 | 4 | 1 | C6-Q27D-063-200 | 63.0 | 27.0 | 18 | 200.0 | 200.0 | | 63.0 | 70 | 80.00 | 8.54 | 11000 | |
| | 27 | 3 | 4 | 1 | C6-Q27D-063-260 | 63.0 | 27.0 | 18 | 260.0 | 260.0 | | 63.0 | 70 | 80.00 | 9.88 | 8000 | |
| | 27 | 3 | 4 | 1 | C6-Q27D-063-310 | 63.0 | 27.0 | 18 | 310.0 | 310.0 | | 63.0 | 70 | 80.00 | 11.57 | 5000 | |
| C8 | 27 | 3 | 4 | 2 | C8-Q27D-076-220 | 80.0 | 27.0 | 18 | 220.0 | 187.2 | 220.0 | 76.0 | 80.0 | 70 | 80.00 | 12.92 | 12000 |
| | 27 | 3 | 4 | 2 | C8-Q27D-076-320 | 80.0 | 27.0 | 18 | 320.0 | 287.2 | 320.0 | 76.0 | 80.0 | 70 | 80.00 | 13.40 | 8000 |
| | 27 | 3 | 4 | 2 | C8-Q27D-076-360 | 80.0 | 27.0 | 18 | 360.0 | 327.2 | 360.0 | 76.0 | 80.0 | 70 | 80.00 | 18.20 | 6000 |
| | 32 | 3 | 4 | 1 | C8-Q32D-080-220 | 80.0 | 32.0 | 20 | 220.0 | 220.0 | | 80.0 | 70 | 180.00 | 13.73 | 10000 | |
| | 32 | 3 | 4 | 1 | C8-Q32D-080-320 | 80.0 | 32.0 | 20 | 320.0 | 320.0 | | 80.0 | 70 | 180.00 | 18.00 | 6000 | |
| | 32 | 3 | 4 | 1 | C8-Q32D-080-360 | 80.0 | 32.0 | 20 | 360.0 | 360.0 | | 80.0 | 70 | 180.00 | 19.60 | 4000 | |
| C10 | 32 | 3 | 4 | 2 | C10-Q32D-095-400 | 100.0 | 32.0 | 20 | 400.0 | 361.0 | 400.0 | 95.0 | 100.0 | 70 | 180.00 | 30.00 | 5000 |
| | 40 | 3 | 4 | 1 | C10-Q40D-100-400 | 100.0 | 40.0 | 23 | 400.0 | 400.0 | | 100.0 | 70 | 300.00 | 28.30 | 5000 | |

Coromant Capto® to arbor with driving screws damped adaptor



For CoroMill® QD with internal coolant supply

| | | | | | Dimensions, mm | | | | | | | |
|-------------------|-------------------|------|------|-----------------|--------------------|------|--------------------|-----|-------|-----|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DBC | DCON _{WS} | LSC | LF | BAR | NM | KG |
| C3 | X10 | 3 | 4 | C3-X10D-032-128 | 32.0 | 22.0 | 10.0 | 2 | 128.0 | 70 | 6.40 | 1.10 |
| C4 | X22 | 3 | 3 | C4-X22D-040-160 | 40.0 | 32.0 | 22.0 | 2 | 160.0 | 70 | 3.90 | 1.92 |
| C6 | X32 | 3 | 3 | C6-X32D-063-252 | 63.0 | 45.0 | 32.0 | 2 | 252.0 | 70 | 6.40 | 9.30 |
| C8 | X40 | 3 | 3 | C8-X40D-080-320 | 80.0 | 63.0 | 40.0 | 2 | 320.0 | 70 | 70.00 | 17.45 |

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

M1

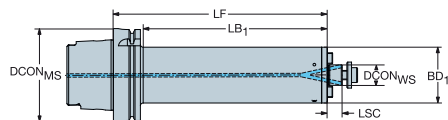


N23



N15

HSK to arbor damped adaptor



●●● SilentTools®

| | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-----|-------|-----------------|-----------------|-----|--------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | LB ₁ | BD ₁ | BAR | NM | KG | RPMX |
| 63 | 16 | 1 | 4 | HA06-Q16D-038-160 | 63.0 | 16.0 | 11 | 160.0 | 131.0 | 38.0 | 70 | 22.00 | 4.35 | 16000 |
| 16 | 1 | 4 | | HA06-Q16D-038-230 | 63.0 | 16.0 | 11 | 230.0 | 201.0 | 38.0 | 70 | 22.00 | 5.06 | 8000 |
| 22 | 1 | 4 | | HA06-Q22D-048-210 | 63.0 | 22.0 | 16 | 210.0 | 181.0 | 47.5 | 70 | 45.00 | 6.10 | 8000 |
| 22 | 1 | 4 | | HA06-Q22D-048-260 | 63.0 | 22.0 | 16 | 260.0 | 231.0 | 47.5 | 70 | 45.00 | 6.89 | 5000 |
| 100 | 22 | 1 | 4 | HA10-Q22D-048-213 | 100.0 | 22.0 | 16 | 213.0 | 181.0 | 47.5 | 70 | 45.00 | 7.68 | 14000 |
| 22 | 1 | 4 | | HA10-Q22D-048-263 | 100.0 | 22.0 | 16 | 263.0 | 231.0 | 47.5 | 70 | 45.00 | 8.55 | 9000 |
| 22 | 1 | 4 | | HA10-Q22D-060-230 | 100.0 | 22.0 | 16 | 230.0 | 198.0 | 60.0 | 70 | 45.00 | 9.78 | 14000 |
| 22 | 1 | 4 | | HA10-Q22D-060-340 | 100.0 | 22.0 | 16 | 340.0 | 308.0 | 60.0 | 70 | 45.00 | 12.96 | 7000 |
| 27 | 1 | 4 | | HA10-Q27D-076-250 | 100.0 | 27.0 | 18 | 250.0 | 218.0 | 76.0 | 70 | 80.00 | 14.13 | 10000 |
| 27 | 1 | 4 | | HA10-Q27D-076-390 | 100.0 | 27.0 | 18 | 390.0 | 358.0 | 76.0 | 70 | 80.00 | 20.00 | 5000 |
| 32 | 1 | 4 | | HA10-Q32D-080-250 | 100.0 | 32.0 | 20 | 250.0 | 218.0 | 80.0 | 70 | 180.00 | 15.30 | 10000 |
| 32 | 1 | 4 | | HA10-Q32D-080-390 | 100.0 | 32.0 | 20 | 390.0 | 358.0 | 80.0 | 70 | 180.00 | 21.07 | 5000 |

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



M1



N23



N15

Accessories

Coromant Capto® M2

Assembly fixture M3
Tool wagon for Coromant Capto® M4
Cassettes (polygon seating) M5
Locking mechanism for cassettes M6
Assembly item M7-M9
Torque value M10

HSK

Assembly item M11

Accessory item for CoroBore®

Corobore® XL pre measuring unit M12
Shim set M12

Arbor

Arbor mounting screws with coolant hole M13
Spacing rings M14

Sleeves and collets

Cylindrical sleeves M15-M18
Extractor for cylindrical sleeves M18
Cylindrical sleeve with mechanical locking interface M19
Eccentric sleeve M20
ER collet M21
ER Collet for tap shank M24
ER collet sealing discs M25
Sleeve for fine boring head M26
Assembly item M27

Adaptors

Slide to adjustable drill adaptor M28
VL M28

Keys and torque wrenches

Assembly tools M29
Torx Plus® torque wrench M32

Pull studs M33-M34

Coromant Capto®

Three systems in one

Application

- Coromant Capto works in all machine types:
- Turning centers – quick-change and high pressure coolant delivery.
- Multi-task machines and machining centers - rotating spindle interface, modular tooling, and quick change.
- Available in six sizes, there is a flexible Coromant Capto solution for every need: C3-C10



Benefits and features

- Flexible with extensive modularity
- High basic stability and accuracy
- Minimized tool inventory
- Reduced set-up time
- High torque transmission
- High bending strength
- Quick-change and automated tool change
- Advanced nozzle technology for process security even at low pressures
- Through-tool delivery of high-pressure coolant, from machine to cutting edge
- Balanced and concentric
- Self-centering

www.sandvik.coromant.com/coromantcapto

Quick change

- Turning centres
- Vertical lathes

Coromant Capto clamping units and driven tool holders reduce set-up and tool change time for high machine utilization.

Integrated spindle

- Multi-task machines
- Vertical lathes
- Machining centres with turning option

Coromant Capto integrated in the spindle adds stability and versatility.

Modular system

- Machining centres
- Multi-task machines
- Vertical lathes

Coromant Capto machine interface adaptors in combination with extension and reduction adaptors enable assembling of tools with different lengths and design regardless of the machine interface.

Coromant Capto® range

Coromant Capto programme includes machine interface adaptors, clamping units, tool holders, integrated cutting tools, adaptors and chucks.

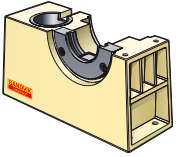


Assembly fixture

Fixture body

Ordering code:

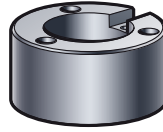
391.500



Fixture body for sleeves

Ordering code:

391.501



Ordering code



| Sleeve | For holder type, size |
|--------------|-------------------------|
| 391.540-C3 | Coromant Capto Size C3 |
| 391.540-C4 | Coromant Capto Size C4 |
| 391.540-C5 | Coromant Capto Size C5 |
| 391.540-C6 | Coromant Capto Size C6 |
| 391.540-C8 | Coromant Capto Size C8 |
| 391.540-C10 | Coromant Capto Size C10 |
| 391.540-HA04 | HSK 40 Form A/C |
| 391.540-HA05 | HSK 50 Form A/C |
| 391.540-HA06 | HSK 63 Form A/C |
| 391.540-HA08 | HSK 80 Form A/C |
| 391.540-HA10 | HSK 100 Form A/C |
| 391.540-30 | MAS-BT/CAT/ISO 30 |
| 391.540-40 | MAS-BT/CAT/ISO 40 |
| 391.540-50 | MAS-BT/CAT/ISO 50 |

Ordering code

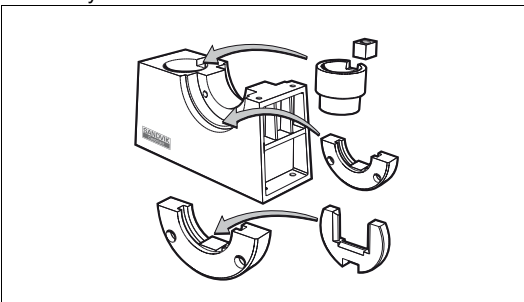


| Flange | Collar | For holder type, size |
|-----------------|----------------|--|
| 391.510-140 50 | 391.530-C3 | Coromant Capto Size C3 |
| 391.510-140 50 | 391.530-C4 | Coromant Capto Size C4 |
| 391.510-140 50 | 391.530-C5 | Coromant Capto Size C5 |
| 391.510-140 50 | 391.530-C6 | Coromant Capto Size C6 |
| 391.510-140 50 | 391.530-C8 | Coromant Capto Size C8 |
| 391.510-140 50 | 391.530-C10* | Coromant Capto Size C10 |
| 391.510-HA04 | | HSK 40 Form A |
| 391.510-HA05 | | HSK 50 Form A |
| 391.510-HA06 | | HSK 63 Form A |
| 391.510-HA08 | | HSK 80 Form A |
| 391.510-HA10 | | HSK 100 Form A |
| 391.510-HA12 | | HSK 125 Form A |
| 391.510-55 30 | | MAS-BT 30 |
| 391.510-55 40 | | MAS-BT 40 |
| 391.510-55 50 | | MAS-BT 50 |
| 391.510-562-40 | | BIG-PLUS, MAS-BT 40 |
| 391.510-562-50 | | BIG-PLUS, MAS-BT 50 |
| 391.510-140 40 | | DIN 69871/40, ANSIB 5.50-40. ISO7388/1-40, CAT 40 |
| 391.510-140 50 | | DIN 69871/50, ANSIB 5.50-40. ISO7388/1-50, CAT 50 |
| 391.510-540 40 | | BIG-PLUS DIN69871/1-40, BIG-PLUS 7388/1-40, CAT 40 |
| 391.510-540 50 | | BIG-PLUS DIN69871/1-50, BIG-PLUS 7388/1-50, CAT 50 |
| 391.510-00 40 | | DIN 2080-40/NMTB 40 |
| 391.510-00 50 | | DIN 2080-50/NMTB 50 |
| A391.510-45 40 | | ANSIB 5.50-2009, CAT-V 40-2009 |
| A391.510-45 50 | | ANSIB 5.50-2009, CAT-V 50-2009 |
| A391.510-545 40 | | BIG-PLUS ANSIB 5.50-2009, CAT-V 40-2009 |
| A391.510-545 50 | | BIG-PLUS ANSIB 5.50-2009, CAT-V 50-2009 |
| 391.510-140 50 | 391.530-970-11 | CoroChuck 970, ER11 |
| 391.510-140 50 | 391.530-970-20 | CoroChuck 970, ER20 |
| 391.510-140 50 | 391.530-970-25 | CoroChuck 970, ER25 |
| 391.510-140 50 | 391.530-970-32 | CoroChuck 970, ER32 |
| 391.510-140 50 | 391.530-970-40 | CoroChuck 970, ER40 |

Note: Key is delivered with the sleeve.

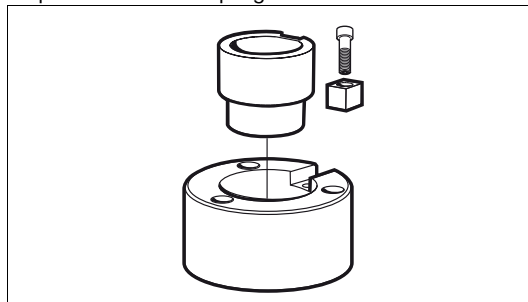
* Combined collar and flange

Assembly fixture 391.500



Choose flange, collar and sleeve to suit tool to be assembled.

Fixture 391.501 for maintenance of tools with Coromant Capto® and HSK couplings



Choose sleeve to suit coupling.
The fixture should be fastened to the bench with three socket head screws (not delivered with fixture)

Tool wagon for Coromant Capto®

Quick change tooling



1. Cradle carrier
2. Tool cradles
3. Molded tool holders (To be ordered separately)

| Ordering code | Kit consist of: | | |
|---------------|-----------------|----------|--------------------------------|
| CCW-KIT | TC-0 | 4 pieces | Tool cradles |
| | TCC-2 | 4 pairs | Frame carriers for tool cradle |

To order a complete wagon 1 pcs CCW-KIT + Molded tool holders

Tool cradles and cradle carriers could be bought extra as accessories.

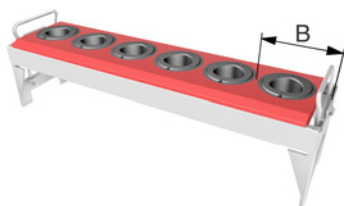
Bench stand



| Ordering code |
|---------------|
| BS-KIT |

No accessory codes for bench stand.

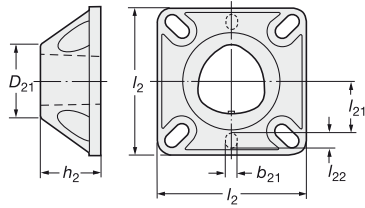
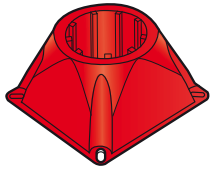
Molded tool holders - to be ordered separately



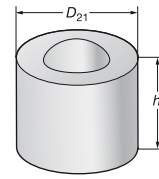
| Ordering code | Width (B), mm | Max. number of tool holders in a cradle |
|---------------|---------------|---|
| C3-IC-1 | 58 | C3 = 9 |
| C4-IC-1 | 58 | C4 = 9 |
| C5-IC-1 | 65.5 | C5 = 8 |
| C6-IC-1 | 81.5 | C6 = 6 |
| C8-IC-1 | 105 | C8 = 5 |
| C10-IC-1 | 120 | C10 = 4 |

Cassettes (polygon seating)

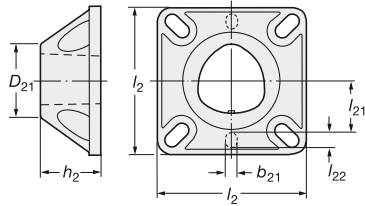
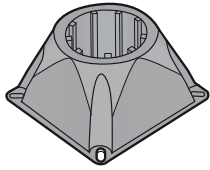
Coromant Capto®



-4000
Plastic storage cassettes (red)

-6000-B

Aluminium cassette blanks

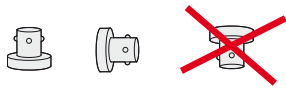
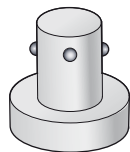


-5000
High grade plastic in-machine tool storage (black)

| Coupling size | Ordering code | Dimensions, mm | | | | | | |
|---------------|---------------|----------------|----------|-------|-------|----------|----------|--|
| | | b_{21} | D_{21} | h_2 | l_2 | l_{21} | l_{22} | |
| C3 | C3-C-4000 | - | 32 | 26 | 65 | - | - | All plastic cassettes conforming to hole pattern 17 mm, 20 mm, 25 mm. High grade plastic. Red colour. To be used: – alone for upright storage – with mechanism type PL-01 for horizontal or upright position. |
| C4 | C4-C-4000 | 6 | 50 | 39 | 74 | 26 | 8 | |
| C5 | C5-C-4000 | 6 | 50 | 39 | 74 | 26 | 8 | |
| C6 | C6-C-4000 | 8 | 80 | 63 | 116 | 41 | 10 | |
| C8 | C8-C-4000 | 8 | 80 | 63 | 116 | 41 | 10 | High grade re-inforced black plastic. For in-machine tool storage with mechanism AL-01. |
| C4 | C4-C-5000 | 6 | 50 | 39 | 74 | 26 | 8 | |
| C5 | C5-C-5000 | 6 | 50 | 39 | 74 | 26 | 8 | |
| C6 | C6-C-5000 | 8 | 80 | 63 | 116 | 41 | 10 | |
| C8 | C8-C-5000 | 8 | 80 | 63 | 116 | 41 | 10 | |
| C10 | C10-C-5000 | 8 | 100 | 80 | 150 | 60 | 68 | Aluminium cassette blanks for individual adaptation. To be used with AL-01. |
| C6 | C6-C-6000-B | - | 120 | 63 | - | - | - | |
| C8 | C8-C-6000-B | - | 120 | 63 | - | - | - | |
| C10 | C10-C-6000-B | - | 138 | 80 | - | - | - | |

Locking mechanism for cassettes

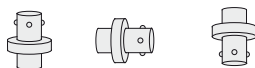
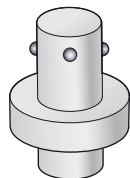
-PL



Passive locking mechanism

For vertical upwards and horizontal storage. NEVER upside down storage.

-AL



Active locking mechanism

For storage at all angles: vertical upwards and downwards or horizontal.

K

| CZC | Ordering code | Pull action force, N | |
|-----|---------------|----------------------|--|
| C4 | C4-PL-01 | 55 | Central passive locking mechanism. Spring loaded clamping. Fits directly into all cassettes type 4000. |
| C5 | C5-PL-01 | 120 | |
| C6 | C6-PL-01 | 150 | |
| C8 | C8-PL-01 | 240 | |

| CZC | Ordering code | Rec. max. tool weight, kg | |
|-----|---------------|---------------------------|---|
| C4 | C4-AL-01 | 40 | Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000. |
| C5 | C5-AL-01 | 60 | |
| C6 | C6-AL-01 | 75 | |
| C8 | C8-AL-01 | 110 | |
| C10 | C10-AL-01 | 150 | |

L

| CZC | Ordering code | Rec. max. tool weight, kg | |
|-----|---------------|---------------------------|---|
| C6 | C6-AL-02 | 75 | Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000. |
| C8 | C8-AL-02 | 110 | |
| | | | |

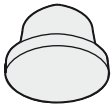
M

N

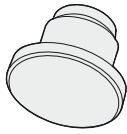
Assembly item

Cover plug

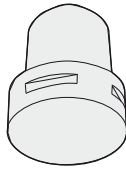
CP-11



CP-01



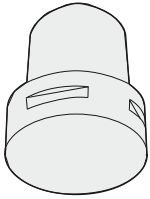
CPA-01



| Coupling size | Ordering code | | |
|---------------|---------------|----------------|-----------|
| | Manual unit | Automatic unit | Type 3000 |
| C3 | C3-CP-01 | - | C3-CP-11 |
| C4 | C4-CP-01 | C4-CPA-01 | C4-CP-11 |
| C5 | C5-CP-01 | C5-CPA-01 | C5-CP-11 |
| C6 | C6-CP-01 | C6-CPA-01 | - |
| C8 | C8-CP-01 | C8-CPA-01 | - |
| C10 | - | C10-CPA-01 | - |

Balancing tool

Cx-BAT-01

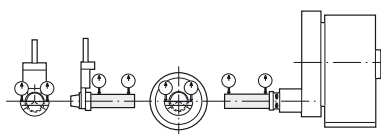


| Coupling size | Ordering code |
|---------------|---------------|
| C3 | C3-BAT-01 |
| C4 | C4-BAT-01 |
| C5 | C5-BAT-01 |
| C6 | C6-BAT-01 |
| C8 | C8-BAT-01 |
| C10 | C10-BAT-01 |

Assembly item

Master setting gauges

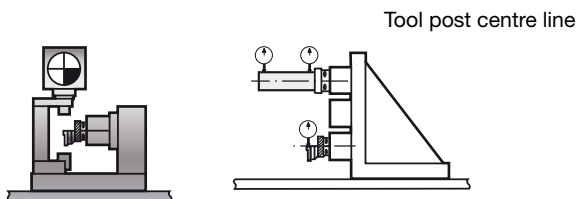
Checking position for grippers Spindle orientation



The Coromant Capto system guarantees exceptional, repeatable accuracy but this is of little use unless the various other components in the total machining process are correctly and accurately positioned.

Coromant offers a range of axial and centre height master setting gauges for the various coupling sizes which are strongly recommended for setting important parameters such as:

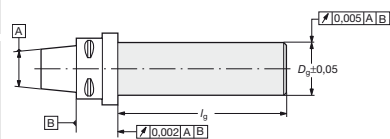
- The centre line of the tool post
- Spindle orientation
- The position of the tool for grippers
- Tool centre height and cutting edge position (f_1 and l_1 dimensions). Gauges can be used in a pre-measuring fixture
- Component fixtures



Tool presetting Component fixture geometric control

Axial gauge

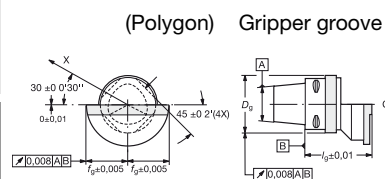
Master setting gauges MAS-11



| | | Dimensions, mm | |
|---------------|---------------|----------------|-------|
| Coupling size | Ordering code | D_g | l_g |
| C3 | C3-MAS-11 | 25 | 160 |
| C4 | C4-MAS-11 | 25 | 160 |
| C5 | C5-MAS-11 | 32 | 210 |
| C6 | C6-MAS-11 | 40 | 315 |
| C8 | C8-MAS-11 | 40 | 315 |
| C10 | C10-MAS-11 | 60 | 420 |

Centre height gauge

Master setting gauges MAS-01



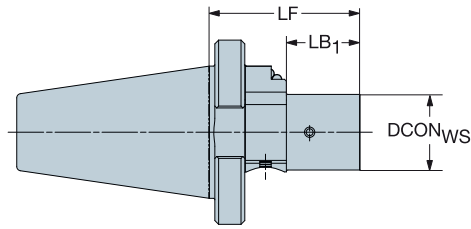
| | | Dimensions, mm | | |
|---------------|---------------|----------------|-------|-------|
| Coupling size | Ordering code | f_g | l_g | D_g |
| C3 | C3-MAS-01 | 22 | 40 | 34 |
| C4 | C4-MAS-01 | 27 | 50 | 42 |
| C5 | C5-MAS-01 | 35 | 60 | 52 |
| C6 | C6-MAS-01 | 45 | 65 | 65 |
| C8 | C8-MAS-01 | 55 | 80 | 82 |
| C10 | C10-MAS-01 | 65 | 100 | 102 |

Centre height gauge

| | | Dimensions, mm | |
|---------------|---------------|----------------|-------|
| Coupling size | Ordering code | l_g | D_g |
| C4 | C4-MAS-25 140 | 140 | 25 |
| C5 | C5-MAS-32 145 | 145 | 32 |
| C6 | C6-MAS-40 180 | 180 | 40 |
| C8 | C8-MAS-40 240 | 240 | 40 |

Assembly item

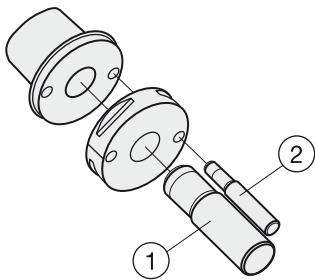
Pre-measuring unit



| | | | | Dimensions, mm | | | |
|-------------------|-------------------|------|------|----------------|--------------------|-----|-----------------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{WS} | LF | LB ₁ |
| 50 | C3 | 0 | 0 | C3-PMU-I50 | 32 | 75 | 36 |
| | C4 | 0 | 0 | C4-PMU-I50 | 40 | 80 | 39 |
| | C5 | 0 | 0 | C5-PMU-I50 | 50 | 90 | 45 |
| | C6 | 0 | 0 | C6-PMU-I50 | 63 | 107 | 56 |
| | C8 | 0 | 0 | C8-PMU-I50 | 80 | 127 | 60 |

Alignment tool

This tool is used to check the Automatic Tool Change positioning tolerance between the gripper arm and magazine and the clamping unit/spindle. If the tolerance is not achieved the result can be abnormal wear on cutting tool or Coromant Capto interface, wrong clamping, dropped tools, personal injuries etc. Instructions and tolerances are available in the box together with the tool.



| Coupling size | Ordering code Tool | Spare parts | |
|---------------|-----------------------|----------------|----------------|
| | | 1 Gauge pin | 2 Gauge pin |
| C4 | C4-AMT-01 | 5552 069-03 | 5552 069-01 |
| C5 | C5-AMT-01 | 5552 069-04 | 5552 069-01 |
| C6 | C6-AMT-01 | 5552 069-05 | 5552 069-02 |
| C8 | C8-AMT-01 | 5552 069-05 | 5552 069-02 |
| C10 | C10-AMT-01 | 5552 069-09 | 5552 069-08 |

Torque value

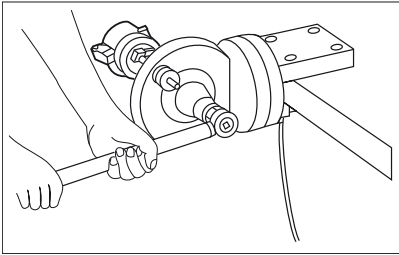
Tightening torque recommendations

Coromant Capto® tightening torque:

Manual clamping units and driven tool holders with camshaft mechanism

| CZC | Torque Nm |
|-----|--------------|
| C3 | 35 |
| C4 | 50 |
| C5 | 70 |
| C6 | 90 |
| C8 | 130 |
| C10 | 285 |

Coromant Capto® basic holders



Centre bolt clamping

| CZC | Torque Nm |
|-----|--------------|
| C3 | 45 |
| C4 | 55 |
| C5 | 95 |
| C6 | 170 |
| C8 | 170 |
| C10 | 380 |

Assembly item

Coolant tube for solid HSK assortment



| HSK size | Ordering code | Dimensions, mm | | | | Key | |
|----------|---------------|----------------|------|------|------|---------------|-----------|
| | | BD | THL | OAL | KG | Ordering code | Torque Nm |
| 40 | 5692 022-02 | 8 | 7.5 | 29.5 | 0.01 | 5680 094-02 | 10 |
| 50 | 5692 022-03 | 10 | 9.5 | 32.8 | 0.02 | 5680 094-03 | 15 |
| 63 | 5692 022-04 | 12 | 11.5 | 46.5 | 0.03 | 5680 094-04 | 20 |
| 100 | 5692 022-06 | 16 | 15.5 | 44.5 | 0.05 | 5680 094-06 | 30 |
| 100 | 5692 022-16 | 16.0 | 16.0 | 44 | 0.06 | 5680 094-06 | 30 |
| 125 | 5692 022-07 | 18 | 17.5 | 48 | 0.08 | 5680 094-07 | 30 |

Shrink fit MQL screws

Fig. 1

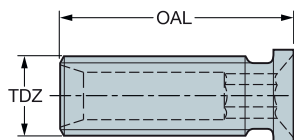
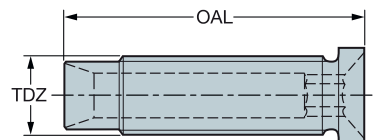


Fig. 2



| Ordering code | Size | Fig. | Dimensions | | |
|---------------|-------|------|------------|-------|----------|
| | | | OAL | TDZ | Key size |
| 5692 039-01 | 6 mm | 2 | 34 | M5 | SW 2,5 |
| 5692 039-02 | 6 mm | 1 | 17 | M5 | SW 2,5 |
| 5692 039-03 | 8 mm | 2 | 34 | M6 | SW 3 |
| 5692 039-04 | 8 mm | 1 | 18 | M6 | SW 3 |
| 5692 039-05 | 10 mm | 2 | 35 | M8x1 | SW 4 |
| 5692 039-06 | 10 mm | 1 | 18 | M8x1 | SW 4 |
| 5692 039-07 | 12 mm | 2 | 35 | M10x1 | SW 5 |
| 5692 039-08 | 12 mm | 1 | 18 | M10x1 | SW 5 |
| 5692 039-09 | 16 mm | 2 | 37 | M10x1 | SW 5 |
| 5692 039-10 | 16 mm | 1 | 22 | M10x1 | SW 5 |
| 5692 039-11 | 20 mm | 2 | 40 | M10x1 | SW 5 |
| 5692 039-12 | 20 mm | 1 | 23,5 | M10x1 | SW 5 |
| 5692 039-13 | 25 mm | 1 | 27,5 | M10x1 | SW 5 |
| 5692 039-14 | 25 mm | 1 | 30,5 | M10x1 | SW 5 |

Balancing screws



| |
|---------------|
| Ordering code |
| 5514 100-01 |

Adjustment screws for MQL tap holder CoroChuck 970-HAxxQ-xx-xxx

Taps with external center

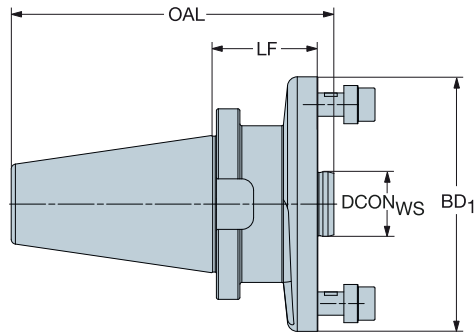
| Tap shank diameter, mm | ER20 | ER25 |
|------------------------|-------------|-------------|
| 6, 7 | 5692 037-01 | |
| 8, 9 | 5692 037-02 | 5692 037-04 |
| 10 | 5692 037-03 | 5692 037-03 |
| 11-16 | | 5692 037-05 |



N23



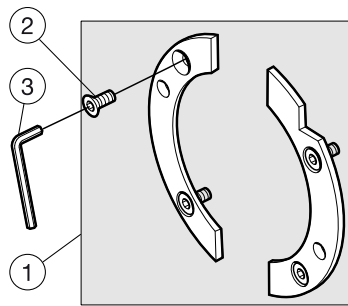
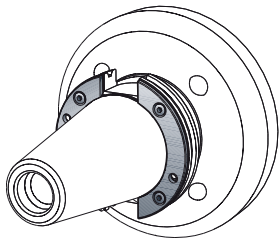
Corobore® XL pre measuring unit



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | Ordering code | DCON | OAL | LF | BD ₁ | KG |
|-------------------|-------------------|------|---------------|------|--------|------|-----------------|------|
| 50 | 33 | 0 | I50-PMU-A33 | 33 | 178.30 | 50.0 | 130.0 | 5.59 |

Shim set

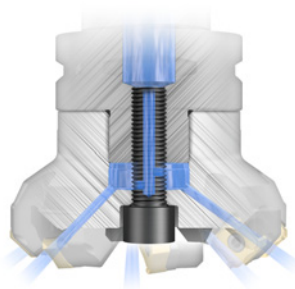


| | | |
|------------------------------|----------------------------|--------------------------------|
| 1 Shim set 5549 128-50 | 2 Screw 3213 011-256 | 3 Key 3021 010-025 (2.5) |
|------------------------------|----------------------------|--------------------------------|

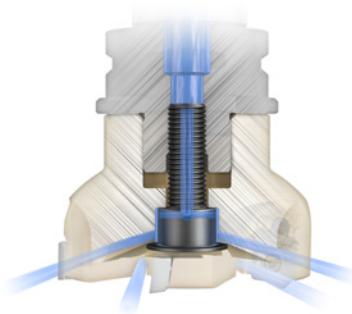


Arbor mounting screws with coolant hole

ISO A



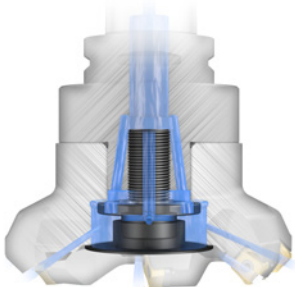
| Arbor size | Screw | Key |
|------------|-------------------|---------------------|
| 16 | 5512 073-03 (M8) | 3021 010-060 (6.0) |
| 22 | 5512 073-01 (M10) | 3021 010-080 (8.0) |
| 22 | 5512 073-04 (M10) | 3021 010-080 (8.0) |
| 27 | 5512 073-02 (M12) | 3021 010-100 (10.0) |
| 32 | 5512 073-05 (M16) | 3021 010-140 (12.0) |



| Arbor size | Screw | Key |
|------------|--------------------|--------------------|
| 22 | 5512 087-01 (M10) | 5680 043-17 (30IP) |
| 27 | 5512 087-02 (M12) | 5680 043-18 (50IP) |
| 27 | 5512 098-05* (M12) | 5680 043-13 (15IP) |
| | | 5680 043-18 (50IP) |
| 32 | 5512 087-03 (M16) | 5680 043-19 (55IP) |

* Screw set have an adjustable cap

ISO B

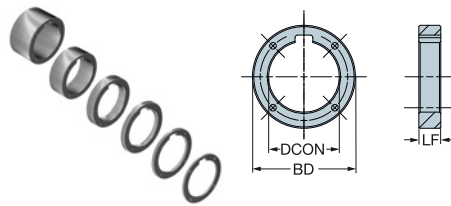


| Arbor size | Screw | Key |
|------------|-------------------|---------------------|
| 32 | 5512 098-04 (M16) | 3021 010-060 (6.0) |
| | | 3021 010-120 (12.0) |
| 40 | 5512 098-03 (M20) | 3021 010-060 (6.0) |
| | | 3021 010-120 (12.0) |

Spacing rings

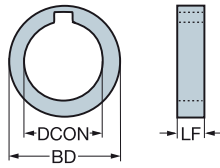
Assembly items for CoroMill® 331

Set with hole



| Metric, mm | LF | 0.5 | 1 | 1.5 | 2 | 3 | 4 | 5 | 6 | 10 | 20 | 30 |
|--------------|------|-----|----|-----|----|----|----|----|----|----|----|----|
| Set code | DCON | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD |
| 5549 091-032 | 27 | 39 | 39 | 39 | 41 | 41 | 41 | 41 | 41 | 41 | 41 | 41 |
| 5549 091-042 | 32 | 45 | 45 | 45 | 47 | 47 | 47 | 47 | 47 | 47 | 47 | 47 |
| 5549 091-052 | 40 | 54 | 54 | 54 | 55 | 55 | 55 | 55 | 55 | 55 | 55 | 55 |

Set without hole



| Ordering code | For adaptor | Dimensions, mm | | | | | | | | | | | | |
|---------------|--------------|----------------|-----|-----|-----|-----|-----|-----|-----|-----|------|------|------|----|
| | | LF | 0.5 | 1.0 | 1.5 | 2.0 | 3.0 | 4.0 | 5.0 | 6.0 | 10.0 | 20.0 | 30.0 | |
| | | DCON | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD | |
| 5549 091-011 | 391.10-16... | 16 | 25 | 25 | 25 | 27 | 27 | 27 | 27 | 27 | 27 | 27 | 27 | — |
| 5549 091-021 | 391.10-22... | 22 | 33 | 33 | 33 | 34 | 34 | 34 | 34 | 34 | 34 | 34 | 34 | 34 |
| 5549 091-061 | 391.10-50... | 50 | 67 | 67 | — | 68 | 68 | 68 | 68 | 68 | 68 | 68 | 68 | 68 |
| 5549 091-071 | 391.10-60... | 60 | 84 | 84 | — | 84 | 84 | 84 | 84 | 84 | 84 | 84 | 84 | 84 |

Coolant screw and washer to CoroMill® 331

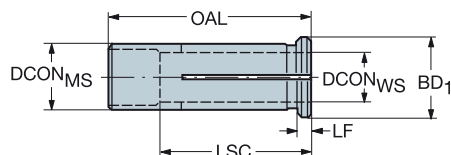


Metric

| Set code | Screw code | Washer code | Arbor size |
|--------------|-------------|-------------|------------|
| 5512 076-101 | 5512 076-01 | 5549 210-01 | 27 |
| 5512 076-102 | 5512 076-02 | 5549 210-02 | 32 |
| 5512 076-103 | 5512 076-03 | 5549 210-03 | 40 |

Cylindrical sleeves

Metallic sealed for coolant through tool



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|--------------------|--------------------|--------------------|----|------|-----|----|-----|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | BD | LSC | OAL | LF | BAR | KG | | |
| 6 | 3 | 1 | 1 | 393.CGS-06 03 27 | 6 | 3 | 9 | 27.0 | 30 | 3 | 80 | 0.012 | | |
| 12 | 3 | 1 | 1 | 393.CGS-12 03 40 | 12 | 3 | 16 | 40.0 | 44 | 4 | 80 | 0.036 | | |
| | 4 | 1 | 1 | 393.CGS-12 04 40 | 12 | 4 | 16 | 40.0 | 44 | 4 | 80 | 0.035 | | |
| | 5 | 1 | 1 | 393.CGS-12 05 40 | 12 | 5 | 16 | 40.0 | 44 | 4 | 80 | 0.030 | | |
| | 6 | 1 | 1 | 393.CGS-12 06 40 | 12 | 6 | 16 | 40.0 | 44 | 4 | 80 | 0.035 | | |
| | 7 | 1 | 1 | 393.CGS-12 07 40 | 12 | 7 | 16 | 40.0 | 44 | 4 | 80 | 0.032 | | |
| | 8 | 1 | 1 | 393.CGS-12 08 40 | 12 | 8 | 16 | 40.0 | 44 | 4 | 80 | 0.029 | | |
| | 9 | 1 | 1 | 393.CGS-12 09 40 | 12 | 9 | 16 | 40.0 | 44 | 4 | 80 | 0.024 | | |
| | 10 | 1 | 1 | 393.CGS-12 10 40 | 12 | 10 | 16 | 40.0 | 44 | 4 | 80 | 0.020 | | |
| 20 | 3 | 1 | 1 | 393.CGS-20 03 52 | 20 | 3 | 25 | 50.0 | 54 | 4 | 80 | 0.118 | | |
| | 4 | 1 | 1 | 393.CGS-20 04 52 | 20 | 4 | 25 | 50.0 | 54 | 4 | 80 | 0.104 | | |
| | 5 | 1 | 1 | 393.CGS-20 05 52 | 20 | 5 | 25 | 50.0 | 54 | 4 | 80 | 0.100 | | |
| | 6 | 1 | 1 | 393.CGS-20 06 52 | 20 | 6 | 25 | 50.0 | 54 | 4 | 80 | 0.110 | | |
| | 7 | 1 | 1 | 393.CGS-20 07 52 | 20 | 7 | 25 | 50.0 | 54 | 4 | 80 | 0.110 | | |
| | 8 | 1 | 1 | 393.CGS-20 08 52 | 20 | 8 | 25 | 50.0 | 54 | 4 | 80 | 0.108 | | |
| | 9 | 1 | 1 | 393.CGS-20 09 52 | 20 | 9 | 25 | 50.0 | 54 | 4 | 80 | 0.106 | | |
| | 9.7 | 1 | 1 | 393.CGS-20 09.7 50 | 20 | 9 | 25 | 50.0 | 54 | 4 | 80 | 0.102 | | |
| | 10 | 1 | 1 | 393.CGS-20 10 52 | 20 | 10 | 25 | 50.0 | 54 | 4 | 80 | 0.102 | | |
| | 11.7 | 1 | 1 | 393.CGS-20 11.7 50 | 20 | 11 | 25 | 50.0 | 54 | 4 | 80 | 0.094 | | |
| | 12 | 1 | 1 | 393.CGS-20 12 52 | 20 | 12 | 25 | 50.0 | 54 | 4 | 80 | 0.094 | | |
| | 14 | 1 | 1 | 393.CGS-20 14 52 | 20 | 14 | 25 | 50.0 | 54 | 4 | 80 | 0.081 | | |
| | 15.7 | 1 | 1 | 393.CGS-20 15.7 50 | 20 | 15 | 25 | 50.0 | 54 | 4 | 80 | 0.067 | | |
| | 16 | 1 | 1 | 393.CGS-20 16 52 | 20 | 16 | 25 | 50.0 | 54 | 4 | 80 | 0.065 | | |
| | 18 | 1 | 1 | 393.CGS-20 18 52 | 20 | 18 | 25 | 50.0 | 54 | 4 | 80 | 0.045 | | |
| 25 | 3 | 1 | 1 | 393.CGS-25 03 56 | 25 | 3 | 30 | 56.0 | 60 | 4 | 80 | 0.212 | | |
| | 4 | 1 | 1 | 393.CGS-25 04 56 | 25 | 4 | 30 | 56.0 | 60 | 4 | 80 | 0.191 | | |
| | 5 | 1 | 1 | 393.CGS-25 05 56 | 25 | 5 | 30 | 56.0 | 60 | 4 | 80 | 0.208 | | |
| | 6 | 1 | 1 | 393.CGS-25 06 56 | 25 | 6 | 30 | 56.0 | 60 | 4 | 80 | 0.192 | | |
| | 7 | 1 | 1 | 393.CGS-25 07 56 | 25 | 7 | 30 | 56.0 | 60 | 4 | 80 | 0.204 | | |
| | 8 | 1 | 1 | 393.CGS-25 08 56 | 25 | 8 | 30 | 56.0 | 60 | 4 | 80 | 0.200 | | |
| | 9 | 1 | 1 | 393.CGS-25 09 56 | 25 | 9 | 30 | 56.0 | 60 | 4 | 80 | 0.197 | | |
| | 9.7 | 1 | 1 | 393.CGS-25 09.7 56 | 25 | 9 | 30 | 56.0 | 60 | 4 | 80 | 0.185 | | |
| | 10 | 1 | 1 | 393.CGS-25 10 56 | 25 | 10 | 30 | 56.0 | 60 | 4 | 80 | 0.186 | | |
| | 11.7 | 1 | 1 | 393.CGS-25 11.7 56 | 25 | 11 | 30 | 56.0 | 60 | 4 | 80 | 0.161 | | |
| | 12 | 1 | 1 | 393.CGS-25 12 56 | 25 | 12 | 30 | 56.0 | 60 | 4 | 80 | 0.167 | | |
| | 14 | 1 | 1 | 393.CGS-25 14 56 | 25 | 14 | 30 | 56.0 | 60 | 4 | 80 | 0.156 | | |
| | 15.7 | 1 | 1 | 393.CGS-25 15.7 56 | 25 | 15 | 30 | 56.0 | 60 | 4 | 80 | 0.151 | | |
| | 16 | 1 | 1 | 393.CGS-25 16 56 | 25 | 16 | 30 | 56.0 | 60 | 4 | 80 | 0.150 | | |
| | 18 | 1 | 1 | 393.CGS-25 18 56 | 25 | 18 | 30 | 56.0 | 60 | 4 | 80 | 0.121 | | |
| | 19.7 | 1 | 1 | 393.CGS-25 19.7 56 | 25 | 19 | 30 | 56.0 | 60 | 4 | 80 | 0.102 | | |
| | 20 | 1 | 1 | 393.CGS-25 20 56 | 25 | 20 | 30 | 56.0 | 60 | 4 | 80 | 0.100 | | |
| 32 | 8 | 1 | 1 | 393.CGS-32 08 60 | 32 | 8 | 36 | 60.0 | 64 | 4 | 80 | 0.329 | | |
| | 10 | 1 | 1 | 393.CGS-32 10 60 | 32 | 10 | 36 | 60.0 | 64 | 4 | 80 | 0.300 | | |
| | 12 | 1 | 1 | 393.CGS-32 12 60 | 32 | 12 | 36 | 60.0 | 64 | 4 | 80 | 0.312 | | |
| | 14 | 1 | 1 | 393.CGS-32 14 60 | 32 | 14 | 36 | 60.0 | 64 | 4 | 80 | 0.300 | | |
| | 15.7 | 1 | 1 | 393.CGS-32 15.7 60 | 32 | 15 | 36 | 60.0 | 64 | 4 | 80 | 0.287 | | |
| | 16 | 1 | 1 | 393.CGS-32 16 60 | 32 | 16 | 36 | 60.0 | 64 | 4 | 80 | 0.288 | | |
| | 18 | 1 | 1 | 393.CGS-32 18 60 | 32 | 18 | 36 | 60.0 | 64 | 4 | 80 | 0.268 | | |
| | 19.7 | 1 | 1 | 393.CGS-32 19.7 60 | 32 | 19 | 36 | 60.0 | 64 | 4 | 80 | 0.248 | | |
| | 20 | 1 | 1 | 393.CGS-32 20 60 | 32 | 20 | 36 | 60.0 | 64 | 4 | 80 | 0.248 | | |
| | 24.7 | 1 | 1 | 393.CGS-32 24.7 60 | 32 | 24 | 36 | 60.0 | 64 | 4 | 80 | 0.184 | | |
| | 25 | 1 | 1 | 393.CGS-32 25 60 | 32 | 25 | 36 | 60.0 | 64 | 4 | 80 | 0.181 | | |

LSC Clamping length required to achieve sealing effect.

For extractors for cylindrical collets, see page M18



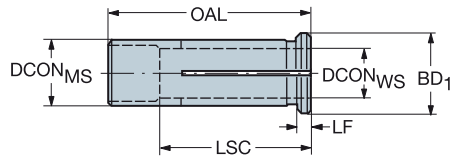
N23



N15

Cylindrical sleeves

Precision coolant supply



| | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|------|-----------------|-------------------|--------------------|--------------------|-------|-------|----|------|------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | OAL | LF | BAR | KG | |
| 12 | 2.90 | 1 | 4 | 393.CF-12 02.9 40 | 12.00 | 2.90 | 40.00 | 44.00 | 4 | 80 | 0.03 | |
| | 3.00 | 1 | 4 | 393.CF-12 03 40 | 12.00 | 3.00 | 40.00 | 44.00 | 4 | 80 | 0.03 | |
| | 3.80 | 1 | 4 | 393.CF-12 03.8 40 | 12.00 | 3.80 | 29.00 | 44.00 | 4 | 80 | 0.03 | |
| | 4.00 | 1 | 4 | 393.CF-12 04 40 | 12.00 | 4.00 | 40.00 | 44.00 | 4 | 80 | 0.03 | |
| | 4.80 | 1 | 4 | 393.CF-12 04.8 40 | 12.00 | 4.80 | 30.00 | 44.00 | 4 | 80 | 0.03 | |
| | 5.00 | 1 | 4 | 393.CF-12 05 40 | 12.00 | 5.00 | 36.00 | 44.00 | 4 | 80 | 0.03 | |
| | 5.80 | 1 | 4 | 393.CF-12 05.8 40 | 12.00 | 5.80 | 36.00 | 44.00 | 4 | 80 | 0.03 | |
| | 6.00 | 1 | 4 | 393.CF-12 06 40 | 12.00 | 6.00 | 36.00 | 44.00 | 4 | 80 | 0.03 | |
| 20 | 7.80 | 1 | 4 | 393.CF-12 07.8 40 | 12.00 | 7.80 | 37.00 | 44.00 | 4 | 80 | 0.02 | |
| | 8.00 | 1 | 4 | 393.CF-12 08 40 | 12.00 | 8.00 | 40.00 | 44.00 | 4 | 80 | 0.02 | |
| | 6.00 | 1 | 4 | 393.CF-20 06 50 | 20.00 | 6.00 | 50.00 | 54.00 | 4 | 80 | 0.11 | |
| | 8.00 | 1 | 4 | 393.CF-20 08 50 | 20.00 | 8.00 | 37.00 | 54.00 | 4 | 80 | 0.10 | |
| | 9.70 | 1 | 4 | 393.CF-20 09.7 50 | 20.00 | 9.70 | 40.00 | 54.00 | 4 | 80 | 0.10 | |
| | 10.00 | 1 | 4 | 393.CF-20 10 50 | 20.00 | 10.00 | 45.00 | 54.00 | 4 | 80 | 0.09 | |
| | 11.70 | 1 | 4 | 393.CF-20 11.7 50 | 20.00 | 11.70 | 45.00 | 54.00 | 4 | 80 | 0.09 | |
| | 12.00 | 1 | 4 | 393.CF-20 12 50 | 20.00 | 12.00 | 45.00 | 54.00 | 4 | 80 | 0.09 | |
| 25 | 15.70 | 1 | 4 | 393.CF-20 15.7 50 | 20.00 | 15.70 | 50.00 | 54.00 | 4 | 80 | 0.06 | |
| | 16.00 | 1 | 4 | 393.CF-20 16 50 | 20.00 | 16.00 | 48.00 | 54.00 | 4 | 80 | 0.06 | |
| | 9.70 | 1 | 4 | 393.CF-25 09.7 56 | 25.00 | 9.70 | 56.00 | 60.00 | 4 | 80 | 0.18 | |
| | 10.00 | 1 | 4 | 393.CF-25 10 56 | 25.00 | 10.00 | 56.00 | 60.00 | 4 | 80 | 0.16 | |
| | 11.70 | 1 | 4 | 393.CF-25 11.7 56 | 25.00 | 11.70 | 41.00 | 60.00 | 4 | 80 | 0.16 | |
| | 12.00 | 1 | 4 | 393.CF-25 12 56 | 25.00 | 12.00 | 46.00 | 60.00 | 4 | 80 | 0.16 | |
| | 15.70 | 1 | 4 | 393.CF-25 15.7 56 | 25.00 | 15.70 | 56.00 | 60.00 | 4 | 80 | 0.15 | |
| | 16.00 | 1 | 4 | 393.CF-25 16 56 | 25.00 | 16.00 | 56.00 | 60.00 | 4 | 80 | 0.15 | |
| 32 | 19.70 | 1 | 4 | 393.CF-25 19.7 56 | 25.00 | 19.70 | 56.00 | 60.00 | 4 | 80 | 0.10 | |
| | 20.00 | 1 | 4 | 393.CF-25 20 56 | 25.00 | 20.00 | 50.00 | 60.00 | 4 | 80 | 0.10 | |
| | 15.70 | 1 | 4 | 393.CF-32 15.7 60 | 32.00 | 15.70 | 60.00 | 64.00 | 4 | 80 | 0.28 | |
| | 19.70 | 1 | 4 | 393.CF-32 19.7 60 | 32.00 | 19.70 | 60.00 | 64.00 | 4 | 80 | 0.24 | |
| | 20.00 | 1 | 4 | 393.CF-32 20 60 | 32.00 | 20.00 | 60.00 | 64.00 | 4 | 80 | 0.24 | |
| | 24.70 | 1 | 4 | 393.CF-32 24.7 60 | 32.00 | 24.70 | 56.00 | 64.00 | 4 | 80 | 0.18 | |
| 25.00 | 1 | 4 | 393.CF-32 25 60 | 32.00 | 25.00 | 57.00 | 64.00 | 4 | 80 | 0.18 | | |

For extractors for cylindrical collets, see page M18



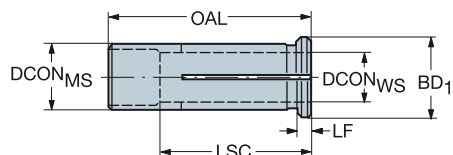
N23



N15

Cylindrical sleeves

Coolant through sleeve



| | | | | | Dimensions, mm | | | | | | | | | | |
|-------------------|-------------------|------|------|-----------------|--------------------|--------------------|----|------|-----|----|-----|-------|--|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | BD | LSC | OAL | LF | BAR | KG | | | |
| 12 | 6 | 1 | 4 | 393.CG-12 06 40 | 12 | 6 | 16 | 40.0 | 44 | 4 | 80 | 0.034 | | | |
| | 7 | 1 | 4 | 393.CG-12 07 40 | 12 | 7 | 16 | 40.0 | 44 | 4 | 80 | 0.030 | | | |
| | 8 | 1 | 4 | 393.CG-12 08 40 | 12 | 8 | 16 | 40.0 | 44 | 4 | 80 | 0.029 | | | |
| | 9 | 1 | 4 | 393.CG-12 09 40 | 12 | 9 | 16 | 40.0 | 44 | 4 | 80 | 0.025 | | | |
| | 10 | 1 | 4 | 393.CG-12 10 40 | 12 | 10 | 16 | 40.0 | 44 | 4 | 80 | 0.020 | | | |
| 20 | 3 | 1 | 4 | 393.CG-20 03 52 | 20 | 3 | 25 | 50.0 | 54 | 4 | 80 | 0.120 | | | |
| | 4 | 1 | 4 | 393.CG-20 04 52 | 20 | 4 | 25 | 50.0 | 54 | 4 | 80 | 0.114 | | | |
| | 5 | 1 | 4 | 393.CG-20 05 52 | 20 | 5 | 25 | 50.0 | 54 | 4 | 80 | 0.100 | | | |
| | 6 | 1 | 4 | 393.CG-20 06 52 | 20 | 6 | 25 | 50.0 | 54 | 4 | 80 | 0.113 | | | |
| | 7 | 1 | 4 | 393.CG-20 07 52 | 20 | 7 | 25 | 50.0 | 54 | 4 | 80 | 0.100 | | | |
| | 8 | 1 | 4 | 393.CG-20 08 52 | 20 | 8 | 25 | 50.0 | 54 | 4 | 80 | 0.109 | | | |
| | 9 | 1 | 4 | 393.CG-20 09 52 | 20 | 9 | 25 | 50.0 | 54 | 4 | 80 | 0.103 | | | |
| | 10 | 1 | 4 | 393.CG-20 10 52 | 20 | 10 | 25 | 50.0 | 54 | 4 | 80 | 0.101 | | | |
| | 12 | 1 | 4 | 393.CG-20 12 52 | 20 | 12 | 25 | 50.0 | 54 | 4 | 80 | 0.095 | | | |
| | 14 | 1 | 4 | 393.CG-20 14 52 | 20 | 14 | 25 | 50.0 | 54 | 4 | 80 | 0.080 | | | |
| 25 | 6 | 1 | 4 | 393.CG-25 06 56 | 25 | 6 | 30 | 56.0 | 60 | 4 | 80 | 0.192 | | | |
| | 8 | 1 | 4 | 393.CG-25 08 56 | 25 | 8 | 30 | 56.0 | 60 | 4 | 80 | 0.200 | | | |
| | 10 | 1 | 4 | 393.CG-25 10 56 | 25 | 10 | 30 | 56.0 | 60 | 4 | 80 | 0.171 | | | |
| | 12 | 1 | 4 | 393.CG-25 12 56 | 25 | 12 | 30 | 56.0 | 60 | 4 | 80 | 0.168 | | | |
| | 14 | 1 | 4 | 393.CG-25 14 56 | 25 | 14 | 30 | 56.0 | 60 | 4 | 80 | 0.154 | | | |
| | 16 | 1 | 4 | 393.CG-25 16 56 | 25 | 16 | 30 | 56.0 | 60 | 4 | 80 | 0.139 | | | |
| | 18 | 1 | 4 | 393.CG-25 18 56 | 25 | 18 | 30 | 56.0 | 60 | 4 | 80 | 0.120 | | | |
| | 20 | 1 | 4 | 393.CG-25 20 56 | 25 | 20 | 30 | 56.0 | 60 | 4 | 80 | 0.100 | | | |
| 32 | 6 | 1 | 4 | 393.CG-32 06 60 | 32 | 6 | 36 | 60.0 | 64 | 4 | 80 | 0.306 | | | |
| | 8 | 1 | 4 | 393.CG-32 08 60 | 32 | 8 | 36 | 60.0 | 64 | 4 | 80 | 0.328 | | | |
| | 10 | 1 | 4 | 393.CG-32 10 60 | 32 | 10 | 36 | 60.0 | 64 | 4 | 80 | 0.324 | | | |
| | 12 | 1 | 4 | 393.CG-32 12 60 | 32 | 12 | 36 | 60.0 | 64 | 4 | 80 | 0.314 | | | |
| | 14 | 1 | 4 | 393.CG-32 14 60 | 32 | 14 | 36 | 60.0 | 64 | 4 | 80 | 0.300 | | | |
| | 16 | 1 | 4 | 393.CG-32 16 60 | 32 | 16 | 36 | 60.0 | 64 | 4 | 80 | 0.282 | | | |
| | 18 | 1 | 4 | 393.CG-32 18 60 | 32 | 18 | 36 | 60.0 | 64 | 4 | 80 | 0.267 | | | |
| | 20 | 1 | 4 | 393.CG-32 20 60 | 32 | 20 | 36 | 60.0 | 64 | 4 | 80 | 0.246 | | | |
| | 25 | 1 | 4 | 393.CG-32 25 60 | 32 | 25 | 36 | 60.0 | 64 | 4 | 80 | 0.181 | | | |

For extractors for cylindrical collets, see page M18



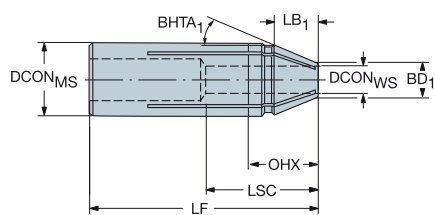
N23



N15

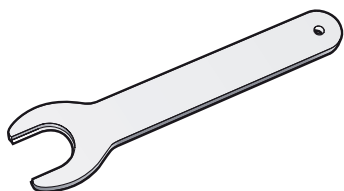
Cylindrical sleeves

Pencil type



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|------------------|--------------------|--------------------|----|----|------|------|----|-----|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | BD | LB | BHTA | LSC | LF | BAR | KG | |
| 20 | 3 | 1 | 4 | 393.CGP-20 03 72 | 20 | 3 | 7 | 14 | 20° | 55.0 | 72 | 80 | 0.134 | |
| | 6 | 1 | 4 | 393.CGP-20 06 72 | 20 | 6 | 9 | 14 | 20° | 55.0 | 72 | 80 | 0.139 | |
| | 8 | 1 | 4 | 393.CGP-20 08 72 | 20 | 8 | 11 | 13 | 17° | 55.0 | 72 | 80 | 0.127 | |
| | 10 | 1 | 4 | 393.CGP-20 10 72 | 20 | 10 | 13 | 13 | 15° | 55.0 | 72 | 80 | 0.123 | |
| | 12 | 1 | 4 | 393.CGP-20 12 72 | 20 | 12 | 15 | 13 | 13° | 55.0 | 72 | 80 | 0.112 | |

Extractor for cylindrical sleeves



| Ordering code | For collet size |
|---------------|-----------------|
| 5680 061-01 | 12 |
| 5680 061-02 | 16 |
| 5680 061-03 | 20 |
| 5680 061-04 | 25 |
| 5680 061-05 | 32 |



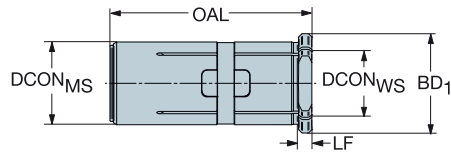
N23



N15

Cylindrical sleeve with mechanical locking interface

393.CLF



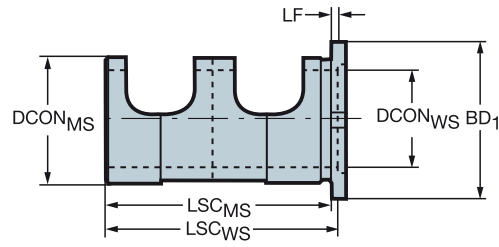
| Application | Ordering code | Dimensions, mm | | | | | Accessories | |
|-----------------------|----------------|--------------------|--------------------|-----------------|----|-----|--------------|---------------|
| | | DCON _{WS} | DCON _{MS} | BD ₁ | LF | OAL | Anchor screw | Assembly tool |
| CoroChuck™ 930 HD32 | 393.CLF-321660 | 16 | 32 | 36 | 4 | 65 | 5519 140-02 | 5680 140-02 |
| | 393.CLF-322060 | 20 | 32 | 36 | 4 | 65 | | |
| | 393.CLF-322560 | 25 | 32 | 36 | 4 | 65 | | |
| CoroChuck™ 930 HD/S25 | 393.CLF-251256 | 12 | 25 | 30 | 4 | 61 | 5519 140-02 | 5680 140-02 |
| | 393.CLF-251656 | 16 | 25 | 30 | 4 | 61 | | |
| | 393.CLF-252056 | 20 | 25 | 30 | 4 | 61 | | |
| CoroChuck™ 930 HD/S20 | 393.CLF-201052 | 10 | 20 | 25 | 4 | 55 | 5519 140-01 | 5680 140-01 |
| | 393.CLF-201252 | 12 | 20 | 25 | 4 | 55 | | |
| | 393.CLF-201652 | 16 | 20 | 25 | 4 | 55 | | |

Anchor screw and assembly tool to be ordered separately.

For assembly instructions, please see www.sandvik.coromant.com/corochuck930/instructions

Eccentric sleeve

For CoroDrill® 880



Dimensions, mm

| CZC _{MS} | CZC _{WS} | ADJLN | ADJLX | Ordering code | DCON _{MS} | DCON _{WS} | BD ₁ | LB ₁ | OAL | LF | KG |
|-------------------|-------------------|-------|-------|---------------|--------------------|--------------------|-----------------|-----------------|-----|----|-------|
| 25 | 20 | -0.30 | 0.30 | 416.2-L20-25 | 25 | 20 | 33 | 5 | 60 | 2 | 0.084 |
| 32 | 25 | -0.30 | 0.30 | 416.2-L25-32 | 32 | 25 | 40 | 5 | 65 | 3 | 0.153 |
| 40 | 32 | -0.30 | 0.30 | 416.2-L32-40 | 40 | 32 | 50 | 5 | 75 | 2 | 0.238 |
| 50 | 40 | -0.30 | 0.30 | 416.2-L40-50 | 50 | 40 | 60 | 5 | 85 | 2 | 0.419 |



N23

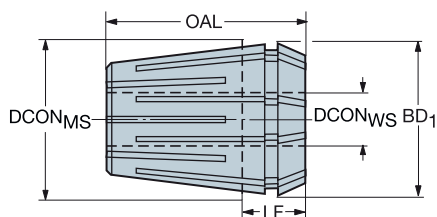


N15

ER collet

Metallic sealed for coolant through tool

Compatible with DIN 6499-B



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|--------|--------------|---------------|--------------------|--------------------|---------------------|---------------------|-----------------|-----|-----|-------|-------|-------|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | DCON _{NWS} | DCON _{XWS} | BD ₁ | OAL | LF | BAR | KG | |
| ER16 | 3 (H9) | 1 | 1 | 393.15-16 03 | 17 | 3 | | | 17 | 27 | 10 | 300 | 0.026 | |
| | 4 (H9) | 1 | 1 | 393.15-16 04 | 17 | 4 | | | 17 | 27 | 10 | 300 | 0.025 | |
| | 5.0 - 4.5 | 1 | 1 | 393.15-16 05 | 17 | | 4.5 | 5.0 | 17 | 27 | 10 | 300 | 0.026 | |
| | 6.0 - 5.5 | 1 | 1 | 393.15-16 06 | 17 | | 5.5 | 6.0 | 17 | 27 | 10 | 300 | 0.024 | |
| | 8.0 - 7.5 | 1 | 1 | 393.15-16 08 | 17 | | 7.5 | 8.0 | 17 | 27 | 10 | 300 | 0.021 | |
| | 10.0 - 9.5 | 1 | 1 | 393.15-16 10 | 17 | | 9.5 | 10.0 | 17 | 27 | 10 | 300 | 0.017 | |
| ER20 | 3 (H9) | 1 | 1 | 393.15-20 03 | 21 | 3 | | | 21 | 31 | 11 | 300 | 0.047 | |
| | 4 (H9) | 1 | 1 | 393.15-20 04 | 21 | 4 | | | 21 | 31 | 11 | 300 | 0.046 | |
| | 5 (H9) | 1 | 1 | 393.15-20 05 | 21 | 5 | | | 21 | 31 | 11 | 300 | 0.045 | |
| | 6 (H9) | 1 | 1 | 393.15-20 06 | 21 | 6 | | | 21 | 31 | 11 | 300 | 0.044 | |
| | 8.0 - 7.5 | 1 | 1 | 393.15-20 08 | 21 | | 7.5 | 8.0 | 21 | 31 | 11 | 300 | 0.041 | |
| | 10.0 - 9.5 | 1 | 1 | 393.15-20 10 | 21 | | 9.5 | 10.0 | 21 | 31 | 11 | 300 | 0.036 | |
| | 12.0 - 11.5 | 1 | 1 | 393.15-20 12 | 21 | | 11.5 | 12.0 | 21 | 31 | 11 | 300 | 0.030 | |
| | ER25 | 6 (H9) | 1 | 1 | 393.15-25 06 | 26 | 6 | | | 26 | 34 | 11 | 300 | 0.080 |
| 8.0 - 7.5 | | 1 | 1 | 393.15-25 08 | 26 | | 7.5 | 8.0 | 26 | 34 | 11 | 300 | 0.078 | |
| 10.0 - 9.5 | | 1 | 1 | 393.15-25 10 | 26 | | 9.5 | 10.0 | 26 | 34 | 11 | 300 | 0.074 | |
| 12.0 - 11.5 | | 1 | 1 | 393.15-25 12 | 26 | | 11.5 | 12.0 | 26 | 34 | 11 | 300 | 0.066 | |
| 14.0 - 13.5 | | 1 | 1 | 393.15-25 14 | 26 | | 13.5 | 14.0 | 26 | 34 | 11 | 300 | 0.060 | |
| 16.0 - 15.5 | | 1 | 1 | 393.15-25 16 | 26 | | 15.5 | 16.0 | 26 | 34 | 11 | 300 | 0.049 | |
| ER32 | 6 (H9) | 1 | 1 | 393.15-32 06 | 33 | 6 | | | 33 | 40 | 12 | 300 | 0.163 | |
| | 8.0 - 7.5 | 1 | 1 | 393.15-32 08 | 33 | | 7.5 | 8.0 | 33 | 40 | 12 | 300 | 0.167 | |
| | 10.0 - 9.5 | 1 | 1 | 393.15-32 10 | 33 | | 9.5 | 10.0 | 33 | 40 | 12 | 300 | 0.158 | |
| | 12.0 - 11.5 | 1 | 1 | 393.15-32 12 | 33 | | 11.5 | 12.0 | 33 | 40 | 12 | 300 | 0.154 | |
| | 14.0 - 13.5 | 1 | 1 | 393.15-32 14 | 33 | | 13.5 | 14.0 | 33 | 40 | 12 | 300 | 0.135 | |
| | 16.0 - 15.5 | 1 | 1 | 393.15-32 16 | 33 | | 15.5 | 16.0 | 33 | 40 | 12 | 300 | 0.124 | |
| | 18.0 - 17.5 | 1 | 1 | 393.15-32 18 | 33 | | 17.5 | 18.0 | 33 | 40 | 12 | 300 | 0.112 | |
| | 20.0 - 19.5 | 1 | 1 | 393.15-32 20 | 33 | | 19.5 | 20.0 | 33 | 40 | 12 | 300 | 0.098 | |
| ER40 | 6 (H9) | 1 | 1 | 393.15-40 06 | 41 | 6 | | | 41 | 46 | 14 | 300 | 0.291 | |
| | 8 (H9) | 1 | 1 | 393.15-40 08 | 41 | 8 | | | 41 | 46 | 14 | 300 | 0.289 | |
| | 10.0 - 9.5 | 1 | 1 | 393.15-40 10 | 41 | | 9.5 | 10.0 | 41 | 46 | 14 | 300 | 0.293 | |
| | 12.0 - 11.5 | 1 | 1 | 393.15-40 12 | 41 | | 11.5 | 12.0 | 41 | 46 | 14 | 300 | 0.286 | |
| | 14.0 - 13.5 | 1 | 1 | 393.15-40 14 | 41 | | 13.5 | 14.0 | 41 | 46 | 14 | 300 | 0.276 | |
| | 16.0 - 15.5 | 1 | 1 | 393.15-40 16 | 41 | | 15.5 | 16.0 | 41 | 46 | 14 | 300 | 0.265 | |
| | 18.0 - 17.5 | 1 | 1 | 393.15-40 18 | 41 | | 17.5 | 18.0 | 41 | 46 | 14 | 300 | 0.250 | |
| | 20.0 - 19.5 | 1 | 1 | 393.15-40 20 | 41 | | 19.5 | 20.0 | 41 | 46 | 14 | 300 | 0.232 | |
| 25.0 - 24.5 | 1 | 1 | 393.15-40 25 | 41 | | 24.5 | 25.0 | 41 | 46 | 14 | 300 | 0.181 | | |



N23

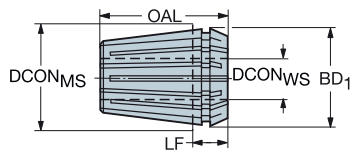


N15

ER collet

Coolant through collet

Compatible with DIN 6499-B



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|----------------|----------------|--------------------|--------------------|---------------------|-----------------|-----|-----|-------|-------|--|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | DCON _{XWS} | BD ₁ | OAL | LF | BAR | KG | | |
| ER8 | 3.00 - 2.50 | 1 | 4 | 393.14-08 0300 | 8 | 2.5 | 3.0 | 8 | 13 | 4 | 300 | 0.005 | | |
| | 3.50 - 3.00 | 1 | 4 | 393.14-08 0350 | 8 | 3.0 | 3.5 | 8 | 13 | 4 | 300 | 0.005 | | |
| | 4.00 - 3.50 | 1 | 4 | 393.14-08 0400 | 8 | 3.5 | 4.0 | 11 | 13 | 4 | 300 | 0.005 | | |
| ER11 | 1.00 - 0.75 | 1 | 4 | 393.14-11 0100 | 11 | 0.8 | 1.0 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 1.25 - 1.00 | 1 | 4 | 393.14-11 0125 | 11 | 1.0 | 1.3 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 1.50 - 1.25 | 1 | 4 | 393.14-11 0150 | 11 | 1.3 | 1.5 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 1.75 - 1.50 | 1 | 4 | 393.14-11 0175 | 11 | 1.5 | 1.8 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 2.00 - 1.75 | 1 | 4 | 393.14-11 0200 | 11 | 1.8 | 2.0 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 2.25 - 2.00 | 1 | 4 | 393.14-11 0225 | 11 | 2.0 | 2.3 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 2.50 - 2.25 | 1 | 4 | 393.14-11 0250 | 11 | 2.3 | 2.5 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 3.00 - 2.50 | 1 | 4 | 393.14-11 0300 | 11 | 2.5 | 3.0 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 3.50 - 3.00 | 1 | 4 | 393.14-11 0350 | 11 | 3.0 | 3.5 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 4.00 - 3.50 | 1 | 4 | 393.14-11 0400 | 11 | 3.5 | 4.0 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 4.50 - 4.00 | 1 | 4 | 393.14-11 0450 | 11 | 4.0 | 4.5 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 5.00 - 4.50 | 1 | 4 | 393.14-11 0500 | 11 | 4.5 | 5.0 | 11 | 18 | 6 | 300 | 0.009 | | |
| | 5.50 - 5.00 | 1 | 4 | 393.14-11 0550 | 11 | 5.0 | 5.5 | 11 | 18 | 6 | 300 | 0.008 | | |
| | 6.00 - 5.50 | 1 | 4 | 393.14-11 0600 | 11 | 5.5 | 6.0 | 11 | 18 | 6 | 300 | 0.007 | | |
| | 6.50 - 6.00 | 1 | 4 | 393.14-11 0650 | 11 | 6.0 | 6.5 | 11 | 18 | 6 | 300 | 0.007 | | |
| 7.00 - 6.50 | 1 | 4 | 393.14-11 0700 | 11 | 6.5 | 7.0 | 11 | 18 | 6 | 300 | 0.006 | | | |
| ER16 | 1.0 - 0.5 | 1 | 4 | 393.14-16 0100 | 17 | 0.5 | 1.0 | 17 | 27 | 10 | 300 | 0.027 | | |
| | 1.5 - 1.0 | 1 | 4 | 393.14-16 0150 | 17 | 1.0 | 1.5 | 17 | 27 | 10 | 300 | 0.027 | | |
| | 2.0 - 1.0 | 1 | 4 | 393.14-16 0200 | 17 | 1.0 | 2.0 | 17 | 27 | 10 | 300 | 0.027 | | |
| | 2.5 - 1.5 | 1 | 4 | 393.14-16 0250 | 17 | 1.5 | 2.5 | 17 | 27 | 10 | 300 | 0.027 | | |
| | 3.0 - 2.0 | 1 | 4 | 393.14-16 0300 | 17 | 2.0 | 3.0 | 17 | 27 | 10 | 300 | 0.024 | | |
| | 4.0 - 3.0 | 1 | 4 | 393.14-16 0400 | 17 | 3.0 | 4.0 | 17 | 27 | 10 | 300 | 0.003 | | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-16 0500 | 17 | 4.0 | 5.0 | 17 | 27 | 10 | 300 | 0.025 | | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-16 0600 | 17 | 5.0 | 6.0 | 17 | 27 | 10 | 300 | 0.023 | | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-16 0700 | 17 | 6.0 | 7.0 | 17 | 27 | 10 | 300 | 0.021 | | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-16 0800 | 17 | 7.0 | 8.0 | 17 | 27 | 10 | 300 | 0.020 | | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-16 0900 | 17 | 8.0 | 9.0 | 17 | 27 | 10 | 300 | 0.018 | | |
| 10.0 - 9.0 | 1 | 4 | 393.14-16 1000 | 17 | 9.0 | 10.0 | 17 | 27 | 10 | 300 | 0.016 | | | |
| ER20 | 1.5 - 1.0 | 1 | 4 | 393.14-20 015 | 21 | 1.0 | 1.5 | 21 | 31 | 11 | 300 | 0.047 | | |
| | 2.0 - 1.5 | 1 | 4 | 393.14-20 020 | 21 | 1.5 | 2.0 | 21 | 31 | 11 | 300 | 0.049 | | |
| | 2.5 - 2.0 | 1 | 4 | 393.14-20 025 | 21 | 2.0 | 2.5 | 21 | 31 | 11 | 300 | 0.048 | | |
| | 3.0 - 2.5 | 1 | 4 | 393.14-20 030 | 21 | 2.5 | 3.0 | 21 | 31 | 11 | 300 | 0.046 | | |
| | 4.0 - 3.0 | 1 | 4 | 393.14-20 040 | 21 | 3.0 | 4.0 | 21 | 31 | 11 | 300 | 0.045 | | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-20 050 | 21 | 4.0 | 5.0 | 21 | 31 | 11 | 300 | 0.044 | | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-20 060 | 21 | 5.0 | 6.0 | 21 | 31 | 11 | 300 | 0.043 | | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-20 070 | 21 | 6.0 | 7.0 | 21 | 31 | 11 | 300 | 0.041 | | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-20 080 | 21 | 7.0 | 8.0 | 21 | 31 | 11 | 300 | 0.037 | | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-20 090 | 21 | 8.0 | 9.0 | 21 | 31 | 11 | 300 | 0.037 | | |
| | 10.0 - 9.0 | 1 | 4 | 393.14-20 100 | 21 | 9.0 | 10.0 | 21 | 31 | 11 | 300 | 0.034 | | |
| | 11.0 - 10.0 | 1 | 4 | 393.14-20 110 | 21 | 10.0 | 11.0 | 21 | 31 | 11 | 300 | 0.033 | | |
| | 12.0 - 11.0 | 1 | 4 | 393.14-20 120 | 21 | 11.0 | 12.0 | 21 | 31 | 11 | 300 | 0.031 | | |
| 13.0 - 12.0 | 1 | 4 | 393.14-20 130 | 21 | 12.0 | 13.0 | 21 | 31 | 11 | 300 | 0.026 | | | |
| ER25 | 2.0 - 1.5 | 1 | 4 | 393.14-25 020 | 26 | 1.5 | 2.0 | 26 | 34 | 11 | 300 | 0.079 | | |
| | 2.5 - 2.0 | 1 | 4 | 393.14-25 025 | 26 | 2.0 | 2.5 | 26 | 34 | 11 | 300 | 0.079 | | |
| | 3.0 - 2.5 | 1 | 4 | 393.14-25 030 | 26 | 2.5 | 3.0 | 26 | 34 | 11 | 300 | 0.078 | | |
| | 4.0 - 3.0 | 1 | 4 | 393.14-25 040 | 26 | 3.0 | 4.0 | 26 | 34 | 11 | 300 | 0.079 | | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-25 050 | 26 | 4.0 | 5.0 | 26 | 34 | 11 | 300 | 0.078 | | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-25 060 | 26 | 5.0 | 6.0 | 26 | 34 | 11 | 300 | 0.076 | | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-25 070 | 26 | 6.0 | 7.0 | 26 | 34 | 11 | 300 | 0.076 | | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-25 080 | 26 | 7.0 | 8.0 | 26 | 34 | 11 | 300 | 0.073 | | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-25 090 | 26 | 8.0 | 9.0 | 26 | 34 | 11 | 300 | 0.078 | | |
| | 10.0 - 9.0 | 1 | 4 | 393.14-25 100 | 26 | 9.0 | 10.0 | 26 | 34 | 11 | 300 | 0.070 | | |
| | 11.0 - 10.0 | 1 | 4 | 393.14-25 110 | 26 | 10.0 | 11.0 | 26 | 34 | 11 | 300 | 0.067 | | |
| | 12.0 - 11.0 | 1 | 4 | 393.14-25 120 | 26 | 11.0 | 12.0 | 26 | 34 | 11 | 300 | 0.064 | | |
| | 13.0 - 12.0 | 1 | 4 | 393.14-25 130 | 26 | 12.0 | 13.0 | 26 | 34 | 11 | 300 | 0.063 | | |
| | 14.0 - 13.0 | 1 | 4 | 393.14-25 140 | 26 | 13.0 | 14.0 | 26 | 34 | 11 | 300 | 0.057 | | |
| 15.0 - 14.0 | 1 | 4 | 393.14-25 150 | 26 | 14.0 | 15.0 | 26 | 34 | 11 | 300 | 0.054 | | | |
| 16.0 - 15.0 | 1 | 4 | 393.14-25 160 | 26 | 15.0 | 16.0 | 26 | 34 | 11 | 300 | 0.047 | | | |



N23

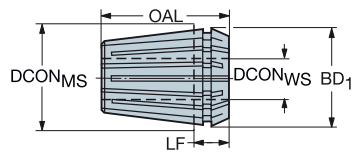


N15

ER collet

Coolant through collet

Compatible with DIN 6499-B



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|---------------|---------------|--------------------|--------------------|--------------------|-----------------|-----|-----|-------|-------|--|--|
| CZG _{MS} | CZG _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | DCON _{WS} | BD ₁ | OAL | LF | BAR | KG | | |
| ER32 | 2.5 - 2.0 | 1 | 4 | 393.14-32 025 | 33 | 2.0 | 2.5 | 33 | 40 | 12 | 300 | 0.155 | | |
| | 3.0 - 2.5 | 1 | 4 | 393.14-32 030 | 33 | 2.5 | 3.0 | 33 | 40 | 12 | 300 | 0.161 | | |
| | 4.0 - 3.0 | 1 | 4 | 393.14-32 040 | 33 | 3.0 | 4.0 | 33 | 40 | 12 | 300 | 0.154 | | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-32 050 | 33 | 4.0 | 5.0 | 33 | 40 | 12 | 300 | 0.151 | | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-32 060 | 33 | 5.0 | 6.0 | 33 | 40 | 12 | 300 | 0.157 | | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-32 070 | 33 | 6.0 | 7.0 | 33 | 40 | 12 | 300 | 0.161 | | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-32 080 | 33 | 7.0 | 8.0 | 33 | 40 | 12 | 300 | 0.158 | | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-32 090 | 33 | 8.0 | 9.0 | 33 | 40 | 12 | 300 | 0.157 | | |
| | 10.0 - 9.0 | 1 | 4 | 393.14-32 100 | 33 | 9.0 | 10.0 | 33 | 40 | 12 | 300 | 0.144 | | |
| | 11.0 - 10.0 | 1 | 4 | 393.14-32 110 | 33 | 10.0 | 11.0 | 33 | 40 | 12 | 300 | 0.151 | | |
| | 12.0 - 11.0 | 1 | 4 | 393.14-32 120 | 33 | 11.0 | 12.0 | 33 | 40 | 12 | 300 | 0.147 | | |
| | 13.0 - 12.0 | 1 | 4 | 393.14-32 130 | 33 | 12.0 | 13.0 | 33 | 40 | 12 | 300 | 0.143 | | |
| | 14.0 - 13.0 | 1 | 4 | 393.14-32 140 | 33 | 13.0 | 14.0 | 33 | 40 | 12 | 300 | 0.142 | | |
| | 15.0 - 14.0 | 1 | 4 | 393.14-32 150 | 33 | 14.0 | 15.0 | 33 | 40 | 12 | 300 | 0.124 | | |
| | 16.0 - 15.0 | 1 | 4 | 393.14-32 160 | 33 | 15.0 | 16.0 | 33 | 40 | 12 | 300 | 0.126 | | |
| | 17.0 - 16.0 | 1 | 4 | 393.14-32 170 | 33 | 16.0 | 17.0 | 33 | 40 | 12 | 300 | 0.114 | | |
| 18.0 - 17.0 | 1 | 4 | 393.14-32 180 | 33 | 17.0 | 18.0 | 33 | 40 | 12 | 300 | 0.108 | | | |
| 19.0 - 18.0 | 1 | 4 | 393.14-32 190 | 33 | 18.0 | 19.0 | 33 | 40 | 12 | 300 | 0.109 | | | |
| 20.0 - 19.0 | 1 | 4 | 393.14-32 200 | 33 | 19.0 | 20.0 | 33 | 40 | 12 | 300 | 0.095 | | | |
| ER40 | 4.0 - 3.0 | 1 | 4 | 393.14-40 040 | 41 | 3.0 | 4.0 | 41 | 46 | 14 | 300 | 0.302 | | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-40 050 | 41 | 4.0 | 5.0 | 41 | 46 | 14 | 300 | 0.316 | | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-40 060 | 41 | 5.0 | 6.0 | 41 | 46 | 14 | 300 | 0.304 | | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-40 070 | 41 | 6.0 | 7.0 | 41 | 46 | 14 | 300 | 0.282 | | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-40 080 | 41 | 7.0 | 8.0 | 41 | 46 | 14 | 300 | 0.305 | | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-40 090 | 41 | 8.0 | 9.0 | 41 | 46 | 14 | 300 | 0.302 | | |
| | 10.0 - 9.0 | 1 | 4 | 393.14-40 100 | 41 | 9.0 | 10.0 | 41 | 46 | 14 | 300 | 0.299 | | |
| | 11.0 - 10.0 | 1 | 4 | 393.14-40 110 | 41 | 10.0 | 11.0 | 41 | 46 | 14 | 300 | 0.295 | | |
| | 12.0 - 11.0 | 1 | 4 | 393.14-40 120 | 41 | 11.0 | 12.0 | 41 | 46 | 14 | 300 | 0.292 | | |
| | 13.0 - 12.0 | 1 | 4 | 393.14-40 130 | 41 | 12.0 | 13.0 | 41 | 46 | 14 | 300 | 0.286 | | |
| | 14.0 - 13.0 | 1 | 4 | 393.14-40 140 | 41 | 13.0 | 14.0 | 41 | 46 | 14 | 300 | 0.281 | | |
| | 15.0 - 14.0 | 1 | 4 | 393.14-40 150 | 41 | 14.0 | 15.0 | 41 | 46 | 14 | 300 | 0.275 | | |
| | 16.0 - 15.0 | 1 | 4 | 393.14-40 160 | 41 | 15.0 | 16.0 | 41 | 46 | 14 | 300 | 0.269 | | |
| | 17.0 - 16.0 | 1 | 4 | 393.14-40 170 | 41 | 16.0 | 17.0 | 41 | 46 | 14 | 300 | 0.261 | | |
| | 18.0 - 17.0 | 1 | 4 | 393.14-40 180 | 41 | 17.0 | 18.0 | 41 | 46 | 14 | 300 | 0.253 | | |
| | 19.0 - 18.0 | 1 | 4 | 393.14-40 190 | 41 | 18.0 | 19.0 | 41 | 46 | 14 | 300 | 0.250 | | |
| 20.0 - 19.0 | 1 | 4 | 393.14-40 200 | 41 | 19.0 | 20.0 | 41 | 46 | 14 | 300 | 0.228 | | | |
| 21.0 - 20.0 | 1 | 4 | 393.14-40 210 | 41 | 20.0 | 21.0 | 41 | 46 | 14 | 300 | 0.217 | | | |
| 22.0 - 21.0 | 1 | 4 | 393.14-40 220 | 41 | 21.0 | 22.0 | 41 | 46 | 14 | 300 | 0.220 | | | |
| 23.0 - 22.0 | 1 | 4 | 393.14-40 230 | 41 | 22.0 | 23.0 | 41 | 46 | 14 | 300 | 0.210 | | | |
| 24.0 - 23.0 | 1 | 4 | 393.14-40 240 | 41 | 23.0 | 24.0 | 41 | 46 | 14 | 300 | 0.198 | | | |
| 25.0 - 24.0 | 1 | 4 | 393.14-40 250 | 41 | 24.0 | 25.0 | 41 | 46 | 14 | 300 | 0.187 | | | |
| 26.0 - 25.0 | 1 | 4 | 393.14-40 260 | 41 | 25.0 | 26.0 | 41 | 46 | 14 | 300 | 0.174 | | | |
| ER50 | 26.0 - 24.0 | 1 | 4 | 393.14-50 260 | 52 | 24.0 | 26.0 | 52 | 60 | 21 | 300 | 0.478 | | |
| | 28.0 - 26.0 | 1 | 4 | 393.14-50 280 | 52 | 26.0 | 28.0 | 52 | 60 | 21 | 300 | 0.461 | | |
| | 30.0 - 28.0 | 1 | 4 | 393.14-50 300 | 52 | 28.0 | 30.0 | 52 | 60 | 21 | 300 | 0.413 | | |
| | 32.0 - 30.0 | 1 | 4 | 393.14-50 320 | 52 | 30.0 | 32.0 | 52 | 60 | 21 | 300 | 0.371 | | |
| | 34.0 - 32.0 | 1 | 4 | 393.14-50 340 | 52 | 32.0 | 34.0 | 52 | 60 | 21 | 300 | 0.332 | | |
| | 36.0 - 34.0 | 1 | 4 | 393.14-50 360 | 52 | 34.0 | 36.0 | 52 | 60 | 21 | 300 | 0.279 | | |



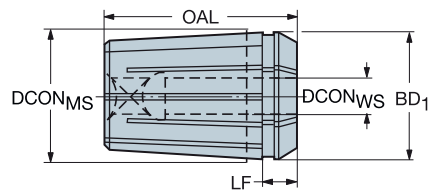
N23



N15

ER Collet for tap shank

Compatible with DIN 6499-B



| | | | | | Dimensions, mm | | | | | | | | |
|-------------------|-------------------|-------------|--------------------|---------------------|--------------------|--------------------|-----------------|-----|-----|-------|-------|-------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | BD ₁ | OAL | LF | BAR | KG | | |
| ER11 | 4.00 x 3.15 | 1 | 4 | 393.14-11 D040X0315 | 11 | 4 | 11 | 18 | 4 | 300 | 0.009 | | |
| | 2.50 x 2.00 | 1 | 4 | 393.14-11 D025X021 | 11 | 2 | 11 | 18 | 4 | 300 | 0.009 | | |
| | 2.80 x 2.10 | 1 | 4 | 393.14-11 D028X021 | 11 | 2 | 11 | 18 | 4 | 300 | 0.010 | | |
| | 5.00 x 4.00 | 1 | 4 | 393.14-11 D050X040 | 11 | 5 | 11 | 18 | 4 | 300 | 0.008 | | |
| | 3.50 x 2.70 | 1 | 4 | 393.14-11 D035X027 | 11 | 3 | 11 | 18 | 4 | 300 | 0.010 | | |
| | 4.00 x 3.00 | 1 | 4 | 393.14-11 D040X030 | 11 | 4 | 11 | 18 | 4 | 300 | 0.009 | | |
| | 4.50 x 3.40 | 1 | 4 | 393.14-11 D045X034 | 11 | 4 | 11 | 18 | 4 | 300 | 0.008 | | |
| 6.00 x 4.90 | 1 | 4 | 393.14-11 D060X049 | 11 | 6 | 11 | 18 | 4 | 300 | 0.007 | | | |
| ER20 | 4.00 x 3.15 | 1 | 4 | 393.14-20 D040X0315 | 20 | 4 | 21 | 31 | 7 | 300 | 0.047 | | |
| | 5.00 x 4.00 | 1 | 4 | 393.14-20 D050X040 | 20 | 5 | 21 | 31 | 7 | 300 | 0.044 | | |
| | 3.50 x 2.70 | 1 | 4 | 393.14-20 D035X027 | 20 | 3 | 21 | 31 | 7 | 300 | 0.045 | | |
| | 6.30 x 5.00 | 1 | 4 | 393.14-20 D063X050 | 20 | 6 | 21 | 31 | 7 | 300 | 0.042 | | |
| | 7.10 x 5.60 | 1 | 4 | 393.14-20 D071X056 | 20 | 7 | 21 | 31 | 7 | 300 | 0.043 | | |
| | 4.50 x 3.40 | 1 | 4 | 393.14-20 D045X034 | 20 | 4 | 21 | 31 | 7 | 300 | 0.043 | | |
| | 8.00 x 6.30 | 1 | 4 | 393.14-20 D080X063 | 20 | 8 | 21 | 31 | 7 | 300 | 0.039 | | |
| | 5.50 x 4.30 | 1 | 4 | 393.14-20 D055X043 | 20 | 5 | 21 | 31 | 7 | 300 | 0.043 | | |
| | 9.00 x 7.10 | 1 | 4 | 393.14-20 D090X071 | 20 | 9 | 21 | 31 | 7 | 300 | 0.039 | | |
| | 6.00 x 4.90 | 1 | 4 | 393.14-20 D060X049 | 20 | 6 | 21 | 31 | 7 | 300 | 0.042 | | |
| | 10.00 x 8.00 | 1 | 4 | 393.14-20 D100X080 | 20 | 10 | 21 | 31 | 7 | 300 | 0.035 | | |
| | 7.00 x 5.50 | 1 | 4 | 393.14-20 D070X055 | 20 | 7 | 21 | 31 | 7 | 300 | 0.041 | | |
| | ER25 | 8.00 x 6.30 | 1 | 4 | 393.14-25 D080X063 | 25 | 8 | 26 | 34 | 8 | 300 | 0.077 | |
| 9.00 x 7.10 | | 1 | 4 | 393.14-25 D090X071 | 25 | 9 | 26 | 34 | 8 | 300 | 0.077 | | |
| 6.00 x 4.90 | | 1 | 4 | 393.14-25 D060X049 | 25 | 6 | 26 | 34 | 8 | 300 | 0.077 | | |
| 10.00 x 8.00 | | 1 | 4 | 393.14-25 D100X080 | 25 | 10 | 26 | 34 | 8 | 300 | 0.074 | | |
| 7.00 x 5.50 | | 1 | 4 | 393.14-25 D070X055 | 25 | 7 | 26 | 34 | 8 | 300 | 0.076 | | |
| 11.20 x 9.00 | | 1 | 4 | 393.14-25 D112X090 | 25 | 11 | 26 | 34 | 8 | 300 | 0.071 | | |
| 12.50 x 10.00 | | 1 | 4 | 393.14-25 D125X100 | 25 | 12 | 26 | 34 | 8 | 300 | 0.065 | | |
| 14.00 x 11.20 | | 1 | 4 | 393.14-25 D140X112 | 25 | 14 | 26 | 34 | 8 | 300 | 0.057 | | |
| 11.00 x 9.00 | | 1 | 4 | 393.14-25 D110X090 | 25 | 11 | 26 | 34 | 8 | 300 | 0.071 | | |
| 12.00 x 9.00 | | 1 | 4 | 393.14-25 D120X090 | 25 | 12 | 26 | 34 | 8 | 300 | 0.067 | | |
| 16.00 x 12.00 | 1 | 4 | 393.14-25 D160X120 | 25 | 16 | 26 | 34 | 8 | 300 | 0.047 | | | |
| ER40 | 12.50 x 10.00 | 1 | 4 | 393.14-40 D125X100 | 40 | 12 | 41 | 46 | 11 | 300 | 0.283 | | |
| | 14.00 x 11.20 | 1 | 4 | 393.14-40 D140X112 | 40 | 14 | 41 | 46 | 11 | 300 | 0.275 | | |
| | 16.00 x 12.50 | 1 | 4 | 393.14-40 D160X125 | 40 | 16 | 41 | 46 | 11 | 300 | 0.265 | | |
| | 12.00 x 9.00 | 1 | 4 | 393.14-40 D120X090 | 40 | 12 | 41 | 46 | 11 | 300 | 0.281 | | |
| | 18.00 x 14.50 | 1 | 4 | 393.14-40 D180X145 | 40 | 18 | 41 | 46 | 11 | 300 | 0.248 | | |
| | 20.00 x 16.00 | 1 | 4 | 393.14-40 D200X160 | 40 | 20 | 41 | 46 | 11 | 300 | 0.234 | | |
| | 22.00 x 18.00 | 1 | 4 | 393.14-40 D220X180 | 40 | 22 | 41 | 46 | 11 | 300 | 0.213 | | |
| ER50 | 22.00 x 18.00 | 1 | 4 | 393.14-50 D220X180 | 52 | 22 | 52 | 60 | 17 | 300 | 0.543 | | |
| | 25.00 x 20.00 | 1 | 4 | 393.14-50 D250X200 | 52 | 25 | 52 | 60 | 17 | 300 | 0.500 | | |
| | 28.00 x 22.00 | 1 | 4 | 393.14-50 D280X220 | 52 | 28 | 52 | 60 | 17 | 300 | 0.449 | | |
| | 32.00 x 24.00 | 1 | 4 | 393.14-50 D320X240 | 52 | 32 | 52 | 60 | 17 | 300 | 0.380 | | |

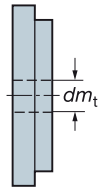
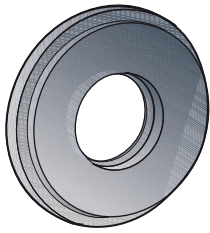


N23



N15

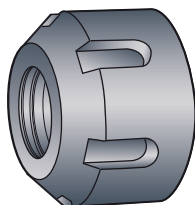
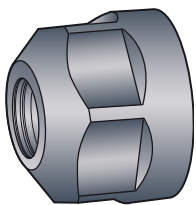
ER collet sealing discs



| Size 16 | | Size 25 | | Size 32 | | Size 40 | |
|---------------------|---------------|---------------------|---------------|---------------------|---------------|---------------------|---------------|
| Range, mm dm_t | Ordering code | Range, mm dm_t | Ordering code | Range, mm dm_t | Ordering code | Range, mm dm_t | Ordering code |
| 3.0-2.5 | 3916.00300 | 6.0-5.5 | 3925.00600 | 3.0-2.5 | 3932.00300 | 6.0-5.5 | 3940.00600 |
| 4.0-3.5 | 3916.00400 | 7.0-6.5 | 3925.00700 | 4.0-3.5 | 3932.00400 | 7.0-6.5 | 3940.00700 |
| 5.0-4.5 | 3916.00500 | 8.0-7.5 | 3925.00800 | 5.0-4.5 | 3932.00500 | 8.0-7.5 | 3940.00800 |
| 6.0-5.5 | 3916.00600 | 9.0-8.5 | 3925.00900 | 6.0-5.5 | 3932.00600 | 9.0-8.5 | 3940.00900 |
| 7.0-6.5 | 3916.00700 | 10.0-9.5 | 3925.01000 | 7.0-6.5 | 3932.00700 | 10.0-9.5 | 3940.01000 |
| 8.0-7.5 | 3916.00800 | 11.0-10.5 | 3925.01100 | 8.0-7.5 | 3932.00800 | 11.0-10.5 | 3940.01100 |
| 9.0-8.5 | 3916.00900 | 12.0-11.5 | 3925.01200 | 9.0-8.5 | 3932.00900 | 12.0-11.5 | 3940.01200 |
| 10.0-9.5 | 3916.01000 | 13.0-12.5 | 3925.01300 | 10.0-9.5 | 3932.01000 | 13.0-12.5 | 3940.01300 |
| | | 14.0-13.5 | 3925.01400 | 11.0-10.5 | 3932.01100 | 14.0-13.5 | 3940.01400 |
| | | 15.0-14.5 | 3925.01500 | 12.0-11.5 | 3932.01200 | 15.0-14.5 | 3940.01500 |
| | | 16.0-15.5 | 3925.01600 | 13.0-12.5 | 3932.01300 | 16.0-15.5 | 3940.01600 |
| | | | | 14.0-13.5 | 3932.01400 | 17.0-16.5 | 3940.01700 |
| | | | | 15.0-14.5 | 3932.01500 | 18.0-17.5 | 3940.01800 |
| | | | | 16.0-15.5 | 3932.01600 | 19.0-18.5 | 3940.01900 |
| | | | | 17.0-16.5 | 3932.01700 | 20.0-19.5 | 3940.02000 |
| | | | | 18.0-17.5 | 3932.01800 | 21.0-20.5 | 3940.02100 |
| | | | | 19.0-18.5 | 3932.01900 | 22.0-21.5 | 3940.02200 |
| | | | | 20.0-19.5 | 3932.02000 | 25.0-24.5 | 3940.02500 |
| | | | | | | 26.0-25.5 | 3940.02600 |
| Size 20 | | | | | | | |
| Range, mm dm_t | Ordering code | | | | | | |
| 3.0-2.5 | 3920.00300 | | | | | | |
| 4.0-3.5 | 3920.00400 | | | | | | |
| 5.0-4.5 | 3920.00500 | | | | | | |
| 6.0-5.5 | 3920.00600 | | | | | | |
| 7.0-6.5 | 3920.00700 | | | | | | |
| 8.0-7.5 | 3920.00800 | | | | | | |
| 9.0-8.5 | 3920.00900 | | | | | | |
| 10.0-9.5 | 3920.01000 | | | | | | |
| 11.0-10.5 | 3920.01100 | | | | | | |
| 12.0-11.5 | 3920.01200 | | | | | | |
| 13.0-12.5 | 3920.01300 | | | | | | |

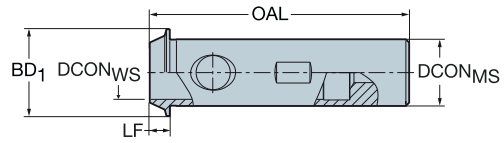
0.5 mm capacity per disc. Max 150 bar coolant pressure.

ER collet nuts for through-coolant with sealing disc



| CZC | Ordering code | TDZ | Wrench |
|------|---------------|-----------|-------------|
| ER16 | 5533 051-01 | M22 x 1.5 | 5680 091-01 |
| ER20 | 5533 051-02 | M25 x 1.5 | 5680 091-02 |
| ER25 | 5533 051-03 | M32 x 1.5 | 5680 096-02 |
| ER32 | 5533 051-04 | M40 x 1.5 | 5680 096-03 |
| ER40 | 5533 051-05 | M50 x 1.5 | 5680 096-04 |

Sleeve for fine boring head



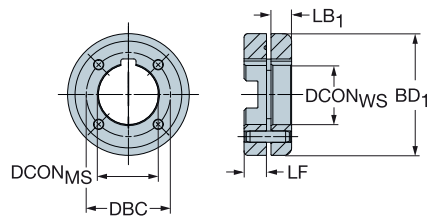
| | | | | | Dimensions, mm | | | | | | |
|-------------------|-------------------|------|------|-------------------|--------------------|--------------------|-----------------|-----|----|-----|-------|
| CZC _{MS} | CZC _{MS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | BD ₁ | OAL | LF | BAR | KG |
| 20 | 16 | 1 | 1 | 393.37A-20 16 072 | 20 | 16 | 26 | 78 | 6 | 20 | 0.114 |

To be used with R429U/R429.90 boring bars

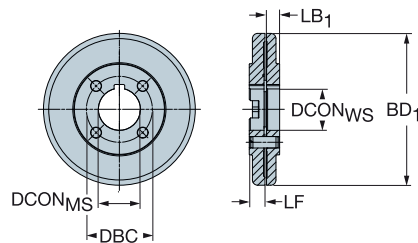


Assembly item

Driving collar for CoroMill® QD



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|---------------|--------------------|--------------------|------|-------|----|-----------------|-----------------|-------|------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | OAL | LF | LB ₁ | BD ₁ | (BAR) | (KG) | |
| 32 | X32 | 4 | 4 | 5549 201-011 | 32.00 | 32.00 | 2.40 | 25.40 | 12 | 11.00 | 65.00 | 80 | 0.46 | |
| 40 | X40 | 4 | 4 | 5549 201-021 | 40.00 | 40.00 | 2.40 | 29.00 | 15 | 11.60 | 87.00 | 80 | 0.98 | |



| | | | | | Dimensions, mm | | | | | | | | | |
|-------------------|-------------------|------|------|---------------|--------------------|--------------------|------|-------|----|-----------------|-----------------|-------|------|--|
| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | OAL | LF | LB ₁ | BD ₁ | (BAR) | (KG) | |
| 40 | X40 | 4 | 4 | 5549 201-041 | 40.00 | 40.00 | 2.40 | 29.00 | 15 | 12.50 | 145.00 | 80 | 2.75 | |
| | X40 | 4 | 4 | 5549 201-081 | 40.00 | 40.00 | 2.40 | 29.00 | 15 | 11.60 | 185.00 | 80 | 4.62 | |

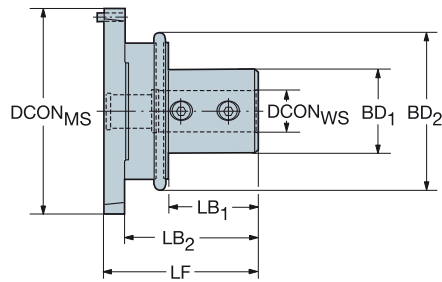


N23



N15

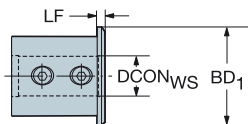
Slide to adjustable drill adaptor



Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LF | LB ₁ | LB ₂ | LB ₃ | BD ₁ | BD ₂ | BD ₃ | BAR | KG |
|-------------------|-------------------|------|------|--------------------|--------------------|--------------------|-------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----|------|
| 01 | 20 | 1 | 1 | 393.277-20 01 075A | 78.0 | 20.0 | 75.0 | 44.0 | 65.0 | 75.0 | 40.0 | 55.2 | 78.0 | 20 | 0.85 |
| | 25 | 1 | 1 | 393.277-25 01 080A | 78.0 | 25.0 | 80.0 | 50.0 | 70.0 | 80.0 | 45.0 | 55.2 | 78.0 | 20 | 0.94 |
| 02 | 20 | 1 | 1 | 393.277-20 02 075A | 98.0 | 20.0 | 75.0 | 44.0 | 65.0 | 75.0 | 40.0 | 75.2 | 98.0 | 20 | 1.26 |
| | 25 | 1 | 1 | 393.277-25 02 085A | 98.0 | 25.0 | 85.0 | 54.0 | 75.0 | 85.0 | 45.0 | 75.2 | 98.0 | 20 | 1.39 |
| | 32 | 1 | 1 | 393.277-32 02 085A | 98.0 | 32.0 | 85.0 | 54.0 | 75.0 | 85.0 | 52.0 | 75.2 | 98.0 | 20 | 1.47 |
| 03 | 40 | 1 | 1 | 393.277-40 03 090A | 136.0 | 40.0 | 90.0 | 65.0 | 90.0 | | 65.0 | 136.0 | | 20 | 3.52 |
| | 50 | 1 | 1 | 393.277-50 03 100A | 136.0 | 50.0 | 100.0 | 75.0 | 110.0 | | 75.0 | 163.0 | | 20 | 3.90 |

Sleeve

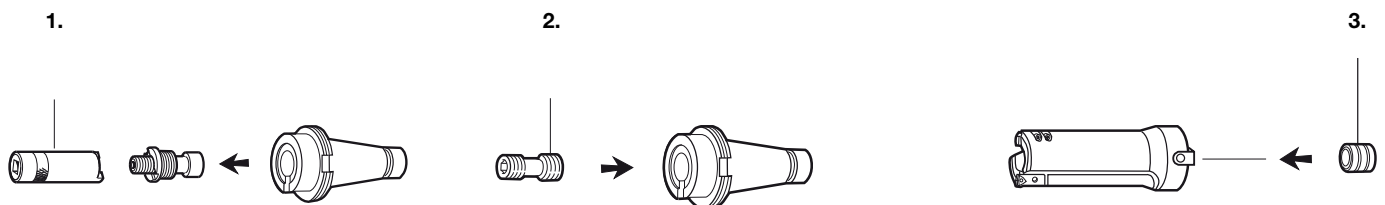


Dimensions, mm

| CZC _{MS} | CZC _{WS} | CNSC | CXSC | Ordering code | DCON _{MS} | DCON _{WS} | LSC | LF | BD ₁ | BAR | KG |
|-------------------|-------------------|------|------|--------------------|--------------------|--------------------|-----|-----|-----------------|-----|------|
| 40 | 32 | 1 | 1 | 393.277-40 32 074A | 40.0 | 32.0 | 70 | 4.0 | 48.0 | 80 | 0.30 |

VL

Trepanning tool



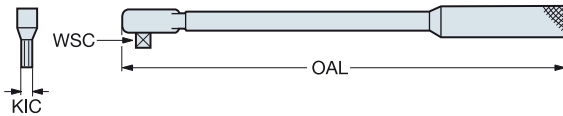
| 1. Ordering code Key | 2. Ordering code Screw | 3. Ordering code Centering sleeve |
|-------------------------|---------------------------|--------------------------------------|
| 5680 065-02 | 5516 030-01 | 5638 030-01 |



Assembly tools

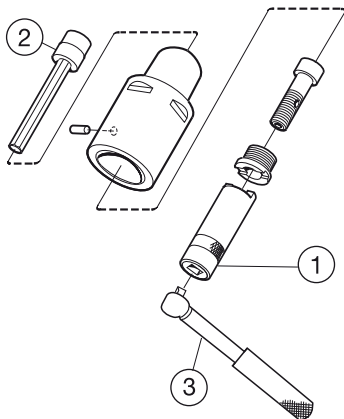
Coromant Capto®

Torque wrench for manual clamping units, Quick change



| Coupling size | Torque wrench | | Dimensions, mm | | Key adaptor | |
|---------------|---------------|------------------|----------------|-----|---------------|-----|
| | Ordering code | Torque range, Nm | WSC | OAL | Ordering code | KIC |
| C3 | C-TK-01M | 20-100 | 1/2" | 345 | 5680 035-14 | 8 |
| C4 | C-TK-01M | 20-100 | 1/2" | 345 | 5680 035-06 | 10 |
| C5 | C-TK-01M | 20-100 | 1/2" | 345 | 5680 035-07 | 12 |
| C6 | C-TK-01M | 20-100 | 1/2" | 345 | 5680 035-07 | 12 |
| C8 | C-TK-02 | 40-200 | 1/2" | 440 | 5680 035-07 | 12 |
| C10 | C-TK-03 | 60-300 | 1/2" | 548 | 5680 035-10 | 17 |

Torque wrench for modular assemblies, centre bolt clamping



| Coupling size | 3. Torque wrench | | Dimensions, mm | | 2. Extension key | | 1. Retaining nut spanner | |
|---------------|------------------|------------------|----------------|-----|------------------|-----|--------------------------|--|
| | Ordering code | Torque range, Nm | WSC | OAL | Ordering code | KIC | Ordering code | |
| C3 | C-TK-02 | 40-200 | 1/2" | 345 | 5680 015-05 | 8 | 5680 065-13 | |
| C4 | C-TK-02 | 40-200 | 1/2" | 345 | 5680 015-05 | 8 | 5680 065-10 | |
| C5 | C-TK-02 | 40-200 | 1/2" | 345 | 5680 015-01 | 10 | 5680 065-11 | |
| C6 | C-TK-02 | 40-200 | 1/2" | 345 | 5680 015-02 | 14 | 5680 065-12 | |
| C8 | C-TK-02 | 40-200 | 1/2" | 440 | 5680 015-02 | 14 | 5680 065-12 | |
| C10 | C-TK-04 | 80-400 | 3/4" | 683 | 5680 015-06 | 17 | 5680 065-14 | |

To be calibrated according to ISO 6789, accuracy within 4%

Assembly tools

Torque wrench



Ordering code Torque range Bits interface

| | | |
|-----------|-----------|----|
| ER-TK-01M | 10-50 Nm | 16 |
| ER-TK-02M | 50-300 Nm | 16 |

Bits



Ordering code ER size Bits interface

| | | |
|-------------|-------|----|
| 5680 103-01 | ER 11 | 16 |
| 5680 103-02 | ER 16 | 16 |
| 5680 103-03 | ER 20 | 16 |



Ordering code ER size MDI size Bits interface

| | | | |
|-------------|-------|----|----|
| 5680 103-04 | ER 25 | | 16 |
| 5680 103-05 | ER 32 | 20 | 16 |
| 5680 103-06 | ER 40 | 25 | 16 |
| 5680 103-07 | | 32 | 16 |
| 5680 103-08 | | 40 | 16 |
| 5680 103-09 | | 50 | 16 |

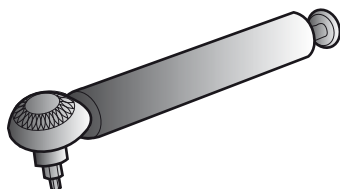
Assembly tools

Key for integrated collet

| CZC | Ordering code | |
|------|---------------|--|
| ER11 | 5680 091-03 | |
| ER16 | 5680 096-06 | |
| ER20 | 5680 096-01 | |
| ER25 | 5680 096-02 | |
| ER32 | 5680 096-03 | |

CoroChuck™ 930

Torque wrench



Ordering code

5680 099-01

Coromant EH

Main spare parts

| Coupling size | Key | Torque wrench head ¹⁾ | Torque wrench head for 2-edge end mill ¹⁾ | Torque value Nm | Torque range | |
|---------------|-------------|----------------------------------|--|--------------------|-----------------------------|-------|
| | | | | | Torque wrench ¹⁾ | Nm |
| E10 | 5680 093-01 | 5680 089-01 | 5680 089-06 | 12 | 5680 088-01 | 10-20 |
| E12 | 5680 093-02 | 5680 089-02 | 5680 089-07 | 15 | 5680 088-01 | 10-20 |
| E16 | 5680 093-03 | 5680 089-03 | 5680 089-08 | 30 | 5680 088-02 | 25-65 |
| E20 | 5680 093-04 | 5680 089-04 | | 50 | 5680 088-02 | 25-65 |
| E25 | 5680 093-05 | 5680 089-05 | | 65 | 5680 088-02 | 25-65 |

¹⁾ Accessories, must be ordered separately

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.

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 screw-drivers do NOT fit into the standard Torx screws.



5680 100-07 (20IP) and 5680 100-08 (25IP)

Torx Plus® torque wrench

| Torque wrench | Size | Torque Nm |
|---------------|-------|-----------|
| 5680 100-01 | 6IP | 0.6 |
| 5680 100-02 | 7IP | 0.9 |
| 5680 100-03 | 8IP | 1.2 |
| 5680 100-04 | 9IP | 1.4 |
| 5680 100-05 | 10IP | 2.0 |
| 5680 100-06 | 15IP | 3.0 |
| 5680 100-07 | 20IP | 5.0 |
| 5680 100-08 | 25IP | 7.5 |
| 5680 100-09 | HEX 5 | 6.0 |
| 5680 100-10 | 20IP | 6.0 |

Torque wrench and bits

5680 105-01
5680 105-02



5680 105-05
5680 105-06



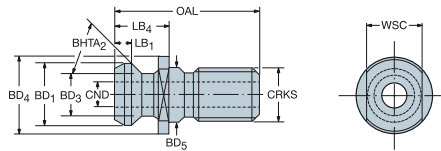
| Torque wrench | Torque range | |
|---------------|--------------|----------|
| | Nm | Handle |
| 5680 105-01 | 0.3 - 1.2 | Straight |
| 5680 105-02 | 1.2 - 3.0 | Straight |
| 5680 105-05 | 3.0 - 6.0 | Angled |
| 5680 105-06 | 4.0 - 8.8 | Angled |

| Bit | Torx Plus | |
|-------------|-----------|----------------|
| | OAL mm | N _T |
| 5680 084-01 | 50 | 8IP |
| 5680 084-02 | 50 | 15IP |
| 5680 084-03 | 89 | 15IP |
| 5680 084-04 | 50 | 7IP |
| 5680 084-05 | 50 | 9IP |
| 5680 084-06 | 50 | 10IP |
| 5680 084-07 | 50 | 20IP |
| 5680 084-08 | 89 | 20IP |
| 5680 084-09 | 89 | 25IP |
| 5680 084-10 | 89 | 30IP |
| 5680 084-11 | 50 | 6IP |
| 5680 084-12 | 80 | 27IP |
| 5680 084-13 | 35 | 50IP |

| Bit | Torx Plus | |
|-------------|-----------|----------------|
| | OAL mm | N _T |
| 5680 084-14 | 50 | 30IP |
| 5680 084-15 | 25 | 15IP |
| 5680 084-16 | 25 | 30IP |
| 5680 084-17 | 25 | 6IP |
| 5680 084-18 | 25 | 7IP |
| 5680 084-19 | 25 | 8IP |
| 5680 084-20 | 25 | 9IP |
| 5680 084-21 | 25 | 10IP |
| 5680 084-22 | 25 | 20IP |
| 5680 084-23 | 25 | 25IP |
| 5680 083-01 | 25 | HEX3 |
| 5680 083-04 | 50 | HEX2,5 |

Pull studs

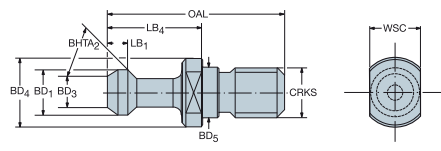
PS-VxxC



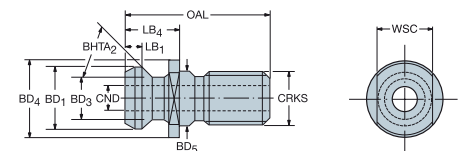
CAT-V

| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-----|---------|------|------|----------------|----------------|-----------------|-----------------|-----|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|---------|--|
| CZC | CRKS | CNSC | CXSC | Ordering code | WSC | LB ₁ | LB ₄ | CND | BD ₁ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | OAL | (KG) | Machine | |
| 40 | M16 | 1 | 1 | PS-V40C-45-001 | 18 | 5.4 | 16.4 | 7 | 19.0 | 12.9 | 22.5 | | 45° | 38 | 0.04 | | |
| | M16 | 1 | 1 | PS-V40C-45-006 | 19 | 5.1 | 19.1 | 6 | 18.8 | 12.4 | 22.1 | 17 | 45° | 47 | 0.06 | Fadal | |
| 50 | M24 | 1 | 1 | PS-V50C-45-001 | 30 | 7.7 | 25.5 | 11 | 29.1 | 19.6 | 37.0 | | 45° | 59 | 0.15 | | |
| | 1-8 UNC | 1 | 1 | PS-V50C-45-005 | 31 | 7.6 | 25.4 | 11 | 29.0 | 20.8 | 36.3 | 26 | 45° | 58 | 0.17 | Mazak | |
| | 1-8 UNC | 1 | 1 | PS-V50C-45-008 | 29 | 9.9 | 45.2 | 9 | 22.9 | 16.9 | 38.1 | 24 | 45° | 79 | 0.20 | Makino | |
| | 1-8 UNC | 1 | 1 | PS-V50C-60-001 | 29 | 9.9 | 44.9 | 6 | 23.0 | 17.0 | 38.1 | 25 | 60° | 82 | 0.29 | Okuma | |

PS-Ixx



PS-IxxC



ISO

| | | | | | Dimensions, mm | | | | | | | | | | | | |
|-----|------|------|------|----------------|----------------|-----------------|-----------------|-----|-----------------|-----------------|-----------------|-----------------|-------------------|-----|------|------------|------------|
| CZC | CRKS | CNSC | CXSC | Ordering code | WSC | LB ₁ | LB ₄ | CND | BD ₁ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | OAL | (KG) | BSG | Machine |
| 30 | M12 | 0 | 0 | PS-I30-75-001 | 14 | 5.0 | 24.0 | | 13.0 | 9.0 | 17.0 | 13 | 75° | 44 | 0.04 | | |
| 40 | M16 | 0 | 0 | PS-I40-75-001 | 19 | 6.0 | 26.0 | | 19.0 | 14.0 | 23.0 | 17 | 75° | 54 | 0.05 | DIN 69872 | |
| | M16 | 1 | 1 | PS-I40C-45-001 | 18 | 5.3 | 16.4 | 7 | 19.0 | 12.9 | 22.5 | 17 | 45° | 44 | 0.05 | ISO 7388 B | |
| | M16 | 1 | 1 | PS-I40C-45-002 | 19 | 5.0 | 16.2 | 7 | 18.8 | 12.4 | 21.8 | 17 | 45° | 41 | 0.05 | | Mazak |
| | M16 | 1 | 1 | PS-I40C-45-003 | 19 | 5.0 | 19.1 | 7 | 18.8 | 12.4 | 22.0 | 17 | 45° | 44 | 0.05 | | Mazak |
| | M16 | 1 | 1 | PS-I40C-75-001 | 19 | 6.0 | 26.0 | 7 | 19.0 | 14.0 | 23.0 | 17 | 75° | 54 | 0.05 | DIN 69872 | |
| | M16 | 1 | 1 | PS-I40C-75-002 | 19 | 6.0 | 26.0 | 7 | 19.0 | 14.0 | 23.0 | 17 | 75° | 54 | 0.05 | ISO 7388 | |
| | M16 | 1 | 1 | PS-I40C-75-003 | 19 | 6.0 | 29.0 | 7 | 19.0 | 14.1 | 23.0 | 17 | 75° | 54 | 0.05 | | Mori Seiki |
| 50 | M24 | 0 | 0 | PS-I50-45-001 | 30 | 7.6 | 25.5 | | 29.1 | 19.6 | 37.0 | 25 | 45° | 65 | 0.15 | ISO 7388 B | |
| | M24 | 0 | 0 | PS-I50-75-001 | 30 | 9.0 | 34.0 | | 28.0 | 21.0 | 36.0 | 25 | 75° | 74 | 0.15 | DIN 69872 | |
| | M24 | 0 | 0 | PS-I50-75-002 | 30 | 9.0 | 34.0 | | 28.0 | 21.0 | 36.0 | 20 | 75° | 74 | 0.15 | | |
| | M24 | 0 | 0 | PS-I50-75-003 | 30 | 9.0 | 34.0 | | 28.0 | 21.1 | 36.0 | 25 | 75° | 74 | 0.15 | | |
| | M24 | 0 | 0 | PS-I50-90-001 | 30 | 10.0 | 46.6 | | 22.0 | 16.0 | 39.0 | 32 | 90° | 99 | 0.15 | | GSP |
| | M24 | 1 | 1 | PS-I50C-45-001 | 30 | 7.6 | 25.5 | 11 | 29.1 | 19.6 | 37.0 | 25 | 45° | 65 | 0.15 | ISO 7388 B | |
| | M24 | 1 | 1 | PS-I50C-45-002 | 26 | 5.2 | 16.4 | 7 | 19.0 | 12.9 | 30.0 | 25 | 45° | 56 | 0.15 | | |
| | M24 | 1 | 1 | PS-I50C-45-003 | 30 | 7.6 | 25.4 | 10 | 29.0 | 20.8 | 36.5 | 25 | 45° | 65 | 0.15 | | Yamazaki |
| | M24 | 1 | 1 | PS-I50C-45-004 | 30 | 7.6 | 25.4 | 10 | 29.0 | 20.8 | 36.5 | 25 | 45° | 65 | 0.15 | | Yamazaki |
| | M24 | 1 | 1 | PS-I50C-75-001 | 30 | 9.0 | 34.0 | 11 | 28.0 | 21.0 | 36.0 | 25 | 75° | 74 | 0.15 | DIN 69872 | |
| | M24 | 1 | 1 | PS-I50C-75-002 | 30 | 9.0 | 34.0 | 11 | 28.0 | 21.0 | 36.0 | 25 | 75° | 74 | 0.15 | ISO 7388 | |
| | M24 | 1 | 1 | PS-I50C-90-001 | 30 | 6.5 | 32.5 | 6 | 20.0 | 13.0 | 38.5 | | 90° | 70 | 0.15 | | Forest |



N23



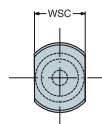
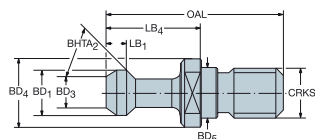
N15



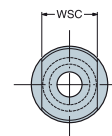
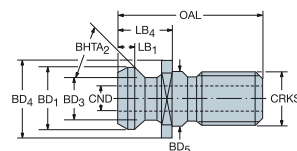
Pull studs



PS-Bxx



PS-BxxC



MAS-BT

| | | | | | Dimensions, mm | | | | | | | | | | | | | | |
|-----|------|------|----------------|----------------|----------------|-----------------|-----------------|------|-----------------|-----------------|-----------------|-----------------|-------------------|------|---------------|-------|------------|--|--|
| CZC | CRKS | CNSC | CXSC | Ordering code | WSC | LB ₁ | LB ₄ | CND | BD ₁ | BD ₃ | BD ₄ | BD ₅ | BHTA ₂ | OAL | ^{KG} | BSG | Machine | | |
| 30 | M12 | 0 | 0 | PS-B30-45-001 | 13 | 5.0 | 23.0 | | 11.0 | 7.0 | 16.0 | 12 | 45° | 43 | 0.03 | | | | |
| | M12 | 0 | 0 | PS-B30-60-001 | 13 | 7.0 | 35.0 | | 11.0 | 7.0 | 16.0 | 12 | 60° | 43 | 0.03 | | | | |
| | M12 | 1 | 1 | PS-B30C-45-001 | 13 | 5.0 | 23.0 | 2 | 11.0 | 7.0 | 16.5 | 12 | 45° | 43 | 0.03 | | | | |
| | M12 | 1 | 1 | PS-B30C-45-002 | 13 | 5.0 | 23.0 | 2 | 11.0 | 7.0 | 16.5 | 12 | 45° | 43 | 0.03 | | Mori Seiki | | |
| | M12 | 1 | 1 | PS-B30C-45-003 | 13 | 5.0 | 23.0 | 4 | 11.0 | 8.0 | 16.5 | 12 | 45° | 43 | 0.03 | | Fanuc | | |
| | M12 | 1 | 1 | PS-B30C-60-001 | 13 | 5.0 | 23.0 | 2 | 11.0 | 7.0 | 16.5 | 12 | 60° | 43 | 0.03 | | | | |
| | M12 | 1 | 1 | PS-B30C-60-002 | 13 | 5.0 | 23.0 | 2 | 11.0 | 7.5 | 16.5 | 12 | 60° | 43 | 0.03 | | Brother | | |
| 40 | M16 | 0 | 0 | PS-B40-45-001 | 19 | 7.0 | 35.0 | | 15.0 | 10.0 | 23.0 | 17 | 45° | 60 | 0.05 | | | | |
| | M16 | 0 | 0 | PS-B40-60-001 | 19 | 7.0 | 35.0 | | 15.0 | 10.0 | 23.0 | 17 | 60° | 60 | 0.05 | | | | |
| | M16 | 0 | 0 | PS-B40-90-001 | 19 | 7.0 | 35.0 | | 15.0 | 10.0 | 23.0 | 17 | 90° | 60 | 0.05 | | | | |
| | M16 | 1 | 1 | PS-B40C-45-001 | 19 | 7.0 | 35.0 | 4 | 15.0 | 10.0 | 23.0 | 17 | 45° | 60 | 0.05 | | | | |
| | M16 | 1 | 1 | PS-B40C-60-001 | 19 | 7.0 | 35.0 | 3 | 15.0 | 10.0 | 23.0 | 17 | 60° | 60 | 0.05 | | | | |
| | M16 | 1 | 1 | PS-B40C-75-001 | 18 | 11.4 | 25.1 | 7 | 25.3 | 21.1 | 25.3 | 17 | 75° | 53 | 0.05 | | | | |
| | M16 | 1 | 1 | PS-B40C-75-002 | 19 | 6.0 | 29.0 | 7 | 19.0 | 14.0 | 23.0 | 17 | 75° | 54 | 0.05 | | JIS 40 | | |
| | M16 | 1 | 1 | PS-B40C-90-001 | 19 | 7.0 | 35.0 | 3 | 15.0 | 10.0 | 23.0 | 17 | 90° | 60 | 0.05 | | | | |
| 50 | M24 | 0 | 0 | PS-B50-45-001 | 30 | 10.0 | 45.0 | | 23.0 | 17.0 | 38.0 | 25 | 45° | 85 | 0.25 | | | | |
| | M24 | 0 | 0 | PS-B50-60-001 | 30 | 10.0 | 45.0 | | 23.0 | 17.0 | 38.0 | 25 | 60° | 85 | 0.25 | | | | |
| | M24 | 0 | 0 | PS-B50-90-001 | 30 | 10.0 | 45.0 | | 23.0 | 17.0 | 38.0 | 25 | 90° | 85 | 0.25 | | Okuma | | |
| | M24 | 1 | 1 | PS-B50C-45-001 | 30 | 10.0 | 45.0 | 7 | 23.0 | 17.0 | 38.0 | 25 | 45° | 85 | 0.25 | | | | |
| | M24 | 1 | 1 | PS-B50C-60-001 | 30 | 10.0 | 45.0 | 8 | 23.0 | 17.0 | 38.0 | 25 | 60° | 85 | 0.25 | | | | |
| | M24 | 1 | 1 | PS-B50C-75-001 | 30 | 9.0 | 34.0 | 11 | 28.0 | 21.0 | 36.0 | 25 | 75° | 74 | 0.22 | | JIS 50 | | |
| | M24 | 1 | 1 | PS-B50C-90-001 | 30 | 8.0 | 31.0 | 6 | 24.0 | 18.0 | 36.0 | 25 | 90° | 71 | 0.20 | | Mitsui | | |
| M24 | 1 | 1 | PS-B50C-90-002 | 30 | 10.0 | 45.0 | 8 | 23.0 | 17.0 | 38.0 | 25 | 90° | 85 | 0.25 | | Okuma | | | |



N23



N15

General information

Wiper

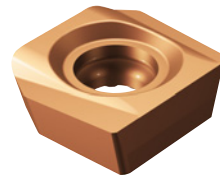
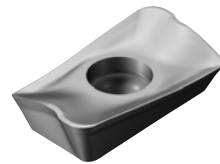
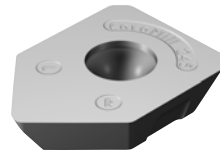
Inserts for increased productivity

Wiper

Excellent surface finishes can be achieved with standard inserts in combination with one or more wiper inserts. Wiper inserts work most usefully at a high feed per revolution, f_n , in larger diameter cutters with extra close pitch and setting facilities.

Feed per revolution can be increased approx. four times while still maintaining good surface quality. Wiper inserts can be used in milling in most materials to produce good surface textures – even under unfavorable conditions.

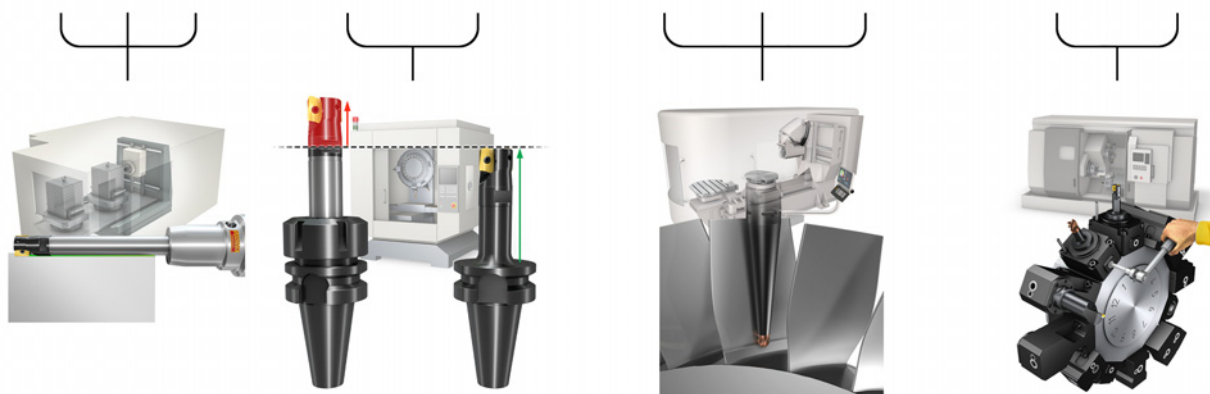
TECHNOLOGY
Wiper



Modular system - Coromant EH

Tooling flexibility for small diameters

CoroMill® 316 CoroMill® 495 CoroMill® 490 CoroMill® 390 CoroBore® 825 EH CoroBore® 824 XS CoroMill® 216 CoroMill® 300



Large machining centres
Long overhang with stability and clearance.

Small and medium machining centres
When gauge line is critical.

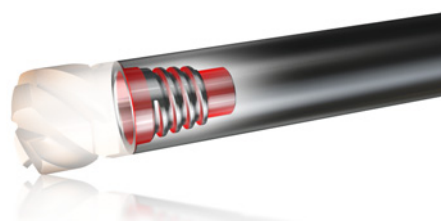
Medium to large machining centres
Modularity with Coromant Capto® in different lengths.

Turning centres with driven tool holders
Short gauge length and swing diameter.

For more information about Coromant EH system:
www.sandvik.coromant.com/coromanteh

Coromant EH coupling

The Coromant EH coupling is based on a self-centering screw thread for secure mounting, rigidity and strength. The coupling has a physical stop which makes it easy to feel when the head is correctly tightened and helps to not overstress the clamping.



CoroChuck™ 930

High-precision hydraulic chuck with high pull-out security and precision

Application

- Suitable for milling and drilling operations where precision, easy handling and high pull-out security are required
- Covers all of the important machine interfaces

Benefits and features

- High metal removal rate provides increased productivity
- Secure process and safe machining
- Quick tool change and set-up
- Enhanced surface finish and increased tool life
- Close hole tolerance
- Best pull-out security on the market due to the latest Fulcrum technology* used for uppermost clamping performance with high clamping force. The clamping force repeats time after time
- Easy handling with torque wrench used for secure clamping
- The machine-side coupling is ground as last operation to guarantee the highest demands on precision
- High precision repetition
- Balancing according to DIN 69888
- Clamping length can be adjusted with an adjustment screw



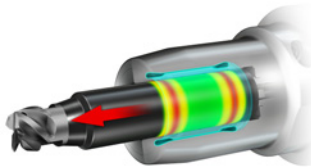
www.sandvik.coromant.com/corochuck930

Available coupling types

- Coromant Capto®
- HSK
- BIG-PLUS
- ISO
- CAT-V
- MAS-BT



CoroChuck™ 930 can be used with or without reduction collets. For internal coolant use 393.CGS collets and for external coolant use 393.CG.



Fulcrum technology* gives best pull-out security on the market. It allows for secure clamping with two supports on each side (fulcrums).



Also available with BIG-PLUS interface for machining centers.

CoroChuck™ 970

For a secure tapping process

Application

- For elimination of oversized threading
- Suitable for all synchronized tapping operations

Benefits and features

- Improves tapping tool life
- Secure machining process
- Reduces the risk of cutting oversized threads significantly
- Synchronized tapping reduces thrust force on tap flanks
- Accurate depth thanks to limited axial compensation
- New, improved design for internal coolant
- Suitable for high-pressure coolant up to 80 bar (1160 psi)
- More back-ends to fit your machine



www.sandvik.coromant.com/corochuck970

Available coupling types

- Coromant Capto®
- ISO-Cone (ISO, MAS-BT, CAT-V)
- HSK
- Cylindrical
- Weldon
- Coromant EH

Product range

- ER sizes for CoroChuck 970: 8, 11, 20, 25, 32, 40 and 50.
- ER-size 50 has a square inside the adaptor and should be used with the largest tap (M48). The collet that will be used with this large tap will be a collet without a square.
- For HSK 63 and HSK 100 it is possible to use MQL on ER sizes 20 and 25.

Product range

| Design | Coromant Capto® | Coromant EH | ISO-Cone (ISO, MAS-BT, CAT-V) | BIG-PLUS (ISO, MAS-BT, CAT-V) | HSK | Cylindrical | Weldon |
|--------------|-------------------------|-------------|----------------------------------|----------------------------------|---------|-------------|------------------------|
| SynchroFlex® | C3, C4, C5, C6, C8, C10 | 25 | 30, 40, 50 | 30, 40, 50 | 63, 100 | 12, 16, 20 | 12, 16, 25, 25A, 40 |

Tailor Made

Additional tool options designed for your specific requirements.



Apart from a comprehensive standard programme we can offer tools to your dimensions on standard tool terms. In our Tailor Made offer you are free to specify your own dimensions without paying the price of a special tool.

What you can expect from us

- Quick quotation
- Easy ordering
- Performance guarantee at given product and cutting data
- Competitive delivery times

CoroMill® 490

Even more possibilities thanks to tailored design! If you do not find what you need in our comprehensive standard programme, choose the tool shape you require and we will tailor it for you to your dimensions.

Options

| | | |
|--|-----------|---|
| Insert size: 08 or 14 | f_s | Reach length: -08, 21 mm = 3 × D_1 |
| D_1 | f_2 | -14, 40 mm = 2 × D_1 |
| -08, Diameter = 10.05-44 mm | f_3 | Total length: -08, 74-200 mm |
| -14, Diameter = 20.1-254 mm | f_4 | -14, 99-200 mm |
| Pitch type: Even or Differential | f_5 | Programming length: -08, 40-175.8 mm |
| P_2 | f_6 | -14, 40-188.5 mm |
| -08, No. of inserts 2-8 | Coil | -08, Yes - $D_2 < 43$ mm/No |
| -14, No. of inserts 2-20 | Coil hole | -14, Yes/No - all TDC and TDB size 50.8 |
| Mounting: Cylindrical, Weldon, Coromant Capto, HSK-A, Arbor mounting | | |
| d_{min}/D_{min} | | |
| Mounting size, see above | | |

www.sandvik.coromant.com/tailormade

The Tailor Made option is available in the following product families:

Milling

- CoroMill® 245
- CoroMill® 300
- CoroMill® 390
- CoroMill® 419
- CoroMill® 490
- CoroMill® 790
- CoroMill® Century
- CoroMill® 331
- CoroMill® QD
- CoroMill® 415
- CoroMill® 425
- CoroMill® 345
- CoroMill® 365
- CoroMill® 745

Drilling

- CoroDrill® 870
- CoroDrill® 880
- CoroDrill® DS20

Adaptors

- Coromant EH
- CoroChuck™ 930
- Coromant Capto®

Engineered solutions

When standard or Tailor Made solutions do not fulfill your needs you can depend on Sandvik Coromant's wide experience in engineered tool solutions to handle particularly demanding criteria. Access our Tailor Made forms at www.sandvik.coromant.com

For the sake of the environment

Get into the Sandvik Coromant Recycling Concept (CRC) now!

The Sandvik Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts and solid carbide tools offered by Sandvik Coromant to all its customers.

In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers.

Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way.

All used carbide inserts are collected in the collection box at the workplace.

When the collection box is sufficiently full, its contents are transferred to the transport box.

The full transport box is then sent to the nearest Sandvik Coromant office or to your Sandvik Coromant dealer who can also give you more information.

The benefits of the CRC speak for themselves

- A worldwide ISO and OHAS certified recycling system.
- Open to all Sandvik Coromant customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.



Order collection boxes for each lathe, milling machine, drill or for your machining centre. We recommend one collection box for inserts and one separate box for solid carbide tools for each cutting workplace.

For detailed instructions on how to sell your used cemented carbide, please visit www.sandvik.coromant.com and select your market.

| | |
|--|---------------|
| Collection box: | Order numbers |
| Transport box for solid carbide tools (plywood): | 91617 |
| Transport box inserts (plywood): | 92994 |
| | 92995 |

Safety information

Material composition

Tool holders

Tool holders mainly contain iron (FE), and low alloy elements such as chromium, nickel, manganese, molybdenum and silicon.

Indexable inserts/cutting tools/round tools

Substances in cemented carbide products contain mostly wolfram carbide and cobalt. They may also contain carbides and carbonitrides of the following elements: titanium, tantalum, niobium, chromium, molybdenum and vanadium.

Routes of exposure

Grinding or heating of hard metal blanks or hard metal products will produce products that give off dangerous dust and fumes. Avoiding ingestion and contact with skin or eyes is very important.

Acute toxicity

Intake of the aforementioned substances is toxic. Inhalation may cause irritation and inflammation of the airways. Significantly higher acute inhalation toxicity has been reported during simultaneous inhalation of cobalt and tungsten carbide compared to inhalation of cobalt alone.

Skin contact can cause irritation and rash. Sensitive individuals may even experience an allergic reaction.

Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction of the airways. Prolonged exposure to increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers previously exposed to high concentrations of tungsten carbide/cobalt carried an increased risk of developing lung cancer.

Cobalt and nickel are potent skin sensitizers. Repeated or prolonged contact can cause irritation and sensitization.

Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation

Toxic when inhaled

Limited evidence of a carcinogenic effect.

May cause sensitization by inhalation and skin contact

Preventive measures

Avoid formation and inhalation of dust. Use adequate local exhaust ventilation to keep personal exposure well below nationally authorised limits.

If ventilation is not available or adequate, use respirators appropriately approved for the purpose.

Use safety goggles or glasses with side shields when necessary.

Avoid repeated skin contact. Wear suitable gloves. Wash skin thoroughly after handling.

Use suitable protective clothing. Launder clothing if needed.

Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.



General code key for CoroMill cutter

| | | | | | | | | | | | |
|----------|----------|------------|----------|------------|----------|-----------|----------|----------|-----------|----------|------------|
| R | A | 390 | - | 063 | Q | 22 | L | - | 11 | M | 050 |
| 1 | 2 | 3 | | 4 | 5 | 6 | 7 | | 8 | 9 | 10 |

| | | | | |
|---|---|--|---|---|
| <p>1 Style</p> <p>R = Right hand rotating</p> | <p>2 Performance</p> <p>A = Inch</p> | <p>3 Main code</p> <p>E.g.: 390 = CoroMill® 390</p> | | |
| <p>4 Cutting diameter</p> <p>E.g.: 063 = 63 mm</p> | <p>5 Type of coupling</p> <table border="0"> <tr> <td style="vertical-align: top;"> <p>A = Cylindrical, mm</p> <p>B = Weldon mm</p> <p>C = Coromant Capto®</p> <p>D = Cylindrical inch</p> <p>J = CIS arbor mounting</p> <p>M = Weldon, inch</p> <p>N = Whistle Notch inch</p> <p>Q = Arbor mounting mm</p> <p>O = Cylindrical inch</p> </td> <td style="vertical-align: top;"> <p>R = Arbor mounting inch</p> <p>T = Threaded coupling</p> <p>W = Whistle Notch mm</p> <p>HA= HSK form A</p> </td> </tr> </table> | | <p>A = Cylindrical, mm</p> <p>B = Weldon mm</p> <p>C = Coromant Capto®</p> <p>D = Cylindrical inch</p> <p>J = CIS arbor mounting</p> <p>M = Weldon, inch</p> <p>N = Whistle Notch inch</p> <p>Q = Arbor mounting mm</p> <p>O = Cylindrical inch</p> | <p>R = Arbor mounting inch</p> <p>T = Threaded coupling</p> <p>W = Whistle Notch mm</p> <p>HA= HSK form A</p> |
| <p>A = Cylindrical, mm</p> <p>B = Weldon mm</p> <p>C = Coromant Capto®</p> <p>D = Cylindrical inch</p> <p>J = CIS arbor mounting</p> <p>M = Weldon, inch</p> <p>N = Whistle Notch inch</p> <p>Q = Arbor mounting mm</p> <p>O = Cylindrical inch</p> | <p>R = Arbor mounting inch</p> <p>T = Threaded coupling</p> <p>W = Whistle Notch mm</p> <p>HA= HSK form A</p> | | | |
| <p>6 Coupling size</p> <p>22 = 22 mm</p> | <p>9</p> <p>L = Coarse pitch</p> <p>M = Close pitch</p> <p>H = Extra close pitch</p> | <p>10 Length, LF</p> <p>E.g.: 050 = 50 mm</p> | | |
| <p>7 Extra long</p> <p>L = Extra long</p> | <p>8 Insert size</p> <p>11 = 11 mm (LE)</p> | | | |

General code key for CoroMill inserts

| | | | | | | | | | | |
|----------|------------|---|-----------|-----------|-----------|----------|---|----------|----------|----------|
| R | 390 | - | 11 | T3 | 12 | M | - | P | L | W |
| 1 | 2 | | 3 | 4 | 5 | 6 | | 7 | 8 | 9 |

| | | |
|--|--|---|
| <p>1 Hand of insert</p> <p>R = Right hand L = Left hand</p> | <p>2 Main code</p> <p>E.g.: 390= CoroMill® 390</p> | <p>3 Insert width</p> <p>E.g.: 11 = 11 mm</p> |
| <p>4 Insert thickness, S mm</p> <p>E.g.: T3 S = 3.97 04 S = 4.76 06 S = 6.33</p> | <p>5 Corner radius</p> <p>E.g.: 12 = 1.2 mm</p> | <p>6 Edge performance</p> <p>M = Highest edge security E = Highest sharpness and precision H = High edge sharpness and high precision K = High cutting sharpness</p> |
| <p>7 Main ISO application area</p> <p>P M K N S H</p> | <p>8 Operation</p> <p>L = Light cutting M = Medium H = Heavy T = Turn milling</p> | <p>9 Wiper</p> <p>W = Wiper</p> |

Code key for CoroMill® 327

CoroMill 327 insert

Grooving and chamfering

| | | | | | | | | | |
|------------|----------|-----------|---|-----------|------------|-----------|-----------|---|-----------|
| 327 | R | 12 | - | 22 | 130 | 45 | 08 | - | GC |
| 1 | 2 | 3 | | 4 | 5 | 9 | 12 | | 7 |

Threading

| | | | | | | | | |
|------------|----------|-----------|---|-----------|------------|-----------|---|-----------|
| 327 | R | 06 | - | 12 | 100 | VM | - | TH |
| 1 | 2 | 3 | | 4 | 10 | 11 | | 7 |

Profiling

| | | | | | | | | |
|------------|----------|-----------|---|-----------|------------|-----------|---|-----------|
| 327 | R | 06 | - | 12 | 220 | 11 | - | RM |
| 1 | 2 | 3 | | 4 | 5 | 6 | | 7 |

Grooving

| | | | | | | | | | |
|------------|----------|-----------|---|-----------|------------|-----------|---|-----------|----------|
| 327 | R | 12 | - | 28 | 150 | 01 | - | GM | M |
| 1 | 2 | 3 | | 4 | 5 | 6 | | 7 | 8 |

- 1 Product name
- 2 Right-hand insert
- 3 Coupling size (interface)
- 4 D_{min} (mm)
- 5 Insert width
- 6 Radius ex 02 = radius 0.2 mm
- 7 Type of insert

GM = Grooving
 RM = Fullnose radius
 CH = Chamfering
 GC = Grooving and chamfering
 TH = Threading

- 8 M = Close pitch
- 9 Chamfer 45°
- 10 Thread pitch mm: pitch x 100
- 11 Type of thread VM = V-Profile 60°
 MM = Metric 60°
 WH = Whitworth 55°
- 12 Max cutting depth, CDX in mm

CoroMill® 327 holders

| | | | | | | | | |
|------------|---|-----------|----------|-----------|----------|----------|---|-----------|
| 327 | - | 12 | B | 15 | S | C | - | 06 |
| 1 | | 2 | 3 | 4 | 5 | 6 | | 7 |

- 1 Product name
- 2 Shank diameter, DCON
- 3 Shank type B = Weldon
- 4 Reach length
- 5 Shank materials S = steel
 E = solid carbide
- 6 Internal coolant
- 7 Coupling size (interface)

Code key for CoroMill® 328

CoroMill® 328 insert

Chamfering

| | | | | | | | |
|------------|----------|-----------|---|------------|-----------|---|-----------|
| 328 | R | 13 | - | 110 | 45 | - | GC |
| 1 | 2 | 3 | | 4 | 7 | | 6 |

Threading

| | | | | | | | |
|------------|----------|-----------|---|------------|-----------|---|-----------|
| 328 | R | 13 | - | 150 | VM | - | TH |
| 1 | 2 | 3 | | 8 | 9 | | 6 |

Grooving

| | | | | | | | |
|------------|----------|-----------|---|------------|-----------|---|-----------|
| 328 | R | 13 | - | 110 | 01 | - | GM |
| 1 | 2 | 3 | | 4 | 5 | | 6 |

- | | | | | |
|---|------------------------------|---|----------------|--------------------|
| 1 | Product name | 7 | Chamfer 45° | |
| 2 | Right-hand insert | 8 | Thread pitch | mm: pitch x 100 |
| 3 | Insert size | 9 | Type of thread | VM = V-Profile 60° |
| 4 | Insert width | | | |
| 5 | Radius ex 02 = radius 0.2 mm | | | |
| 6 | Geometry | | | |
| | GM = Grooving | | | |
| | GC = Grooving and chamfering | | | |
| | TH = Threading | | | |

CoroMill® 328 cutters

| | | | | | | | |
|------------|---|------------|----------|-----------|---|-----------|----------|
| 328 | - | 039 | B | 25 | - | 13 | M |
| 1 | | 2 | 3 | 4 | | 5 | 6 |

- | | | |
|---|---------------------------------|----------------------|
| 1 | Product name | |
| 2 | Cutting diameter, DC | |
| 3 | Shank type | B = Weldon |
| | | Q = Arbor |
| | | S = Bore with keyway |
| 4 | Shank/couplings diameter (DCON) | |
| 5 | Insert size | |
| 6 | Pitch | |

Code key for tool holders

Cylindrical holder

| | | | | | | | | | |
|----------|------------|---|----------|-----------|---|----------|----------|---|------------|
| A | E12 | - | A | 20 | - | S | S | - | 140 |
| 1 | 2 | | 3 | 4 | | 5 | 6 | | 7 |

Coromant Capto® holder

| | | | | | | |
|-----------|---|----------|---------------|---|-----------|------------|
| C3 | - | A | 391.EH | - | 10 | 035 |
| 8 | | 1 | 9 | | 10 | 7 |

Solid holder

| | | | | | | |
|-----------------|---|-----------|---|-----------|---|------------|
| 392.45EH | - | 40 | - | 10 | - | 056 |
| 9 | | 11 | | 10 | | 7 |

| | | | |
|---|--|--|--|
| <p>1 System of measurement</p> <hr/> <p>A = Inch version</p> | <p>2 Size of interface</p> <hr/> <p>E12= EH coupling size</p> | <p>3 Holder type</p> <hr/> <p>A = Cylindrical</p> | |
| <p>4 Holder diameter</p> <hr/> <p>E.g.: DCON = 20 mm</p> | <p>5 Type of holder</p> <hr/> <p>S = Straight C = Conical</p> | <p>6 Holder material</p> <hr/> <p>S = Steel E = Solid carbide</p> | <p>7 Length of holder</p> <hr/> <p>E.g.: 140 = 140 mm</p> |
| <p>8 Coupling size</p> <hr/> <p>C = Coromant Capto®</p> | <p>9 Family/ holder type</p> <hr/> <p>391.EH = Coromant Capto® EH holder 392.140EH = ISO 7388.1 392.55EH = MAS-BT 403 A392.45EH = CAT V 392.410EH = HSK holder Form A/C A392.R8EH = Bridgeport holder 392.EREH = ER integrated holder</p> | <p>10 Size of interface</p> <hr/> <p>EH coupling size</p> | <p>11 Taper size</p> <hr/> <p>Taper size for Coromant solid holders</p> |

Code key for solid holding tools

| | | | | | | | | |
|----------|----------|----------|----------|-----------|---|-----------|-----------|------------|
| A | A | 1 | B | 05 | - | 50 | 32 | 060 |
| 1 | 2 | 3 | 4 | 5 | | 6 | 7 | 8 |

1 Inch version**2 Coolant through centre****3 Spindle type**

1=ISO 7388/1 (DIN 69871)
 2= MAS-BT
 3=CAT V-Flange

4

B= Coolant through flange
 F= Flange mounting
 X= Extra short

5 Holder type

05 = Face mill holder
 14= ER Collet chuck
 20=End mill holder Weldon type
 27= Short hole drill holder-shank ISO 9766

6 Taper size 30, 40, 50**7 Size bore or pilot, DCON_{ws}**

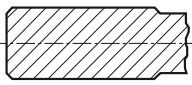
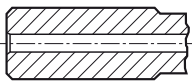
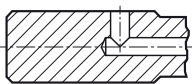
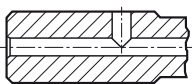
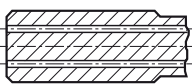
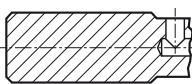
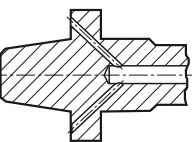
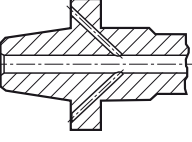

| | | |
|----|----|----|
| mm | | |
| 09 | 19 | 38 |
| 13 | 25 | 51 |
| 16 | 32 | 63 |

8 Programming length, mm

060 = 60 mm

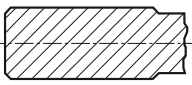
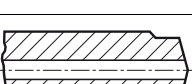
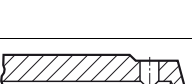



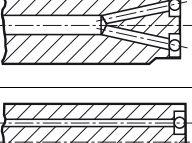
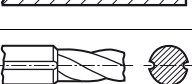
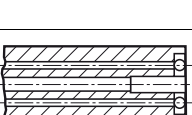
CNSC

Coolant entry style code

| Code | Description | Image |
|------|-----------------------------------|---|
| 0 | Without coolant |  |
| 1 | Axial concentric entry |  |
| 2 | Radial entry |  |
| 3 | Axial concentric and radial entry |  |
| 4 | Axial concentric entry on circle |  |
| 5 | Radial entry before adaptor |  |
| 6 | Decentral over flange |  |
| 7 | Decentral over flange and axial |  |
| 8 | Decentral over slots on the shank |  |

CXSC


Coolant exit style code

| Code | Description | Image |
|------|---|---|
| 0 | No coolant exit |  |
| 1 | Axial concentric exit |  |
| 2 | Radial exit |  |
| 3 | Axial inclined exit |  |
| 4 | Axial concentric on circle |  |
| 5 | Axial inclined exit with nozzle, adjustable |  |
| 6 | Decentral exit with nozzle, adjustable |  |
| 7 | Decentral over slots on the shank |  |
| 8 | Axial or decentral with nozzle, adjustable |  |

Formulas and definitions:

| | |
|---|-----------------------------|
| v_c = cutting speed | m/min (meter/minute) |
| n = spindle speed | rpm (revolution per minute) |
| v_f = table feed | mm/min |
| z_1 = total number of cutting edges | |
| z_c = number of effective cutting edges | |
| f_z = feed per tooth | mm/z |
| f_n = feed per revolution | mm/rev |
| h_{ex} = maximum thickness | mm |
| a_p = cutting depth | mm |
| a_e/D_c % = Radial immersion | % |
| T = machining time | min |
| Q = metal removal rate | cm ³ /min |
| n_{ap} = number of passes | |
| k_c = specific cutting force | N/mm ² |
| R_a = surface roughness | μm |

Insert size

 = cutting edge length in mm

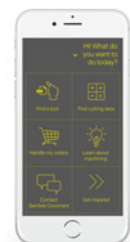
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Material cross reference list

| ISO | MC | CMC | Country | | | | | | | | | | |
|---------------------|-----------------|-----------------|-------------|------------|---------------|-------------------|------|------------|-----------------|-----------------|-------------|------------------|------------|
| | | | Europe | Germany | Great Britain | Sweden | USA | France | Italy | Spain | Japan | | |
| | | | Standard | W.-nr. | | BS | EN | SS | AISI/SAE/ASTM | AFNOR | UNI | UNE | JIS |
| | | | DIN EN | | | | | | | | | | |
| P | Unalloyed steel | | | | | | | | | | | | |
| | P1.1.Z.AN | 01.1 | S235JR G2 | 1.0038 | 4360 40 C | - | 1311 | A570.36 | E 24-2 Ne | - | - | STKM 12A;C | |
| | P1.1.Z.AN | 01.1 | S235J2 G3 | 1.0116 | 4360 40 B | - | 1312 | A573-81 65 | E 24-U | Fe37-3 | - | - | |
| | P1.1.Z.AN | 01.1 | C15 | 1.0401 | 080M15 | - | 1350 | 1015 | CC12 | C15C16 | F.111 | - | |
| | P1.1.Z.AN | 01.1 | C22 | 1.0402 | 050A20 | 2C/2D | 1450 | 1020 | CC20 | C20C21 | F.112 | - | |
| | P1.1.Z.AN | 01.1 | C15E | 1.1141 | 080M15 | 32C | 1370 | 1015 | XC12 | C16 | C15K | S15C | |
| | P1.1.Z.AN | 01.1 | C25E | 1.1158 | - | - | - | 1025 | - | - | - | S25C | |
| | P1.1.Z.AN | 01.1 | S380N | 1.8900 | 4360 55 E | - | 2145 | A572-60 | - | FeE390KG | - | - | |
| | P1.1.Z.AN | 01.1 | 17MnV7 | 1.0870 | 4360 55 E | - | 2142 | A572-60 | NFA 35-501 E 36 | - | - | - | |
| | P1.1.Z.AN | 02.1 | 55Si7 | 1.0904 | 250A53 | 45 | 2085 | 9255 | 55S7 | 55Si8 | 56Si7 | - | |
| | P1.1.Z.AN | 02.2 | - | - | - | - | 2090 | 9255 | 55S7 | - | - | - | |
| | P1.2.Z.AN | 01.2 | C35 | 1.0501 | 060A35 | - | 1550 | 1035 | CC35 | C35 | F.113 | - | |
| | P1.2.Z.AN | 01.2 | C45 | 1.0503 | 080M46 | - | 1650 | 1045 | CC45 | C45 | F.114 | - | |
| | P1.2.Z.AN | 01.2 | 40Mn4 | 1.1157 | 150M36 | 15 | - | 1039 | 35M5 | - | - | - | |
| | P1.2.Z.AN | 01.2 | 36Mn5 | 1.1167 | - | - | 2120 | 1335 | 40M5 | - | 36Mn5 | SMn438(H) | |
| | P1.2.Z.AN | 01.2 | 28Mn6 | 1.1170 | 150M28 | 14A | - | 1330 | 20M5 | C28Mn | - | SCMn1 | |
| | P1.2.Z.AN | 01.2 | C35G | 1.1183 | 060A35 | - | 1572 | 1035 | XC38TS | C36 | - | S35C | |
| | P1.2.Z.AN | 01.2 | C45E | 1.1191 | 080M46 | - | 1672 | 1045 | XC42 | C45 | C45K | S45C | |
| | P1.2.Z.AN | 01.2 | C53G | 1.1213 | 060A52 | - | 1674 | 1050 | XC48TS | C53 | - | S50C | |
| | P1.2.Z.AN | 01.3 | C55 | 1.0535 | 070M55 | - | 1655 | 1055 | - | C55 | - | - | |
| | P1.2.Z.AN | 01.3 | C55E | 1.1203 | 070M55 | - | - | 1055 | XC55 | C50 | C55K | S55C | |
| | P1.2.Z.AN | 02.1 | S275J2G3 | 1.0144 | 4360 43C | - | 1412 | A573-81 | E 28-3 | - | - | SM 400A;B;C | |
| | P1.2.Z.AN | 02.1 | S355J2G3+C2 | 1.0570 | 4360 50B | - | 2132 | - | E36-3 | Fe52BFN/Fe52CFN | - | SM490A;B;C;YA;YB | |
| | P1.2.Z.AN | 02.1 | S355J2G3 | 1.0841 | 150 M 19 | - | 2172 | 5120 | 20 MC 5 | Fe52 | F-431 | - | |
| | P1.3.Z.AN | 01.3 | C60E | 1.0601 | 080A62 | 43D | - | 1060 | CC55 | C60 | - | - | |
| | P1.3.Z.AN | 01.3 | C60E | 1.1221 | 080A62 | 43D | 1678 | 1060 | XC60 | C60 | - | S58C | |
| | P1.3.Z.AN | 01.4 | C101E | 1.1274 | 060 A 96 | - | 1870 | 1095 | XC 100 | - | F-5117 | - | |
| | P1.3.Z.AN | 01.4 | C101u | 1.1545 | BW 1A | - | 1880 | W 1 | Y105 | C36KU | F-5118 | SK 3 | |
| | P1.3.Z.AN | 01.4 | C105W1 | - | BW2 | - | 2900 | W210 | Y120 | C120KU | F.515 | SUP4 | |
| | P1.3.Z.AN | 02.1 | S340 MGC | 1.0961 | - | - | - | 9262 | 60SC7 | 60SiCr8 | 60SiCr8 | - | |
| | P1.4.Z.AN | 01.1 | 11SMn30 | 1.0715 | 230M07 | - | 1912 | 1213 | S250 | CF9SMn28 | 11SMn28 | SUM22 | |
| | P1.4.Z.AN | 01.1 | 11SMnPb30 | 1.0718 | - | - | 1914 | 12L13 | S250Pb | CF9SMnPb28 | 11SMnPb28 | SUM22L | |
| | P1.4.Z.AN | 01.1 | 10SPb20 | 1.0722 | - | - | - | - | 10PbF2 | CF10SPb20 | 10SPb20 | - | |
| | P1.4.Z.AN | 01.1 | 11SMn37 | 1.0736 | 240M07 | 1B | - | 1215 | S 300 | CF9SMn36 | 12SMn35 | - | |
| | P1.4.Z.AN | 01.1 | 11SMnPb37 | 1.0737 | - | - | 1926 | 12L14 | S300Pb | CF9SMnPb36 | 12SMnP35 | - | |
| | P1.4.Z.AN | 01.2 | 35S20 | 1.0726 | 212M36 | 8M | 1957 | 1140 | 35MF4 | - | F210G | - | |
| | P1.5.C.UT | 01.1 | GC16E | 1.1142 | 030A04 | 1A | 1325 | 1115 | - | - | - | - | |
| | Steel | Low-alloy steel | | | | | | | | | | | |
| | | P2.1.Z.AN | 02.1 | 16Mo3 | 1.5415 | 1501-240 | - | 2912 | A204Gr.A | 15D3 | 16Mo3KW | 16Mo3 | - |
| | | P2.1.Z.AN | 02.1 | 14Ni6 | 1.5622 | - | - | - | A350LF5 | 16N6 | 14Ni6 | 15Ni6 | - |
| | | P2.1.Z.AN | 02.1 | 21NiCrMo2 | 1.6523 | 805M20 | 362 | 2506 | 8620 | 20NCD2 | 20NiCrMo2 | 20NiCrMo2 | SNCM220(H) |
| | | P2.1.Z.AN | 02.1 | 17CrNiMo6 | 1.6587 | 820A16 | - | - | - | 18NCD6 | - | 14NiCrMo13 | - |
| | | P2.1.Z.AN | 02.1 | 15Cr3 | 1.7015 | 523M15 | - | - | 5015 | 12C3 | - | - | SCR415(H) |
| | | P2.1.Z.AN | 02.1 | 55Cr3 | 1.7176 | 527A60 | 48 | - | 5155 | 55C3 | - | - | SUP9(A) |
| | | P2.1.Z.AN | 02.1 | 15CrMo5 | 1.7262 | - | - | 2216 | - | 12CD4 | - | 12CrMo4 | SCM415(H) |
| | | P2.1.Z.AN | 02.1 | 13CrMo4-5 | 1.7335 | 1501-620Gr27 | - | - | A182 F11;F12 | 15CD3.5 | 14CrMo4 5 | 14CrMo45 | - |
| | | | | | | | | | | 15CD4.5 | - | - | - |
| | | P2.1.Z.AN | 02.1 | 10CrMo9 10 | 1.7380 | 1501-622 Gr.31;45 | - | 2218 | A182 F22 | 12CD9, 10 | 12CrMo9, 10 | TU.H | - |
| | | P2.1.Z.AN | 02.1 | 14MoV6 3 | 1.7715 | 1503-660-440 | - | - | - | - | - | 13MoCrV6 | - |
| | | P2.1.Z.AN | 02.1 | 50CoMo4 | 1.7228 | 823M30 | 33 | 2512 | - | - | 653M31 | - | - |
| | | P2.1.Z.AN | 02.2 | 14NiCr10 | 1.5732 | - | - | - | 3415 | 14NC11 | 16NiCr11 | 15NiCr11 | SNC415(H) |
| | | P2.1.Z.AN | 02.2 | 14NiCr14 | 1.5752 | 655M13; A12 | 36A | - | 3415;3310 | 12NC15 | - | - | SNC815(H) |
| P2.1.Z.AN | | 02.1/02.2 | 16MnCr5 | 1.7131 | (527M20) | - | 2511 | 5115 | 16MC5 | 16MnCr5 | 16MnCr5 | - | |
| P2.1.Z.AN | | 02.1/02.2 | 34CrMo4 | 1.7220 | 708A37 | 19B | 2234 | 4137;4135 | 35CD4 | 35CrMo4 | 34CrMo4 | SCM432;SCCRM3 | |
| P2.1.Z.AN | | 02.1/02.2 | 41CrMo4 | 1.7223 | 708M40 | 19A | 2244 | 4140;4142 | 42CD4TS | 41CrMo4 | 42CrMo4 | SCM 440 | |
| P2.1.Z.AN | | 02.1/02.2 | 42CrMo4 | 1.7225 | 708M40 | 19A | 2244 | 4140 | 42CD4 | 42CrMo4 | 42CrMo4 | SCM440(H) | |
| P2.1.Z.AN | | 03.11 | 14NiCrMo134 | 1.6657 | 832M13 | 36C | - | - | - | 15NiCrMo13 | 14NiCrMo131 | - | |
| P2.2.Z.AN | | 02.1 | 31CrMo12 | 1.8515 | 722 M 24 | - | 2240 | - | 30 CD 12 | 30CrMo12 | F-1712 | - | |
| P2.2.Z.AN | | 02.1 | 39CrMoV13 9 | 1.8523 | 897M39 | 40C | - | - | - | 36CrMoV12 | - | - | |
| P2.2.Z.AN | | 02.1 | 41CrS4 | 1.7039 | 524A14 | - | 2092 | L1 | - | 105WCR 5 | - | - | |
| P2.2.Z.AN | | 02.1 | 50NiCr13 | 1.2721 | - | - | 2550 | L6 | 55NCV6 | - | F-528 | - | |
| P2.2.Z.AN | | 03.11 | 45WCrV7 | 1.2542 | BS1 | - | 2710 | S1 | - | 45WCrV8KU | 45WCrS18 | - | |
| P2.2.Z.AN/P2.5.Z.HT | | 02.1/02.2 | 36CrNiMo4 | 1.6511 | 816M40 | 110 | - | 9840 | 40NCD3 | 38NiCrMo4(KB) | 35NiCrMo4 | - | |
| P2.2.Z.AN/P2.5.Z.HT | | 02.1/02.2 | 34CrNiMo6 | 1.6582 | 817M40 | 24 | 2541 | 4340 | 35NCD6 | 35NiCrMo6(KB) | - | - | |
| P2.2.Z.AN/P2.5.Z.HT | | 02.1/02.2 | 34Cr4 | 1.7033 | 530A32 | 18B | - | 5132 | 32C4 | 34Cr4(KB) | 35Cr4 | SCR430(H) | |
| P2.2.Z.AN/P2.5.Z.HT | | 02.1/02.2 | 41Cr4 | 1.7035 | 530A40 | 18 | - | 5140 | 42C4 | 41Cr4 | 42Cr4 | SCR440(H) | |
| P2.2.Z.AN/P2.5.Z.HT | | 02.1/02.2 | 32CrMo12 | 1.7361 | 722M24 | 40B | 2240 | - | 30CD12 | 32CrMo12 | F.124.A | - | |
| P2.2.Z.AN/P2.5.Z.HT | | 02.1/02.2 | 51CrV4 | 1.8159 | 735A50 | 47 | 2230 | 6150 | 50CV4 | 50CrV4 | 51CrV4 | SUP10 | |
| P2.2.Z.AN/P2.5.Z.HT | | 02.1/02.2 | 41CrAlMo7 | 1.8509 | 905M39 | 41B | 2940 | - | 40CAD6, 12 | 41CrAlMo7 | 41CrAlMo7 | - | |
| P2.3.Z.AN | | 02.1 | 100Cr6 | 1.3505 | 534A99 | 31 | 2258 | 52100 | 100C6 | 100C6 | F.131 | SUJ2 | |

Material cross reference list

| ISO | MC | CMC | Country | | | | | | | | | |
|---|-------------------------|---------------|----------------|---------------|---------------|--------|-----------|---------------|---------------|-----------------|-----------|---------------|
| | | | Europe | Germany | Great Britain | Sweden | USA | France | Italy | Spain | Japan | |
| | | | Standard | | | | | | | | | |
| | | | DIN EN | W.-nr. | BS | EN | SS | AISI/SAE/ASTM | AFNOR | UNI | UNE | JIS |
| P | P2.3.Z.AN/H1.2.Z.HA | 02.1/02.2 | 105WCr6 | 1.2419 | - | - | 2140 | - | 105WC13 | 10WCr6 | 105WCr5 | SKS31 |
| | P2.3.Z.AN/H1.2.Z.HA | - | - | - | - | - | - | - | - | 107WCr5KU | - | SKS2, SKS3 |
| | P2.3.Z.AN/H1.2.Z.HA | 02.1/02.2 | - | 1.2714 | - | - | - | - | L6 | 55NCDV7 | - | SKT4 |
| | P2.3.Z.AN/H1.3.Z.HA | 02.1/02.2 | 100Cr6 | 1.2067 | BL3 | - | - | L3 | Y100C6 | - | 100Cr6 | - |
| | P2.4.Z.AN | 02.1 | 16MnCr5 | 1.7139 | - | - | 2127 | - | - | - | - | - |
| | P2.5.Z.HT | 02.1 | 16Mo5 | 1.5423 | 1503-245-420 | - | - | 4520 | - | 16Mo5 | 16Mo5 | - |
| | P2.5.Z.HT | 02.1 | 40NiCrMo8-4 | 1.6562 | 311-Type 7 | - | - | 8740 | - | 40NiCrMo2(KB) | 40NiCrMo2 | SNCM240 |
| | P2.5.Z.HT | 02.1 | 42Cr4 | 1.7045 | - | - | 2245 | 5140 | - | - | 42Cr4 | SCR440 |
| | P2.5.Z.HT | 02.1 | 31NiCrMo14 | 1.5755 | 830 M 31 | - | 2534 | - | - | - | F-1270 | - |
| | P2.5.Z.HT | 02.2 | 36NiCr6 | 1.5710 | 640A35 | 111A | - | 3135 | 35NC6 | - | - | SNC236 |
| | P2.6.C.UT | 02.1 | 22Mo4 | 1.5419 | 605A32 | - | 2108 | 8620 | - | - | F520.S | - |
| | P2.6.C.UT | 02.1/02.2 | 25CrMo4 | 1.7218 | 1717CDS110 | - | 2225 | 4130 | 25CD4 | 25CrMo4(KB) | AM26CrMo4 | SCM420,SCM430 |
| | P2.6.C.UT | 06.2 | - | - | - | - | 2223 | - | - | - | - | - |
| | High-alloy steel | | | | | | | | | | | |
| P3.0.Z.AN | 03.11 | X210Cr12 | 1.2080 | BD3 | - | - | D3 | Z200C12 | X210Cr13KU | X210Cr12 | SKD1 | |
| P3.0.Z.AN | 03.11 | X43Cr13 | 1.2083 | - | - | 2314 | - | - | - | X250Cr12KU | - | |
| P3.0.Z.AN | 03.11 | X40CrMoV5 1 | 1.2344 | BH13 | - | 2242 | H13 | Z40CDV5 | X35CrMoV05KU | X40CrMoV5 | SKD61 | |
| P3.0.Z.AN | 03.11 | X100CrMoV5 1 | 1.2363 | BA2 | - | 2260 | A2 | Z100CDV5 | X40CrMoV511KU | X100CrMoV5 | SKD12 | |
| P3.0.Z.AN | 03.11 | X210CrW12 | 1.2436 | - | - | 2312 | - | - | X100CrMoV51KU | X210CrW12 | SKD2 | |
| P3.0.Z.AN | 03.11 | X30WCrV9 3 | 1.2581 | BH21 | - | - | H21 | Z30WCV9 | X28W09KU | X30WCrV9 | SKD5 | |
| P3.0.Z.AN | 03.11 | X165CrMoV 12 | 1.2601 | - | - | 2310 | - | - | X30WCrV9 3KU | X160CrMoV12 | - | |
| P3.0.Z.AN | 03.21 | X155CrMoV12-1 | 1.2379 | - | - | 2736 | HNV3 | - | X165CrMoV12KU | - | - | |
| P3.0.Z.HT | 03.11 | X8Ni9 | 1.5662 | 1501-509;510 | - | - | ASTM A353 | - | X10Ni9 | XBNI09 | - | |
| P3.0.Z.HT | 03.11 | 12Ni19 | 1.5680 | - | - | - | 2515 | Z18N5 | - | - | - | |
| P3.1.Z.AN | 03.11 | S6-5-2 | 1.3343 | 4959BA2 | - | 2715 | D3 | Z40CSD10 | 15NiCrMo13 | - | SUH3 | |
| P3.1.Z.AN | 03.13 | - | - | BM 2 | - | 2722 | M 2 | Z85WDCV | HS 6-5-2-2 | F-5603. | SKH 51 | |
| P3.1.Z.AN | 03.13 | HS 6-5-2-5 | 1.3243 | BM 35 | - | 2723 | M 35 | 6-5-2-5 | HS 6-5-2-5 | F-5613 | SKH 55 | |
| P3.1.Z.AN | 03.13 | HS 2-9-2 | 1.3348 | HS 2-9-2 | - | 2782 | M 7 | - | HS 2-9-2 | F-5607 | - | |
| P3.2.C.AQ | 06.33 | G-X120Mn12 | 1.3401 | Z120M12 | - | 2183 | L3 | Z120M12 | XG120Mn12 | X120Mn12 | SCMnH/1 | |
| Ferritic/martensitic stainless steel | | | | | | | | | | | | |
| Steel | P5.0.Z.AN | 05.11/15.11 | X10CrAL13 | 1.4724 | 403S17 | - | - | 405 | Z10C13 | X10CrAl12 | F.311 | SUS405 |
| | P5.0.Z.AN | 05.11/15.11 | X10CrAL18 | 1.4742 | 430S15 | 60 | - | 430 | Z10CAS18 | X8Cr17 | F.3113 | SUS430 |
| | P5.0.Z.AN | 05.11/15.11 | X10CrAL2-4 | 1.4762 | - | - | 2322 | 446 | Z10CAS24 | X16Cr26 | - | SUH446 |
| | P5.0.Z.AN | 05.11/15.11 | X1CrMoTi18-2 | 1.4521 | - | - | 2326 | S44400 | - | - | - | - |
| | P5.0.Z.AN/P5.0.Z.HT | 05.11/15.11 | X6Cr13 | 1.4000 | 403S17 | - | 2301 | 403 | Z6C13 | X6Cr13 | F.3110 | SUS403 |
| | P5.0.Z.AN/P5.0.Z.HT | - | X7Cr14 | 1.4001 | - | - | - | - | - | - | F.8401 | - |
| | P5.0.Z.AN/P5.0.Z.HT | 05.11/15.11 | X10Cr13 | 1.4006 | 410S21 | 56A | 2302 | 410 | Z10C14 | X12Cr13 | F.3401 | SUS410 |
| | P5.0.Z.AN/P5.0.Z.HT | 05.11/15.11 | X6Cr17 | 1.4016 | 430S15 | 96D | 2320 | 430 | Z8C17 | X8Cr17 | F.3113 | SUS430 |
| | P5.0.Z.AN/P5.0.Z.HT | 05.11/15.11 | X6CrAL13 | 1.4002 | 405S17 | - | - | 405 | Z8CA12 | X6CrAl13 | - | - |
| | P5.0.Z.AN/P5.0.Z.HT | 05.11/15.11 | X20Cr13 | 1.4021 | 420S37 | - | 2303 | 420 | Z20C13 | X20Cr13 | - | - |
| | P5.0.Z.AN/P5.0.Z.HT | 05.11/15.11 | X6CrMo17-1 | 1.4113 | 434S17 | - | 2325 | 434 | Z8CD17.01 | X8CrMo17 | - | SUS434 |
| | P5.0.Z.HT | 03.11 | X45CrS9-3-1 | 1.4718 | 401S45 | 52 | - | HW3 | Z45CS9 | X45CrSi8 | F.322 | SUH1 |
| | P5.0.Z.HT | 05.11/15.11 | X85CrMoV18-2 | 1.4748 | 443S65 | 59 | - | HNV6 | Z80CSN20.02 | X80CrSiNi20 | F.320B | SUH4 |
| | P5.0.Z.HT | 05.11/15.11 | X20CrMoV12-1 | 1.4922 | - | - | 2317 | - | - | X20CrMoNi 12.01 | - | - |
| | P5.0.Z.PH | 05.11/15.11 | X12CrS13 | 1.4005 | 416 S 21 | - | 2380 | 416 | Z11CF13 | X12 CrS 13 | F-3411 | SUS 416 |
| | P5.0.Z.PH | 05.11/15.11 | X46Cr13 | 1.4034 | 420S45 | 56D | 2304 | - | Z40CM | X40Cr14 | F.3405 | SUS420J2 |
| | P5.0.Z.PH | 05.11/15.11 | X19CrNi17-2 | 1.4057 | 431S29 | 57 | 2321 | 431 | Z15CNI6.02 | X16CrNi16 | F.3427 | SUS431 |
| | P5.0.Z.PH | 05.12/15.12 | X5CrNiCuNb16-4 | 1.4542 1.4548 | - | - | - | 630 | Z7CNU17-04 | - | - | - |
| | P5.0.Z.PH | 15.21 | X4 CrNiMo16-5 | 1.4418 | - | - | 2387 | - | Z6CND16-04-01 | - | - | - |
| P5.1.Z.AN/P5.0.Z.HT | 05.11/15.11 | X14CrMoS17 | 1.4104 | - | - | 2383 | 430F | Z10CF17 | X10CrS17 | F.3117 | SUS430F | |
| P2.1.Z.AN | 02.1 | | | | | | | | | | | |
| P2.2.Z.AN | 02.1 | | 1.0045 | | | | | | | | | |
| P2.2.Z.AN | 02.1 | | | | | | | | | | | |
| P2.5.Z.HT | 02.2 | | | | | | | | | | | |
| P1.2.Z.AN | | | | | | | | | | | | |
| P1.2.Z.AN | | | | | | | | | | | | |
| P1.2.Z.AN | | | | | | | | | | | | |
| P2.5.Z.HT | | | | | | | | | | | | |
| P2.5.Z.HT | 02.2 | | | | | | | | | | | |
| P2.5.Z.HT | 02.2 | | | | | | | | | | | |
| P2.5.Z.HT | | | | | | | | | | | | |
| P2.5.Z.HT | | | | | | | | | | | | |

Material cross reference list

| ISO | MC | CMC | Country | | | | | | | | | | |
|-----------|---|-------------|--------------------|---------|---------------|---------|------------|-------------|-----------------------|-----------------|---------------|--------------|----------------|
| | | | Europe | Germany | Great Britain | Sweden | USA | France | Italy | Spain | Japan | | |
| | | | Standard | | | | | | | | | | |
| DIN EN | W.-nr. | BS | EN | SS | AISI/SAE/ASTM | AFNOR | UNI | UNE | JIS | | | | |
| M | Austenitic stainless steel | | | | | | | | | | | | |
| | M1.0.Z.AQ | 05.11/15.11 | X3CrNiMo13-4 | 1.4313 | 425C11 | - | 2385 | CA6-NM | Z4CND13.4M Z38C13M | (G)X6CrNi304 | - | SCS5 | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.11/15.11 | X53CrMnNiN12-9 | 1.4871 | 349S54 | - | - | EV8 | Z52CMN21.09 | X53CrMnNiN12 9 | - | SUH35, SUH36 | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X2CrNiN18-10 | 1.4311 | 304S62 | - | 2371 | 304LN | Z2CN18.10 | - | - | SUS304LN | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X2CrNiMoN17-13-3 | 1.4429 | - | - | 2375 | 316LN | Z2CND17.13 | - | - | SUS316LN | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X2CrNiMo17-12-2 | 1.4404 | 316S13 | - | 2348 | 316L | Z2CND17-12 | X2CrNiMo1712 | - | - | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X2CrNiMo18-14-3 | 1.4435 | 316S13 | - | 2353 | 316L | Z2CND17.12 | X2CrNiMo17 12 | - | - | SCS16, SUS316L |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X3CrNiMo17-3-3 | 1.4436 | 316S33 | - | 2343, 2347 | 316 | Z6CND18-12-03 | X8CrNiMo1713 | - | - | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X2CrNiMo18-15-4 | 1.4438 | 317S12 | - | 2367 | 317L | Z2CND19.15 | X2CrNiMo18 16 | - | - | SUS317L |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X6CrNiN18-10 | 1.4550 | 347S17 | 58F | 2338 | 347 | Z6CND18.10 | X6CrNiN18 11 | F.3552 F.3524 | SUS347 | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X6CrNiMoTi17-12-2 | 1.4571 | 320S17 | 58J | 2350 | 316Ti | Z6NDT17.12 | X6CrNiMoTi17 12 | F.3535 | - | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X10CrNiMoNb 18-12 | 1.4583 | - | - | - | 318 | Z6CNDNb17 13B | X6CrNiMoNb17 13 | - | - | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X15CrNiSi20-12 | 1.4828 | 309S24 | - | - | 309 | Z15CNS20.12 | - | - | - | SUH309 |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X2CrNiMoN17-11-2 | 1.4406 | 301S21 | 58C | 2370 | 308 | Z1NCDU25.20 | - | F.8414 | SCS17 | |
| | M1.0.Z.AQ | 05.21/15.21 | X1CrNiMoCuN20-18-7 | 1.4547 | - | - | 2378 | S31254 | Z1CNDU20-18-06AZ | - | - | - | |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X9CrNi18-8 | 1.4310 | - | - | 2331 | 301 | Z12CN17.07 | X12CrNi17 07 | F.3517 | SUS301 | |
| | M1.0.Z.PH | 05.22/15.22 | X7CrNiAl17-7 | 1.4568 | 1.4504 | 316S111 | - | - | 17-7PH | Z8CNA17-07 | X2CrNiMo1712 | - | - |
| | M1.0.Z.AQ/M1.0.C.UT | 05.21/15.21 | X2CrNi19-11 | 1.4306 | 304S11 | - | 2352 | 304L | Z2CN18-10 | X2CrNi18 11 | - | - | |
| | M1.1.Z.AQ | 05.21/15.21 | - | - | 304S12 | - | - | - | - | - | - | - | |
| | M1.1.Z.AQ | 05.21/15.21 | X5CrNi18-10 | 1.4301 | 304S31 | 58E | 2332, 2333 | 304 | Z6CN18.09 | X5CrNi18 10 | F.3504 F.3541 | SUS304 | |
| | M1.1.Z.AQ | 05.21/15.21 | X5CrNi18-10 | 1.4301 | 304S15 | 58E | 2332 | 304 | Z6CN18.09 | X5CrNi18 10 | F.3551 | SUS304 | |
| | M1.1.Z.AQ | 05.21/15.21 | X5CrNiMo17-2-2 | 1.4401 | 316S16 | 58J | 2347 | 316 | Z6CND17.11 | X5CrNiMo17 12 | F.3543 | SUS316 | |
| | M1.1.Z.AQ | 05.21/15.21 | X6CrNiTi18-10 | 1.4541 | 321S12 | 58B | 2337 | 321 | Z6CNT18.10 | X6CrNiTi18 11 | F.3553 F.3523 | SUS321 | |
| | M1.2.Z.AQ | 05.21/15.21 | X8CrNiSi18-9 | 1.4305 | 303S21 | 58M | 2346 | 303 | Z10CNF 18.09 | X10CrNiSi 18.09 | F.3508 | SUS303 | |
| | Super austenitic (Ni>20%) stainless steel | | | | | | | | | | | | |
| | M2.0.C.AQ | 20.11 | G-X40NiCrSi36-18 | 1.4865 | 330C11 | - | - | - | - | XG50NiCr39 19 | - | - | SCH15 |
| | M2.0.Z.AQ | 05.21/15.21 | X1NiCrMoCu25-20-5 | 1.4539 | - | - | 2562 | UNS V 0890A | Z2 NCDU25-20 | - | - | - | |
| | M2.0.Z.AQ | 05.21/15.21 | X8CrNi25-21 | 1.4845 | 310S24 | - | 2361 | 310S | Z12CN25 20 | X6CrNi25 20 | F.331 | SUH310 | |
| | M2.0.Z.AQ | 20.11 | X12NiCrSi36 16 | 1.4864 | - | - | - | 330 | Z12NCS35.16 | F-3313 | - | - | SUH330 |
| | M2.0.Z.AQ | 05.23/15.23 | X1NiCrMoCu31-27-4 | 1.4563 | - | - | 2584 | NO8028 | Z1NCDU31-27-03 | - | - | - | |
| | Duplex (austenitic/ferritic) stainless steel | | | | | | | | | | | | |
| | M3.1.Z.AQ/M3.1.C.AQ | 05.51/15.51 | X2CrNiN23-4 | 1.4362 | - | - | 2376 | S31500 | - | - | - | - | |
| | M3.1.Z.AQ/M3.1.C.AQ | 05.51/15.51 | X8CrNiMo27-5 | - | - | - | 2324 | S32900 | - | - | - | - | |
| | M3.2.Z.AQ/M3.2.C.AQ | 05.52/15.52 | X2CrNiN23-4 | - | - | - | 2327 | S32304 | Z2CN23-04AZ | - | - | - | |
| | M3.2.Z.AQ/M3.2.C.AQ | 05.52/15.52 | - | - | - | - | 2328 | - | - | - | - | - | |
| | M3.2.Z.AQ/M3.2.C.AQ | 05.52/15.52 | X2CrNiMoN22-53 | - | - | - | 2377 | S31803 | Z2CND22-05-03 | - | - | - | |
| | M1.1.Z.AQ | 05.21/15.21 | | | | | | | | | | | |
| | M1.1.Z.AQ | 05.21/15.21 | | 1.0045 | | | | | | | | | |
| | M1.1.Z.AQ | 05.21/15.21 | | | | | | | | | | | |
| | M1.1.Z.AQ | 05.21/15.21 | | | | | | | | | | | |
| | M1.0.Z.AQ | 05.23/15.23 | | | | | | | | | | | |
| | M2.0.Z.AQ | 05.23/15.23 | | | | | | | | | | | |
| M3.2.Z.AQ | 05.52/15.52 | | | | | | | | | | | | |
| M3.2.Z.AQ | 05.52/15.52 | | | | | | | | | | | | |

Material cross reference list

| ISO | MC | CMC | Country | | | | | | | | | | |
|-----------|---------------------------------|--------------------------------|-------------------|---------|---------------|---------|-----------------|---------------|------------|-----------|-----------|---------|--------|
| | | | Europe | Germany | Great Britain | Sweden | USA | France | Italy | Spain | Japan | | |
| | | | Standard | | | | | | | | | | |
| | | | DIN EN | W.-nr. | BS | EN | SS | AISI/SAE/ASTM | AFNOR | UNI | UNE | JIS | |
| K | Malleable cast iron | | | | | | | | | | | | |
| | K1.1.C.NS | 07.1 | - | - | 8 290/6 | - | 0814 | - | MN 32-8 | - | - | FCMB310 | |
| | K1.1.C.NS | 07.1 | EN-GJMB350-10 | 0.8135 | B 340/12 | - | 0815 | 32510 | MN 35-10 | - | - | FCMW330 | |
| | K1.1.C.NS | 07.2 | EN-GJMB450-6 | 0.8145 | P 440/7 | - | 0852 | 40010 | Mn 450 | GMN 45 | - | FCMW370 | |
| | K1.1.C.NS | 07.2 | EN-GJMB550-4 | 0.8155 | P 510/4 | - | 0854 | 50005 | MP 50-5 | GMN 55 | - | FCMP490 | |
| | | | | | | P 570/3 | | 0858 | 70003 | MP 60-3 | | FCMP540 | |
| | K1.1.C.NS | 07.2 | EN-GJMB650-2 | 0.8165 | P570/3 | - | 0856 | A220-70003 | Mn 650-3 | GMN 65 | - | FCMP590 | |
| | K1.1.C.NS | 07.3 | EN-GJMB700-2 | 0.8170 | P690/2 | - | 0862 | A220-80002 | Mn700-2 | GMN 70 | - | FCMP690 | |
| | | Grey cast iron | | | | | | | | | | | |
| | K2.1.C.UT | 08.1 | - | - | - | - | 0100 | - | - | - | - | - | - |
| | K2.1.C.UT | 08.1 | EN-GJL-100 | 0.6010 | - | - | 0110 | No 20 B | Ft 10 D | - | - | - | FC100 |
| | K2.1.C.UT | 08.1 | EN-GJL-150 | 0.6015 | Grade 150 | - | 0115 | No 25 B | Ft 15 D | G 15 | FG 15 | - | FC150 |
| | K2.1.C.UT | 08.1 | EN-GJL-200 | 0.6020 | Grade 220 | - | 0120 | No 30 B | Ft 20 D | G 20 | - | - | FC200 |
| | K2.1.C.UT | 08.2 | EN-GJL-250 | 0.6025 | Grade 260 | - | 0125 | No 35 B | Ft 25 D | G 25 | FG 25 | - | FC250 |
| | K2.1.C.UT | 08.2 | EN-JLZ | 0.6040 | Grade 400 | - | 0140 | No 55 B | Ft 40 D | - | - | - | - |
| | K2.2.C.UT | 08.2 | EN-GJL-300 | 0.6030 | Grade 300 | - | 0130 | No 45 B | Ft 30 D | G 30 | FG 30 | - | FC300 |
| | K2.2.C.UT | 08.2 | EN-GJL-350 | 0.6035 | Grade 350 | - | 0135 | No 50 B | Ft 35 D | G 35 | FG 35 | - | FC350 |
| | K2.3.C.UT | 08.3 | GGL-NiCr20-2 | 0.6660 | L-NiCuCr202 | - | 0523 | A436 Type 2 | L-NC 202 | - | - | - | - |
| | | Nodular cast iron | | | | | | | | | | | |
| | K3.1.C.UT | 09.1 | EN-GJS-400-15 | 0.7040 | SNG 420/12 | - | 0717-02 | 60-40-18 | FCS 400-12 | GS 370-17 | FGE 38-17 | - | FCD400 |
| | K3.1.C.UT | 09.1 | EN-GJS-400-18-LT | 0.7043 | SNG 370/17 | - | 0717-12 | - | FGS 370-17 | - | - | - | - |
| | K3.1.C.UT | 09.1 | EN-GJS-350-22-LT | 0.7033 | - | - | 0717-15 | - | - | - | - | - | - |
| | K3.1.C.UT | 09.1 | EN-GJS-800-7 | 0.7050 | SNG 500/7 | - | 0727 | 80-55-06 | FGS 500-7 | GS 500 | FGE 50-7 | - | FCD500 |
| | K3.2.C.UT | 09.2 | EN-GJS-600-3 | 0.7060 | SNG 600/3 | - | 0732-03 | - | FGS 600-3 | - | - | - | FCD600 |
| | K3.3.C.UT | 09.2 | EN-GJS-700-2 | 0.7070 | SNG 700/2 | - | 0737-01 | 100-70-03 | FGS 700-2 | GS 700-2 | FGS 70-2 | - | FCD700 |
| | K3.5.C.UT | - | EN-GJSA-XNiCr20-2 | 0.7660 | Grade S6 | - | 0776 | A43D2 | S-NC 202 | - | - | - | - |
| | | Compacted graphite iron | | | | | | | | | | | |
| K4.1.C.UT | - | EN-GJV-300 | | | | | | | | | | | |
| K4.1.C.UT | - | EN-GJV-350 | | | | | | | | | | | |
| K4.2.C.UT | - | EN-GJV-400 | | | | | | | | | | | |
| K4.2.C.UT | - | EN-GJV-450 | | | | | | | | | | | |
| K4.2.C.UT | - | EN-GJV-500 | | | | | | | | | | | |
| | Austempered ductile iron | | | | | | | | | | | | |
| K5.1.C.NS | - | EN-GJS-800-8 | - | - | - | - | ASTM A897 No. 1 | - | - | - | - | - | |
| K5.1.C.NS | - | EN-GJS-1000-5 | - | - | - | - | ASTM A897 No. 2 | - | - | - | - | - | |
| K5.2.C.NS | - | EN-GJS-1200-2 | - | - | - | - | ASTM A897 No. 3 | - | - | - | - | - | |
| K5.2.C.NS | - | EN-GJS-1400-1 | - | - | - | - | ASTM A897 No. 4 | - | - | - | - | - | |
| K5.3.C.NS | - | - | - | - | - | - | ASTM A897 No. 5 | - | - | - | - | - | |

Material cross reference list

| ISO | MC | CMC | Country | | | | | | | | | | | |
|-----------------------------|-------------------------------|--|----------------------------|------------------|-----------------|--------------|--------|---------------|------------|------------|--------|-----|-------|---|
| | | | Europe | Germany | Great Britain | Sweden | USA | France | Italy | Spain | Japan | | | |
| | | | Standard | | | | | | | | | | | |
| | | | DIN EN | W.-nr. | BS | EN | SS | AISI/SAE/ASTM | AFNOR | UNI | UNE | JIS | | |
| N | Aluminium based alloys | | | | | | | | | | | | | |
| | Non-ferrous metals | N1.3.C.AG | 30.21 | G-AISI9MGWA | 3.2373 | - | - | 4251 | SC64D | A-S7G | - | - | C4BS | |
| | | N1.3.C.UT | 30.21 | G-ALMG5 | - | LM5 | - | 4252 | GD-AISI12 | A-SU12 | - | - | AC4A | |
| | | N1.3.C.UT/N1.3.C.AG | 30.21/30.22 | - | - | LM25 | - | 4244 | 356.1 | - | - | - | A5052 | |
| | | N1.3.C.UT | - | GD-AISI12 | - | - | - | 4247 | A413.0 | - | - | - | A6061 | |
| | | N1.3.C.AG | - | GD-AISI8Cu3 | - | LM24 | - | 4250 | A380.1 | - | - | - | A7075 | |
| | | N1.3.C.UT | - | G-AISI12(Cu) | - | LM20 | - | 4260 | A413.1 | - | - | - | ADC12 | |
| | | N1.3.C.UT | - | G-AISI12 | - | LM6 | - | 4261 | A413.2 | - | - | - | - | |
| | | N1.3.C.AG | - | G-AISI10Mg(Cu) | - | LM9 | - | 4253 | A360.2 | - | - | - | - | |
| | | S | Nickel based alloys | | | | | | | | | | | |
| Heat resistant super alloys | | | S2.0.Z.AG | 20.22 | S-NiCr13A16MoNb | LW2 4670 | mar-46 | - | - | 5391 | NC12AD | - | - | - |
| | S2.0.C.UT | | 20.24 | NiCo15Cr10MoAlTi | LW2 4674 | - | - | - | AMS 5397 | - | - | - | - | |
| | S2.0.Z.AG | | 20.22 | NiFe35Cr14MoTi | LW2.4662 | - | - | - | 5660 | ZSNCDT42 | - | - | - | |
| | S2.0.Z.AG | | 20.22 | NiCr19Fe19NbMo | LW2.4668 | HR8 | - | - | 5383 | NC19eNB | - | - | - | |
| | S2.0.Z.AG | | 20.22 | NiCr20TiAk | 2.4631 | HR401.601 | - | - | - | NC20TA | - | - | - | |
| | S2.0.Z.AG | | 20.22 | NiCr19Co11MoTi | 2.4973 | - | - | - | AMS 5399 | NC19KDT | - | - | - | |
| | S2.0.Z.AG | | 20.22 | NiCr19Fe19NbMo | LW2.4668 | - | - | - | AMS 5544 | NC20K14 | - | - | - | |
| | S2.0.Z.AN | | 20.21 | - | 2.4603 | - | - | - | 5390A | NC22FeD | - | - | - | |
| | S2.0.Z.AN | | 20.21 | NiCr22Mo9Nb | 2.4856 | - | - | - | 5666 | NC22FeDNB | - | - | - | |
| | S2.0.Z.AN | | 20.21 | NiCr20Ti | 2.4630 | HR5.203-4 | - | - | - | NC20T | - | - | - | |
| | S2.0.Z.AG | | 20.22 | NiCu30AL3Ti | 2.4375 | 3072-76 | - | - | 4676 | - | - | - | - | |
| | Cobalt alloys | | | | | | | | | | | | | |
| | - | | - | CoCr20W15Ni | - | - | - | - | 5537C, AMS | KC20WN | - | - | - | - |
| | S3.0.Z.AG | | 20.32 | CoCr22W14Ni | LW2.4964 | - | - | - | 5772 | KC22WN | - | - | - | - |
| | Titanium alloys | | | | | | | | | | | | | |
| | S4.2.Z.AN | | 23.22 | TiAl5Sn2.5 | 3.7115.1 | TA14/17 | - | - | UNS R54520 | T-A5E | - | - | - | - |
| | S4.2.Z.AN | | 23.22 | TiAl6V4 | 3.7165.1 | TA10-13/TA28 | - | - | UNS R56401 | UNS R56400 | - | - | - | - |
| | S4.3.Z.AN | | 23.22 | TiAl5V5Mo5Cr3 | - | - | - | - | - | T-A6V | - | - | - | - |
| | S4.2.Z.AN | | 23.22 | TiAl4Mo4Sn4Si0.5 | 3.7185 | - | - | - | - | - | - | - | - | - |
| | Trade names | | | | | | | | | | | | | |
| Iron based alloys | | | | | | | | | | | | | | |
| S2.0.Z.UT/S2.0.Z.AN | 20.11 | Incoloy 800 | | | | | | | | | | | | |
| Nickel based alloys | | | | | | | | | | | | | | |
| S2.0.Z.AN | 20.2 | Haynes 600 | | | | | | | | | | | | |
| S2.0.Z.AN | 20.2 | Nimocast PD16 | | | | | | | | | | | | |
| S2.0.Z.AG | 20.2 | Nimonic PE 13 | | | | | | | | | | | | |
| S2.0.Z.AG | 20.2 | Rene 95 | | | | | | | | | | | | |
| S2.0.Z.AN | 20.21 | Hastelloy C | | | | | | | | | | | | |
| S2.0.Z.AN | 20.21 | Incoloy 825 | | | | | | | | | | | | |
| S2.0.Z.AN | 20.21 | Inconel 600 | | | | | | | | | | | | |
| S2.0.Z.AN | 20.21 | Monel 400 | | | | | | | | | | | | |
| S2.0.Z.AG | 20.22 | Inconel 700 | | | | | | | | | | | | |
| S2.0.Z.AG | S2.0.Z.AG | Inconel 718 | | | | | | | | | | | | |
| S2.0.Z.AG | 20.22 | Mar - M 432 | | | | | | | | | | | | |
| S2.0.Z.AG | 20.22 | Nimonic 901 | | | | | | | | | | | | |
| S2.0.Z.AG | 20.22 | Waspaloy | | | | | | | | | | | | |
| S2.0.C.NS | 20.24 | Jessop G 64 | | | | | | | | | | | | |
| S3.0.Z.AG | 20.3 | Cobalt alloys Air Resist 213 | | | | | | | | | | | | |
| S3.0.Z.AG | 20.3 | Jetalloy 209 | | | | | | | | | | | | |
| H | Hardened materials | | | | | | | | | | | | | |
| | Hardened materials | H1.2.Z.HA | 04.1 | X100CrMo13 | 1.4108 | - | - | 2258 08 | 440A | - | - | - | C4BS | |
| | | H1.3.Z.HA | 04.1 | X110CrMoV15 | 1.4111 | - | - | 2534 05 | 610 | - | - | - | AC4A | |
| | | H1.2.Z.HA | 04.1 | X65CrMo14 | - | - | - | 2541 06 | 0-2 | - | - | - | AC4A | |
| | | | | | | | | | | | | | | |

ISO 13399 is an international standard that strives to simplify the exchange of data for cutting tools. You will notice a slight difference through the new parameters and descriptions of each tool.

For the first time ever, there is a standardized way of describing product data regarding cutting tools. When all tools in the industry share the same parameters and definitions, communicating tool information becomes very straightforward.

What does this mean to you?

Basically, it means that your systems can talk to ours, as they all speak the same language. Download product data from our web site and use it directly in your CAD/CAM software to assemble tools that you use in production. No need to look for information in catalogues and interpret data from one system to another. Imagine how much time this will save you!

| Short name | Preferred Name |
|----------------------|--|
| ADJLN | Minimum adjustment limit |
| ADJLX | Maximum adjustment limit |
| ADJRG | Adjustment range |
| ALP | Clearance angle axial |
| AN | Clearance angle major |
| ANN | Clearance angle minor |
| APMX | Depth of cut maximum |
| APMX_EFW | Depth of cut maximum - end feed |
| APMX_FFW | Depth of cut maximum - side feed |
| AZ | Maximum plunge depth |
| B | Shank width |
| BAWS | Body angle workpiece side |
| BAMS | Body angle machine side |
| BBD | Balanced by design |
| BBR | Balanced by rotational test |
| BCH | Corner chamfer length |
| BD | Body diameter |
| BHTA | Body half taper angle |
| BN | Face land width |
| BS | Wiper edge length |
| BSG | Basic standard group |
| BSR | Wiper edge radius |
| CDX | Cutting depth maximum |
| CEMR | Cutting edge major radius |
| CF | Spot chamfer |
| CHBA | Chamfer body angle |
| CHBL | Chamfer body length |
| CHW | Corner chamfer width |
| CICT | Cutting item count |
| CICT _{BALL} | Cutting item count - Ball nose insert |
| CICT _E | Cutting item count - end position |
| CICT _P | Cutting item count - peripheral position |
| CICT _S | Cutting item count - side position |
| CICT _{SP} | Cutting item count - Shank protection insert |
| CICT _T | Cutting item count - total |
| CND | Coolant entry diameter |
| CNSC | Coolant entry style code |
| CNT | Coolant entry thread size |
| COATING | Coating |
| CP | Max coolant pressure |
| CRKS | Connection retention knob thread size |
| CRNT | Coolant radial entry thread size |
| CTPT | Operation type |
| CUTDIA | Work piece parting diameter maximum |
| CW | Cutting width |
| CWN | Minimum cutting width |
| CWTOLL | Cutting width lower tolerance |
| CWTOLU | Cutting width upper tolerance |
| CWX | Cutting width maximum |
| CXSC | Coolant exit style code |
| CZC | Connection size code |
| CZC _{MS} | Connection size code machine side |
| CZC _{WS} | Connection size code workpiece side |
| D1 | Fixing hole diameter |
| DAH | Diameter access hole |
| DAXIN | Axial groove inside diameter minimum |
| DAXN | Minimum axial groove outside diameter |
| DAXX | Axial groove outside diameter maximum |

| | |
|---------------------|--|
| DBC | Diameter bolt circle |
| DC | Cutting diameter |
| DCB | Connection bore diameter |
| DCBN | Connection bore diameter minimum |
| DCBX | Connection bore diameter maximum |
| DCF | Cutting diameter face contact |
| DCIN | Cutting diameter internal |
| DCN | Cutting diameter minimum |
| DCON | Connection diameter |
| DCON _{MS} | Connection diameter machine side |
| DCON _{WS} | Connection diameter workpiece side |
| DCONN _{WS} | Connection diameter minimum workpiece side |
| DCONX _{WS} | Connection diameter maximum workpiece side |
| DCPS | Data chip provision size |
| DCSF _{MS} | Contact surface diameter machine side |
| DCSF _{WS} | Contact surface diameter workpiece side |
| DCX | Cutting diameter maximum |
| DHUB | Hub diameter |
| DIX | Tool changer interference diameter maximum |
| DMIN | Minimum bore diameter |
| DMM | Shank diameter |
| DN | Neck diameter |
| DRVCT | Drive count |
| DSGN | Design |
| EPSR | Insert included angle |
| FHA | Flute helix angle |
| FLGT | Flange thickness |
| FTDZ | For thread diameter size |
| GB | Face land angle |
| H | Shank height |
| HA | Thread height theoretical |
| HB | Thread height difference |
| HBH | Head bottom offset height |
| HC | Thread height actual |
| HF | Functional height |
| HRY | Lowest point from reference plain |
| HTB | Body height |
| HTH | Height |
| IC | Inscribed circle diameter |
| INSL | Insert length |
| INSUC | Insert usage code |
| IZC | Insert size code |
| KAPR | Tool cutting edge angle |
| KAPR_EFW | Tool cutting edge angle - end feed |
| KCH | Corner chamfer |
| KRINS | Major cutting edge angle |
| KWW | Keyway width |
| L | Cutting edge length |
| LAMS | Inclination angle |
| LB | Body length |
| LCF | Length chip flute |
| LCOX | Cut off length maximum |
| LE | Cutting edge effective length |
| LF | Functional length |
| LFN | Minimum functional length |
| LH | Head length |
| LPR | Protruding length |
| LS | Shank length |
| LSC | Clamping length |
| LSCN | Clamping length minimum |
| LSCS | Distance to clamping start |
| LSCX | Clamping length maximum |
| LSD | Dead shank length |
| LU | Usable length (max. recommended) |
| LU_BFW | Usable length - back facing |
| LUX | Usable length maximum |
| MHD | Mounting hole distance |
| MIID | Master insert identification |
| MIID _E | Master insert identification - end position |
| MIID _S | Master insert identification - side position |
| MIID _C | Master insert identification - central position |
| MIID _P | Master insert identification - peripheral position |
| MIID _I | Master insert identification - intermediate position |
| MMCC | Code for preset torque |
| MMCX | Max. cutting torque |
| NOF | Flute count |
| NT | Tooth count |
| OAH | Overall height |
| OAL | Overall length |
| OAW | Overall width |
| OH | Overhang recommended |
| OHN | Overhang minimum |
| OHX | Overhang maximum |
| ORDCODE | Ordercode |

| | |
|------------------|--|
| PCL | Peripheral cylindrical length |
| PDX | Profile distance ex |
| PDY | Profile distance ey |
| PHD | Premachined hole diameter |
| PHDX | Maximum premachined hole diameter |
| PL | Point length |
| PNA | Profile included angle |
| PRFRAD | Profile radius |
| PRSPC | Profile specification |
| PSIR | Tool lead angle |
| PSIRL | Cutting edge angle major left hand |
| PSIRR | Cutting edge angle major right hand |
| PSW | Premachined slot width |
| RADH | Radial body height |
| RADW | Radial body width |
| RAR | Right hand relief angle |
| RE | Corner radius |
| REEQ | Corner radius equivalent |
| REL | Corner radius left |
| RER | Corner radius right |
| RETOLL | Corner radius lower tolerance |
| RETOLU | Corner radius upper tolerance |
| RGL | Regrind length |
| RMPX | Maximum ramping angle |
| RPMX | Rotational speed maximum |
| S | Insert thickness |
| SDL | Step diameter length |
| SIG | Point angle |
| SPTL | Splitline |
| SSC | Insert seat size code |
| SSC _E | Insert seat size code - end position |
| SSC _P | Insert seat size code - peripheral position |
| SSC _S | Insert seat size code - side position |
| STA | Step included angle |
| STDNO | Standard number |
| SUBSTRATE | Substrate |
| TCDC | Tolerance class cutting diameter |
| TCDCON | Connection diameter tolerance |
| TCDMM | Shank diameter tolerance |
| TCHA | Achievable hole tolerance |
| TCHAL | Achievable hole tolerance lower |
| TCHAU | Achievable hole tolerance upper |
| TCT | Tolerance class tool |
| TCTR | Thread tolerance class |
| TD | Thread diameter |
| TDZ | Thread diameter size |
| TFLA | Tap floating length ahead |
| TFLB | Tap floating length behind |
| TG | Taper gradient |
| THBTP | Thread back taper property |
| THCA | Thread helix correction angle |
| THCHT | Threading chamfer type |
| THFT | Form type |
| THFTS | Thread form standard series |
| THL | Thread length |
| THUB | Hub thickness |
| TP | Thread pitch |
| TPI | Threads per inch |
| TPIN | Threads per inch minimum |
| TPIX | Threads per inch maximum |
| TPN | Thread pitch minimum |
| TPT | Thread profile type |
| TPX | Maximum thread pitch |
| TRMAX | Tap range max |
| TQ | Torque |
| TSYC | Tool style code |
| TTP | Thread type |
| ULDR | Usable length diameter ratio |
| VCX | Maximum cutting speed |
| W1 | Insert width |
| WB | Body width |
| WF | Functional width |
| WFCIRP | Width to cutting item reference point |
| WSC | Clamping width |
| WT | Weight of item |
| ZADJ | Insert adjustable count |
| ZEFF | Face effective cutting edge count |
| ZEFP | Peripheral effective cutting edge count (ZEFP) |
| ZWX | Maximum number of Wiper inserts |

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| 327-xxB | L100 | 416.2-L | M20 | 880..C-LM | J42 |
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