

# CoroTurn® XS

when there's no room for compromise



CoroTurn XS tooling solutions for internal turning, grooving and threading bring all the performance of CoroTurn down to smaller bores than ever, in a design conceived with small part machining in mind.

CoroTurn XS tooling consists of a two-part assembly: Cutting inserts precisely engineered to machine holes down to .039 inch (1 mm) diameter are available, and fit into holders ranging from 1/2 to 1 inch (10 to 25.4 mm) outer diameter.

Mix and match cutting tool and boring bar to suit your requirements.

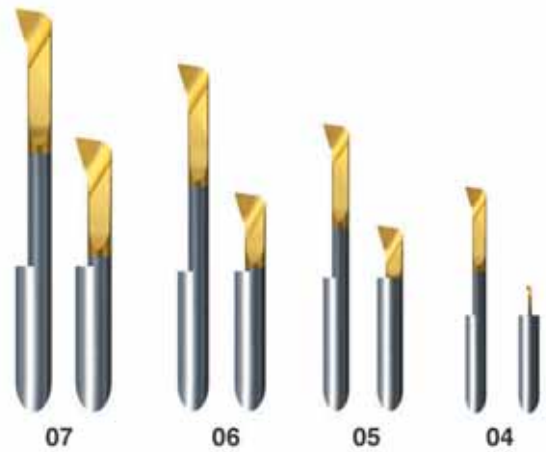
Sandvik Coromant tooling solutions for small part machining focus on the details.

Inserts are available in GC1025 grade, a proven performer for cutting steel, stainless steel and non-ferrous materials, across a range of operations and cutting conditions.



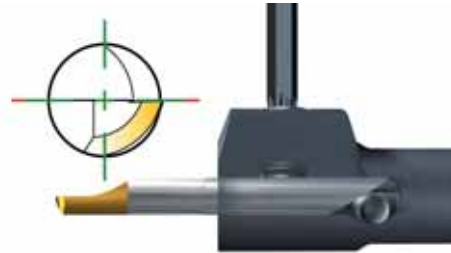
## CoroTurn XS assortment

The program covers four insert sizes, CXS-04, -05, -06, and -07, each including inserts for a range of hole diameters, and available in different lengths to suit different applications.



## CoroTurn XS precision

The inserts locate precisely into the holders thanks to a locating pin, which locks the insert into the correct orientation. Guaranteed precise positioning of the cutting edge, and repeatable accuracy you can rely on every time.



## CoroTurn XS coolant supply

The holders are designed with internal cutting fluid supply, directed at the cutting edge via two nozzles to ensure chip evacuation and sufficient cooling.



## CoroTurn XS grooving

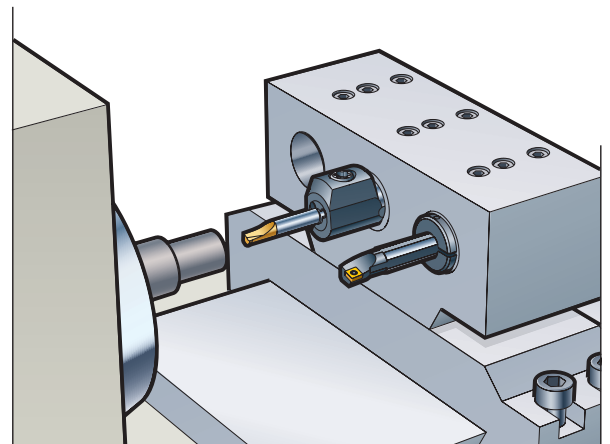
All CoroTurn XS grooving inserts produce grooves with flat bottom and sharp corner radii.

## New EasyFix sleeves

### Clamping bars in Swiss machines

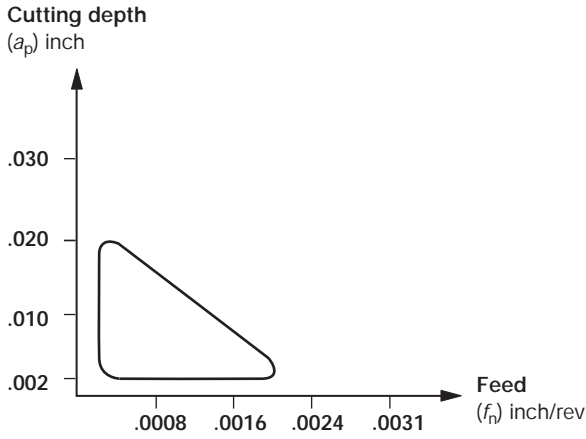
For even greater flexibility, new sizes of EasyFix sleeves allow metric boring bars to be fitted into inch tool posts, and provide a positive locating action to ensure correct center height. See pages 67 and 84.

For the complete assortment of EasyFix sleeves, see main turning tools catalog LIT-CAT 03-T.

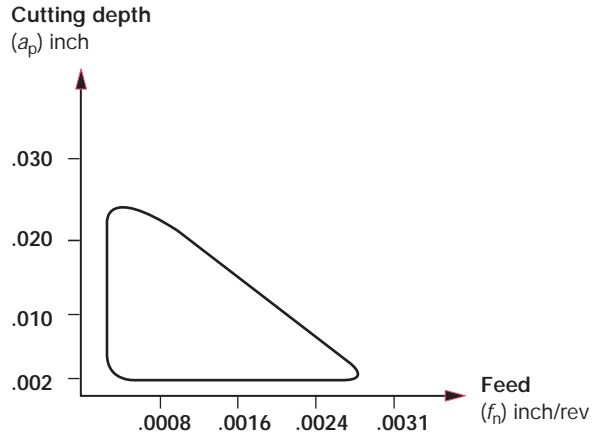


# Cutting data recommendations

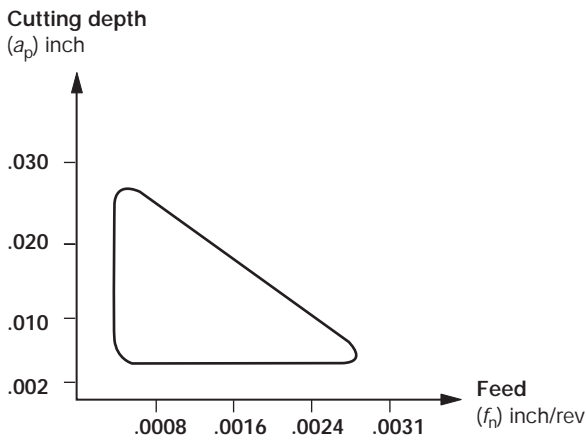
## Turning, insert size 04



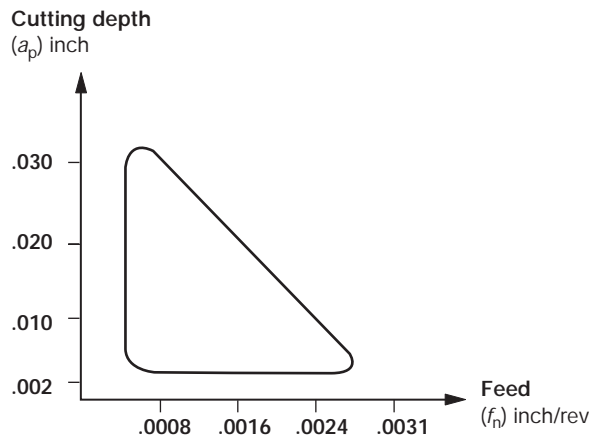
## Turning, insert size 05



## Turning, insert size 06

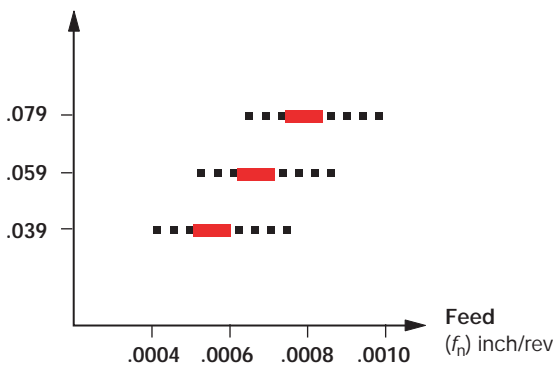


## Turning, insert size 07



## Grooving

Insert width ( $a_p$ ) inch



■ = Recommended starting value.

## Threading, (Infeed recommendations)

Thread	Insert	$a_p$	$nap$
V-profile 60°	CXS-04TH 050VM-4215R	.027	14
	CXS-05TH 050VM-5215R	.011	7
	070VM-5115R	.016	8
	100VM-4815R	.022	11
	CXS-06TH 100VM-6215R	.022	11
	125VM-6215R	.027	11
	150VM-6215R	.032	13
Whitworth 55°	CXS-05TH 24WH-5215R	.026	13
	26WH-5215R	.024	12
	28WH-5215R	.034	14
	CXS-06TH 19WH-6215R	.032	14
	20WH-6215R	.029	12
	22WH-6215R	.027	11
	24WH-6215R	.026	11
	26WH-6215R	.024	10
	28WH-6215R	.011	7
NPT 60°	CXS-06TH 18NT-6215R	.042	18
	27NT-6215R	.028	12

$a_p$  = total depth of thread

$nap$  = number of passes

## Cutting speed recommendations

Cutting speed ( $v_c$ ) ft/min

**P**

195-655

**M**

195-590

**N**

295-1310

**S**

65-165

# Code key for CoroTurn XS

## Insert for turning

<b>CXS</b>	<b>04</b>	<b>T</b>	<b>098</b>	-	<b>10</b>	-	<b>22</b>	<b>06</b>	<b>R</b>
1	2	3	4		5		9	10	12

## Insert for grooving


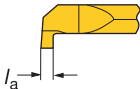

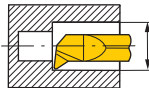
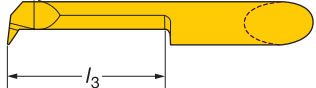
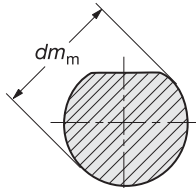
<b>CXS</b>	<b>06</b>	<b>F</b>	<b>100</b>	-	<b>62</b>	<b>15</b>	<b>A</b>	<b>R</b>
1	2	3	6		9	10	11	12

## Insert for threading

<b>CXS</b>	<b>04</b>	<b>TH</b>	<b>050</b>	<b>VM</b>	-	<b>42</b>	<b>15</b>	<b>R</b>
1	2	3	7	8		9	10	12

## HOLDERS

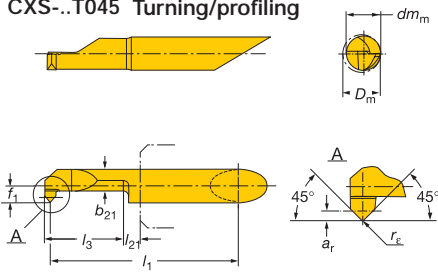
<b>CXS</b>	<b>A</b>	<b>10</b>	-	<b>04</b>
1	13	14		2

<p><b>1 Main code</b></p> <p>CXS = CoroTurn XS</p>	<p><b>2 Insert size mm (inch)</b></p>  <p>04 = 4 mm (.157 inch) 05 = 5 mm (.197 inch) 06 = 6 mm (.236 inch) 07 = 7 mm (.276 inch)</p>	<p><b>3 Type of operation</b></p> <p>T = Turning TE = Turning copying, extended <math>f_1</math>-dimension F = Face grooving G = Grooving GX = Pre-parting R = Profiling full radius TH = Threading</p>
<p><b>4 Entering angle (Turning)</b></p> <p>E.g.: 098 = entering angle 98°, lead angle -8°</p>	<p><b>6 Insert width, <math>l_a</math> mm (Grooving)</b></p>  <p>E.g.: 100 = 1,00 mm</p>	<p><b>7 Pitch, mm (Threading)</b></p> <p>mm: pitch x 100 inch: No. of threads per inch x 10</p>
<p><b>5 Nose radius, <math>r_\epsilon</math> mm (inch) (Turning)</b></p>  <p>10 = 0,1 mm (.004 inch) 15 = 0,15 mm (.006 inch) 20 = 0,2 mm (.008 inch)</p>	<p><b>9 Min hole diameter, <math>D_m</math> min. mm (inch)</b></p>  <p>E.g.: 22 = 2,2 mm (.087 inch)</p>	<p><b>10 Penetration depth, <math>l_3</math> mm (inch)</b></p>  <p>E.g.: 06 = 6 mm (.236 inch)</p>
<p><b>8 Thread profile (Threading)</b></p> <p>VM = V profile 60° WH = Whitworth 55° NT = NPT 60°</p>	<p><b>13 Type of bar</b></p> <p>A = Steel bar with internal coolant supply</p>	<p><b>14 Bar dia, <math>dm_m</math> mm (inch)</b></p> 
<p><b>11 Type of curve (Facegrooving)</b></p> <p>A = A-curved</p>	<p><b>12 Hand of insert</b></p> <p>R = Right hand style L = Left hand style</p>	

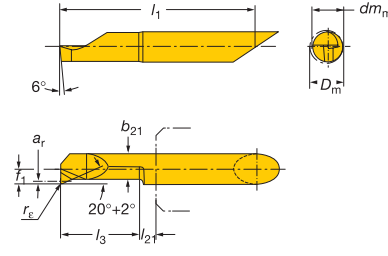
# CoroTurn XS inserts

## Turning and turning/copying

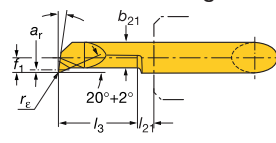
### CXS...T045 Turning/profiling



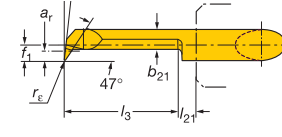
### CXS...T090 Turning



### CXS...T098 Turning

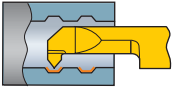
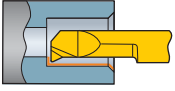
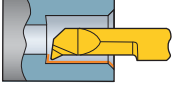
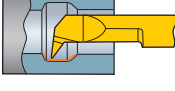


### CXS...TE098 Copying



## Coromant grades

GC = Coated carbide/Cermet

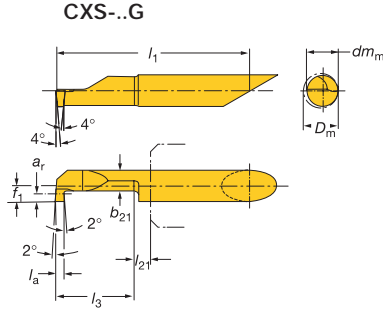
Lead angle	Insert size <sup>1)</sup> <i>dm<sub>m</sub></i>	Ordering code	Dimensions, inch <i>mm</i>											P M N S													
			<i>a<sub>r</sub></i> max	<i>d</i>	<i>D<sub>m</sub></i> min	<i>f<sub>1</sub></i>	<i>l<sub>c</sub></i>	<i>l<sub>1</sub></i>	<i>l<sub>3</sub></i>	<i>r<sub>e</sub></i>	GC																
											1025	1025	1025	1025													
<b>45° Turning/profiling</b> 	05	CXS-05T 045-20-5215R	.028	0.7	.148	3.75	.205	5.2	.096	2.45	.118	3	1.467	37.25	.591	15	.008	0.20	★	★	★	★					
		CXS-05T 045-20-5220R/L	.028	0.7	.148	3.75	.205	5.2	.096	2.45	.118	3	1.663	42.25	.787	20	.008	0.20	★	★	★	★					
	06	CXS-06T 045-20-6220R	.028	0.7	.156	3.95	.244	6.2	.117	2.95	.118	3	1.663	42.25	.787	20	.008	0.20	★	★	★	★					
		CXS-06T 045-20-6225R/L	.028	0.7	.156	3.95	.244	6.2	.117	2.95	.118	3	1.860	47.25	.984	25	.008	0.20	★	★	★	★					
	07	CXS-07T 045-20-7220R/L	.028	0.7	.167	4.25	.283	7.2	.136	3.45	.118	3	2.451	62.25	.787	20	.008	0.20	★	★	★	★					
		CXS-07T 045-20-7240R/L	.028	0.7	.167	4.25	.283	7.2	.136	3.45	.118	3	2.451	62.25	1.574	40	.008	0.20	★	★	★	★					
<b>0° Turning</b> 	04	CXS-04T 090-15-3212R	.008	0.2	.100	2.55	.126	3.2	.057	1.45	.118	3	1.152	29.26	.472	12	.006	0.15	★	★	★	★					
		CXS-04T 090-15-4215R/L	.012	0.3	.136	3.45	.165	4.2	.077	1.95	.118	3	1.546	39.26	.591	15	.006	0.15	★	★	★	★					
	05	CXS-05T 090-20-5210R/L	.020	0.5	.165	4.20	.205	5.2	.096	2.45	.118	3	1.270	32.25	.393	10	.008	0.20	★	★	★	★					
		CXS-05T 090-20-5215R/L	.020	0.5	.165	4.20	.205	5.2	.096	2.45	.118	3	1.467	37.25	.591	15	.008	0.20	★	★	★	★					
		CXS-05T 090-20-5220R/L	.020	0.5	.165	4.20	.205	5.2	.096	2.45	.118	3	1.663	42.25	.787	20	.008	0.20	★	★	★	★					
<b>-8° Turning</b> 	04	CXS-04T 098-10-1004R/L	.004	0.1	.026	0.65	.039	1.0	.018	0.45	.118	3	.837	21.26	.157	4	.004	0.10	★	★	★	★					
		CXS-04T 098-10-1006R	.004	0.1	.026	0.65	.039	1.0	.018	0.45	.118	3	.916	23.26	.236	6	.004	0.10	★	★	★	★					
		CXS-04T 098-10-1706R/L	.008	0.2	.041	1.05	.067	1.7	.028	0.70	.118	3	.916	23.26	.236	6	.004	0.10	★	★	★	★					
		CXS-04T 098-10-1709R/L	.008	0.2	.041	1.05	.067	1.7	.028	0.70	.118	3	1.034	26.26	.354	9	.004	0.10	★	★	★	★					
		CXS-04T 098-10-2206R/L	.008	0.2	.061	1.55	.087	2.2	.037	0.95	.118	3	.916	23.26	.236	6	.004	0.10	★	★	★	★					
		CXS-04T 098-10-2209R/L	.008	0.2	.061	1.55	.087	2.2	.037	0.95	.118	3	1.034	26.26	.354	9	.004	0.10	★	★	★	★					
		CXS-04T 098-10-2213R/L	.008	0.2	.061	1.55	.087	2.2	.037	0.95	.118	3	1.191	30.26	.512	13	.004	0.10	★	★	★	★					
		CXS-04T 098-15-2710R/L	.008	0.2	.081	2.05	.106	2.7	.047	1.20	.118	3	1.073	27.26	.393	10	.006	0.15	★	★	★	★					
		CXS-04T 098-15-2715R/L	.008	0.2	.081	2.05	.106	2.7	.047	1.20	.118	3	1.270	32.26	.591	15	.006	0.15	★	★	★	★					
		CXS-04T 098-15-3210R/L	.008	0.2	.100	2.55	.126	3.2	.057	1.45	.118	3	1.073	27.26	.393	10	.006	0.15	★	★	★	★					
		CXS-04T 098-15-3215R/L	.008	0.2	.100	2.55	.126	3.2	.057	1.45	.118	3	1.270	32.26	.591	15	.006	0.15	★	★	★	★					
		CXS-04T 098-15-3220R/L	.008	0.2	.100	2.55	.126	3.2	.057	1.45	.118	3	1.467	37.26	.787	20	.006	0.15	★	★	★	★					
	CXS-04T 098-15-4210R/L	.012	0.3	.136	3.45	.165	4.2	.077	1.95	.118	3	1.073	27.26	.393	10	.006	0.15	★	★	★	★						
	CXS-04T 098-15-4215R/L	.012	0.3	.136	3.45	.165	4.2	.077	1.95	.118	3	1.270	32.26	.591	15	.006	0.15	★	★	★	★						
	CXS-04T 098-15-4220R/L	.012	0.3	.136	3.45	.165	4.2	.077	1.95	.118	3	1.467	37.26	.787	20	.006	0.15	★	★	★	★						
	CXS-04T 098-15-4225R/L	.012	0.3	.136	3.45	.165	4.2	.077	1.95	.118	3	1.703	43.26	.984	25	.006	0.15	★	★	★	★						
	05	CXS-05T 098-20-5210R/L	.020	0.5	.167	4.25	.205	5.2	.096	2.45	.118	3	1.270	32.25	.393	10	.008	0.20	★	★	★	★					
		CXS-05T 098-20-5220R/L	.020	0.5	.167	4.25	.205	5.2	.096	2.45	.118	3	1.663	42.25	.787	20	.008	0.20	★	★	★	★					
		CXS-05T 098-20-5225R/L	.020	0.5	.167	4.25	.205	5.2	.096	2.45	.118	3	1.860	47.25	.984	25	.008	0.20	★	★	★	★					
		CXS-05T 098-20-5230R/L	.020	0.5	.167	4.25	.205	5.2	.096	2.45	.118	3	2.254	57.25	1.181	30	.008	0.20	★	★	★	★					
06		CXS-06T 098-20-6215R/L	.020	0.5	.207	5.25	.244	6.2	.117	2.95	.118	3	1.467	37.25	.591	15	.008	0.20	★	★	★	★					
		CXS-06T 098-20-6220R/L	.020	0.5	.207	5.25	.244	6.2	.117	2.95	.118	3	1.663	42.25	.787	20	.008	0.20	★	★	★	★					
		CXS-06T 098-20-6225R/L	.020	0.5	.207	5.25	.244	6.2	.117	2.95	.118	3	1.860	47.25	.984	25	.008	0.20	★	★	★	★					
		CXS-06T 098-20-6230R/L	.020	0.5	.207	5.25	.244	6.2	.117	2.95	.118	3	2.057	52.25	1.181	30	.008	0.20	★	★	★	★					
07	CXS-07T 098-20-6235R/L	.020	0.5	.207	5.25	.244	6.2	.117	2.95	.118	3	2.254	57.25	1.378	35	.008	0.20	★	★	★	★						
	CXS-07T 098-20-6240R/L	.020	0.5	.207	5.25	.244	6.2	.117	2.95	.118	3	2.451	62.25	1.567	40	.008	0.20	★	★	★	★						
	CXS-07T 098-20-7225R/L	.020	0.5	.246	6.25	.283	7.2	.136	3.45	.118	3	1.860	47.25	.984	25	.008	0.20	★	★	★	★						
	CXS-07T 098-20-7230R/L	.020	0.5	.246	6.25	.283	7.2	.136	3.45	.118	3	2.254	57.25	1.181	30	.008	0.20	★	★	★	★						
-8° Copying		Insert with extended <i>f<sub>1</sub></i> dimension											P25	M15	N15	S15											
		04	CXS-04TE98-15-4220R/L	.031	0.8	.116	2.95	.165	4.2	.077	1.95	.118					3	1.467	37.26	.787	20	.006	0.15	★	★	★	★
		05	CXS-05TE98-15-5225R/L	.039	1.0	.148	3.75	.205	5.2	.096	2.45	.118					3	1.860	47.25	.984	25	.006	0.15	★	★	★	★
		06	CXS-06TE98-15-6230R/L	.071	1.8	.156	3.95	.244	6.2	.117	2.95	.118					3	2.057	52.25	1.181	30	.006	0.15	★	★	★	★

<sup>1)</sup> To correspond with insert size on holder.

Ordering example: 10 pieces CXS-05T045-20-5220R 1025  
 CXS-05T045-20-5220L 1025  
 R = Right hand, L = Left hand

# CoroTurn XS inserts

## Grooving



### Coromant grades

GC = Coated carbide/Cermet

Selection criteria, inch mm	Insert size <sup>1)</sup>	Ordering code	Dimensions, inch mm				P	M	N	S			
			a <sub>r</sub> max		D <sub>m</sub> min		GC	GC	GC	GC			
			l <sub>a</sub>	l <sub>3</sub>	1025	1025	1025	1025					
	04	CXS-04G	078-4210R	.116 2.95	.077 1.95	.118 3	1.079 27.4	★	★	★	★		
			078-4215R/L	.116 2.95	.077 1.95	.118 3	1.279 32.5	★	★	★	★		
			078-4220R	.116 2.95	.077 1.95	.118 3	1.479 37.6	★	★	★	★		
			100-4210R/L	.116 2.95	.077 1.95	.118 3	1.075 27.3	★	★	★	★		
			100-4215R/L	.116 2.95	.077 1.95	.118 3	1.272 32.3	★	★	★	★		
			100-4220R/L	.116 2.95	.077 1.95	.118 3	1.469 37.3	★	★	★	★		
			CXS-05G	078-5210R	.148 3.75	.096 2.45	.118 3	1.275 32.4	★	★	★	★	
				078-5220R/L	.148 3.75	.096 2.45	.118 3	1.675 42.5	★	★	★	★	
				078-5230R	.148 3.75	.096 2.45	.118 3	2.075 52.7	★	★	★	★	
				100-5210R	.148 3.75	.096 2.45	.118 3	1.272 32.3	★	★	★	★	
				100-5220R/L	.148 3.75	.096 2.45	.118 3	1.665 42.3	★	★	★	★	
				100-5230R	.148 3.75	.096 2.45	.118 3	2.059 52.3	★	★	★	★	
				117-5210R	.148 3.75	.096 2.45	.118 3	1.275 32.4	★	★	★	★	
				117-5220R/L	.148 3.75	.096 2.45	.118 3	1.675 42.5	★	★	★	★	
				117-5230R	.148 3.75	.096 2.45	.118 3	2.075 52.7	★	★	★	★	
				150-5210R/L	.148 3.75	.096 2.45	.118 3	1.272 32.3	★	★	★	★	
				150-5215R/L	.148 3.75	.096 2.45	.118 3	1.469 37.3	★	★	★	★	
				150-5220R/L	.148 3.75	.096 2.45	.118 3	1.665 42.3	★	★	★	★	
				150-5230R	.148 3.75	.096 2.45	.118 3	2.059 52.3	★	★	★	★	
				157-5210R	.148 3.75	.096 2.45	.118 3	1.275 32.4	★	★	★	★	
				157-5220R/L	.148 3.75	.096 2.45	.118 3	1.675 42.5	★	★	★	★	
				157-5230R	.148 3.75	.096 2.45	.118 3	2.075 52.7	★	★	★	★	
				198-5210R	.148 3.75	.096 2.45	.118 3	1.275 32.4	★	★	★	★	
				198-5220R/L	.148 3.75	.096 2.45	.118 3	1.675 42.5	★	★	★	★	
				198-5230R	.148 3.75	.096 2.45	.118 3	2.075 52.7	★	★	★	★	
				200-5210R	.148 3.75	.096 2.45	.118 3	1.272 32.3	★	★	★	★	
				200-5220R/L	.148 3.75	.096 2.45	.118 3	1.665 42.3	★	★	★	★	
				200-5230R	.148 3.75	.096 2.45	.118 3	2.059 52.3	★	★	★	★	
				CXS-06G	078-6210R	.156 3.95	.116 2.95	.118 3	1.275 32.4	★	★	★	★
					078-6215R/L	.156 3.95	.116 2.95	.118 3	1.475 37.5	★	★	★	★
			078-6225R		.156 3.95	.116 2.95	.118 3	1.875 47.6	★	★	★	★	
			078-6235R/L		.156 3.95	.116 2.95	.118 3	2.275 57.8	★	★	★	★	
			100-6210R		.156 3.95	.116 2.95	.118 3	1.272 32.3	★	★	★	★	
			100-6215R/L		.156 3.95	.116 2.95	.118 3	1.469 37.3	★	★	★	★	
			100-6225R/L		.156 3.95	.116 2.95	.118 3	1.862 47.3	★	★	★	★	
			100-6235R		.156 3.95	.116 2.95	.118 3	2.256 57.3	★	★	★	★	
			117-6210R		.156 3.95	.116 2.95	.118 3	1.275 32.4	★	★	★	★	
			117-6215R/L		.156 3.95	.116 2.95	.118 3	1.475 37.5	★	★	★	★	
			117-6225R		.156 3.95	.116 2.95	.118 3	1.875 47.6	★	★	★	★	
			117-6235R/L		.156 3.95	.116 2.95	.118 3	2.275 57.8	★	★	★	★	
			150-6210R		.156 3.95	.116 2.95	.118 3	1.272 32.3	★	★	★	★	
			150-6215R/L		.156 3.95	.116 2.95	.118 3	1.469 37.3	★	★	★	★	
			150-6225R/L		.156 3.95	.116 2.95	.118 3	1.862 47.3	★	★	★	★	
			150-6235R		.156 3.95	.116 2.95	.118 3	2.256 57.3	★	★	★	★	
			157-6210R		.156 3.95	.116 2.95	.118 3	1.275 32.4	★	★	★	★	
			157-6215R/L		.156 3.95	.116 2.95	.118 3	1.475 37.5	★	★	★	★	
			157-6225R		.156 3.95	.116 2.95	.118 3	1.875 47.6	★	★	★	★	
			157-6235R/L		.156 3.95	.116 2.95	.118 3	2.275 57.8	★	★	★	★	
			198-6210R		.156 3.95	.116 2.95	.118 3	1.275 32.4	★	★	★	★	
			198-6215R/L		.156 3.95	.116 2.95	.118 3	1.475 37.5	★	★	★	★	
			198-6225R		.156 3.95	.116 2.95	.118 3	1.875 47.6	★	★	★	★	
			200-6210R		.156 3.95	.116 2.95	.118 3	1.272 32.3	★	★	★	★	
			200-6215R/L		.156 3.95	.116 2.95	.118 3	1.469 37.3	★	★	★	★	
			200-6225R/L		.156 3.95	.116 2.95	.118 3	1.862 47.3	★	★	★	★	

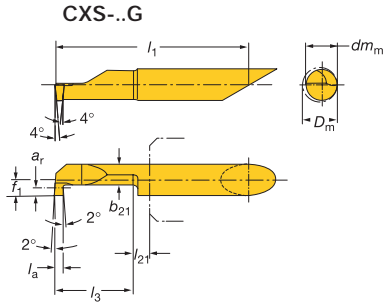
<sup>1)</sup> To correspond with insert size on holder.

Ordering example: 10 pieces CXS-04G078-4215R 1025  
CXS-04G078-4215L 1025

R = Right hand, L = Left hand

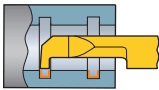
# CoroTurn XS inserts

## Grooving



### Coromant grades

GC = Coated carbide/Cermet

	Selection criteria, inch mm						Insert size <sup>1)</sup>	Ordering code	Dimensions, inch mm				P M N S			
	ar max	Dm min	la	l3	dm	d			f1	lc	l1	GC	M	N	S	
												GC	GC	GC	GC	
	.098 2.50	.283 7.2	.031 0.78	.400 10.2	07	CXS-07G	078-7210R	.167 4.25	.136 3.45	.118 3	1.275 32.4	★	★	★	★	
	.098 2.50	.283 7.2	.031 0.78	.600 15.2			078-7215R/L	.167 4.25	.136 3.45	.118 3	1.475 37.5	★	★	★	★	
	.098 2.50	.283 7.2	.031 0.78	1.000 25.4			078-7225R	.167 4.25	.136 3.45	.118 3	1.875 47.6	★	★	★	★	
	.098 2.50	.283 7.2	.031 0.78	1.400 35.6			078-7235R/L	.167 4.25	.136 3.45	.118 3	2.275 57.8	★	★	★	★	
	.098 2.50	.283 7.2	.039 1.00	.394 10			100-7210R/L	.167 4.25	.136 3.45	.118 3	1.272 32.3	★	★	★	★	
	.098 2.50	.283 7.2	.039 1.00	.591 15			100-7215R/L	.167 4.25	.136 3.45	.118 3	1.469 37.3	★	★	★	★	
	.098 2.50	.283 7.2	.039 1.00	.984 25			100-7225R/L	.167 4.25	.136 3.45	.118 3	1.862 47.3	★	★	★	★	
	.098 2.50	.283 7.2	.039 1.00	1.378 35			100-7235R	.167 4.25	.136 3.45	.118 3	2.256 57.3	★	★	★	★	
	.098 2.50	.283 7.2	.046 1.17	.400 10.2			117-7210R	.167 4.25	.136 3.45	.118 3	1.275 32.4	★	★	★	★	
	.098 2.50	.283 7.2	.046 1.17	.600 15.2			117-7215R/L	.167 4.25	.136 3.45	.118 3	1.475 37.5	★	★	★	★	
	.098 2.50	.283 7.2	.046 1.17	1.000 25.4			117-7225R	.167 4.25	.136 3.45	.118 3	1.875 47.6	★	★	★	★	
	.098 2.50	.283 7.2	.046 1.17	1.400 35.6			117-7235R/L	.167 4.25	.136 3.45	.118 3	2.275 57.8	★	★	★	★	
	.098 2.50	.283 7.2	.059 1.50	.394 10			150-7210R	.167 4.25	.136 3.45	.118 3	1.272 32.3	★	★	★	★	
	.098 2.50	.283 7.2	.059 1.50	.591 15			150-7215R/L	.167 4.25	.136 3.45	.118 3	1.469 37.3	★	★	★	★	
	.098 2.50	.283 7.2	.059 1.50	.984 25			150-7225R/L	.167 4.25	.136 3.45	.118 3	1.862 47.3	★	★	★	★	
	.098 2.50	.283 7.2	.059 1.50	1.378 35			150-7235R	.167 4.25	.136 3.45	.118 3	2.256 57.3	★	★	★	★	
	.098 2.50	.283 7.2	.062 1.57	.400 10.2			157-7210R	.167 4.25	.136 3.45	.118 3	1.276 32.4	★	★	★	★	
	.098 2.50	.283 7.2	.062 1.57	.600 15.2			157-7215R/L	.167 4.25	.136 3.45	.118 3	1.476 37.5	★	★	★	★	
	.098 2.50	.283 7.2	.062 1.57	1.000 25.4			157-7225R	.167 4.25	.136 3.45	.118 3	1.876 47.6	★	★	★	★	
	.098 2.50	.283 7.2	.062 1.57	1.400 35.6			157-7235R/L	.167 4.25	.136 3.45	.118 3	2.275 57.8	★	★	★	★	
	.098 2.50	.283 7.2	.078 1.98	.400 10.2			198-7210R	.167 4.25	.136 3.45	.118 3	1.275 32.4	★	★	★	★	
	.098 2.50	.283 7.2	.078 1.98	.600 15.2			198-7215R/L	.167 4.25	.136 3.45	.118 3	1.475 37.5	★	★	★	★	
	.098 2.50	.283 7.2	.078 1.98	1.000 25.4			198-7225R	.167 4.25	.136 3.45	.118 3	1.875 47.6	★	★	★	★	
	.098 2.50	.283 7.2	.078 1.98	1.400 35.6			198-7235R/L	.167 4.25	.136 3.45	.118 3	2.275 57.8	★	★	★	★	
	.098 2.50	.283 7.2	.079 2.00	.394 10			200-7210R	.167 4.25	.136 3.45	.118 3	1.272 32.3	★	★	★	★	
	.098 2.50	.283 7.2	.079 2.00	.591 15			200-7215R/L	.167 4.25	.136 3.45	.118 3	1.469 37.3	★	★	★	★	
	.098 2.50	.283 7.2	.079 2.00	.984 25			200-7225R/L	.167 4.25	.136 3.45	.118 3	1.862 47.3	★	★	★	★	
	.098 2.50	.283 7.2	.079 2.00	1.378 35			200-7235R	.167 4.25	.136 3.45	.118 3	2.256 57.3	★	★	★	★	

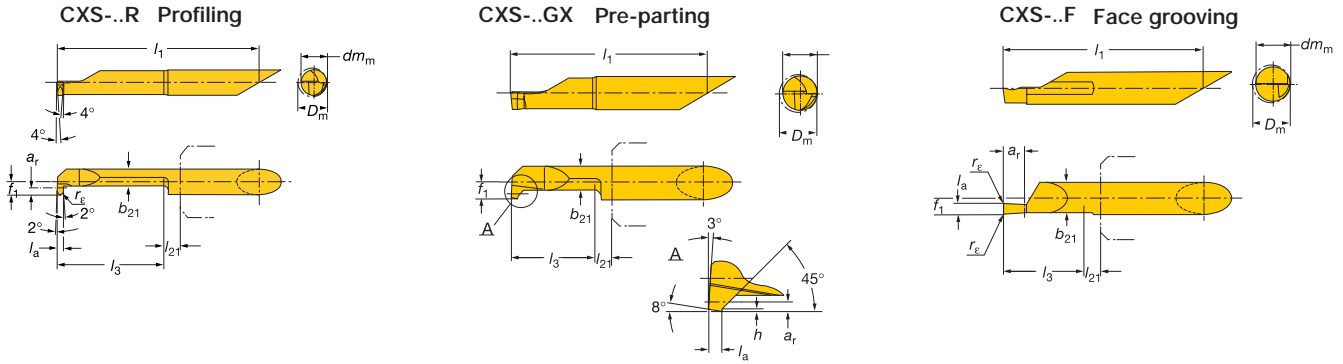
<sup>1)</sup> To correspond with insert size on holder.

Ordering example: 10 pieces CXS-07G078-7215R 1025  
CXs-07G078-7215L 1025

R = Right hand, L = Left hand

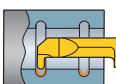
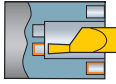
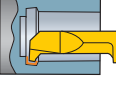
# CoroTurn XS inserts

Profiling, facegrooving and pre-parting



### Coromant grades

GC = Coated carbide/Cermet

	Selection criteria, inch mm						In- sert size 1)	Ordering code	Dimensions, inch mm											P	M	N	S						
									Dimensions, inch mm															GC	GC	GC	GC		
	ar max	Dm min	la	l3	dm	d			f1	h	lc	l1	re	1025	1025	1025	1025												
<b>Profiling</b> 	.031	0.8	.165	4.2	.039	1.00	.591	15	04	CXS-04R	100-4215R/L	.116	2.95	.077	1.95	-	.118	3	1.272	32.3	.020	0.50	★	★	★	★			
	.031	0.8	.165	4.2	.046	1.17	.600	15.2			058-4215R	.116	2.95	.077	1.95	-	.118	3	1.279	32.5	.023	0.58	★	★	★	★			
	.039	1.0	.205	5.2	.039	1.00	.787	20			05	CXS-05R	100-5220R/L	.148	3.75	.096	2.45	-	.118	3	1.665	42.3	.020	0.50	★	★	★	★	
	.039	1.0	.205	5.2	.046	1.17	.800	20.2					058-5220R/L	.148	3.75	.096	2.45	-	.118	3	1.675	42.5	.023	0.58	★	★	★	★	
	.039	1.0	.205	5.2	.059	1.50	.787	20					150-5220R	.148	3.75	.096	2.45	-	.118	3	1.665	42.3	.030	0.75	★	★	★	★	
	.039	1.0	.205	5.2	.064	1.63	.800	20.2					081-5220R/L	.148	3.75	.096	2.45	-	.118	3	1.675	42.5	.032	0.81	★	★	★	★	
	.039	1.0	.205	5.2	.078	1.98	.800	20.2			099-5220R/L	.148	3.75	.096	2.45	-	.118	3	1.675	42.5	.039	0.99	★	★	★	★			
	.039	1.0	.205	5.2	.079	2.00	.787	20			200-5220R	.148	3.75	.096	2.45	-	.118	3	1.665	42.3	.039	1.00	★	★	★	★			
	.071	1.8	.244	6.2	.039	1.00	.984	25			06	CXS-06R	100-6225R/L	.156	3.95	.116	2.95	-	.118	3	1.862	47.3	.020	0.50	★	★	★	★	
	.070	1.8	.244	6.2	.046	1.17	1.000	25.4					058-6225R/L	.156	3.95	.116	2.95	-	.118	3	1.875	47.6	.023	0.58	★	★	★	★	
	.071	1.8	.244	6.2	.059	1.50	.984	25					150-6225R/L	.156	3.95	.116	2.95	-	.118	3	1.862	47.3	.030	0.75	★	★	★	★	
	.070	1.8	.244	6.2	.064	1.63	1.000	25.4					081-6225R/L	.156	3.95	.116	2.95	-	.118	3	1.875	47.6	.032	0.81	★	★	★	★	
	.070	1.8	.244	6.2	.078	1.98	1.000	25.4					099-6225R/L	.156	3.95	.116	2.95	-	.118	3	1.875	47.6	.039	0.99	★	★	★	★	
	.071	1.8	.244	6.2	.079	2.00	.984	25					200-6225R/L	.156	3.95	.116	2.95	-	.118	3	1.862	47.3	.039	1.00	★	★	★	★	
	.098	2.5	.283	7.2	.039	1.00	1.181	30			07	CXS-07R	100-7230R/L	.167	4.25	.136	3.45	-	.118	3	2.059	52.3	.020	0.50	★	★	★	★	
	.098	2.5	.283	7.2	.046	1.17	1.200	30.5					058-7230R/L	.167	4.25	.136	3.45	-	.118	3	2.075	52.7	.023	0.58	★	★	★	★	
	.098	2.5	.283	7.2	.059	1.50	1.181	30					150-7230R/L	.167	4.25	.136	3.45	-	.118	3	2.059	52.3	.030	0.75	★	★	★	★	
	.098	2.5	.283	7.2	.064	1.63	1.200	30.5					081-7230R/L	.167	4.25	.136	3.45	-	.118	3	2.075	52.7	.032	0.81	★	★	★	★	
	.098	2.5	.283	7.2	.078	1.98	1.200	30.5					099-7230R/L	.167	4.25	.136	3.45	-	.118	3	2.075	52.7	.039	0.99	★	★	★	★	
	.098	2.5	.283	7.2	.079	2.00	1.181	30					200-7230R/L	.167	4.25	.136	3.45	-	.118	3	2.059	52.3	.039	1.00	★	★	★	★	
	<b>Face grooving</b> 	.079	2.0	.244	6.2	.039	1.00	.591			15	06	CXS-06F	100-6215AR	.236	6.00	.116	2.95	-	.118	3	1.469	37.3	.006	0.15	★	★	★	★
		.118	3.0	.244	6.2	.059	1.50	.591			15			150-6215AR	.236	6.00	.116	2.95	-	.118	3	1.469	37.3	.006	0.15	★	★	★	★
		.157	4.0	.244	6.2	.079	2.00	.591			15			200-6215AR	.236	6.00	.116	2.95	-	.118	3	1.469	37.3	.006	0.15	★	★	★	★
		.197	5.0	.244	6.2	.098	2.50	.591			15			250-6215AR	.236	6.00	.116	2.95	-	.118	3	1.469	37.3	.006	0.15	★	★	★	★
.236		6.0	.244	6.2	.118	3.00	.591	15	300-6215AR	.236	6.00			.116	2.95	-	.118	3	1.469	37.3	.006	0.15	★	★	★	★			
<b>Pre-parting</b> 	.028	0.7	.205	5.2	.039	1.00	.591	15	05	CXS-05GX	100-5215R/L	.148	3.75	.096	2.45	.008	0.20	.118	3	1.469	37.3	-	-	★	★	★	★		
	.028	0.7	.205	5.2	.039	1.00	.787	20			100-5220R	.148	3.75	.096	2.45	.008	0.20	.118	3	1.665	42.3	-	-	★	★	★	★		
	.028	0.7	.205	5.2	.039	1.00	.984	25			100-5225R/L	.148	3.75	.096	2.45	.008	0.20	.118	3	1.862	47.3	-	-	★	★	★	★		
	.028	0.7	.205	5.2	.039	1.00	1.181	30			100-5230R	.148	3.75	.096	2.45	.008	0.20	.118	3	2.059	52.3	-	-	★	★	★	★		

1) To correspond with insert size on holder.

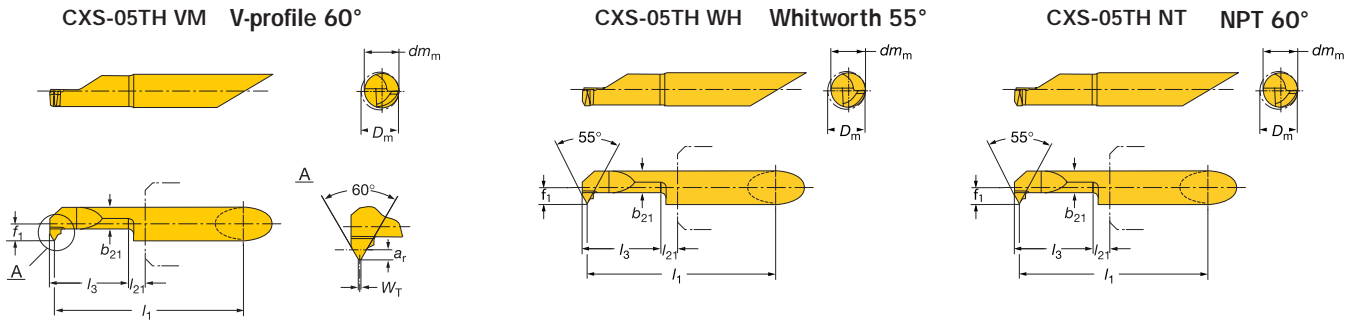
Ordering example: 10 pieces CXS-04R100-4215R 1025  
CXS-04R100-4215L 1025

R = Right hand, L = Left hand



# CoroTurn XS inserts

## Threading



### Coromant grades

GC = Coated carbide/Cermet

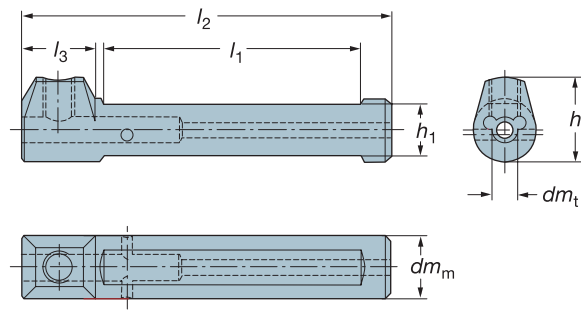
Insert size <sup>1)</sup>	Pitch TPI	Ordering code	Dimensions, inch mm											Coromant grades									
			$a_r$ max	$d$	$D_m$ min	$f_1$	$l_c$	$l_1$	$l_3$	$W_T$	P	M	N	S									
			GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC									
<b>V-profile 60°</b> 	04	40-32	CXS-04TH 050VM-4215R/L	.011	0.27	.116	2.95	.165	4.2	.077	1.95	.118	3	1.272	32.3	.591	15.0	.002	0.06	★	★	★	★
	05	40-32	CXS-05TH 050VM-5215R	.011	0.27	.148	3.75	.205	5.2	.096	2.45	.118	3	1.272	32.3	.591	15.0	.002	0.06	★	★	★	★
		28-24	070VM-5115R	.016	0.40	.144	3.65	.201	5.1	.093	2.35	.118	3	1.272	32.3	.591	15.0	.004	0.09	★	★	★	★
		24	100VM-4815R/L	.022	0.55	.140	3.55	.189	4.8	.089	2.25	.118	3	1.272	32.3	.591	15.0	.005	0.12	★	★	★	★
	06	24	CXS-06TH 100VM-6215R/L	.022	0.55	.140	3.55	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	.005	0.12	★	★	★	★
		28-24	125VM-6215R/L	.027	0.68	.140	3.55	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	.005	0.12	★	★	★	★
20-16		150VM-6215R/L	.034	0.81	.140	3.55	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	.005	0.12	★	★	★	★	
<b>Whitworth 55°</b> 	05	28	CXS-05TH 28WH-5215R	-	.148	3.75	.205	5.2	.096	2.45	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		26	26WH-5215R	-	.148	3.75	.205	5.2	.096	2.45	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		24	24WH-5215R	-	.148	3.75	.205	5.2	.096	2.45	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
	06	28	CXS-06TH 28WH-6215R	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		26	26WH-6215R	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		24	24WH-6215R	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		22	22WH-6215R	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		20	20WH-6215R	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		19	19WH-6215R/L	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
<b>NPT 60°</b> 	06	27	CXS-06TH 27NT-6215R	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
		18	18NT-6215R/L	-	.156	3.95	.244	6.2	.116	2.95	.118	3	1.272	32.3	.591	15.0	-	-	★	★	★	★	
											P25	M15	N15	S15									


<sup>1)</sup> To correspond with insert size on holder.

Ordering example: 10 pieces CXS-04TH050VM-4215R 1025  
 CXS-04TH050VM-4215L 1025  
 R = Right hand, L = Left hand

# CoroTurn XS boring bars

With internal coolant supply

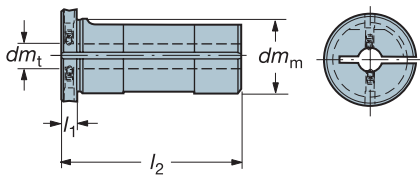


To be used with insert	Ordering code	Dimensions, inch mm							 Torque ft/lbs	Spare parts	
		$dm_m$	$dm_t$	$h$	$h_1$	$l_1$	$l_2$	$l_3$		Screw	Key (Torx Plus)
<b>04</b>	<b>Inch design</b> CXS-A0500-04 A0625-04 A0750-04 A1000-04	.500 .625 .750 1.000	.157 .157 .157 .157	.610 .689 .787 1.000	.394 .551 .709 .921	1.772 2.165 2.756 2.713	2.756 2.953 3.543 3.500	.551 .551 .551 .551	2.2	5514 013-01	5680 049-01 (15IP)
<b>05</b>	<b>CXS-A0500-05</b> A0625-05 A0750-05 A1000-05	.500 .625 .750 1.000	.197 .197 .197 .197	.629 .709 .787 1.000	.394 .551 .709 .921	1.772 2.165 2.756 2.713	2.756 2.953 3.543 3.500	.551 .551 .551 .551	2.2	5514 013-01	5680 049-01 (15IP)
<b>06</b>	<b>CXS-A0500-06</b> A0625-06 A0750-06 A1000-06	.500 .625 .750 1.000	.236 .236 .236 .236	.649 .728 .866 1.000	.394 .551 .709 .921	1.772 2.165 2.756 2.713	2.756 2.953 3.543 3.500	.551 .551 .551 .551	2.2	5514 013-01	5680 049-01 (15IP)
<b>07</b>	<b>CXS-A0625-07</b> A0750-07 A1000-07	.625 .750 1.000	.276 .276 .276	.748 .866 1.000	.551 .709 .921	2.165 2.756 2.713	2.953 3.543 3.500	.551 .551 .551	2.2	5514 013-01	5680 049-01 (15IP)
<b>04</b>	<b>Metric design</b> CXS-A10-04 A12-04 A16-04 A20-04 A22-04 A23-04 A25-04	10 12 16 20 22 23 25	4 4 4 4 4 4 4	14.5 15.5 17.5 20.0 22.0 23.0 25.0	8 10 14 18 20 23 25	45 50 55 70 70 70 70	65 70 75 90 110 110 110	14 14 14 14 14 14 14	Torque Nm 3.0	5514 013-01	5680 049-01 (15IP)
<b>05</b>	<b>CXS-A10-05</b> A12-05 A16-05 A20-05 A22-05 A23-05 A25-05	10 12 16 20 22 23 25	5 5 5 5 5 5 5	15.0 16.0 18.0 20.0 22.0 23.0 25.0	8 10 14 18 20 23 25	45 50 55 70 70 70 70	65 70 75 90 110 110 110	14 14 14 14 14 14 14	3.0	5514 013-01	5680 049-01 (15IP)
<b>06</b>	<b>CXS-A12-06</b> A16-06 A20-06 A22-06 A23-06 A25-06	12 16 20 22 23 25	6 6 6 6 6 6	16.5 18.5 22.0 22.0 23.0 25.0	10 14 18 20 23 25	50 55 70 70 70 70	70 75 90 110 110 110	14 14 14 14 14 14	3.0	5514 013-01	5680 049-01 (15IP)
<b>07</b>	<b>CXS-A16-07</b> A20-07 A22-07 A23-07 A25-07	16 20 22 23 25	7 7 7 7 7	19.0 22.0 22.0 23.0 25.0	14 18 20 23 25	55 70 70 70 70	75 90 110 110 110	14 14 14 14 14	3.0	5514 013-01	5680 049-01 (15IP)

Ordering example: 10 pieces CXS-A10-04

## EasyFix sleeves for Swiss type machines

132L-  
(ISO 9766)



Bar dia.	Ordering code	Dimensions, mm (inch)		
		$l_1$	$l_2$	$dm_m$
<b>5</b>	132L-1205050-B	5 (.197)	50 (1.97)	19.05 (.750)
	-1605050-B	5 (.197)	50 (1.97)	25.4 (1.000)
<b>6</b>	-1206050-B	5 (.197)	50 (1.97)	19.05 (.750)
	-1606050-B	5 (.197)	50 (1.97)	25.4 (1.000)
<b>8</b>	132L-1208050-B	5 (.197)	50 (1.97)	19.05 (.750)
	-1608050-B	5 (.197)	50 (1.97)	25.4 (1.000)
<b>10</b>	-1210050-B	5 (.197)	50 (1.97)	19.05 (.750)
	-1610050-B	5 (.197)	50 (1.97)	25.4 (1.000)

More EasyFix sleeves, see page 84. For the complete assortment of EasyFix sleeves, see main catalog LIT-CAT 03-T.

Ordering example: 2 pieces 132L-1205050-B