

CoroCut® 3

System with 3 cutting edges

Component diameter 1-12 mm

The productive choice for shallow parting

CoroCut 3 is the system for economical shallow parting off and grooving operations in sliding head machines or in multi-spindle machines.

CoroCut 3 is also available in the newly introduced QS™ holding system, see page B32.



CoroCut 3 inserts bring a third cutting edge to your operations enabling you to cut for longer. Inserts available in widths from 1.0 mm up to 2.0 mm in the following geometries:

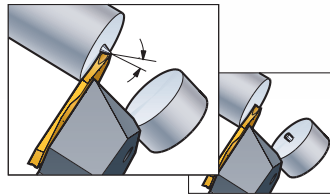
- Chip breaking geometry -CM intended for normal cutting conditions
- Chip forming geometry -CS with an extra sharp edge to be used at very low feeds and in sticky materials, such as low carbon

Accuracy

Very tight tolerances. Small indexing tolerances will maintain a tight length tolerance on the workpiece.

Tool holders

With 125 mm long shanks. Designed with zero offset and available in shank sizes 1010 to 1616 adapted for sliding head machines.

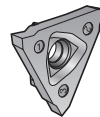


Inserts versions

CoroCut 3 inserts also available with front angle of 5° and 10° for pip and burr free parting.

Unique clamping system

The insert can be indexed directly on the machine by unscrewing two turns. If insert breakage should occur the clamping mechanism will not be affected - just index the insert and re-start the machine.



Blanks for grinding

Insert blanks for "do-it-yourself" grinding are available allowing modification of the insert for any machining operation.

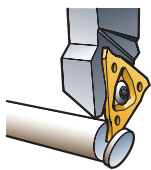


Tailor Made

Tool options designed to individual customer requirements are available. For information on our Tailor Made programme see page H4.

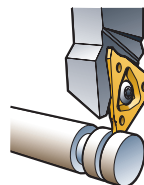
First choice recommendation

Parting off



Insert: N123T3-0100-0000-CS 4125
 Holder: RF123T06-1010BM
 Material: low alloy steel
 v_c m/min: 120
 f_n mm/rev: 0.06

Grooving



Insert: N123T3-0150-0000-CS 4125
 Holder: R123T06-1212BM
 Material: low alloy steel
 v_c m/min: 120
 f_n mm/rev: 0.06

For more specific cutting data, see pages F8, F9, F10

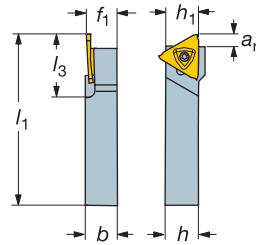
Shank tools

Parting and grooving

Shank tools for shallow parting and grooving

CoroCut 3 edge screw clamping design

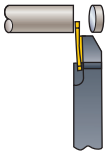
R/LF123



Note!

When using CoroCut3 inserts, the a_r of the insert gives the maximum depth of cut.

Right hand tool with right hand insert seat (T) shown.

Main application	a_r max	Seat size ¹⁾	Ordering code	Dimensions, mm						Gauge inserts	Nm ²⁾
				b	f_1	h	h_1	l_1	l_3		
	6.4	T	RF123T06-1010BM	10	10	10	10	125	23	N123T3-0150- CM	3.0
	6.4		RF123T06-1212BM	12	12	12	12	125	23	N123T3-0150- CM	3.0
	6.4		RF123T06-1616BM	16	16	16	16	125	23	N123T3-0150- CM	3.0
	6.4	U	LF123U06-1010BM	10	10	10	10	125	23	N123U3-0150- CM	3.0
	6.4		LF123U06-1212BM	12	12	12	12	125	23	N123U3-0150- CM	3.0
	6.4		LF123U06-1616BM	16	16	16	16	125	23	N123U3-0150- CM	3.0

¹⁾ To correspond with seat size on insert.

²⁾ Insert tightening torque Nm.

R = Right hand, L = Left hand

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

Main spare parts

Shank size	Screw	Key (Torx Plus)	Screwdriver
1010	5513 020-63	5680 049-02 (15IP)	5680 046-01 (8IP)
1212 - 1616	5513 020-62	5680 049-02 (15IP)	5680 046-01 (8IP)



B36

A

EXTERNAL MACHINING

CoroCut® 3 edge

Introduction

CoroCut® 3

Parting and grooving

Shallow parting

B

External machining

N123T3/R123T3

N123U3/L123U3

C

Internal machining

Tolerances, mm:

 $l_a = \pm 0.03$ $r_\epsilon = \pm 0.05$

D

Milling

E

Drilling

F

Cutting data

G

Grades

H

General information

	Selection criteria, mm	Seat size ¹⁾	Ordering code	PMS							
				GC	GC	GC					
				4125	4125	4125					
	l_a	ψ_r	r_ϵ	D_m max	a_r max						
	1	0°	0	50	4.3	T	N123T3-0100-0000-CS	★	★	★	
	1	5°	0	50	4.2		R123T3-0100-0500-CS	★	★	★	
	1	10°	0	50	4.2		R123T3-0100-1000-CS	★	★	★	
	1.5	0°	0	100	6.4		N123T3-0150-0000-CS	★	★	★	
	1.5	5°	0	100	6.3		R123T3-0150-0500-CS	★	★	★	
	1.5	10°	0	100	6.3		R123T3-0150-1000-CS	★	★	★	
	2	0°	0	100	6.4		N123T3-0200-0000-CS	★	★	★	
	2	5°	0	100	6.3		R123T3-0200-0500-CS	★	★	★	
	2	10°	0	100	6.3		R123T3-0200-1000-CS	★	★	★	
	Medium feed	1	0°	0	50	4.3	U	N123U3-0100-0000-CS	★	★	★
		1	5°	0	50	4.2		L123U3-0100-0500-CS	★	★	★
		1	10°	0	50	4.2		L123U3-0100-1000-CS	★	★	★
		1.5	0°	0	100	6.4		N123U3-0150-0000-CS	★	★	★
		1.5	5°	0	100	6.3		L123U3-0150-0500-CS	★	★	★
		1.5	10°	0	100	6.3		L123U3-0150-1000-CS	★	★	★
		2	0°	0	100	6.4		N123U3-0200-0000-CS	★	★	★
		2	5°	0	100	6.3		L123U3-0200-0500-CS	★	★	★
		2	10°	0	100	6.3		L123U3-0200-1000-CS	★	★	★
			1	0°	0.1	50	4.3	T	N123T3-0100-0001-CM	★	★
1.5	0°		0.1	100	6.4		N123T3-0150-0001-CM	★	★	★	
2	0°		0.1	100	6.4		N123T3-0200-0001-CM	★	★	★	
1	0°		0.1	50	4.3	U	N123U3-0100-0001-CM	★	★	★	
1.5	0°		0.1	100	6.4		N123U3-0150-0001-CM	★	★	★	
2	0°		0.1	100	6.4		N123U3-0200-0001-CM	★	★	★	
								P30	M25	S25	

¹⁾ To correspond with seat size on holder.

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

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

★ = First choice

B35

B32

F8

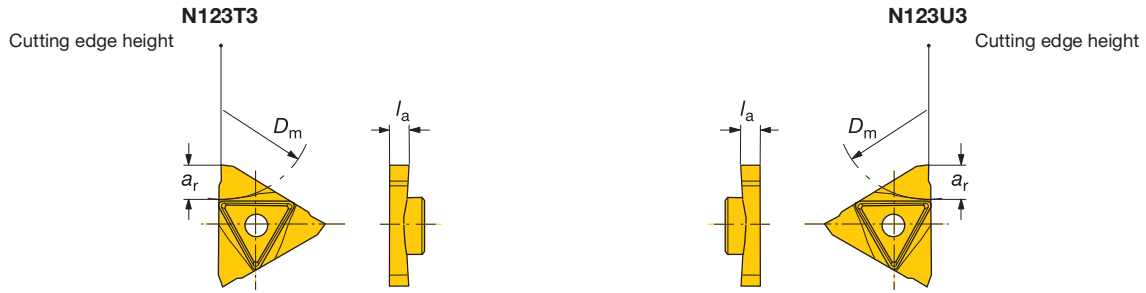
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B 36

CoroCut® 3

Parting and grooving

Blanks



For grinding instructions, see Metalcutting Technical guide.

	Selection criteria, mm					Seat size ¹⁾	Ordering code	HTOF
	la	Width range min	Width range max	Dm max	ar max			
	3.4	0.5	3	100	6.4	T	N123T3-0340-BG	☆
	3.4	0.5	3	100	6.4	U	N123U3-0340-BG	☆

¹⁾ To correspond with seat size on holder.

N = Neutral

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



B35



B32



F8



G5

A Introduction B External machining C Internal machining D Milling E Drilling F Cutting data G Grades H General Information