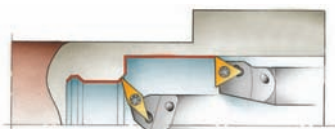


CoroTurn® 107/111 screw clamping

Internal tools for positive basic-shape inserts with 7° and 11° clearance angle

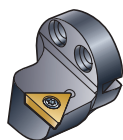
For light roughing to finishing of small, long and slender components, ideal for copy machining

CoroTurn® 107/111 systems are available as Coromant Capto® cutting units and conventional steel shank design for all insert shapes and in different entering angles



A screw clamping system, giving:

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



CoroTurn® SL the modular internal solution

Positive CoroTurn® 107 and 111 systems can also be used in the modular CoroTurn® SL (570) system using exchangeable cutting heads and different types of boring bars, see page A199

Different types of bars

Both CoroTurn® 107 and 111 boring bars are available as:

- Solid steel, for overhang up to 4 x bar dia.
- Carbide reinforced, for overhang up to 6 x bar dia.
- Carbide reinforced and damped, for overhang up to 10 x bar dia.



Correct clamping with EasyFix

Fast, simple and correct setting of centre height due to spring loaded plunger. Available for all cylindrical boring bars. For more information see page A238



CoroTurn® XS

For even smaller bores, down to 0.3mm, use CoroTurn® XS tools. See page A242

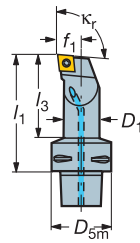
Coromant Capto® boring bars

CoroTurn® 107 screw clamp design

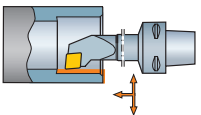


CCMT, CCGT
CCGX
CCMW

SCLCR/L

Entering angle: $\kappa_r 95^\circ$ 

Right hand style shown

| κ_r | Main application | Ordering code | Dimensions, mm | | | | | | | | Gauge inserts | Nm ³⁾ | |
|---------------------|--|------------------------|---------------------|-------|----------|-------|-------|-------|---------------|---------------|---------------|------------------|-----|
| | | | D_m min | D_1 | D_{5m} | f_1 | l_1 | l_3 | γ^1 | λ_s^2 | | | |
| 95° |  | 09 C3-SCLCR/L-11065-09 | 20 | 16 | 32 | 11.0 | 65 | 48.0 | 0° | -12° | CCMT 09 T3 08 | 3.0 | |
| | | C3-SCLCR/L-13075-09 | 25 | 20 | 32 | 13.0 | 75 | 59.0 | 0° | -8° | CCMT 09 T3 08 | 3.0 | |
| | | C3-SCLCR/L-17090-09 | 32 | 25 | 32 | 17.0 | 90 | 75.0 | 0° | -6° | CCMT 09 T3 08 | 3.0 | |
| | | C4-SCLCR/L-11070-09 | 20 | 16 | 40 | 11.0 | 70 | 47.0 | 0° | -12° | CCMT 09 T3 08 | 3.0 | |
| | | C4-SCLCR/L-13080-09 | 25 | 20 | 40 | 13.0 | 80 | 58.0 | 0° | -8° | CCMT 09 T3 08 | 3.0 | |
| | | C4-SCLCR/L-17090-09 | 32 | 25 | 40 | 17.0 | 90 | 69.0 | 0° | -6° | CCMT 09 T3 08 | 3.0 | |
| | | C4-SCLCR/L-27080-09 | 50 | 40 | 40 | 27.0 | 80 | 60.0 | 0° | -6° | CCMT 09 T3 08 | 3.0 | |
| | | C5-SCLCR/L-11070-09 | 20 | 16 | 50 | 11.0 | 70 | 46.0 | 0° | -12° | CCMT 09 T3 08 | 3.0 | |
| | | C5-SCLCR/L-13080-09 | 25 | 20 | 50 | 13.0 | 80 | 56.0 | 0° | -8° | CCMT 09 T3 08 | 3.0 | |
| | | C5-SCLCR/L-17090-09 | 32 | 25 | 50 | 17.0 | 90 | 67.0 | 0° | -6° | CCMT 09 T3 08 | 3.0 | |
| | | C5-SCLCR/L-35100-09 | 63 | 50 | 50 | 35.0 | 100 | 81.0 | 0° | -4° | CCMT 09 T3 08 | 3.0 | |
| | | 12 | C3-SCLCR/L-17090-12 | 32 | 25 | 32 | 17.0 | 90 | 75.0 | 0° | -6° | CCMT 12 04 08 | 3.0 |
| | | | C3-SCLCR/L-22064-12 | 40 | 32 | 32 | 22.0 | 64 | 50.0 | 0° | -10° | CCMT 12 04 08 | 3.0 |
| | | | C3-SCLCR/L-22096-12 | 40 | 32 | 32 | 22.0 | 96 | 82.0 | 0° | -10° | CCMT 12 04 08 | 3.0 |
| | | | C4-SCLCR/L-17090-12 | 32 | 25 | 40 | 17.0 | 90 | 69.0 | 0° | -6° | CCMT 12 04 08 | 3.0 |
| C4-SCLCR/L-22110-12 | 40 | | 32 | 40 | 22.0 | 110 | 89.0 | 0° | -10° | CCMT 12 04 08 | 3.0 | | |
| C4-SCLCR/L-27080-12 | 50 | | 40 | 40 | 27.0 | 80 | 60.0 | 0° | -8° | CCMT 12 04 08 | 3.0 | | |
| C5-SCLCR/L-17090-12 | 32 | | 25 | 50 | 17.0 | 90 | 67.0 | 0° | -6° | CCMT 12 04 08 | 3.0 | | |
| C5-SCLCR/L-22110-12 | 40 | | 32 | 50 | 22.0 | 110 | 88.0 | 0° | -10° | CCMT 12 04 08 | 3.0 | | |
| C5-SCLCR/L-27140-12 | 50 | | 40 | 50 | 27.0 | 140 | 119.0 | 0° | -8° | CCMT 12 04 08 | 3.0 | | |
| C5-SCLCR-35100-12 | 63 | 50 | 50 | 35.0 | 100 | 81.0 | 0° | -6° | CCMT 12 04 08 | 3.0 | | | |

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

3) Insert tightening torque Nm

Ordering example: 2 pieces C3-SCLCR-11065-09

C3-SCLCL-11065-09

R = Right hand, L = Left hand

Main spare parts

| Insert size | Bar dia. | Insert screw (Thread) | Shim | Shim screw (Thread) | Key (Torx Plus/mm) |
|-------------|----------|-----------------------|-------------|-----------------------|------------------------|
| 09 | 20-25 | 5513 020-09 (M3.5) | - | - | 5680 049-01 (15IP/3.5) |
| 09 | 32 | 5513 020-10 (M3.5) | - | - | 5680 049-01 (15IP/3.5) |
| 09 | 50-63 | 5513 020-01 (M3.5) | 5322 232-01 | 5512 090-01 (M5x0.5) | 5680 049-01 (15IP/3.5) |
| 12 | 32 | 5513 020-17 (M4x0.5) | - | - | 5680 049-02 (15IP/4.0) |
| 12 | 40-63 | 5513 020-18 (M4x0.5) | 5322 232-02 | 5512 090-03 (M6x0.75) | 5680 049-02 (15IP/4.0) |



A9



A168



A310



G6



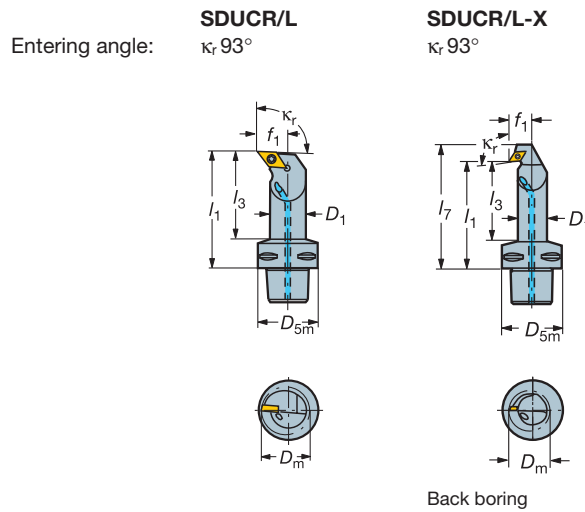
A2

Coromant Capto® boring bars

CoroTurn® 107 screw clamp design



- DCMT, DCMX
DCGT, DCGX
- DCMW



Right hand style shown

| κ_r | Main application | Ordering code | Dimensions, mm | | | | | | | | | | Gauge inserts | Nm ³⁾ |
|---------------------|------------------|-------------------------|----------------|-------|----------|-------|-------|-------|---------------|-------------|----------------|---------------|---------------|------------------|
| | | | D_m min | D_1 | D_{5m} | f_1 | l_1 | l_3 | l_7 | $\gamma^1)$ | $\lambda_s^2)$ | | | |
| 93° | | 07 C3-SDUCR/L-11065-07 | 20 | 16 | 32 | 11.0 | 65 | 48.0 | 0° | -8° | DCMT 07 02 04 | 0.9 | | |
| | | C4-SDUCR/L-11070-07 | 20 | 16 | 40 | 11.0 | 70 | 47.0 | 0° | -8° | DCMT 07 02 04 | 0.9 | | |
| | | C5-SDUCR/L-11070-07 | 20 | 16 | 50 | 11.0 | 70 | 46.0 | 0° | -8° | DCMT 07 02 04 | 0.9 | | |
| | | 11 C3-SDUCR/L-13075-11 | 25 | 20 | 32 | 13.0 | 75 | 59.0 | 0° | -8° | DCMT 11 T3 08 | 3.0 | | |
| | | C3-SDUCR/L-17090-11 | 32 | 25 | 32 | 17.0 | 90 | 75.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | |
| | | C3-SDUCR/L-22064-11 | 40 | 32 | 32 | 22.0 | 64 | 50.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | |
| | | C3-SDUCR/L-22096-11 | 40 | 32 | 32 | 22.0 | 96 | 82.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | |
| | | C4-SDUCR/L-13080-11 | 25 | 20 | 40 | 13.0 | 80 | 58.0 | 0° | -8° | DCMT 11 T3 08 | 3.0 | | |
| | | C4-SDUCR/L-17090-11 | 32 | 25 | 40 | 17.0 | 90 | 69.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | |
| | | C4-SDUCR/L-22110-11 | 40 | 32 | 40 | 22.0 | 110 | 89.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | |
| | | C4-SDUCR/L-27080-11 | 50 | 40 | 40 | 27.0 | 80 | 60.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | |
| | | C5-SDUCR/L-13080-11 | 25 | 20 | 50 | 13.0 | 80 | 56.0 | 0° | -8° | DCMT 11 T3 08 | 3.0 | | |
| | | C5-SDUCR/L-17090-11 | 32 | 25 | 50 | 17.0 | 90 | 67.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | |
| C5-SDUCR/L-22110-11 | 40 | 32 | 50 | 22.0 | 110 | 88.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | | | | |
| C5-SDUCR/L-35100-11 | 63 | 50 | 50 | 35.0 | 100 | 81.0 | 0° | -4° | DCMT 11 T3 08 | 3.0 | | | | |
| 93° | | 07 C3-SDUCR/L-13070-07X | 22 | 16 | 32 | 13.0 | 70 | 54.0 | 80.7 | 0° | -6° | DCMT 07 02 04 | 0.9 | |
| | | C3-SDUCR/L-15080-07X | 27 | 20 | 32 | 15.0 | 80 | 64.0 | 80.7 | 0° | -3° | DCMT 07 02 04 | 0.9 | |
| | | C4-SDUCR/L-13070-07X | 22 | 16 | 40 | 13.0 | 70 | 48.0 | 80.7 | 0° | -6° | DCMT 07 02 04 | 0.9 | |
| | | C4-SDUCR/L-15080-07X | 27 | 20 | 40 | 15.0 | 80 | 58.0 | 91.5 | 0° | -3° | DCMT 07 02 04 | 0.9 | |
| | | C4-SDUCR/L-18090-07X | 32 | 25 | 40 | 18.0 | 90 | 69.0 | 101.5 | 0° | -3° | DCMT 07 02 04 | 0.9 | |
| | | C5-SDUCR/L-15080-07X | 27 | 20 | 50 | 15.0 | 80 | 57.0 | 91.5 | 0° | -3° | DCMT 07 02 04 | 0.9 | |
| | | C5-SDUCR/L-18090-07X | 32 | 25 | 50 | 18.0 | 90 | 67.0 | 101.5 | 0° | -3° | DCMT 07 02 04 | 0.9 | |

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

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C3-SDUCR-11065-07
C3-SDUCL-11065-07

R = Right hand, L = Left hand

Main spare parts

| Insert size | | | | | |
|-------------|-----------------------|-------------|-------------------------|------------------------|--|
| Bar dia. | Insert screw (Thread) | Shim | Shim screw (Thread) | Key (Torx Plus/mm) | |
| 07 20-32 | 5513 020-03 (M2.5) | - | - | 5680 051-02 (7IP) | |
| 11 25-32 | 5513 020-10 (M3.5) | - | - | 5680 049-01 (15IP/3.5) | |
| 11 40-63 | 5513 020-01 (M3.5) | 5322 263-01 | 5512 090-01 (Mx0.5/3.5) | 5680 049-01 (15IP/3.5) | |



A9



A168



A310



G6



A2

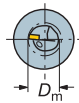
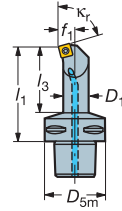
Coromant Capto® boring bars

CoroTurn® 107 screw clamp design

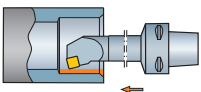


SCMT, SCGX
SCMW

Entering angle: κ_r 75°



Right hand style shown

| κ_r | Main application | □ | Ordering code | Dimensions, mm | | | | | | | Gauge inserts | Nm ³⁾ | |
|------------|---|----|---------------------|----------------|-------|----------|-------|-------|-------|------------|---------------|------------------|---------------|
| | | | | D_m min | D_1 | D_{5m} | f_1 | l_1 | l_3 | γ^1 | | | λ_s^2 |
| 75° |  | 09 | C4-SSKCR-13080-09 | 25 | 20 | 40 | 13.0 | 80 | 58.0 | 0° | -6° | SCMT 09 T3 08 | 3.0 |
| | | | C5-SSKCR/L-13080-09 | 25 | 20 | 50 | 13.0 | 80 | 56.0 | 0° | -6° | SCMT 09 T3 08 | 3.0 |
| | | 12 | C4-SSKCR/L-22110-12 | 40 | 32 | 40 | 22 | 110 | 89 | 0° | -10° | SCM. 12 04 08 | 3.9 |
| | | | C5-SSKCR/L-17090-12 | 32 | 25 | 50 | 17 | 90 | 67 | 0° | -10° | SCM. 12 04 08 | 3.9 |

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

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C5-SSKCR-13080-09

C5-SSKCL-13080-09

R = Right hand, L = Left hand

Main spare parts

| Insert size | | | | | |
|-------------|----------|-----------------------|-------------|-----------------------|------------------------|
| □ | Bar dia. | Insert screw (Thread) | Shim | Shim screw (Thread) | Key (Torx plus/mm) |
| 09 | 20-25 | 5513 020-09 (M3.5) | - | - | 5680 049-01 (15IP/3.5) |
| 09 | 32 | 5513 020-10 (M3.5) | - | - | 5680 049-01 (15IP/3.5) |
| 12 | 32-40 | 5513 020-17 (M4x0.5) | - | - | 5680 049-02 (15IP/4.0) |
| 12 | 50-63 | 5513 020-18(M4x0.5) | 5322 420-02 | 5512 090-03 (M6x0.75) | 5680 049-02 (15IP/4.0) |



A9



A168



A310



G6



A2

A 180

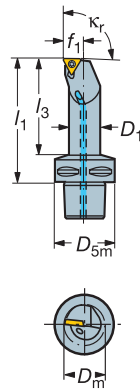
Coromant Capto® boring bars

CoroTurn® 107 screw clamp design



TCMT, TCMX
TCGT, TCGX
TCMW

STFCR/L
Entering angle: $\kappa_r 91^\circ$



| κ_r | Main application | Ordering code | Dimensions, mm | | | | | | | | Gauge inserts | Nm ³⁾ |
|---------------------|------------------|--------------------------------------|----------------|-------|----------|-------|-------|-------|---------------|---------------|---------------|------------------|
| | | | D_m min | D_1 | D_{5m} | f_1 | l_1 | l_3 | γ^1 | λ_s^2 | | |
| 91° | | C3-STFCR/L-11065-11-B1 ⁴⁾ | 20 | 16 | 32 | 11.0 | 65 | 48.0 | 0° | -4° | TCMT 11 03 04 | 0.9 |
| | | C3-STFCR/L-13075-11-B1 ⁴⁾ | 25 | 20 | 32 | 13.0 | 75 | 59.0 | 0° | -3° | TCMT 11 03 04 | 0.9 |
| | | C4-STFCR/L-11070-11-B1 ⁴⁾ | 20 | 16 | 40 | 11.0 | 70 | 47.0 | 0° | -4° | TCMT 11 03 04 | 0.9 |
| | | C4-STFCR/L-13080-11-B1 ⁴⁾ | 25 | 20 | 40 | 13.0 | 80 | 57.0 | 0° | -3° | TCMT 11 03 04 | 0.9 |
| | | C5-STFCR/L-11070-11-B1 ⁴⁾ | 20 | 16 | 50 | 11.0 | 70 | 46.0 | 0° | -4° | TCMT 11 03 04 | 0.9 |
| | | C5-STFCR/L-13080-11-B1 ⁴⁾ | 25 | 20 | 50 | 13.0 | 80 | 56.0 | 0° | -3° | TCMT 11 03 04 | 0.9 |
| | | C3-STFCR/L-11065-11 | 20 | 16 | 32 | 11.0 | 65 | 48.0 | 0° | -4° | TCMT 11 02 04 | 0.9 |
| | | C3-STFCR/L-13075-11 | 25 | 20 | 32 | 13.0 | 75 | 59.0 | 0° | -3° | TCMT 11 02 04 | 0.9 |
| | | C4-STFCR/L-11070-11 | 20 | 16 | 40 | 11.0 | 70 | 47.0 | 0° | -4° | TCMT 11 02 04 | 0.9 |
| | | C4-STFCR/L-13080-11 | 25 | 20 | 40 | 13.0 | 80 | 58.0 | 0° | -3° | TCMT 11 02 04 | 0.9 |
| | | C5-STFCR/L-11070-11 | 20 | 16 | 50 | 11.0 | 70 | 46.0 | 0° | -4° | TCMT 11 02 04 | 0.9 |
| | | C5-STFCR/L-13080-11 | 25 | 20 | 50 | 13.0 | 80 | 56.0 | 0° | -3° | TCMT 11 02 04 | 0.9 |
| | | C3-STFCR-17090-16 | 32 | 25 | 32 | 17.0 | 90 | 75.0 | 0° | -6° | TCMT 16 T3 08 | 3.0 |
| | | C4-STFCR/L-17090-16 | 32 | 25 | 40 | 17.0 | 90 | 69.0 | 0° | -6° | TCMT 16 T3 08 | 3.0 |
| | | C4-STFCR/L-22110-16 | 40 | 32 | 40 | 22.0 | 110 | 89.0 | 0° | -10° | TCMT 16 T3 08 | 3.0 |
| C5-STFCR/L-17090-16 | 32 | 25 | 50 | 17.0 | 90 | 67.0 | 0° | -6° | TCMT 16 T3 08 | 3.0 | | |
| C5-STFCR/L-22110-16 | 40 | 32 | 50 | 22.0 | 110 | 88.0 | 0° | -10° | TCMT 16 T3 08 | 3.0 | | |

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

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

⁴⁾ B1 = For insert with thickness 03 = 3.18 mm.

Ordering example: 2 pieces C3-STFCR-11065-11-B1

C3-STFCL-11065-11-B1

R = Right hand, L = Left hand

Main spare parts

| Insert size | Bar dia. | Insert screw (Thread) | Shim | Shim screw (Thread) | Key (Torx Plus/mm) |
|-------------|----------|-----------------------|-------------|----------------------|------------------------|
| 11 | 20-25 | 5513 020-03 (M2.5) | - | - | 5680 051-02 (7IP) |
| 16 | 32 | 5513 020-10 (M3.5) | - | - | 5680 049-01 (15IP) |
| 16 | 40 | 5513 020-01 (M3.5) | 5322 320-01 | 5512 090-01 (M5x0.5) | 5680 049-01 (15IP/3.5) |



A9



A168



A310



G6



A2

Coromant Capto® boring bars

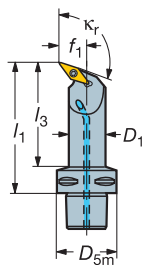
CoroTurn® 107 screw clamp design



VBMT, VBGT
VCGX, VCEX,
VCGT

VBMW, VCMW

SVQBR/L
Entering angle: $\kappa_r 107^\circ 30'$



Right hand style shown

| κ_r | Main application | Ordering code | Dimensions, mm | | | | | | | | Gauge inserts | Nm ³⁾ |
|---------------------|------------------|------------------------|----------------|-------|----------|-------|-------|-------|---------------|----------------|---------------|------------------|
| | | | D_m min | D_1 | D_{5m} | f_1 | l_1 | l_3 | $\gamma^1)$ | $\lambda_s^2)$ | | |
| 107.5° | | 11 C3-SVQBR/L-13070-11 | 22 | 16 | 32 | 13.0 | 70 | 54.0 | 0° | -7° | VBMT 11 02 04 | 0.9 |
| | | C3-SVQBR/L-15080-11 | 27 | 20 | 32 | 15.0 | 80 | 64.0 | 0° | -5° | VBMT 11 02 04 | 0.9 |
| | | C4-SVQBR/L-13070-11 | 25 | 20 | 40 | 13.0 | 70 | 48.0 | 0° | -7° | VBMT 11 02 04 | 0.9 |
| | | C4-SVQBR/L-15080-11 | 27 | 20 | 40 | 15.0 | 80 | 58.0 | 0° | -5° | VBMT 11 02 04 | 0.9 |
| | | C5-SVQBR/L-15080-11 | 27 | 20 | 50 | 15.0 | 80 | 57.0 | 0° | -5° | VBMT 11 02 04 | 0.9 |
| | | 16 C3-SVQBR/L-18090-16 | 33 | 25 | 32 | 18.0 | 90 | 75.0 | 0° | -6° | VBMT 16 04 08 | 3.0 |
| | | C3-SVQBR/L-22096-16 | 40 | 32 | 32 | 22.0 | 96 | 82.0 | 0° | -8° | VBMT 16 04 08 | 3.0 |
| | | C3-SVQBR-22064-16 | 40 | 32 | 32 | 22.0 | 64 | 50.0 | 0° | -8° | VBMT 16 04 08 | 3.0 |
| | | C4-SVQBR/L-18090-16 | 33 | 25 | 40 | 18.0 | 90 | 69.0 | 0° | -6° | VBMT 16 04 08 | 3.0 |
| | | C4-SVQBR/L-22110-16 | 40 | 32 | 40 | 22.0 | 110 | 89.0 | 0° | -8° | VBMT 16 04 08 | 3.0 |
| C4-SVQBR/L-27080-16 | 50 | 40 | 40 | 27.0 | 80 | 60.0 | 0° | -8° | VBMT 16 04 08 | 3.0 | | |
| C4-SVQBR/L-27120-16 | 50 | 40 | 40 | 27.0 | 120 | 100.0 | 0° | -8° | VBMT 16 04 08 | 3.0 | | |
| C5-SVQBR/L-18090-16 | 33 | 25 | 50 | 18.0 | 90 | 67.0 | 0° | -6° | VBMT 16 04 08 | 3.0 | | |
| C5-SVQBR/L-22110-16 | 40 | 32 | 50 | 22.0 | 110 | 88.0 | 0° | -8° | VBMT 16 04 08 | 3.0 | | |
| C5-SVQBR/L-27140-16 | 50 | 40 | 50 | 27.0 | 140 | 119.0 | 0° | -8° | VBMT 16 04 08 | 3.0 | | |
| C5-SVQBR/L-35100-16 | 63 | 50 | 50 | 35.0 | 100 | 81.0 | 0° | -7° | VBMT 16 04 08 | 3.0 | | |
| C5-SVQBR/L-35150-16 | 63 | 50 | 50 | 35.0 | 150 | 131.0 | 0° | -7° | VBMT 16 04 08 | 3.0 | | |
| C6-SVQBR/L-22120-16 | 40 | 32 | 63 | 22.0 | 120 | 94.0 | 0° | -8° | VBMT 16 04 08 | 3.0 | | |
| C6-SVQBR/L-27145-16 | 50 | 40 | 63 | 27.0 | 145 | 120.0 | 0° | -8° | VBMT 16 04 08 | 3.0 | | |
| C6-SVQBR/L-35175-16 | 63 | 50 | 63 | 35.0 | 175 | 152.0 | 0° | -8° | VBMT 16 04 08 | 3.0 | | |

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

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C3-SVQBR-13070-11
C3-SVQBL-13070-11

R = Right hand, L = Left hand

Main spare parts

| Insert size | Bar dia. | Insert screw (Thread) | Shim | Shim screw (Thread) | Key (Torx Plus/mm) |
|-------------|----------|-----------------------|-------------|----------------------|------------------------|
| 11 | 22-27 | 5513 020-03 (M2.5) | - | - | 5680 051-02 (7IP) |
| 16 | 32 | 5513 020-10 (M2.5) | - | - | 5680 049-01 (15IP/3.5) |
| 16 | 40-63 | 5513 020-01 (M2.5) | 5322 270-01 | 5512 090-01 (M5x0.5) | 5680 049-01 (15IP/3.5) |



A9



A168



A310



G6



A2

Boring bars

CoroTurn® 107 screw clamp design

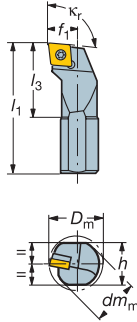
Cylindrical with flats

Entering angle:

S...-SCLCR/L
 $\kappa_r 95^\circ$



CCMT, CCGT
CCGX
CCMW



Max overhang $4 \times dm_m$

Right hand style shown

| κ_r | Main application | Ordering code | Dimensions, mm | | | | | | | | Gauge inserts | Nm ³⁾ |
|------------|------------------|----------------------|----------------|--------------|-------|-----|-------|-------|-------------|----------------|---------------|------------------|
| | | | dm_m | D_m min | f_1 | h | l_1 | l_3 | $\gamma^1)$ | $\lambda_s^2)$ | | |
| 95° | | 06 S08K-SCLCR/L 06 | 8 | 10 | 5.0 | 7 | 125 | 16.8 | 0° | -12° | CCMT 06 02 04 | 0.9 |
| | | S10M-SCLCR/L 06 | 10 | 12 | 6.0 | 9 | 150 | 16.8 | 0° | -10° | CCMT 06 02 04 | 0.9 |
| | | S12M-SCLCR/L 06 | 12 | 16 | 9.0 | 11 | 150 | 24.5 | 0° | -15° | CCMT 06 02 04 | 0.9 |
| | | S16R-SCLCR/L 06 | 16 | 20 | 11.0 | 15 | 200 | 32.5 | 0° | -12° | CCMT 06 02 04 | 0.9 |
| | | 09 S16R-SCLCR/L 09-M | 16 | 20 | 11.0 | 15 | 200 | 32.5 | 0° | -12° | CCMT 09 T3 08 | 3.0 |
| | | S20S-SCLCR/L 09-M | 20 | 25 | 13.0 | 18 | 250 | 30.7 | 0° | -8° | CCMT 09 T3 08 | 3.0 |
| | | S25T-SCLCR/L 09-M | 25 | 32 | 17.0 | 23 | 300 | 45.0 | 0° | -6° | CCMT 09 T3 08 | 3.0 |
| | | 12 S25T-SCLCR/L 12 | 25 | 32 | 17.0 | 23 | 300 | 45.0 | 0° | -6° | CCMT 12 04 08 | 3.0 |
| | | S32U-SCLCR/L 12 | 32 | 40 | 22.0 | 30 | 350 | 50.0 | 0° | -10° | CCMT 12 04 08 | 3.0 |
| | | S40V-SCLCR/L 12 | 40 | 50 | 27.0 | 37 | 400 | 60.0 | 0° | -6° | CCMT 12 04 08 | 3.0 |

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

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces S08K-SCLCR 06

S08K-SCLCL 06

R = Right hand, L = Left hand

Main spare parts

| Insert size | Bar dia. | Insert screw | Shim | Shim screw | Key (Torx Plus) |
|-------------|----------|--------------|-------------|-------------|--------------------|
| 06 | 8-16 | 5513 020-03 | - | - | 5680 051-02 (7IP) |
| 09 | 16-20 | 5513 020-09 | - | - | 5680 049-01 (15IP) |
| 09 | 25 | 5513 020-10 | - | - | 5680 049-01 (15IP) |
| 12 | 25 | 5513 020-17 | - | - | 5680 049-02 (15IP) |
| 12 | 32-40 | 5513 020-18 | 5322 232-02 | 5512 090-03 | 5680 049-02 (15IP) |



A9



A178



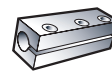
A310



G6



A2



A238

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical

Entering angle:

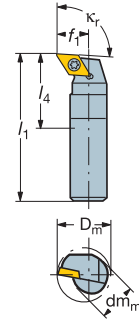
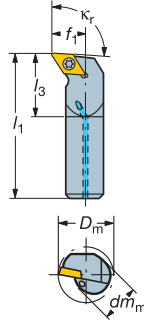
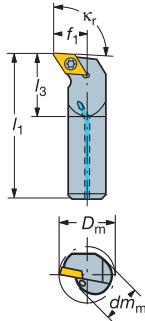
A...-SDUCR/L
 $\kappa_r 93^\circ$

E...-SDUCR/L
 $\kappa_r 93^\circ$

F...-SDUCR/L
 $\kappa_r 93^\circ$



DCMT, DCMX
 DCGT, DCGX
 DCMW



Max overhang

4 x dm_m

6 x dm_m

10 x dm_m

With internal coolant supply

With internal coolant supply

Right hand style shown

Silent Tools™

| κ_r | Main application | Ordering code | Dimensions, mm | | | | | | | Gauge inserts | Nm ³⁾ | |
|------------|------------------|-----------------------|----------------|-----------|-------|-------|-------|-------|------------|---------------|------------------|---------------|
| | | | dm_m | D_m min | f_1 | l_1 | l_3 | l_4 | γ^1 | | | λ_s^2 |
| 93° | | 07 A10K-SDUCR/L 07-ER | 10 | 15 | 9.0 | 125 | 16.4 | | 0° | -7° | DCMT 07 02 04 | 0.9 |
| | | A12M-SDUCR/L 07-ER | 12 | 18 | 11.0 | 150 | 18.2 | | 0° | -5° | DCMT 07 02 04 | 0.9 |
| | | E10M-SDUCR/L 07-ER | 10 | 15 | 9.0 | 150 | 21.3 | | 0° | -5° | DCMT 07 02 04 | 0.9 |
| | | E12Q-SDUCR/L 07-ER | 12 | 18 | 11.0 | 180 | 25.3 | | 0° | -5° | DCMT 07 02 04 | 0.9 |
| | | E16R-SDUCR/L 07-ER | 16 | 22 | 13.0 | 200 | 33.0 | | 0° | -5° | DCMT 07 02 04 | 0.9 |
| | | F10M-SDUCR/L 07-ER | 10 | 15 | 9.0 | 150 | | | 0° | -7° | DCMT 07 02 04 | 0.9 |
| | | F12Q-SDUCR/L 07-ER | 12 | 18 | 11.0 | 180 | | 72 | 0° | -9° | DCMT 07 02 04 | 0.9 |

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

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces A10K-SDUCR 07-ER

A10K-SDUCL 07-ER

R = Right hand, L = Left hand

Main spare parts

Insert size

| Bar dia. | Insert screw | Shim | Shim screw | Key (Torx Plus) |
|----------|--------------|------|------------|-------------------|
| 07 10-16 | 5513 020-03 | - | - | 5680 051-02 (71P) |



A9



A179



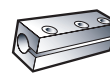
A310



G6



A2



A238

Boring bars

CoroTurn® 107 screw clamp design

Cylindrical with flats

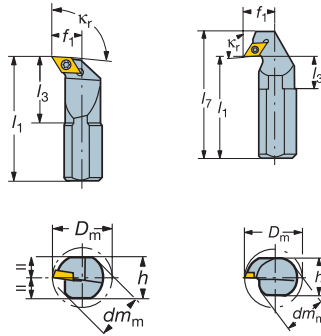
Entering angle:

S...-SDUCR/L
 $\kappa_r 93^\circ$

S...-SDUCR/L-X
 $\kappa_r 93^\circ$



- DCMT, DCMX
DCGT, DCGX
- DCMW



Max overhang 4 x dm_m

Right hand style shown

Back boring

| κ_r | Main application | Ordering code | Dimensions, mm | | | | | | | | | Gauge inserts | Nm ³⁾ |
|------------|------------------|-----------------------|----------------|-----------|-------|-----|-------|-------|-------|------------|---------------|---------------|------------------|
| | | | dm_m | D_m min | f_1 | h | l_1 | l_3 | l_7 | γ^1 | λ_s^2 | | |
| 93° | | 07 S10K-SDUCR/L 07 | 10 | 13 | 7.0 | 9 | 125 | 19.8 | 0° | -15° | DCMT 07 02 04 | 0.9 | |
| | | S12M-SDUCR/L 07 | 12 | 16 | 9.0 | 11 | 150 | 22.0 | 0° | -10° | DCMT 07 02 04 | 0.9 | |
| | | S16R-SDUCR/L 07 | 16 | 20 | 11.0 | 15 | 200 | 27.0 | 0° | -8° | DCMT 07 02 04 | 0.9 | |
| | | 11 S20S-SDUCR/L 11-M | 20 | 25 | 13.0 | 18 | 250 | 30.4 | 0° | -6° | DCMT 11 T3 08 | 3.0 | |
| 93° | | 07 S25T-SDUCR/L 11-M | 25 | 32 | 17.0 | 23 | 300 | 46.0 | 0° | -6° | DCMT 11 T3 08 | 3.0 | |
| | | 07 S16R-SDUCR/L 07-EX | 16 | 22 | 13.0 | 15 | 200 | 16.0 | 212 | 0° | -6° | DCMT 07 02 04 | 0.9 |
| | | S20S-SDUCR/L 07-EX | 20 | 27 | 15.0 | 18 | 250 | 20.0 | 262 | 0° | -3° | DCMT 07 02 04 | 0.9 |
| | | S25T-SDUCR/L 07-DX | 25 | 33 | 18.0 | 23 | 300 | 25.0 | 312 | 0° | -3° | DCMT 07 02 04 | 0.9 |
| | | 11 S32U-SDUCR/L 11-X | 32 | 40 | 22.0 | 30 | 350 | 32.0 | 366 | 0° | -10° | DCMT 11 T3 08 | 3.0 |

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

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces S10K-SDUCR 07

S10K-SDUCL 07

R = Right hand, L = Left hand

Main spare parts

| Insert size | | | | | |
|-------------|--------------|-------------|-------------|--------------------|--|
| Bar dia. | Insert screw | Shim | Shim screw | Key (Torx Plus) | |
| 07 10-16 | 5513 020-03 | - | - | 5680 051-02 (7IP) | |
| 11 20 | 5513 020-09 | - | - | 5680 049-01 (15IP) | |
| 11 25 | 5513 020-10 | - | - | 5680 049-01 (15IP) | |
| 11 32 | 5513 020-01 | 5322 263-01 | 5512 090-01 | 5680 049-01 (15IP) | |



A9



A179



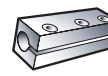
A310



G6



A2



A238

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