

Coromant Capto® cutting units

CoroTurn® RC rigid clamp design

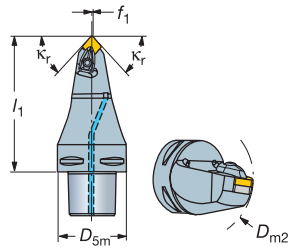


- CNMM, CNGP
- CNMG
- CNMA, CNGA

Entering angle:

DCMNN

$\kappa_r 50^\circ (95^\circ)$



Neutral style

κ_r	Main application	Alternative use		Ordering code	Dimensions, mm						Gauge inserts	Nm ³⁾
					D_{5m}	D_{m2} min	f_1	l_1	$\gamma^1)$	$\lambda_s^2)$		
95°			12	C5-DCMNN-00105-12	50	110	0	105	-6	-6	CNMG 12 04 08	3.9
				C6-DCMNN-00090-12	63	0	90	-6	-6	CNMG 12 04 08	3.9	
				C6-DCMNN-00115-12	63	0	115	-6	-6	CNMG 12 04 08	3.9	
				C6-DCMNN-00090-16	63	110	0	90	-6	-6	CNMG 16 06 12	6.4
			16	C8-DCMNN-00150-16	80	115	0	150	-6	-6	CNMG 16 06 12	6.4

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

²⁾ λ = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C5-DCMNN-00105-12
N = Neutral

Main spare parts

Insert size	Insert size			Complete clamp set	
	Shim	Shim screw	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)
12	5322 234-01	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)
16	5322 234-03	5513 020-07	5680 043-14 (20IP)	5412 028-031 ¹⁾	5680 043-14 (20IP)

¹⁾ To modify CoroTurn® RC holders for other inserts, see clamp sets on page A281.



A9



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G6



A2

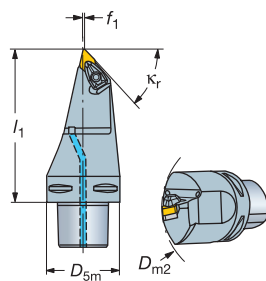
Coromant Capto® cutting units

CoroTurn® RC rigid clamp design

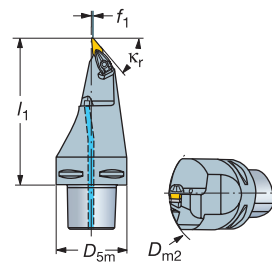


- DNMM, DNGP, DNMX
- DNMG
- DNMA, DNMA

Entering angle:

DDMNL
 $\kappa_r 48^\circ (93^\circ)$


- VNMG
- VNGP

DVMNL
 $\kappa_r 50^\circ (95^\circ)$


Left hand style

κ_r	Main application	Alternative use		Ordering code	Dimensions, mm					Gauge inserts	Nm ³⁾
					D_{5m}	D_{m2} min	f_1	l_1	$\gamma^1)$		
93°				C5-DDMNL-00115-15	50	110	115	-5°	-6°	DNMG 15 06 08	3.9
				C6-DDMNL-00130-15	63	110	130	-5°	-6°	DNMG 15 06 08	3.9
				C6-DDMNL-33120-15	63	130	33.0 120	-5°	-6°	DNMG 15 06 08	3.9
				C8-DDMNL-00160-15	80	120	160	-5°	-6°	DNMG 15 06 08	3.9

¹⁾ γ = Rake angle (valid with flat insert).²⁾ λ = Angle of inclination.³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C5-DDMNL-00115-15

L = Left hand

κ_r	Main application	Alternative use		Ordering code	Dimensions, mm					Gauge inserts	Nm ³⁾
					D_{5m}	D_{m2} min	l_1	$\gamma^1)$	$\lambda_s^2)$		
95°				C8-DVMNL-00160-16	80	110	160	-4°	-14°	VNMG 16 04 08	3.0

¹⁾ γ = Rake angle (valid with flat insert).²⁾ λ = Angle of inclination.³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C8-DVMNL-00160-16

L = Left hand

Main spare parts

Insert size		Shim			Shim screw			Key (Torx Plus)			Complete clamp set		Key (Torx Plus)	
		Shim	Shim screw	Key (Torx Plus)	Shim	Shim screw	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	
15		5322 266-02	5513 020-02	5680 049-01 (15IP)	5322 266-02	5513 020-02	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)	5412 028-021 ¹⁾	5680 049-01 (15IP)	
16		5322 269-01	5513 020-09	5680 049-01 (15IP)	5322 269-01	5513 020-09	5680 049-01 (15IP)	5412 028-061	5680 049-01 (15IP)	5412 028-061	5680 049-01 (15IP)	5412 028-061	5680 049-01 (15IP)	

¹⁾ To modify CoroTurn® RC holders for other inserts, see clamp sets on page A281.

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G6



A2

Coromant Capto® cutting units

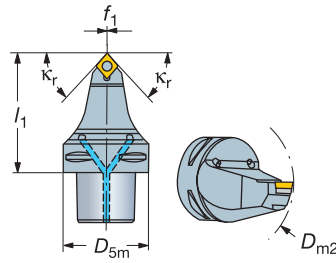
CoroTurn® 107 screw clamp design



- CCMT, CCGT, CCGX
- CCMW

Entering angle:

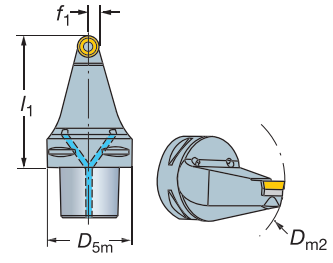
SCMCN
κ_r 50° (95°)



SRDCN



- RCMT, RCGX



Neutral style

κ _r	Main application	Alternative use	□	Ordering code	Dimensions, mm					Gauge inserts	Nm ³⁾
					D _{5m}	D _{m2} min	f ₁	l ₁	γ ¹⁾		
95°			12	C6-SCMCN-00090-12	63	100	90	0°	0°	CCMT 12 04 08	3.9

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

²⁾ λ = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C6-SCMCN-00090-12
N = Neutral

Main application	Alternative use	○	Ordering code	Dimensions, mm					Gauge inserts	Nm ³⁾	
				D _{5m}	D _{m2} min	f ₁	l ₁	γ ¹⁾			λ _s ²⁾
		10	C6-SRDCN-00100-10	63	110	10.6	100	0°	0°	RCMT 10 T3 M0	3.9
		16	C6-SRDCN-00100-16	63	110	14.1	100	0°	0°	RCMT 16 06 M0	6.4

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

²⁾ λ = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C6-SRDCN-00100-10
N = Neutral

Main spare parts

Insert size		Insert screw	Key (Torx Plus)	Shim	Shim screw	Key (Torx Plus)
□	○					
12		5513 020-18	5680 049-01 (15IP)	5322 232-02	5512 090-03	5680 049-01 (15IP)
	10	5513 020-10	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 049-01 (15IP)
	16	5513 020-26	5680 043-14 (20IP)	5322 110-03	5512 090-06	5680 043-14 (20IP)



A9



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G6



A2

Coromant Capto® cutting units

CoroTurn® 107 screw clamp design

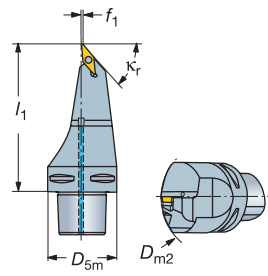


VBMT, VBGT
VCGX, VCEX,
VCGT

VBMW, VCMW

Entering angle:

SVMBL
 $\kappa_r 50^\circ (95^\circ)$



Left hand style

κ_r	Main application	Alternative use	16	Ordering code	Dimensions, mm						Gauge inserts	Nm ³⁾
					D_{5m}	D_{m2} min	f_1	l_1	γ^1	$\lambda_s^{2)}$		
95°				C5-SVMBL-00115-16	50	110	115	0°	0°	VBMT 16 04 08	3.9	
				C6-SVMBL-00130-16	63	110	130	0°	0°	VBMT 16 04 08	3.9	
				C6-SVMBL-33120-16	63	110	33.0	120	0°	0°	VBMT 16 04 08	3.9

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

²⁾ λ = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces C5-SVMBL-00115-16

L = Left hand

Main spare parts

Insert size



16	Insert screw	Key (Torx Plus)	Shim	Shim screw	Key (Torx Plus)
	5513 020-01	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (15IP)



A9



A290



G6

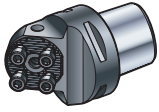


A2

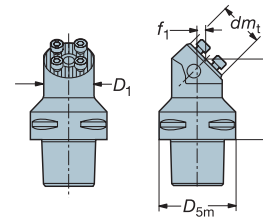
H 16

CoroTurn® SL

Coromant Capto® adapter



Coromant Capto® 45°



Right hand style shown

Ordering code	Coupling size		Dimensions, mm			
	dm_t	D_{5m}	D_1	f_1	l_1	l_2
C5-570-25-R/LX-045	25	50		8	34.5	76
C5-570-32-RX-045-L1	32	50	40	2	90	120
C5-570-32-R/LX-045	32	50		6	34	78
C6-570-25-R/LX-045	25	63		14.5	36	86
C6-570-32-RX-045-L1	32	63	45	2	100	138
C6-570-40-RX-045-L1	32	63	45	2	100	138
C6-570-32-R/LX-045	32	63		12.5	37.5	90

Ordering example: 2 pieces C5-570-25-RX-045
C5-570-25-LX-045
R = Right hand, L = Left hand

Main spare parts

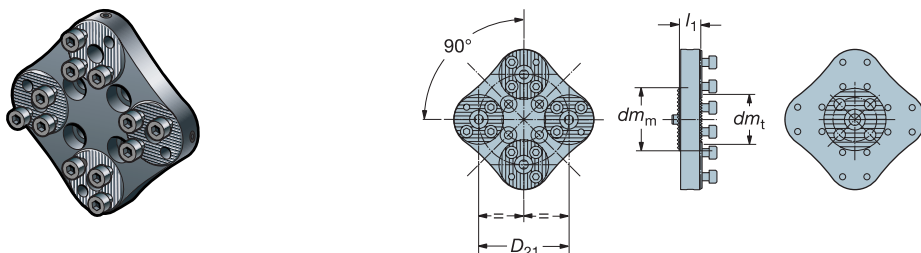
Coromant Capto®	Screw	Key (mm)	Plug	O-ring
Cx-570-25-R/LX-045	3212 010-258	174.1-864 (3.0)	5643 045-01	-
Cx-570-32-R/LX-045	3212 010-308	3021 010-040 (4.0)	5643 045-01	-
Cx-570-32-RX-045	3212 010-308	3021 010-040 (4.0)	5643 045-01	-
Cx-570-40-RX-045	3212 010-358	3021 010-050 (5.0)	5643 045-01	-



G6

CoroPlex™ SL mini-turret for cutting heads and blades with serrated coupling

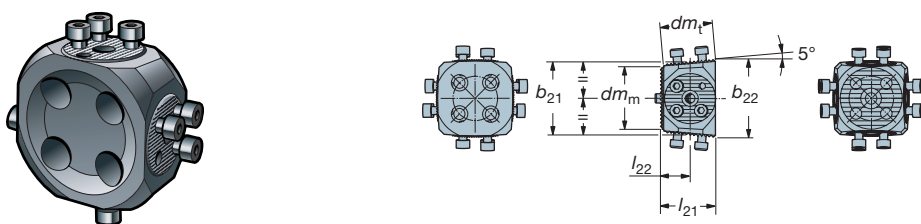
Axial mounting of heads and blades



		Dimensions, mm			
Coupling size	Ordering code	l_1	dm_t	dm_m	D_{21}
25	570-4-25-40-000-AX	12	25	40	50
32	570-4-32-40-000-AX	15	32	40	58

Ordering example: 2 pieces 570-4-25-40-000-AX

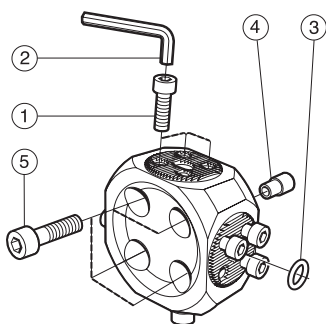
5° radial mounting of heads and blades



		Dimensions, mm					
Coupling size	Ordering code	b_{21}	l_{21}	b_{22}	l_{22}	dm_m	dm_t
25	570-4-25-40-050-RA	46	28	48.50	15	40	25
32	570-4-32-40-050-RA	46	34.50	49.25	18	40	32

Ordering example: 2 pieces 570-4-25-40-050-RA

Spare parts



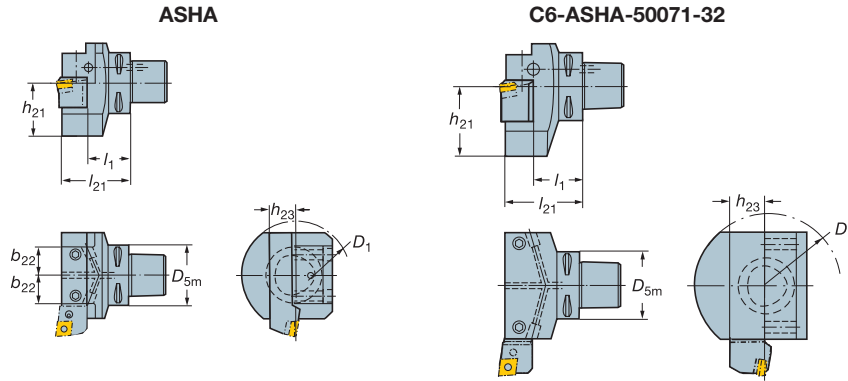
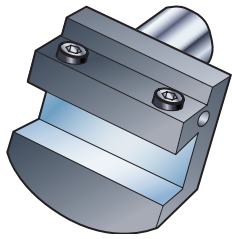
	1	2	3	4	5
	Screw	Key (mm)	O-ring	Coolant tube	Screw
570-4-25-40-000-AX	3212 010-257	174.1-864 (3.0)	–	5638 031-01	3212 010-358
570-4-32-40-000-AX	3212 010-307	3021 010-040 (4.0)	3671 010-113	5638 031-01	3212 010-358
570-4-25-40-050-RA	3212 010-257	174.1-864 (3.0)	–	5638 031-01	3212 010-358
570-4-32-40-050-RA	3212 010-307	3021 010-040 (4.0)	3671 010-113	5638 031-01	3212 010-358

Ordering example: 2 pieces 3212 010-257



Adaptors for shank tools

Radial mounting



Neutral style shown

Coupling size	Ordering code	Dimensions, mm								
		D_1	D_{5m}	b_{22}	h_{21}	h_{23}	l_1	l_{21}	l_{25}	α_{10}
C5	C5-ASHA-38058-20	90	50	23	38	20	38	58	1.72	
C6	C6-ASHA-38060-20	90	63	23	38	20	40	60	1.94	
	C6-ASHA-45071-25	110	63	30	45	25	45	71	2.6	
	C6-ASHA-50071-32	130	63	30	50	32	45	71	3.6	
C8	C8-ASHA-55085-32	142	80	40	55	32	53	85	4.95	
C8X	C8X-ASHA-55090-32	145	100	40	55	32	58	90	5.6	

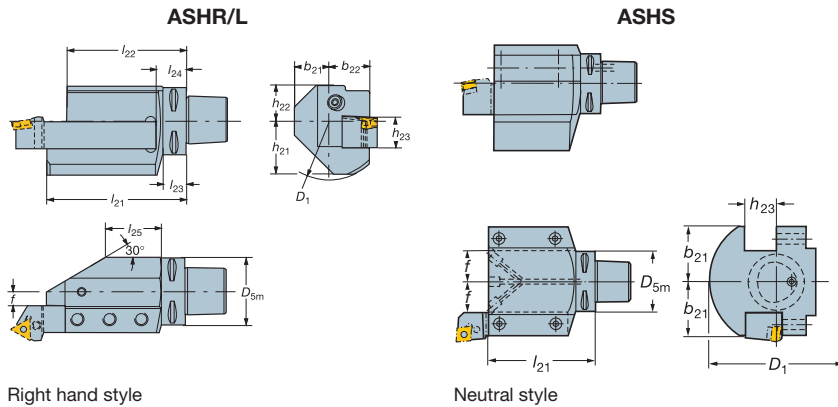
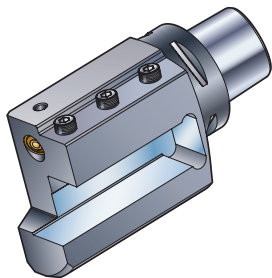
Ordering example: 2 pieces C5-ASHA-38058-20

Warning!

The adaptors are designed for automatic tool change.

Make sure that there is no risk of interference in magazine and tool changing cycle.

Axial mounting



Right hand style

Neutral style

Coupling size	Ordering code	Dimensions, mm												
		D_1	D_{5m}	b_{21}	b_{22}	f	l_{24}	h_{21}	h_{22}	h_{23}	l_{21}	l_{22}	l_{23}	α_{10}
C5	C5-ASHR/L-30098-20	90	50	29	30	10	23	41	33	20	98	88	20	2.5
C6	C6-ASHR/L-30100-20	90	63	29	30	10	25	41	33	20	100	90	22	2.53
	C6-ASHR/L-38130-25	110	63	32	38	13	28	50	33	25	130	112	22	3.42
	C6-ASHS-58115-32	140	63	58		33				32	115		22	7.26
C8	C8-ASHR/L-40140-32	110	80	40	40	8	35	55	30	32	140	130	30	5.1
C8X	C8X-ASHR/L-50143-32	145	100	50	50	18	38	55	30	32	143	133	33	7.3

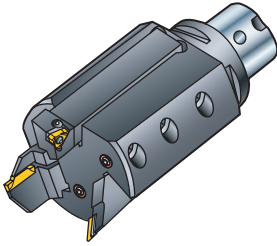
Ordering example: 2 pieces C5-ASHR-30098-20
C5-ASHL-30098-20

R = Right hand, L = Left hand

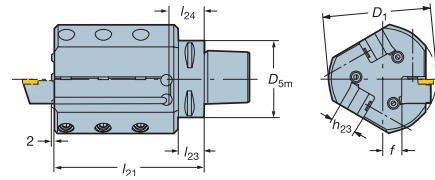


Mini-turret for shank tools

Axial mounting



ASHR/L3



Right hand style shown

Coupling size	Ordering code	Dimensions, mm											
		D_1	D_{5m}	b_{21}	b_{22}	f	l_{24}	h_{21}	h_{22}	h_{23}	l_{21}	l_{22}	l_{23}
C5	C5-ASHR/L3-36123-20	90	50			16	26			20	123	20	3.44
C6	C6-ASHR/L3-36125-20	90	63			16	28			20	125	22	3.8
C8	C8-ASHR/L3-45150-32	120	80			20	36			32	150	30	7.1

Ordering example: 2 pieces C5-ASHR3-36123-20
C5-ASHL3-36123-20
R = Right hand, L = Left hand

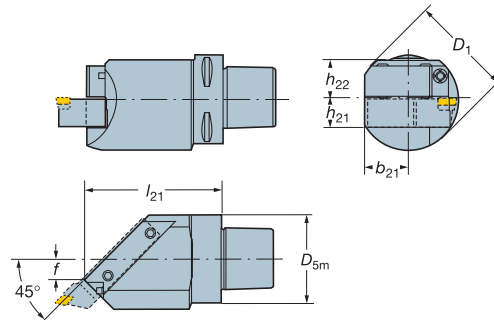
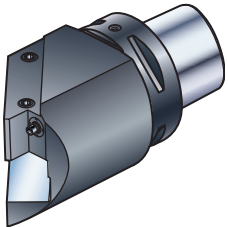
Warning!

The adaptors are designed for automatic tool change.

Make sure that there is no risk of interference in magazine and tool changing cycle.

Adaptors for shank tools

Angular mounting



Normal use is a left hand cutting tool in a right hand adaptor

Right hand style shown

Coupling size	Ordering code	Dimensions, mm					
		D_{5m}	D_1	h_{21}	h_{22}	l_{21}	R_{MG}
C5	C5-ASHR/L45-36097-20	50	72	20	26	97	1.7
C6	C6-ASHR/L45-36099-20	63	72	20	28	99	2.15
C8	C8-ASHR/L45-50135-32	80	140	32	40	135	6.5

Ordering example: 2 pieces C5-ASHR45-36097-20
C5-ASHL45-36097-20
R = Right hand, L = Left hand

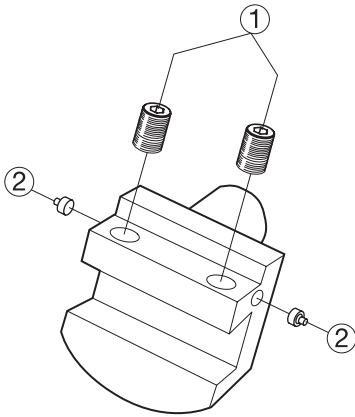


Adaptor for CoroCut® and T-Max Q-Cut® parting blades See page B29



Spare parts

Radial mounting

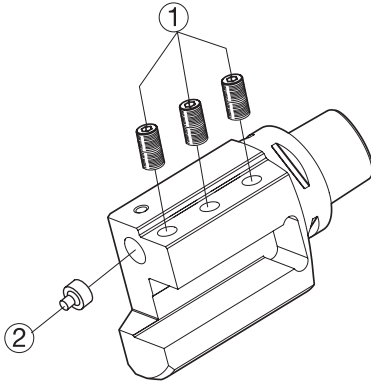


	Screw	Coolant nozzle
C5-ASHA-38058-20	3214 020-461	5691 029-09
C6-ASHA-38060-20	3214 020-411	5691 029-09
C6-ASHA-45071-25	3214 040-462	5691 029-02
C6-ASHA-50071-32	3214 040-462	5691 029-02
C8-ASHA-55085-32	3214 020-512	5691 029-09
C8X-ASHA-55090-32	3214 020-512	5691 029-09

Ordering example: 10 pieces 3214 020-461

Axial mounting

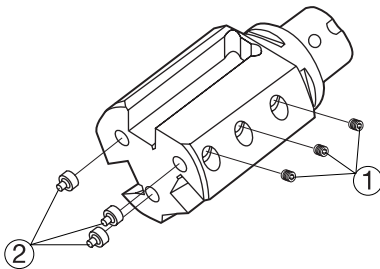
Cx-ASHA



	Screw	Coolant nozzle
C5-ASHR/L-30098-20	3214 020-461	5691 029-10
C6-ASHR/L-30100-20	3214 020-411	5691 029-10
C6-ASHR/L-38130-25	3214 020-512	5691 029-03
C6-ASHR/L-40140-32	3214 020-512	5691 029-10
C8X-ASHR/L-50143-32	3214 020-512	5691 029-10

Ordering example: 10 pieces 3214 020-461

Cx-ASHR3

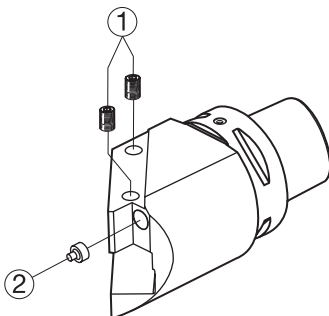


	Screw	Coolant nozzle
C5-ASHR/L3-36123-20	3214 020-512	5691 029-02
C6-ASHR/L3-36125-20	3214 020-512	5691 029-02
C8-ASHR/L3-40140-32	3214 020-512	5691 029-10

Ordering example: 10 pieces 3214 020-512

Angular mounting

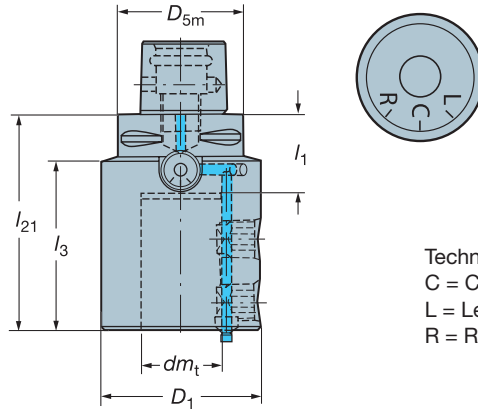
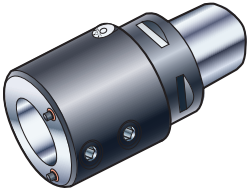
Cx-ASHR45



	Screw	Coolant nozzle
C5-ASHR/L45-36097-20	3214 020-461	5691 029-09
C6-ASHR/L45-36099-20	3214 020-411	5691 029-09
C8-ASHR/L45-50135-32	3214 020-512	5691 029-09

Ordering example: 10 pieces 3214 020-461

Boring bar adaptors for Multi-Task machining



Technical information:

C = Coolant goes straight through the centre

L = Left coolant nozzle will get coolant

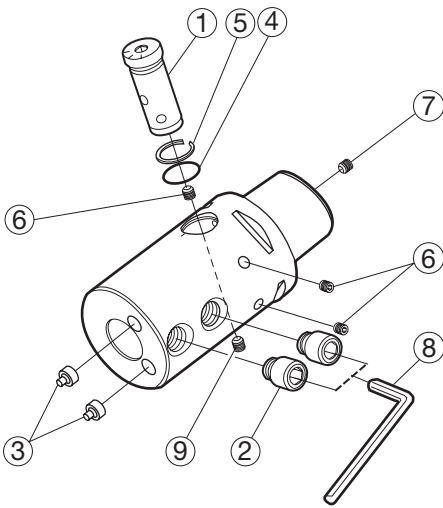
R = Right coolant nozzle will get coolant

l_1 = programming length

Coupling size	Ordering code	Dimensions, mm							$\frac{m}{kg}$
		D_1	D_{5m}	dm_t	l_1	l_{21}	l_3		
C5	C5-131-00100-25	63	50	25	43	100	80	0	
C6	C6-131-00098-25	63	63	25	41	98		2.38	
	C6-131-00112-40	80	63	40	41	112	90	3.50	
C8	C8-131-00098-25	63	80	25	41	98	50	3.42	
	C8-131-00112-40	80	80	40	41	112		4.25	

Ordering example: 2 pieces C5-131-00100-25

Spare parts



	1	2	3	4	5
	Valve bolt	Screw	Coolant nozzle	O-ring	Circlip
C5-131-00100-25	5692 035-03	5514 012-02	5691 029-09	5641 005-06	3421 105-020
C6-131-00098-25	5692 035-01	5514 012-02	5691 029-09	5641 005-06	3421 105-020
C6-131-00112-40	5692 035-01	5514 012-01	5691 029-10	5641 005-06	3421 105-020
C8-131-00098-25	5692 035-02	5514 012-02	5691 029-09	5641 005-06	3421 105-020
C8-131-00112-40	5692 035-02	5514 012-01	5691 029-10	5641 005-06	3421 105-020
	6	7	8	9	
	Screw	Spring plunger	Key	Screw	
C5-131-00100-25	3214 010-355 (DIN913-M6x6-45H)	5514 064-01	3021 010-080 (DIN911-8)	3214 010-406	
C6-131-00098-25	3214 010-355 (DIN913-M6x6-45H)	5514 064-01	3021 010-080 (DIN911-8)	3214 010-406	
C6-131-00112-40	3214 010-355 (DIN913-M6x6-45H)	5514 064-01	3021 010-100 (DIN911-10)	3214 010-406	
C8-131-00098-25	3214 010-355 (DIN913-M6x6-45H)	5514 064-01	3021 010-080 (DIN911-8)	3214 010-406	
C8-131-00112-40	3214 010-355 (DIN913-M6x6-45H)	5514 064-01	3021 010-100 (DIN911-10)	3214 010-406	

Ordering example: 2 pieces 5692 035-03



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