CoroTurn® SL

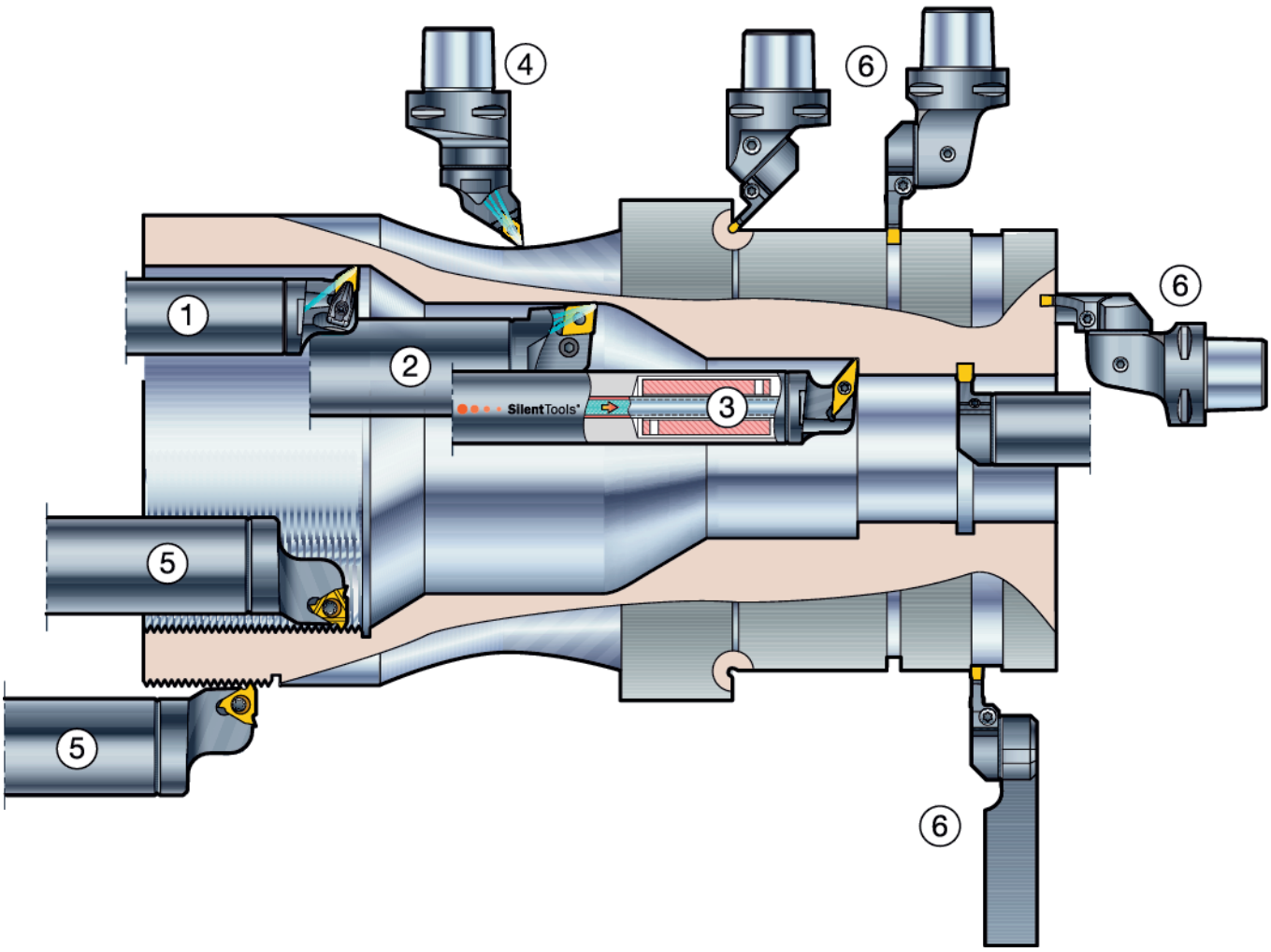
Applications

Products

Accessories

Spare parts

CoroTurn® SL – flexible system



General turning

1. CoroTurn® RC rigid clamp
   See page I5.
2. CoroTurn® HP lever clamp design for high pressure coolant
   See page I5.
3. CoroTurn® 107/111 screw clamp design
   See page I6.
4. CoroTurn® TR screw clamp design
   See page I7.

Threading

5. CoroThread® 266
   T-Max U-Lock®
   See page I8.

Parting & grooving

6. CoroCut® 1-2
   CoroCut® 3
   CoroCut® XS
   T-Max Q-Cut®
   See page I8.

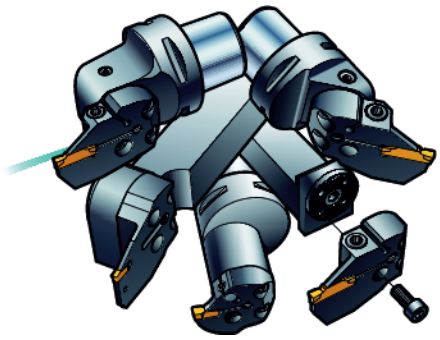
Parting and pocketing

7. CoroCut® 1-2
   CoroTurn® SL70
   Round inserts
   See page I98.

CoroTurn® SL boring bars

The CoroTurn® SL boring bar assortment consists of:
- Both Coromant Capto® and conventional shank design
- Solid steel bars, dampened Silent Tools and dampened carbide
- All types of bars have through coolant supply

See page I9.



CoroTurn® SL adapters

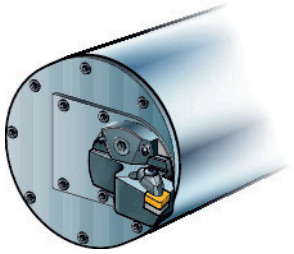
Build your tool for parting, grooving and facegrooving

See page I10.

CoroTurn® SL quick change adapters

For bores from 40 mm (1.575 inch) and overhangs up to 14 x bar diameter

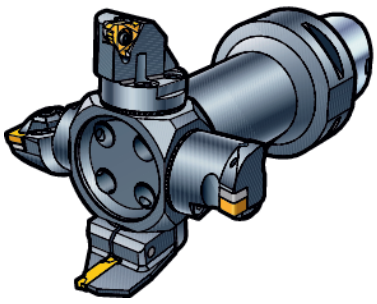
See page I71.



CoroTurn® SL quick change boring bars

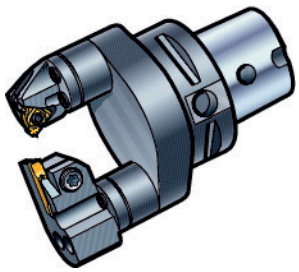
For vibration-free internal machining in bores from 100 mm (3.937 inch) and overhangs up to 14 x bar diameter

See page I77.



Increased productivity in multi-task machining

The CoroPlex™ SL mini-turret, using standard CoroTurn® SL cutting heads, blades and adapters, lets you build customized tools for Multi-Task machines. See chapter H.



CoroTurn® SL, perfect for customized solutions

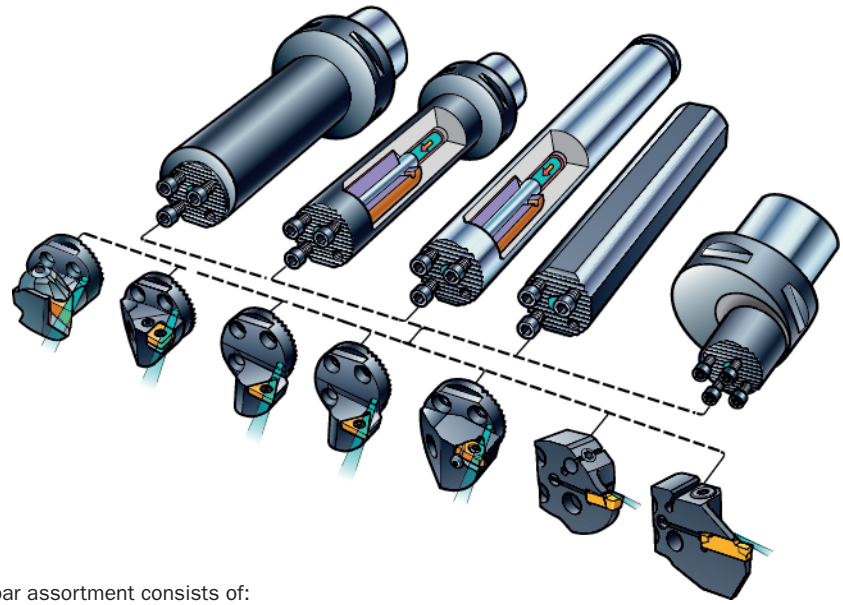
Due to its flexibility, a standard CoroTurn® SL cutting head can be used in conjunction with specially made adapters to build a customized solution. See chapter I.

CoroTurn® SL

Boring bars with exchangeable cutting heads

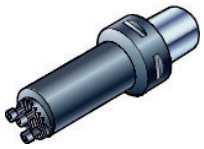
For different types of internal applications

Build the most versatile range of cutting tools from the smallest and most manageable inventory.



Choice of bar

The CoroTurn® SL boring bar assortment consists of:
- Both Coromant Capto® and conventional shank design
- Solid steel bars, dampened Silent Tools and dampened carbide
- All types of bars have through coolant supply



Frontal reduction of large CoroTurn® SL bars

To improve the performance of bars of between 50 and 60 mm (2.000-2.500 inch) diameter the design has a reduced front coupling down to coupling size 40 mm giving:
- Less vibration due to lighter front end
  Better chip evacuation due to more space around the cutting head
  Better economy with the use of smaller cutting heads and a wide range of heads to choose from

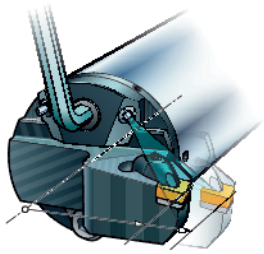
A flexible modular system

By using a CoroTurn® SL bar various types of cutting heads can be used:

For general turning:
- CoroTurn® RC
- CoroTurn® HP (high pressure)
- T-Max P ® lever clamp
- CoroTurn® 107
- CoroTurn® 111
- CoroTurn® TR

For grooving:
- CoroCut® 1-2
- CoroCut® 3
- T-Max Q-Cut®
- CoroCut® XS

For threading:
- CoroThread® 266 for internal and external machining
- T-Max U-Lock®
- Twin Lock® for oil part threading



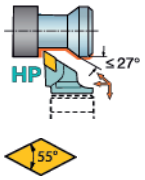
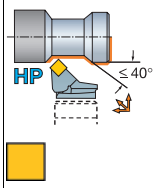
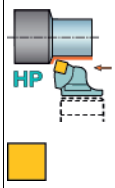
CoroTurn® SL quick change

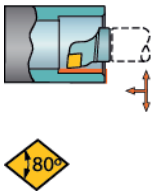
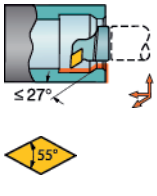
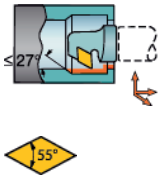
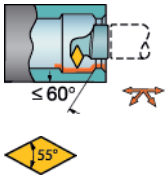
- Cutting heads with integrated tip seat
- Adapter for CoroTurn® SL cutting heads
- Adapter for shank tools
- Adapter for the old 580-system

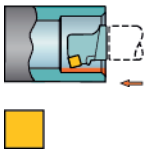
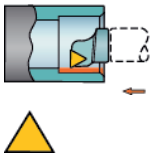
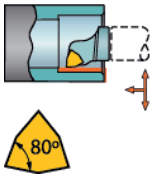
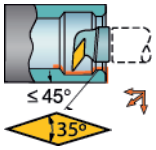
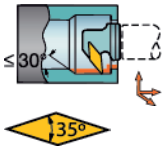
For more information, see page I77

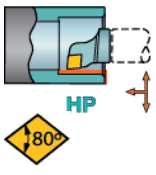
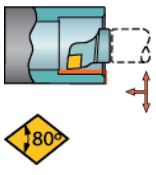
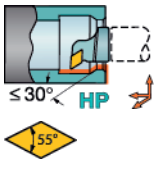
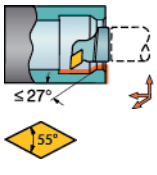
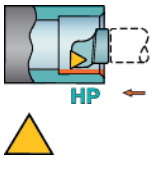
SANDVIK Coromant

Cutting heads with CoroTurn® SL coupling for negative basic-shape inserts

T-Max P lever design External	Entering angle (Lead angle) κ_r 93° (-3°)	κ_r 45° (45°)	κ_r 75° (15°)
			
	PDJNR/L-HP	**PSSNR/L-HP-X**	**PSRNR/L- HP**
Insert size, mm (*iC*, inch)	15 (1/2)	12 (1/2)	12 (1/2)
Coupling size	32-40	40	40
Page	I12	I13	I13

CoroTurn® RC rigid clamp design Internal	Entering angle (Lead angle) κ_r 95° (-5°)	κ_r 93° (-3°)	Back boring κ_r 93° (-3°)	κ_r 62.5° (27.5°)
				
	570-DCLNR/L	**570-DDUNR/L**	**570-DDUNR/L-X**	**570-DDXNR/L**
Insert size, mm (*iC*, inch)	12-19 (3/8-1/2)	11-15 (3/8-1/2)	11-15 (3/8-1/2)	11-15 (3/8-1/2)
Coupling size	32-40	32-40	32-40	32-40
Page	I21	I22	I22	I22

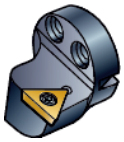
Entering angle (Lead angle) κ_r 75° (15°)	κ_r 91° (-1°)	κ_r 95° (-5°)	κ_r 93° (-3°)	Back boring κ_r 93° (-3°)
				
570 - DSKNR/L	**570-DTFNR/L**	**570-DWLNR/L**	**DVUNR/L**	**DVUNR/L - X**
15 (5/8)	16 (3/8)	06-08 (3/8-1/2)	16 (3/8)	16 (3/8)
40	32-40	32-40	40	40
I23	I24	I24	I25	I25

T-Max P lever design Internal	Entering angle (Lead angle) κ_r 95° (-5°)	κ_r 95° (-5°)	κ_r 93° (-3°)	κ_r 93° (-3°)	κ_r 91° (-1°)
					
	PCLNR/L-HP	**R/L571.31C**	**PDUNR/L-HP**	**R/L571.35C**	**PTFNR/L-HP**
Insert size, mm (*iC*, inch)	12-16 (1/2-3/8)	12-16 (1/2-5/8)	11-15 (3/8-1/2)	15 (1/2)	16 (3/8)
Coupling size	32-40	32-60	32-40	40-60	32-40
Page	I16	I26	I16	I26	I17

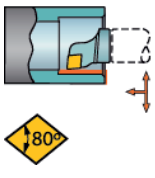
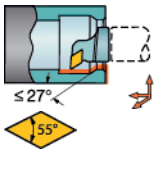
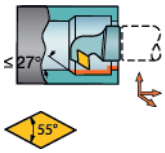
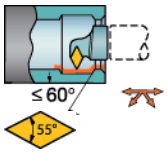
Cutting heads with CoroTurn® SL coupling for positive basic shape inserts

CoroTurn® 107 screw clamp design

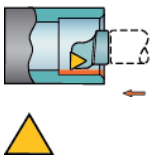
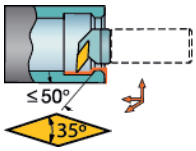
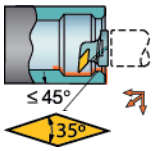
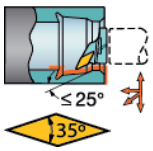
Internal



Entering angle (Lead angle)

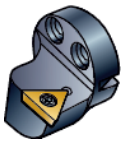
	κ_r 95° (-5°)	κ_r 93° (-3°)	Back boring κ_r 93° (-3°)	κ_r 62.5° (27.5°)
				
	570-SCLCR/L	**570-SDUCR/L**	**570-SDUCR/L-X**	**570-SDXCR/L**
Insert size, mm (*iC*, inch)	06-09 (1/4-3/8)	07-11 (1/4-3/8)	07-11 (1/4-3/8)	07-11 (1/4-3/8)
Coupling size	16-25	16-40	16-40	16-40
Page	I27	I28	I28	I28

Entering angle (Lead angle)

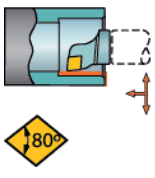
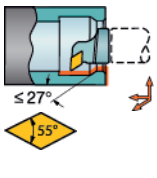
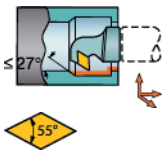
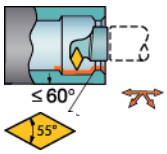
	κ_r 91° (-1°)	κ_r 93° (-3°)	κ_r 95° (-5°)	κ_r 90°/0°
				
	570-STFCR/L	**570C-SVUBR/L**	**570-SVLBR/L**	**570-SVPBR/L**
Insert size, mm (*iC*, inch)	09-16 (7/32-3/8)	11 (1/4)	16 (3/8)	16 (3/8)
Coupling size	16-40	20	25-40	32-40
Page	I29	I30	I30	I30

CoroTurn® 111/107 screw clamp design

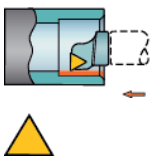
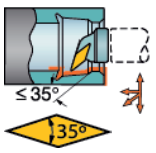
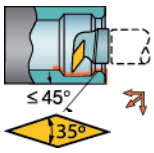
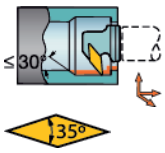
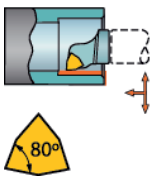
Internal



Entering angle (Lead angle)

	κ_r 95° (-5°)	κ_r 93° (-3°)	Back boring κ_r 93° (-3°)	κ_r 62.5° (27.5°)
				
	570-SCLPR/L	**570-SDUPR/L**	**570-SDUPR/L-X**	**570-SDXPR/L**
Insert size, mm (*iC*, inch)	06 (1/4)	07-11 (1/4-3/8)	07 (1/4)	07 (1/4)
Coupling size	16	16-25	16-25	16-25
Page	I32	I33	I33	I33

Entering angle (Lead angle)

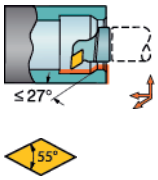
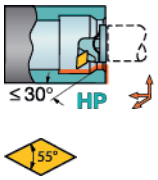
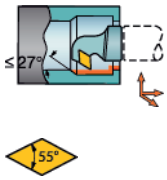
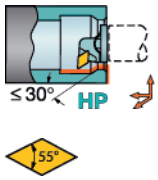
	κ_r 91° (-1°)	κ_r 107.5° (-17.5°)	κ_r 93° (-3°)	Back boring κ_r 93° (-3°)	κ_r 95° (-5°)
					
	570-STFPR/L	CoroTurn® 107 **570-SVQCR/L**	CoroTurn® 107 **570-SVUCR/L**	**570-SVUCR/L -X**	**570-SWLPR/L**
Insert size, mm (*iC*, inch)	11 (1/4)	11 (1/4)	11 (1/4)	11 (1/4)	04 (1/4)
Coupling size	16-25	20-25	20-25	20-25	16
Page	I34	I31	I31	I31	I35

Cutting heads with CoroTurn® SL coupling for positive basic shape inserts

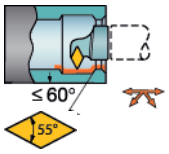
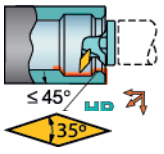
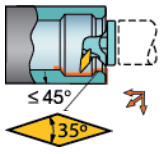
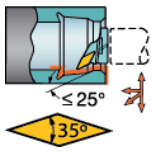
CoroTurn® TR screw clamp design

Internal machining

Entering angle (Lead angle)

	κ_r 93° (-3°)	κ_r 93° (-3°)	Back boring κ_r 93° (-3°)	κ_r 62.5° (27.5°)
				
	TR-SL-D13UCR/L	**TR-SL-D13UCR/L-HP**	**TR-SL-D13UCR/L-X**	**TR-SL-D13XCR-HP**
Insert size	13	13	13	13
Coupling size	25-40	32-40	25-40	32-40
Page	I36	I18	I36	I19

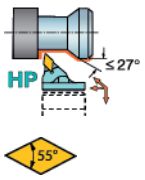
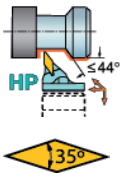
Entering angle (Lead angle)

	κ_r 62.5° (27.5°)	κ_r 95° (-5°)	κ_r 95° (-5°)	κ_r 90°/0°
				
	TR-SL-D13XCR	**TR-SL-V13LBR/L-HP**	**TR-SL-V13LBR/L**	**TR-SL-V13PBR/L**
Insert size	13	13	13	13
Coupling size	25-40	32-40	25-40	25-40
Page	I36	I20	I37	I37

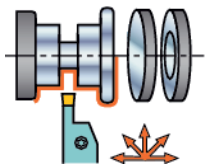
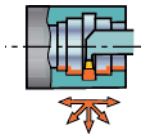
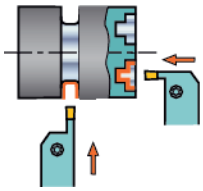
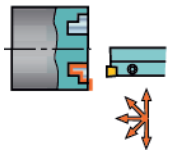
CoroTurn® TR screw clamp design

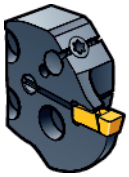
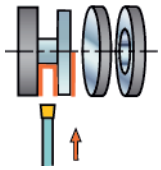
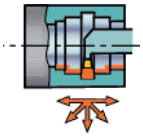
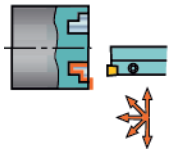
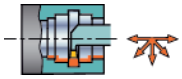
External machining

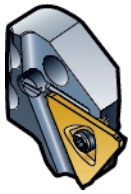
Entering angle (Lead angle)

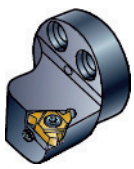
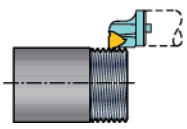
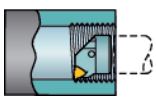
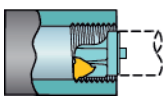
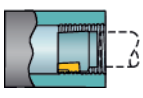
	κ_r 93° (-3°)	κ_r 93° (-3°)
		
	TR-SL-D13JCR/L-HP-X	**TR-SL-V13JBR/L-HP-X**
Insert size	13	13
Coupling size	32-40	32-40
Page	I14	I15

Cutting blades with CoroTurn® SL coupling for parting and grooving

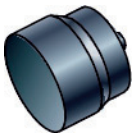
CoroCut® 1-2 SL cutting blades	Grooving, parting off, profiling and turning / Internal grooving	Shallow grooving and face grooving	Face grooving
	 		
	570-R/L 123-B	**570-R/L 123-C**	**570-R/L 123-A/B**
Insert width, mm (inch)	1.50-7.14 (.059-.281)	3.00-7.14 (.118-.281)	2.50-7.14 (.098-.281)
Coupling size	25-40	25-40	32
Page	I42	I43	I44

T-Max Q-Cut® SL cutting blades	Grooving and parting	Internal grooving and profiling	Face grooving	Grooving and face grooving
	For 151.3 inserts	For 151.3 inserts	For 151.3 inserts	For 151.3 inserts
	 			
	570-R/L151.21	**570-R/L151.3**	**570-R/L151.3-A/B**	**R/LAG551.31**
Insert width, mm (inch)	2.00-6.00 (.079-.236)	2.00-7.92 (.079-.312)	3.00-5.56 (.118-.219)	1.85-8.00
Coupling size	25-40	25-40	32	16-40
Page	I47	I48	I49	I50

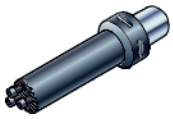
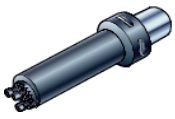
CoroCut® 3 SL cutting blades	Parting off and grooving	**CoroCut® XS SL cutting blades**	Small part precision
			
	R/L 123 T/U		**R/L SMAL**
Insert width	1.00-2.00	Insert size	3
Coupling size	25-40	Coupling size	25-32
Page	I46	Page	I51

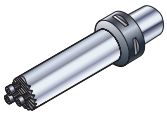
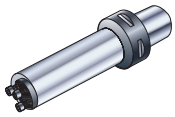
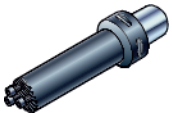
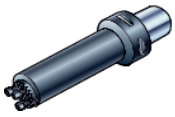
Cutting heads for threading	**CoroThread® 266**		**T-Max® U-Lock**	**T-Max Twin-Lock®**
	External threading	Internal threading	Internal threading	For internal oil pipe threading
	 			
	SL-266R/LFG	**SL-266R/LKF**	**R/L566.0KFC**	**570-R566.39KF**
Insert size, mm (*iC*, inch)	(16) 3/8	16, 22, 27 (3/8, 1/2, 5/8)	11 (3/4)	24 (.945)
Coupling size	20-40	25-40	16-20	40
Page	I52	I53	I54	I54

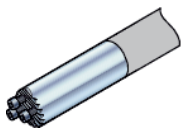
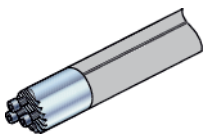
Blanks for cutting heads with CoroTurn® SL coupling

	The rear portion of the blank which forms the coupling to the bar is finish machined and requires no further machining.
	R/L570
Coupling size	16-60
Page	I55

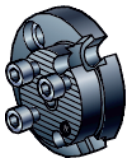
CoroTurn® SL boring bars and adapters

Coromant Capto® bars	Steel boring bar				Dampened boring bar	
					 Silent Tools®	 Silent Tools®
	570-2C	**570-2C**	**570-2C**	**570-2C**	**570-3C**	**570-3C**
Bar diameter, mm (inch)	16-40 (.630-1.575)	50-60 (1.969-2.362)	16-40 (.630-1.575)	50-60 (1.969-2.362)	16-40 (.630-1.575)	50-60 (1.969-2.362)
Coupling size	16-40	40	16-40	40	16-40	40
Page	I56	I56	I60	I60	I57	I57

Coromant Capto® bars	Dampened carbide reinforced boring bar	Carbide boring bar	Dampened boring bar dedicated for threading		Cylindrical boring bar dedicated for threading	
	 Silent Tools®	 Silent Tools®	 Silent Tools®	 Silent Tools®	 Silent Tools®	 Silent Tools®
	Cx-SL3C..CR	**Cx-SL3C..CR**	**Cx-570-4C**	**Cx-570-4C**	**570-4C**	**570-4C**
Bar diameter, mm (inch)	32-50 (1.260-1.968)	60-80 (2.362-3.150)	40 (1.575)	50-60 (1.968-2.362)	40 (1.575)	50-60 (1.968-2.362)
Coupling size	25-40	40	40	40	40	40
Page	I59	I59	I58	I58	I64	I64

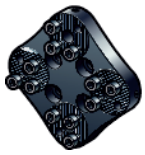
Round shank bars	Steel boring bar		Dampened boring bar		Dampened carbide reinforced boring bar	Carbide boring bar
	Overhang 4 x d		Overhang 7 – 10 x d		Overhang 10 x d	Overhang 6 x d
			 Silent Tools®		 Silent Tools®	
	A570-2C/ 570-2C	**A570-2C/ 570-2C**	**A570-3C/570-3C**	**A570-3C/570-3C**	**A570-3C/570-3C**	**A570-2C/570-2C**
Bar diameter, mm (inch)	16-40 (.625-1.500)	50-60 (1.750-2.500)	16-40 (.625-1.500)	50-60 (1.750-2.500)	16-20 (.625-.750)	16-25 (.625-1.000)
Coupling size	16-40	40	16-40	40	16-20	16-25
Page	I61	I61	I62	I62	I66	I65

CoroTurn® SL reduction adapter



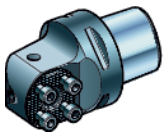
	570
Coupling size	
Machine side	40-60
Tool side	32-40
Page	I67

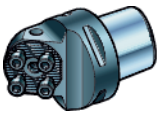
CoroPlex™ SL mini-turret

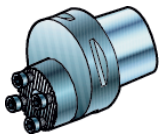


	Axial mounting	5° radial mounting
	570-AX	570-RA
Coupling size		
Machine side	40	40
Tool side	25-32	25-32
Page	H14	H14

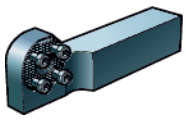
CoroTurn® SL adapters for external machining

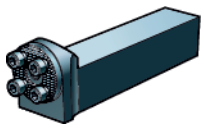






Coromant Capto® adapters	0°	45°	90°
	Cx-570-R/LF	Cx-570-R/LX-045	Cx-570-R/LG/-NG
Coromant Capto® size	C3-C8	C5-C6	C3-C8
Coupling size	25-40	25-32	32-40
Page	I68	I68	I68

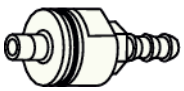


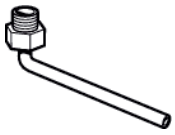


Shank adapter	0°	90°
	570-25-R/LF	570-25-NG
Shank dim., mm	2020-3232	2020-3232
Shank size, inch	.750-1.250	.750-1.250
Coupling size	25-40	25-40
Page	I70	I70

Coromant Capto® Short	0°	45°
	Cx-570-R/LF-T	Cx-570-R/LX-045-T
Coromant Capto® size	C3-C5	C4
Coupling size	25-40	32
Page	I69	I69

Accessories





Accessories for cutting fluid supply	Coolant nozzle	Coolant connector	Coolant tube
	For Coromant Capto® cutting units	For boring bars	For SL cutting blades
Page	A308	A308	I118

CoroTurn® SL

Exchangeable cutting heads

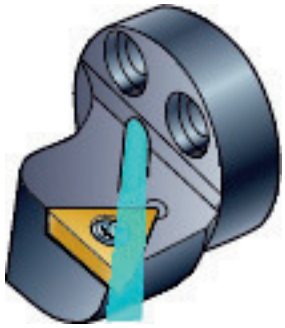
Internal and external operations for general turning

CoroTurn® RC

Rigid clamp design – for internal machinig
See page I22.

CoroTurn® 107/111

Screw clamp design – for internal machining
See page I27.

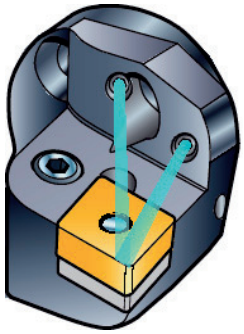


CoroTurn® TR SL

CoroTurn TR SL – for internal and external machining
See page I14.

T-Max® P lever clamp

Lever clamp design available with HP coolant – for internal and external machining
See page I12.



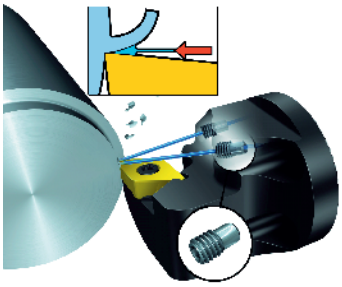
CoroTurn® HP high pressure coolant

Available in CoroTurn® TR and T-Max P cutting heads

Power in precision

Coolant jets directed to an exact point on the insert edge have the biggest effect on productivity and performance. The jet produces a hydraulic wedge to lift the chip, reduce temperature and improve chip control.

See page H21.



Pre-defined target areas on the insert face

High precision jet nozzles

SL cutting heads with CoroTurn® HP

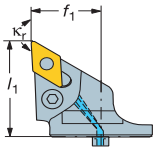
T-Max P lever clamp design

For external turning

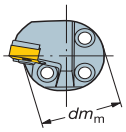
With high pressure coolant

PDJNR/L-HP

Entering angle: κ_r 93°
Lead angle: -3°

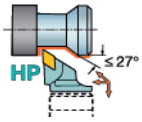


DNMM, DNGP, DNMX
DNMG
DNMA, DNGA



With internal high pressure (HP) coolant supply

Right hand style shown

Main application	⇿	*iC*	**Ordering code**	Coupling size *dm*m	Dimensions, millimeter, inch (mm, in.) *f*1 mm	*f*1 in.	*l*1 mm	*l*1 in.	γ1)	λs2)	Gauge inserts ISO	ANSI	Nm3)
	15	1/2	**SL-PDJNR/L-32-15HP**	32	27.0	1.063	40.0	1.575	-6°	-7°	DNMG 15 06 08	DNMG 442	3.9
			SL-PDJNR/L-40-15HP	40	27.0	1.063	40.0	1.575	-6°	-7°	DNMG 15 06 08	DNMG 442	3.9

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

R = Right hand, L = Left hand

Main spare parts

Insert size ⇿	*iC*	Coupling size, *dm*m	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia mm.)	Shim pin	Shim pin punch	Locating tube
15	1/2	32-40	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5691 026-03 (1 mm)	174.3-861	174.3-871	5638 031-01

 A9
 I110
 A2
 I56
 J2

SL cutting heads with CoroTurn® HP

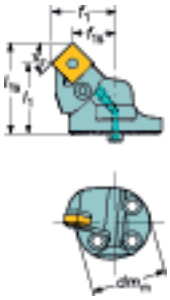
T-Max P lever clamp design

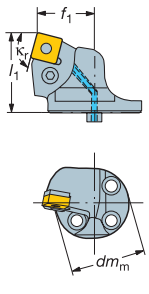
For external turning

With high pressure coolant

	PSSNR/L-HP-X	PSRNR/L-HP
Entering angle:	κ_r 45°	κ_r 75°
Lead angle:	45°	15°

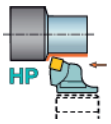
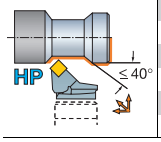
SNMM
SNMG
SNMA, SNGA





With internal high pressure (HP) coolant supply

Right hand style shown

Main application	□	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	f_{1s} mm	f_{1s} in.	l_1 mm	l_1 in.	l_{1s} mm	l_{1s} in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	12	1/2	**SL-PSRNR/L-40-12HP**	40	22.0	.866			35.0	1.378			-6°	-6°	SNMG 12 04 08	SNMG 432	3.9
	12	1/2	**SL-PSSNR/L-40-12HP-X**	40	27.0	1.063	18.2	.716	30.0	1.181	38.3	1.508	-8°	0°	SNMG 12 04 08	SNMG 432	3.9

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

R = Right hand, L = Left hand

Main spare parts

Insert size □	iC	Coupling size, dm_m	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia mm.)	Shim pin	Shim pin punch	Locating tube
12	1/2	40	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M	5691 026-03 (1.0)	174.3-861	174.3-871	5638 031-01

 A9
 I110
 A2
 I56
 J2

SL cutting heads with CoroTurn® HP

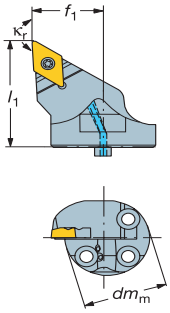
For external turning

CoroTurn® TR screw clamp design

TR-SL-D13JCR/L-HP-X

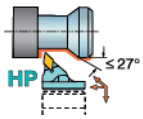
Entering angle: κ_r 93°
Lead angle: -3°

TR-DC



With internal high pressure (HP) coolant supply

Right hand style shown when nothing else is stated

Main application		Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	13	**TR-SL-D13JCR/L-32HP-X**	32	22.0	.866	40.0	1.575	0°	0°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13JCR/L-40HP-X	40	27.0	1.063	45.0	1.772	0°	0°	TR-DC1308	TR-DC1308	3.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size	Coupling size, dm_m	Insert screw	Key (Torx Plus/mm)	Torque wrench[1]	Nozzle (hole dia mm.)	Locating tube
13	32-40	5513 020-01	5680 049-01 (15IP)	5680 100-06	5691 026-03 (1.0)	5638 031-01

1) Accessories, must be ordered separately.

A9 I110 A2 I56 J2

SL cutting heads with CoroTurn® HP

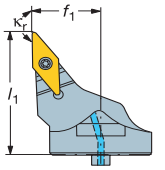
For external turning

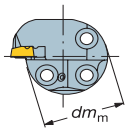
CoroTurn® TR screw clamp design

TR-SL-V13JBR/L-HP-X

Entering angle: κr 93°
Lead angle: -3°

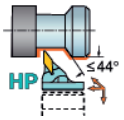
TR-VB





With internal high pressure (HP) coolant supply

Right hand style shown when nothing else is stated

Main application		Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	13	**TR-SL-V13JBR/L-32HP-X**	32	22.0	.866	42.0	1.654	0°	0°	TR-VB1308	TR-VB1308	2.0
		TR-SL-V13JBR/L-40HP-X	40	27.0	1.063	42.0	1.654	0°	0°	TR-VB1308	TR-VB1308	2.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size	Coupling size, dm_m	Insert screw	Key (Torx Plus)	Torque wrench[1]	Nozzle (hole dia mm.)	Locating tube
13	32-40	5513 020-64	5680 049-04 (10IP)	5680 100-05	5691 026-03 (1.0)	5638 031-01

1) Accessories, must be ordered separately.

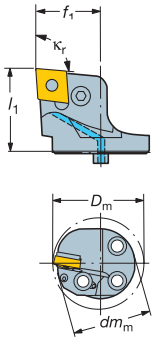
A9 I110 A2 I56 J2

SL cutting heads with CoroTurn® HP

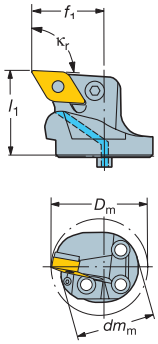
T-Max P lever clamp design

	PCLNR/L-HP	PDUNR/L-HP
Entering angle:	κ_r 95°	κ_r 93°
Lead angle:	-5°	-3°

CNMM, CNGP
CNMG
CNMA, CNGA

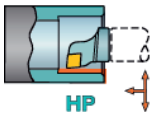


DNMM, DNGP, DNMX
DNMG
DNMA, DNGA

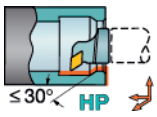


With internal high pressure (HP) coolant supply

Right hand style shown

Main application	□	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI
	09	3/8	SL-PCLNR/L-25-09HP-G[3]	25	34.0	1.339	19.0	.748	28.0	1.102	-6°	-10°	CNMG 09 03 08	CNMG 322
	12	1/2	SL-PCLNR/L-32-12HP	32	40.0	1.575	22.0	.866	32.0	1.260	-6°	-10°	CNMG 12 04 08	CNMG 432
			SL-PCLNR/L-40-12HP	40	50.0	1.968	27.0	1.063	35.0	1.378	-6°	-10°	CNMG 12 04 08	CNMG 432
	16	5/8	SL-PCLNR/L-40-16HP	40	56.0	2.205	27.0	1.063	42.0	1.654	-6°	-10°	CNMG 16 06 08	CNMG 542

HP

Main application	◇	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI
	11	3/8	SL-PDUNR/L-25-11HP-G[3]	25	38.0	1.496	21.0	.827	32.0	1.260	-6°	-10°	DNMG 11 04 08	DNMG 332
			SL-PDUNR/L-32-11HP	32	40.0	1.575	22.0	.866	32.0	1.260	-6°	-10°	DNMG 11 04 08	DNMG 332
	15	1/2	SL-PDUNR/L-40-15HP	40	56.0	2.205	30.0	1.181	36.0	1.417	-6°	-11°	DNMG 15 06 08	DNMG 442

≤30° HP

1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.
3) -G indicates altered main dimensions

R = Right hand, L = Left hand

Main spare parts

Insert size CNM. □	iC	DNM. ◇	iC	Coupling size, dm_m	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia mm.)	Locating tube
09	3/8			25	174.3-845-1	174.3-829	170.3-864 (1.98)	-	5691 026-13 (1.0)	5552 058-02
12	1/2			32	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M	5691 026-03 (1.0)	5638 031-01
12	1/2			40	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M	5691 026-03 (1.0)	5638 031-01
16	5/8			40	438.3-840	438.8-831	174.1-864 (3.0)	171.31-852	5691 026-03 (1.0)	5638 031-01
		11	3/8	25	5432 015-021	438.3-830	174.1-870 (1.98)	-	5691 026-13 (1.0)	5552 058-02
		11	3/8	32	5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01	5691 026-03 (1.0)	5638 031-01
		15	1/2	40	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5691 026-03 (1.0)	5638 031-01

 A9
 I107
 A2
 I56
 J2

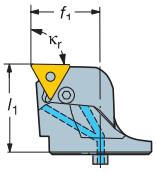
SL cutting heads with CoroTurn® HP

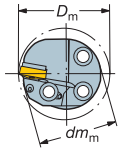
T-Max P lever clamping

PTFNR/L-HP

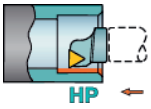
Entering angle: κ_r 91°
Lead angle: -1°

TNMM, TNMX
TNMG
TNMA, TNGA





With internal high pressure (HP) coolant supply
Right hand style shown when nothing else is stated

Main application	△	*iC*	Ordering code	Coupling size *dm*m	Dimensions, millimeter, inch (mm, in.)								Gauge inserts	
					*D*m min mm	*D*m min in.	*f*1 mm	*f*1 in.	*l*1 mm	*l*1 in.	γ1)	λs2)	ISO	ANSI
	16	3/8	**SL-PTFNR/L-32-16HP**	32	40.0	1.575	22.0	.866	35.0	1.378	-6°	-8°	TNMG 16 04 08	TNMG 332
			SL-PTFNR/L-40-16HP	40	50.0	1.968	27.0	1.063	35.0	1.378	-6°	-10°	TNMG 16 04 08	TNMG 332

1) γ = Rake angle.
2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size △	*iC*	Coupling size, *dm*m	Lever	Screw	Key (mm)	Shim	Nozzle (hole dia mm.)	Locating tube
16	3/8	32-40	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M	5691 026-03 (1.0)	5638 031-01


A9

I107

A2

I56

J2

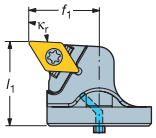
SL cutting heads with CoroTurn® HP

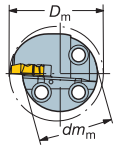
CoroTurn® TR screw clamp design

TR-SL-D13UCR/L-HP

Entering angle: κ_r 93°
Lead angle: -3°

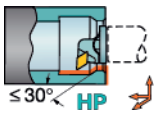
TR-DC





With internal high pressure (HP) coolant supply

Right hand style shown when nothing else is stated

Main application		Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
 ≤30° HP	13	**TR-SL-D13UCR/L-32HP**	32	40.0	1.575	22.0	.866	38.0	1.496	0°	-5°	TR-DC1308	TR-DC1308	2.0
		TR-SL-D13UCR/L-40HP	40	50.0	1.968	27.0	1.063	38.0	1.496	0°	-3°	TR-DC1308	TR-DC1308	2.0

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size	Coupling size, dm_m	Insert screw	Key (Torx Plus/mm)	Torque wrench[1]	Nozzle (hole dia mm.)	Locating tube
13	32-40	5513 020-01	5680 049-01 (15IP)	5680 100-06	5691 026-03 (1.0)	5638 031-01

1) Accessories, must be ordered separately.

 A9
 I110
 A2
 I56
 J2

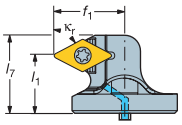
SL cutting heads with CoroTurn® HP

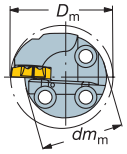
CoroTurn® TR screw clamp design

TR-SL-D13XCR/L

Entering angle: κ_r 62.5°
Lead angle: 27.5°

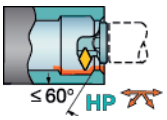
TR-DC





With internal high pressure (HP) coolant supply

Right hand style shown when nothing else is stated

Main application	▱	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	l_7 mm	l_7 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	13	**TR-SL-D13XCR-32HP**	32	45.0	1.772	27.0	1.063	27.0	1.063	34.0	1.339	0°	-5°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13XCR-40HP	40	50.0	1.968	29.0	1.142	22.0	.866	29.5	1.161	0°	-3°	TR-DC1308	TR-DC1308	3.0

≤60° HP

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

R = Right hand, L = Left hand

Main spare parts

Insert size ▱	Coupling size, dm_m	Insert screw	Key (Torx Plus)	Nozzle	Locating tube
13	32-40	5513 020-01	5680 049-01 (15IP)	5691 026-03	5638 031-01

 A9
 I110
 A2
 I56
 J2

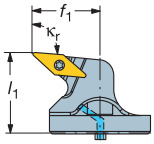
SL cutting heads with CoroTurn® HP

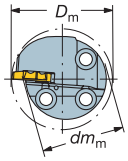
CoroTurn® TR screw clamp design

TR-SL-V13LBR/L-HP

Entering angle: κ_r 95°
Lead angle: -5°

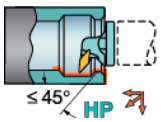
TR-VB





With internal high pressure (HP) coolant supply

Right hand style shown when nothing else is stated

Main application	Insert size	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
	13	**TR-SL-V13LBR/L-32HP**	32	40.0	1.575	22.0	.866	40.0	1.575	0°	-5°	TR-VB1308	TR-VB1308	2.0
		TR-SL-V13LBR/L-40HP	40	50.0	1.968	27.0	1.063	38.0	1.496	0°	-4°	TR-VB1308	TR-VB1308	2.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size	Coupling size, dm_m	Insert screw	Key (Torx Plus)	Torque wrench 1)	Nozzle (hole dia mm.)	Locating tube
13	32-40	5513 020-64	5680 049-04 (10IP)	5680 100-05	5691 026-03 (1.0)	5638 031-01

1) Accessories, must be ordered separately.

 A9
 I110
 A2
 I56
 J2

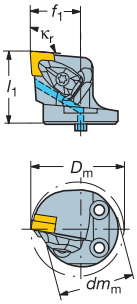
Cutting heads with CoroTurn® SL coupling

CoroTurn® RC rigid clamp design

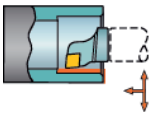
570-DCLNR/L

Entering angle: κ_r 95°
Lead angle: -5°

CNMM, CNGP
CNMG
CNMA, CNGA



With internal coolant supply
Right hand style shown

Main application	□	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ1)	λ_s2)	Gauge inserts ISO	ANSI	Nm3)
	12	1/2	570-DCLNR/L-32-12-L	32	40.0	1.575	22.0	.866	38.0	1.496	-6°	-9°	CNMG 12 04 08	CNMG 432	3.9
			570-DCLNR/L-40-12-L	40	50.0	1.968	27.0	1.063	38.0	1.496	-6°	-10°	CNMG 12 04 08	CNMG 432	3.9
	16	5/8	570-DCLNR/L-40-16-L	40	57.0	2.244	32.0	1.260	40.0	1.575	-6°	-13°	CNMG 16 06 12	CNMG 543	6.4
	19	3/4	570-DCLNR/L-40-19-L	40	57.0	2.244	34.0	1.339	42.0	1.654	-6°	-12°	CNMG 19 06 12	CNMG 643	6.4

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size □	iC	Coupling size, dm_m	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Locating tube
12	1/2	32-40	5513 020-02	5322 236-03	5680 049-01 (15IP)	5412 028-021	5638 031-01
16	5/8	40	5513 020-07	5322 234-03	5680 043-14	5412 028-031	5638 031-01
19	3/4	40	5513 020-07	5322 236-01	5680 043-14	5412 028-041	5638 031-01

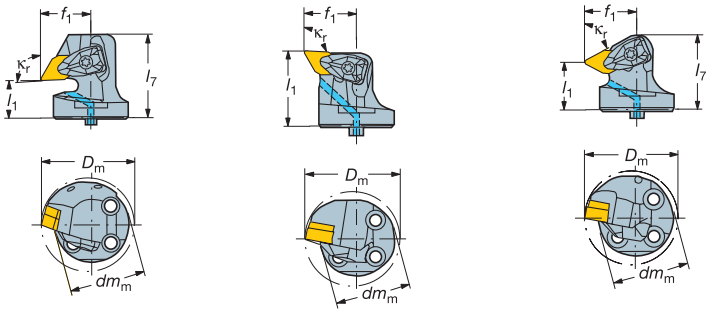
 A9
 I106
 A2
 I56
 J2

Cutting heads with CoroTurn® SL coupling

CoroTurn® RC rigid clamp design

DNMM, DNGP, DNMX
DNMG
DNMA, DNGA

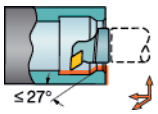
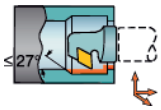
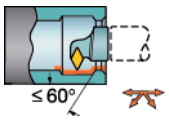
	570-DDUNR/L-X	570-DDUNR/L	570-DDXNR/L
Entering angle:	κ_r 93°	κ_r 93°	κ_r 62.5°
Lead angle:	-3°	-3°	27.5°



Back boring

With internal coolant supply

Right hand style shown

Main application	⇿	iC	Ordering code	Coupling size dmm	Dm min mm	Dm min in.	f1 mm	f1 in.	l1 mm	l1 in.	l7 mm	l7 in.	γ1)	λs2)	Gauge inserts ISO	ANSI	Nm3)
	11	3/8	570-DDUNR/L-32-11	32	40.0	1.575	22.0	.866	32.0	1.260			-6°	-10°	DNMG 11 04 08	DNMG 332	1.7
	15	1/2	570-DDUNR/L-40-15	40	50.0	1.968	27.0	1.063	32.0	1.260			-6°	-12°	DNMG 15 06 08	DNMG 442	3.9
	11	3/8	570-DDUNR/L-32-11X	32	40.0	1.575	22.0	.866	20.0	.787	38.4	1.512	-6°	-9°	DNMG 11 04 08	DNMG 332	1.7
	15	1/2	570-DDUNR/L-40-15X	40	50.0	1.968	27.0	1.063	20.0	.787	44.7	1.760	-6°	-12°	DNMG 15 06 08	DNMG 442	3.9
	11	3/8	570-DDXNR/L-32-11	32	40.0	1.575	22.0	.866	20.0	.787	31.1	1.224	0°	-10°	DNMG 11 04 08	DNMG 332	1.7
	15	1/2	570-DDXNR/L-40-15-L	40	50.0	1.968	27.0	1.063	22.0	.866	35.4	1.394	0°	-11°	DNMG 15 06 08	DNMG 442	3.9

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size ⇿	iC	Coupling size, dmm	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Locating tube
11	3/8	32	5513 020-04	5322 267-01	5680 051-03 (9IP)	5412 028-011	5638 031-01
15	1/2	40	5513 020-02	5322 266-02	5680 049-01 (15IP)	5412 028-021	5638 031-01

A9 I106 A2 I56 J2

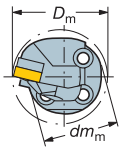
Cutting heads with CoroTurn® SL coupling

CoroTurn® RC rigid clamp design

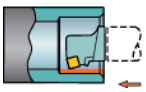
570-DSKNR/L

Entering angle: κ_r 75°
Lead angle: 15°

SNMM
SNMG
SNMA, SNGA



With internal coolant supply
Right hand style shown

Main application	□	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	12	1/2	**570-DSKNR/L-40-12**	40	50.0	1.968	27.0	1.063	38.0	1.496	-6°	-13°	SNMG 12 04 08	SNMG 432	3.9
	15	5/8	**570-DSKNR/L-40-15**	40	55.0	2.165	29.0	1.142	36.0	1.417	-6°	-12°	SNMG 15 06 08	SNMG 542	6.4

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

R = Right hand, L = Left hand

Main spare parts

Insert size □	iC	Coupling size, dm_m	Shim screw	Shim	Key	Complete clamp set	Locating tube
12	1/2	40	5513 020-03	5322 426-02	5680 049-01	5412 028-021	5638 031-01
15	5/8	40	5513 020-07	5322 425-03	5680 049-01	5412 028-031	5638 031-01

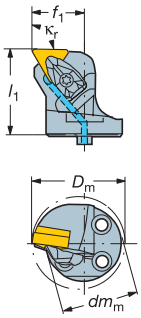
 A9
 A2
 I56
 J2

Cutting heads with CoroTurn® SL coupling

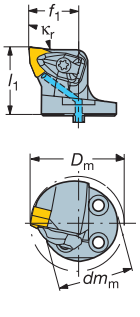
CoroTurn® RC rigid clamp design

	570-DTFNR/L	570-DWLNR/L
Entering angle:	κ_r 91°	κ_r 95°
Lead angle	-1°	-5°

TNMM, TNMX
TNMG
TNMA, TNGA

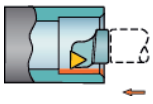


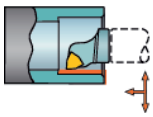
WNMM,
WNMG
WNGA, WNMA



With internal coolant supply

Right hand style shown when nothing else is stated

Main application	△	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	16	3/8	**570-DTFNR/L-32-16-L**	32	40.0	1.575	22.0	.866	36.0	1.417	-6°	-8°	TNMG 16 04 08	TNMG 332	1.7
			570-DTFNR/L-40-16-L	40	50.0	1.968	27.0	1.063	36.0	1.417	-6°	-10°	TNMG 16 04 08	TNMG 332	1.7

Main application	△	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	06	3/8	**570-DWLNR/L-32-06**	32	40.0	1.575	22.0	.866	32.0	1.260	-6°	-10°	WNMG 06 04 08	WNMG 332	1.7
	08	1/2	**570-DWLNR/L-32-08-LE**	32	46.0	1.811	24.0	.945	36.0	1.417	-6°	-12°	WNMG 08 04 08	WNMG 432	3.9
			570-DWLNR/L-40-08-L	40	50.0	1.968	27.0	1.063	36.0	1.417	-6°	-12°	WNMG 08 04 08	WNMG 432	3.9

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size TNM. △	iC	WNM. △	iC	Coupling size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Locating tube
16	3/8			32-40	5513 020-04	5322 316-01	5680 051-03 (9IP)	5412 028-011	5638 031-01
		06	3/8	32	5513 020-04	5322 328-01	5680 051-03 (9IP)	5412 028-011	5638 031-01
		08	1/2	32-40	5513 020-02	5322 331-12	5680 049-01 (15IP)	5412 028-021	5638 031-01

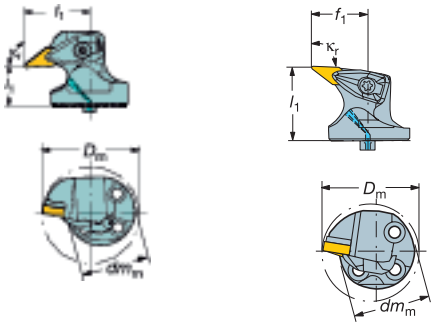
 A9
 I106
 A2
 I56
 J2

Cutting heads with CoroTurn® SL coupling

CoroTurn® RC rigid clamp design

VNMG
VNGP

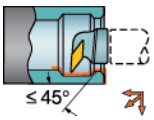
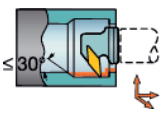
	570-DVUNR/L-X	570-DVUNR/L
Entering angle:	κ_r 93°	κ_r 93°
Lead angle:	-3°	-3°



Back boring

With internal coolant supply

Right hand style shown

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	16	3/8	**570-DVUNR/L-40-16**	40	52.0	2.047	30.0	1.181	36.0	1.417	-6°	-8°	VNMG 16 04 08	VNMG 332	3.0
	16	3/8	**570-DVUNR/L-40-16X**	40	56.0	2.205	34.0	1.339	34.0	1.339	-6°	-8°	VNMG 16 04 08	VNMG 332	3.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size		Coupling size, dm_m	Shim screw	Shim	Key	Complete clamp set	Locating tube
	iC						
16	3/8	40	5513 020-09	5322 269-01	5680 049-01	5412 028-061	5638 031-01

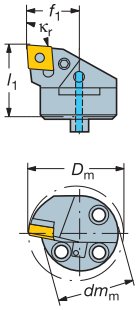
 A9
 I106
 A2
 I56
 J2

Cutting heads with CoroTurn® SL coupling

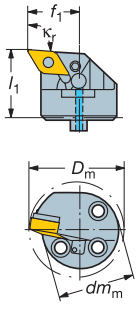
T-Max P lever clamp design

	R/L571.31C	**R/L571.35C**
Entering angle:	κ_r 95°	κ_r 93°
Lead angle:	**-5°**	-3°

CNMM, CNGP
CNMG
CNMA, CNGA

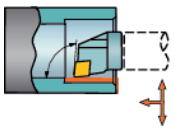


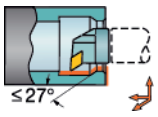
DNMM, DNGP, DNMX
DNMG
DNMA, DNGA



With internal coolant supply

Right hand style shown

Main application	□	*iC*	**Ordering code**	Coupling size *dm*m	*D*m min mm	*D*m min in.	*f*1 mm	*f*1 in.	*l*1 mm	*l*1 in.	γ1)	λs2)	Gauge inserts ISO	Gauge inserts ANSI
	12	1/2	**R/L571.31C-323222-12**	32	40.0	1.575	22.0	.866	32.0	1.260	-6°	-11°	CNMG 12 04 08	CNMG 432
			R/L571.31C-403227-12	40	50.0	1.968	27.0	1.063	32.0	1.260	-6°	-10°	CNMG 12 04 08	CNMG 432
	16	5/8	**R/L571.31C-504035-16**	50	63.0	2.480	35.0	1.378	40.0	1.575	-6°	-11°	CNMG 16 06 12	CNMG 543
			R/L571.31C-604043-16	60	80.0	3.150	43.0	1.693	40.0	1.575	-6°	-10°	CNMG 16 06 12	CNMG 543

Main application	◇	*iC*	**Ordering code**	Coupling size *dm*m	*D*m min mm	*D*m min in.	*f*1 mm	*f*1 in.	*l*1 mm	*l*1 in.	γ1)	λs2)	Gauge inserts ISO	Gauge inserts ANSI
	15	1/2	**R/L571.35C-403227-15**	40	50.0	1.968	27.0	1.063	32.0	1.260	-6°	-11°	DNMG 15 06 08	DNMG 442
			R/L571.35C-504035-15	50	63.0	2.480	35.0	1.378	40.0	1.575	-6°	-10°	DNMG 15 06 08	DNMG 442
			R/L571.35C-604043-15	60	80.0	3.150	43.0	1.693	40.0	1.575	-6°	-8°	DNMG 15 06 08	DNMG 442

1) γ = Rake angle.
2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size CNM. □	*iC*	DNM. ◇	*iC*	Coupling size	Lever	Screw	Key (mm)	Shim	Location tube
12	1/2			32	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M	5638 031-01
12	1/2			40	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M	5638 031-01
16	5/8			50	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852	5638 031-02
16	5/8			60	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852	5638 031-03
		15	1/2	40	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5638 031-01
		15	1/2	50	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5638 031-02
		15	1/2	60	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	5638 031-03

 A9
 I107
 A2
 I56
 J2

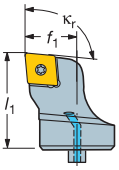
Cutting heads with CoroTurn® SL coupling

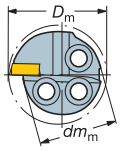
CoroTurn® 107 screw clamp design

570-SCLCR/L

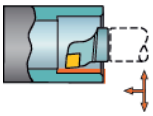
Entering angle: κ_r 95°
Lead angle: -5°

CCMT, CCGT
CCGX, CCET
CCMW





With internal coolant supply
Right hand style shown

Main application	□	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ1)	λ_s2)	Gauge inserts ISO	ANSI	Nm3)
	06	1/4	570-SCLCR/L-16-06	16	20.0	.787	11.0	.433	20.0	.787	0°	-12°	CCMT 06 02 04	CCMT 2(1.5)1	0.9
	09	3/8	570-SCLCR/L-20-09	20	25.0	.984	13.0	.512	20.0	.787	0°	-8°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0
			570-SCLCR/L-25-09	25	32.0	1.260	17.0	.669	20.0	.787	0°	-6°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0
			570-SCLCR/L-32-09	32	40.0	1.575	22.0	.866	32.0	1.260	0°	-10°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0
	12	1/2	570-SCLCR/L-40-12	40	50.0	1.968	27.0	1.063	38.0	1.496	0°	-7°	CCMT 12 04 08	CCMT 432	3.0

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size □	iC	Coupling size, dm_m	Insert screw (thread)	Key (Torx Plus/mm)	Screwdriver (Torx Plus)	Location tube	Shim	Shim screw
06	1/4	16	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)	5552 058-01		
09	3/8	20	5513 020-09 (M3.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)	5552 058-02		
09	3/8	25	5513 020-10 (M3.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)	5552 058-03		
09	3/8	32	5513 020-09 (M3.5)	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)	5638 031-01		
12	1/2	40	5513 020-18 (M4.0)	5680 049-02 (15IP/3.5)	5680 041-06 (8IP)	5638 031-01	5322 232-02	5512 090-03

 A9
 A2
 I56
 J2

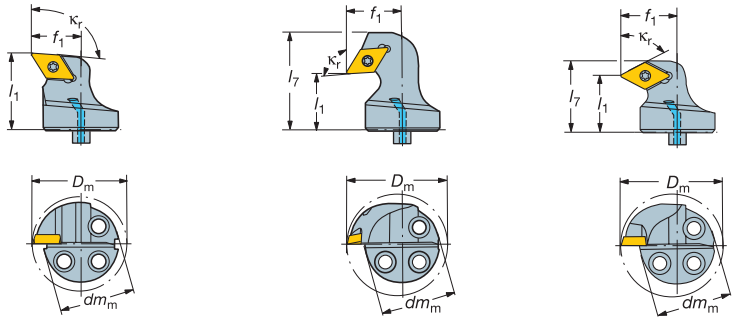
Cutting heads with CoroTurn® SL coupling

CoroTurn® 107 screw clamp design

Rhombic 55°

DCMT, DCMX
DCGT, DCGX, DCET
DCMW

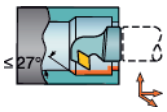
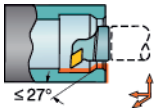
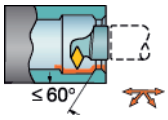
	570-SDUCR/L	570-SDUCR/L...-X	570-SDXCR/L
Entering angle:	κ_r 93°	κ_r 93°	κ_r 62.5°
Lead angle:	-3°	-3°	27.5°



Back boring

With internal coolant supply

Right hand style shown

Main application	↔	Ordering code	Coupling size dm_m	Dimensions, mm, inch D_m min	f_1	l_1	l_7	γ 1)	λ_s 2)	Gauge insert ISO	ANSI	Nm 3)
	07	570-SDUCR/L-16-07-EX	16	22.0	13.0	15	26.5	0°	-6°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
				.866	*.512*	*.591*	*1.043*	*0°*	*-6°*			
		570-SDUCR/L-20-07-EX	20	27.0	15.0	15	26.5	0°	-3°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
				1.063	*.591*	*.591*	*1.043*	*0°*	*-3°*			
		570-SDUCR/L-25-07-DX	25	33.0	18.0	15	26.5	0°	-3°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
				1.299	*.709*	*.591*	*1.043*	*0°*	*-3°*			
	11	570-SDUCR/L-32-11X	32	40.0	22.0	20	38	0°	-10°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				1.575	*.866*	*.787*	*1.496*	*0°*	*-10°*			
		570-SDUCR/L-40-11X	40	50.0	27.0	20	38	0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				1.968	*1.063*	*.787*	*1.496*	*0°*	*-8°*			
	07	570-SDUCR/L-16-07	16	20.0	11.0	20		0°	-8°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
				.787	*.433*	*.787*		*0°*	*-8°*			
	11	570-SDUCR/L-20-11	20	25.0	13.0	20		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				.984	*.512*	*.787*		*0°*	*-6°*			
		570-SDUCR/L-25-11	25	32.0	17.0	20		0°	-6°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				1.260	*.669*	*.787*		*0°*	*-6°*			
		570-SDUCR/L-32-11	32	40.0	22.0	32		0°	-10°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				1.575	*.866*	*1.260*		*0°*	*-10°*			
		570-SDUCR/L-40-11	40	50.0	27.0	32		0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				1.968	*1.063*	*1.260*		*0°*	*-8°*			
	07	570-SDXCR/L-16-07-E	16	22.0	13.0	15	19.5	0°	-6°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
				.866	*.512*	*.591*	*.768*	*0°*	*-6°*			
		570-SDXCR/L-20-07-E	20	27.0	15.0	15	19.5	0°	-3°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
				1.063	*.591*	*.591*	*.768*	*0°*	*-3°*			
		570-SDXCR/L-25-07-D	25	33.0	18.0	15	19.5	0°	-3°	DCMT 07 02 04	DCMT 2(1.5)1	0.9
				1.299	*.709*	*.591*	*.768*	*0°*	*-3°*			
	11	570-SDXCR/L-32-11	32	40.0	22.0	20	28	0°	-10°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				1.575	*.866*	*.787*	*1.102*	*0°*	*-10°*			
		570-SDXCR/L-40-11	40	50.0	27.0	20	28	0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9
				1.968	*1.063*	*.787*	*1.102*	*0°*	*-8°*			

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size ↔	Insert size *iC*	Coupling size, dm_m	Insert screw (thread)	Shim	Shim screw (thread)	Key (Torx Plus/mm)
07	1/4	16-25	5513 020-03 (M2.5)	-	-	5680 051-02 (7IP)
11	3/8	20	5513 020-09 (M3.5)	-	-	5680 049-01 (15IP/3.5)
11	3/8	25	5513 020-10 (M3.5)	-	-	5680 049-01 (15IP/3.5)
11	3/8	32-40	5513 020-01 (M3.5)	5322 263-01	5512 090-01 (M5X0.5)	5680 049-01 (15IP/3.5)

Locating tube, see page I118.

 A9
 I109
 A2
 I56
 J2

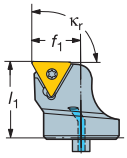
Cutting heads with CoroTurn® SL coupling

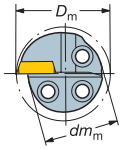
CoroTurn® 107 screw clamp design

	STFCR/L
Entering angle:	κ_r 91°
Lead angle:	-1°

TCMT, TCMX, TCGT, TCGX TCEX

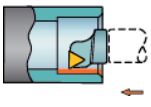
TCMW





With internal coolant supply

Right hand style shown

Main application	△	*iC*	Ordering code	Coupling size *dm*m	Dimensions, millimeter, inch (mm, in.) *D*m min mm	*D*m min in.	*f*1 mm	*f*1 in.	*l*1 mm	*l*1 in.	γ1)	λs2)	Gauge inserts ISO	ANSI	Nm3)
	09	7/32	**570-STFCR/L-16-09**	16	20.0	.787	11.0	.433	20.0	.787	0°	-6°	TCMT 09 02 04	TCMT 1.8(1.5)1	0.9
	11	1/4	**570-STFCR/L-16-11-B1**4)	16	20.0	.787	11.0	.433	20.0	.787	0°	-7°	TCMT 11 03 04	TCMT 221	0.9
			570-STFCR/L-20-11-B14)	20	25.0	.984	13.0	.512	20.0	.787	0°	-4°	TCMT 11 03 04	TCMT 221	0.9
			570-STFCR/L-25-11-B14)	25	32.0	1.260	17.0	.669	20.0	.787	0°	-2°	TCMT 11 03 04	TCMT 221	0.9
	16	3/8	**570-STFCR/L-32-16**	32	40.0	1.575	22.0	.866	32.0	1.260	0°	-10°	TCMT 16 T3 08	TCMT 3(2.5)2	3.9
			570-STFCR/L-40-16	40	50.0	1.968	27.0	1.063	32.0	1.260	0°	-8°	TCMT 16 T3 08	TCMT 3(2.5)2	3.9

R = Right hand, L = Left hand

1) γ = Rake angle.

2) λ_s = Angle of inclination.

3) Insert tightening torque ft-lbs.

4) B1 = For insert with thickness 2 = 1/8".

Main spare parts

Insert size △	*iC*	Coupling size, *dm*m	Insert screw (thread)	Shim	Shim screw (thread)	Key (Torx Plus/mm)
09	7/32	16	5513 020-05 (M2.2)	-	-	5680 051-02 (7IP)
11	1/4	16-25	5513 020-03 (M2.5)	-	-	5680 051-02 (7IP)
16	3/8	32-40	5513 020-01 (M3.5)	5322 320-01	5512 090-01 (M5x0.5)	5680 049-01 (15IP/3.5)

Locating tube, see page I118.

 A9
 I109
 A2
 I56
 J2

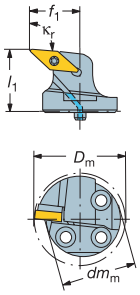
Cutting heads with CoroTurn® SL coupling

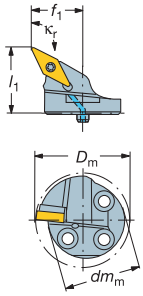
CoroTurn® 107 screw clamp design

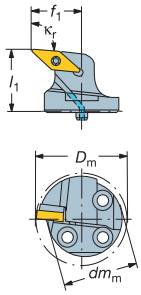
	570C-SVUBR/L	570-SVPBR/L	570-SVLBR/L
Entering angle:	κ_r 93°	κ_r 117.5°	κ_r 95°
Lead angle:	-3°	-27.5°	-5°

VBMT, VBGT
VCGX, VCEX,
VCGT, VCET

VBMW, VCMW

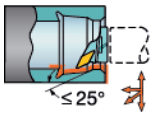
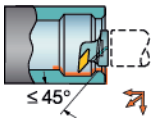
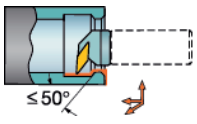






With internal coolant supply

Right hand style shown

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
	16	3/8	570-SVPBR/L-32-16-L	32	40.0	1.575	22.0	.866	34.0	1.339	0°	-5°	VBMT 16 04 08	VBMT 332	3.9
			570-SVPBR/L-40-16-L	40	50.0	1.968	27.0	1.063	34.0	1.339	0°	-4°	VBMT 16 04 08	VBMT 332	3.9
	16	3/8	570-SVLBR/L-25-16-LF	25	35.0	1.378	20.0	.787	22.0	.866	0°	-	VBMT 16 04 08	VBMT 332	3.9
			570-SVLBR/L-32-16	32	40.0	1.575	22.0	.866	32.0	1.260	0°	-9°	VBMT 16 04 08	VBMT 332	3.9
			570-SVLBR/L-40-16	40	50.0	1.968	27.0	1.063	32.0	1.260	0°	-6°	VBMT 16 04 08	VBMT 332	3.9
	20	1/4	570C-SVUBR/L-20-2	20	27.0	1.063	16.0	.630	20.0	.790	0°	-5°	VBMT 11 02 04	VBMT 2(1.5)1	0.9
			570C-SVUBR/L-25-2	25	31.0	1.220	17.0	.669	250	.980	0°	-3°	VBMT 11 02 04	VBMT 2(1.5)1	0.9

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size		Coupling size, dm_m	Insert screw (thread)	Shim	Shim screw	Key (Torx Plus)
	iC					
20	1/4	20-25	5513 020-03 (M2.5)	-	-	5680 051-02 (7IP)
16	3/8	25	5513 020-10 (M3.5)	-	-	5680 049-01 (15IP)
16	3/8	32-40	5513 020-10 (M3.5)	5322 270-01	5512 090-01 (M5x0.5)	5680 049-01 (15IP)

Locating tube, see page I118.

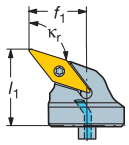
 A9
 I109
 A2
 I56
 J2

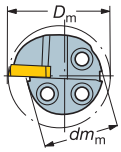
Cutting heads with CoroTurn® SL coupling

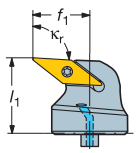
CoroTurn® 107 screw clamp design

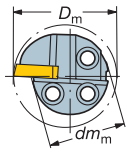
	570-SVQCR/L	570-SVUCR/L	570-SVUCR/L-X
Entering angle:	κ_r 107.5°	κ_r 93°	κ_r 93°
Lead angle:	-17.5°	-3°	-3°

VCMT, VCEX, VCGX
VCMW





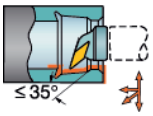
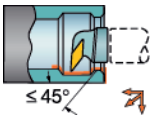
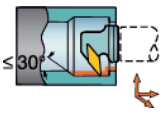




Back boring

With internal coolant supply

Right hand style shown

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
 ≤35°	11	1/4	**570-SVQCR/L-20-11-E**	20	27.0	1.063	15.0	.591	20.0	.787	2°	-3°	VCMT 11 03 04	VCMT 221	0.9
			570-SVQCR/L-25-11-D	25	33.0	1.299	18.0	.709	20.0	.787	2°	-2°	VCMT 11 03 04	VCMT 221	0.9
 ≤45°	11	1/4	**570-SVUCR/L-20-11-E**	20	27.0	1.063	15.0	.591	20.0	.787	2°	-4°	VCMT 11 03 04	VCMT 221	0.9
			570-SVUCR/L-25-11-D	25	33.0	1.299	18.0	.709	20.0	.787	2°	-2°	VCMT 11 03 04	VCMT 221	0.9
 ≤30°	11	1/4	**570-SVUCR/L-20-11X-E**	20	32.0	1.260	20.0	.787	15.0	.591	2°	-3°	VCMT 11 03 04	VCMT 221	0.9
			570-SVUCR/L-25-11X-D	25	37.0	1.457	22.0	.866	15.0	.591	2°	-2°	VCMT 11 03 04	VCMT 221	0.9

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size		Coupling size, dm_m	Insert screw	Key (Torx Plus)
11	1/4	20-25	5513 020-03	5680 051-02 (7IP)

Locating tube, see page I118.

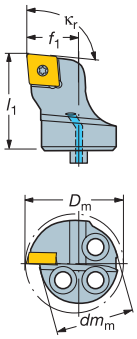
 A9
 I107
 A2
 I56
 J2

Cutting heads with CoroTurn® SL coupling

CoroTurn® 111 screw clamp design

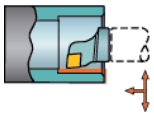
	570-SCLPR/L
Entering angle:	κ_r 95°
Lead angle:	-5°

CPMT



With internal coolant supply

Right hand style shown

Main application	□	*iC*	**Ordering code**	Coupling size *dm*m	Dimensions, millimeter, inch (mm, in.) *D*m min mm	*D*m min in.	*f*1 mm	*f*1 in.	*l*1 mm	*l*1 in.	γ1)	λs2)	Gauge inserts ISO	ANSI	Nm3)
	06	1/4	**570-SCLPR/L-16-06**	16	20.0	.787	11.0	.433	20.0	.787	6°	-2°	CPMT 06 02 04	CPMT 2(1.5)1	0.9

1) γ = Rake angle.
2) λs = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size □	*iC*	Coupling size, *dm*m	**Insert screw**	**Key (Torx Plus)**
06	1/4	16	5513020-03 (M2.5)	5680 051-02 (7IP)

Locating tube, see page I118.

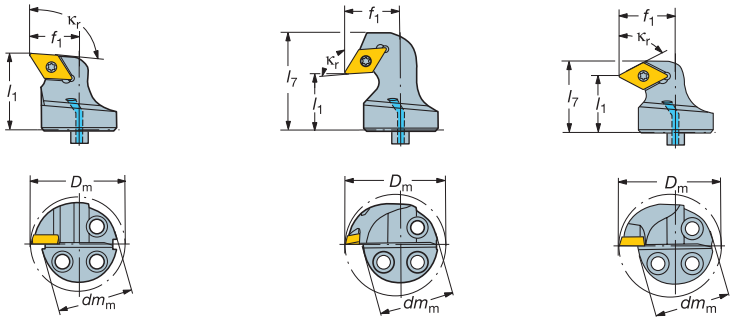
 A9
 I107
 A2
 I56
 J2

Cutting heads with CoroTurn® SL coupling

CoroTurn® 111 screw clamp design

	570-SDUPR/L	570-SDUPR/L-X	570-SDXPR/L
Entering angle:	κ_r 93°	κ_r 93°	κ_r 62.5°
Lead angle:	-3°	-3°	27.5°

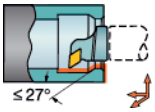
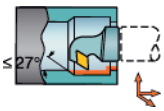
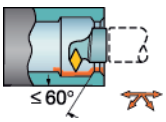
DPMT



Back boring

With internal coolant supply

Right hand style shown

Main application		Ordering code	Coupling size dm_m	Dimensions, mm, inch D_m min	f_1	l_1	l_7	γ[1]	λ_s[2]	Gauge insert ISO	ANSI	Nm[3]
	07	570-SDUPR/L-16-07	16	20.0	11.0	20		6°	0°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.630	*.787*	*.433*	*.787*						
		570-SDUPR/L-20-07	20	25.0	13.0	20		6°	0°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.787	*.984*	*.512*	*.787*						
	11	570-SDUPR/L-25-11	25	32.0	17.0	20		6°	-1°	DPMT 11 T3 08	DPMT 3(2.5)2	3.0
			.984	*1.260*	*.669*	*.787*						
	07	570-SDUPR/L-16-07-EX	16	22.0	13.0	15	26	6°	0°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.630	*.866*	*.512*	*.591*	*1.024*					
		570-SDUPR/L-20-07-EX	20	27.0	15.0	15	26	6°	-1°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.787	*1.063*	*.591*	*.591*	*1.024*					
		570-SDUPR/L-25-07-DX	25	33.0	18.0	15	26	6°	-2°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.984	*1.299*	*.709*	*.591*	*1.024*					
	07	570-SDXPR/L-16-07-E	16	22.0	13.0	15	19	0°	0°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.630	*.866*	*.512*	*.591*	*.748*					
		570-SDXPR/L-20-07-E	20	27.0	15.0	15	19	0°	0°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.787	*1.063*	*.591*	*.591*	*.748*					
		570-SDXPR/L-25-07-D	25	33.0	18.0	15	19	0°	-1°	DPMT 07 02 04	DPMT 2(1.5)1	0.9
			.984	*1.299*	*.709*	*.591*	*.748*					

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size		Coupling size, dm_m	Insert screw	Key (Torx Plus)
	iC			
07	1/4	16-20	5513 020-03	5680 051-02 (7IP)
11	3/8	25	5513 020-09	5680 049-01 (15IP)

Locating tube, see page I118.

 A9
 I107
 A2
 I56
 J2

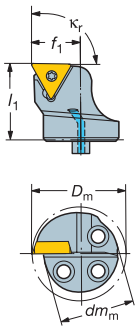
Cutting heads with CoroTurn® SL coupling

CoroTurn® 111 screw clamp design

570-STFPR/L

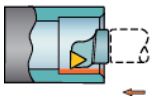
Entering angle: κ_r 91°
Lead angle: -1°

TPMT



With internal coolant supply

Right hand style shown

Main application	△	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ1)	λ_s2)	Gauge inserts ISO	ANSI	Nm3)
	11	1/4	**570-STFPR/L-16-11**	16	20.0	.787	11.0	.433	20.0	.787	6°	-1°	TPMT 11 03 04	TPMT 221	0.9
			570-STFPR/L-20-11	20	25.0	.984	13.0	.512	20.0	.787	6°	0°	TPMT 11 03 04	TPMT 221	0.9
			570-STFPR/L-25-11	25	32.0	1.260	17.0	.669	20.0	.787	6°	-1°	TPMT 11 03 04	TPMT 221	0.9

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size △	iC	Coupling size, dm_m	Insert screw	Key (Torx Plus)
11	1/4	16-25	5513 020-03	5680 051-02 (7IP)

Locating tube, see page I118.

 A9
 I107
 A2
 I56
 J2

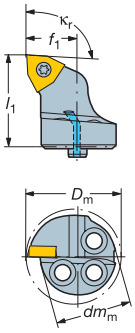
Cutting heads with CoroTurn® SL coupling

CoroTurn® 111 screw clamp design

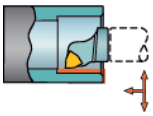
570-SWLPR/L

Entering angle: κ_r 95°
Lead angle: -5°

WPMT



With internal coolant supply
Right hand style shown

Main application		iC	Ordering code	Coupling size dmm	Dimensions, millimeter, inch (mm, in.) Dm min mm	Dm min in.	f1 mm	f1 in.	l1 mm	l1 in.	γ1)	λs2)	Gauge inserts ISO	ANSI	Nm3)
	04	1/4	**570-SWLPR/L-16-04**	16	20.0	.787	11.0	.433	20.0	.787	6°	-2°	WPMT 04 02 04	WPMT 2(1.5)1	0.9

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size		Coupling size, dmm	Insert screw	Key (Torx Plus)
04	1/4	16	5513 020-46	5680 051-02 (7IP)

Locating tube, see page I118.

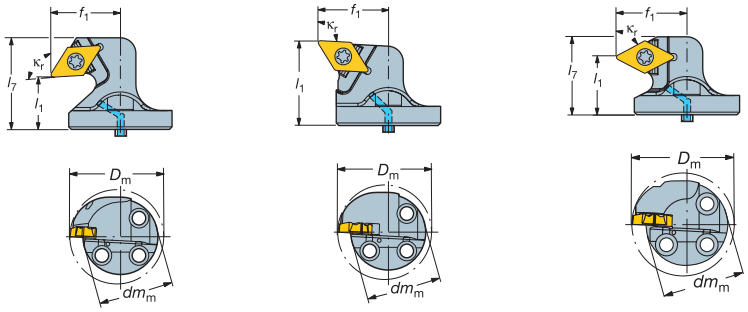
 A9
 I107
 A2
 I56
 J2

Cutting heads with CoroTurn® SL coupling

CoroTurn® TR screw clamp design

TR-DC

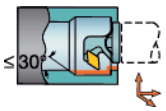
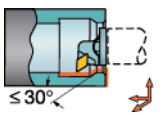
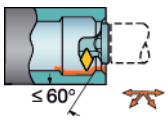
	TR-SL-D13UCR/L-X	TR-SL-D13UCR/L	TR-SL-D13XCR/L
Entering angle:	κ_r 93°	κ_r 93°	κ_r 62.5°
Lead angle:	-3°	-3°	27.5°



Back boring

With internal coolant supply

Right hand style shown when nothing else is stated

Main application		Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
	13	TR-SL-D13UCR/L-25X	25	36.0	1.417	21.0	.827	17.0	.669	0°	-5°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13UCR/L-32X	32	40.0	1.575	22.0	.866	20.0	.787	0°	-5°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13UCR/L-40X	40	50.0	1.968	27.0	1.063	20.0	.787	0°	-3°	TR-DC1308	TR-DC1308	3.0
	13	TR-SL-D13UCR/L-25	25	35.0	1.378	20.0	.787	27.0	1.063	0°	-5°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13UCR/L-32	32	40.0	1.575	22.0	.866	32.0	1.260	0°	-5°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13UCR/L-40	40	50.0	1.968	27.0	1.063	32.0	1.260	0°	-3°	TR-DC1308	TR-DC1308	3.0
	13	TR-SL-D13XCR/L-25	25	35.0	1.378	20.0	.787	20.0	.787	0°	-5°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13XCR/L-32	32	40.0	1.575	22.0	.866	22.0	.866	0°	-5°	TR-DC1308	TR-DC1308	3.0
		TR-SL-D13XCR/L-40	40	50.0	1.968	27.0	1.063	22.0	.866	0°	-3°	TR-DC1308	TR-DC1308	3.0

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque ft-lbs.

Main spare parts

Insert size	Coupling size, dm_m	Insert screw	Key (Torx Plus)	Torque wrench	Locating tube
13	25	5513 020-01	5680 049-01 (15IP)	5680 100-06	5552 058-02
13	32-40	5513 020-01	5680 049-01 (15IP)	5680 100-06	5638 031-01

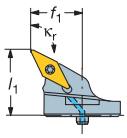
 A9
 I110
 A2
 I56
 J2

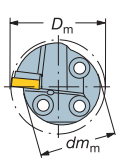
Cutting heads with CoroTurn® SL coupling

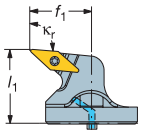
CoroTurn® TR screw clamp design

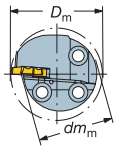
	TR-SL-V13PBR/L	TR-SL-V13LBR/L
Entering angle:	κ_r 117.5°	κ_r 95°
Lead angle:	-27.5°	-5°

TR-VB



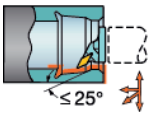
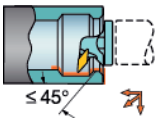






With internal coolant supply

Right hand style shown when nothing else is stated

Main application		Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
	13	**TR-SL-V13PBR/L-25**	25	33.0	1.299	17.0	.669	28.0	1.102	0°	-5°	TR-VB1308	TR-VB1308	2.0
		TR-SL-V13PBR/L-32	32	40.0	1.575	22.0	.866	32.0	1.260	0°	-5°	TR-VB1308	TR-VB1308	2.0
		TR-SL-V13PBR/L-40	40	50.0	1.968	27.0	1.063	32.0	1.260	0°	-5°	TR-VB1308	TR-VB1308	2.0
	13	**TR-SL-V13LBR/L-25**	25	35.0	1.378	20.0	.787	27.0	1.063	0°	-5°	TR-VB1308	TR-VB1308	2.0
		TR-SL-V13LBR/L-32	32	40.0	1.575	22.0	.866	32.0	1.260	0°	-5°	TR-VB1308	TR-VB1308	2.0
		TR-SL-V13LBR/L-40	40	50.0	1.968	27.0	1.063	32.0	1.260	0°	-4°	TR-VB1308	TR-VB1308	2.0

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque ft-lbs.

Main spare parts

Insert size	Coupling size, dm_m	Insert screw	Key (Torx Plus)	Torque wrench	Locating tube
25	.984	5513 020-64	5680 049-04 (10IP)	5680 100-05	5552 058-02
32-40	1.260-1.575	5513 020-64	5680 049-04 (10IP)	5680 100-05	5638 031-01


A9


I107


A2


I56


J2

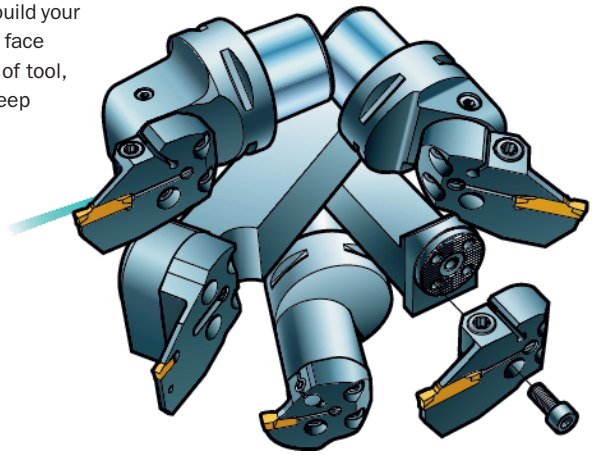
CoroCut® SL and T-Max Q-Cut® SL

Cutting blades for external and internal operations

Build your tool for parting, grooving, face grooving and turning

External machining

With external adapters you can build your tool for parting and grooving. In face grooving you can build any type of tool, right or left hand and A or B sweep design.

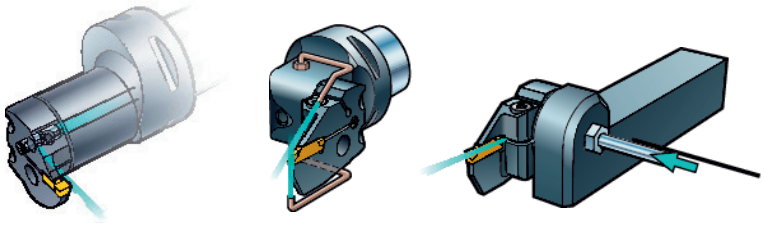


Internal machining

With internal boring bars/adapters using dampened Silent Tools, you can build tools for all types of internal grooving, profiling and turning operations.

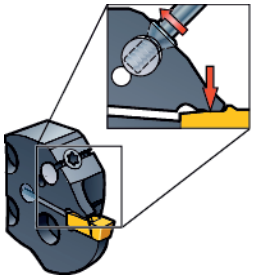
Serrated interface

The extremely robust serrated interface between bars/adaptors and cutting blade is comparable with a solid tool in performance regarding vibration and deflection.



Coolant connection

To ensure good chip evacuation all blades have cutting fluid directed exactly to the cutting edge. Furthermore, for external machining a coolant tube is available to enhance cutting fluid supply.



Unique insert clamping

Cutting blades for small internal diameters, for T-Max Q-Cut® 151.3 inserts, are designed with a new insert clamping screw for maximum strength, stability and ease of use.

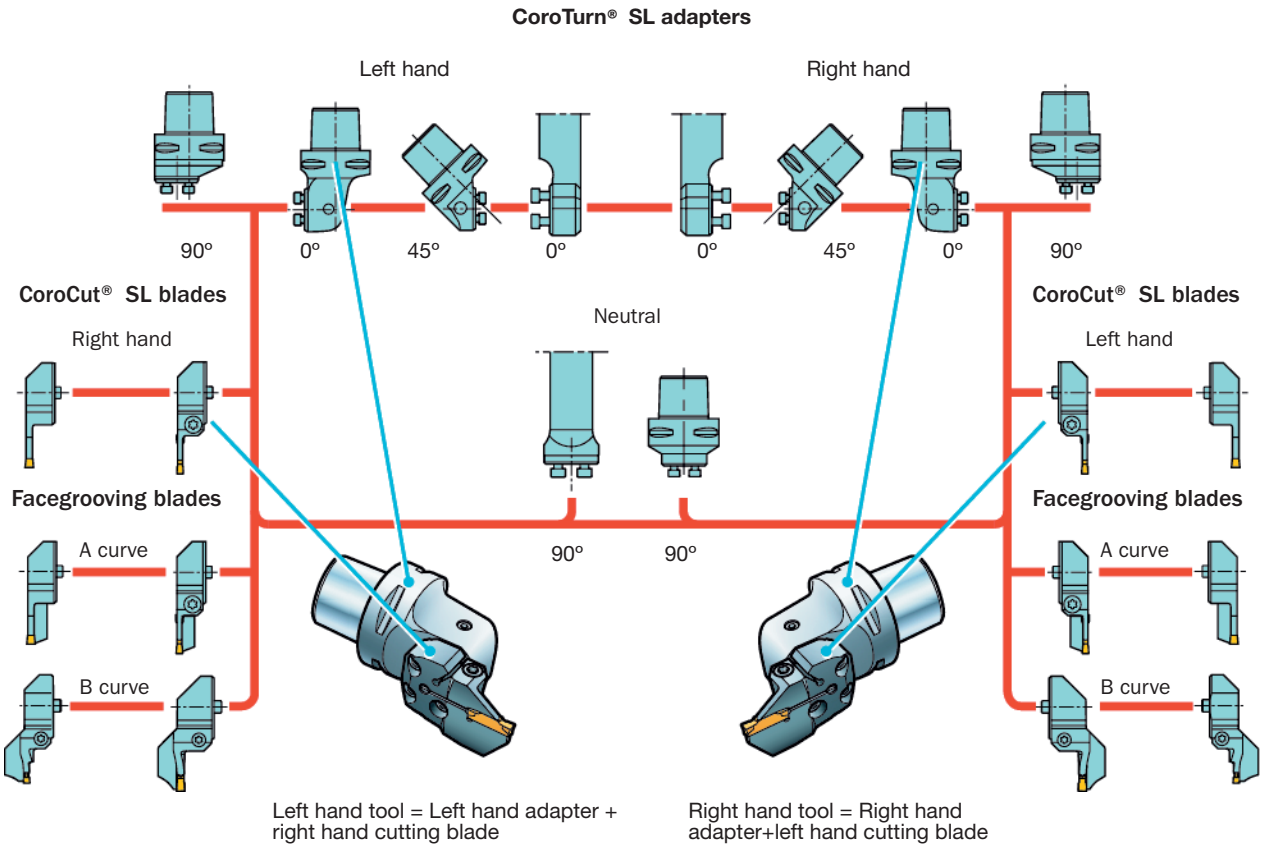
CoroTurn® SL – a flexible modular system for all types of turning operations

By using a CoroTurn® SL bars/adapters and the various types of cutting heads/blades, you can build a large number of tooling solutions from a limited number of items. Thanks to the extremely robust interface between adapter and cutting blade, it is comparable to a solid tool. For more information see page I39.

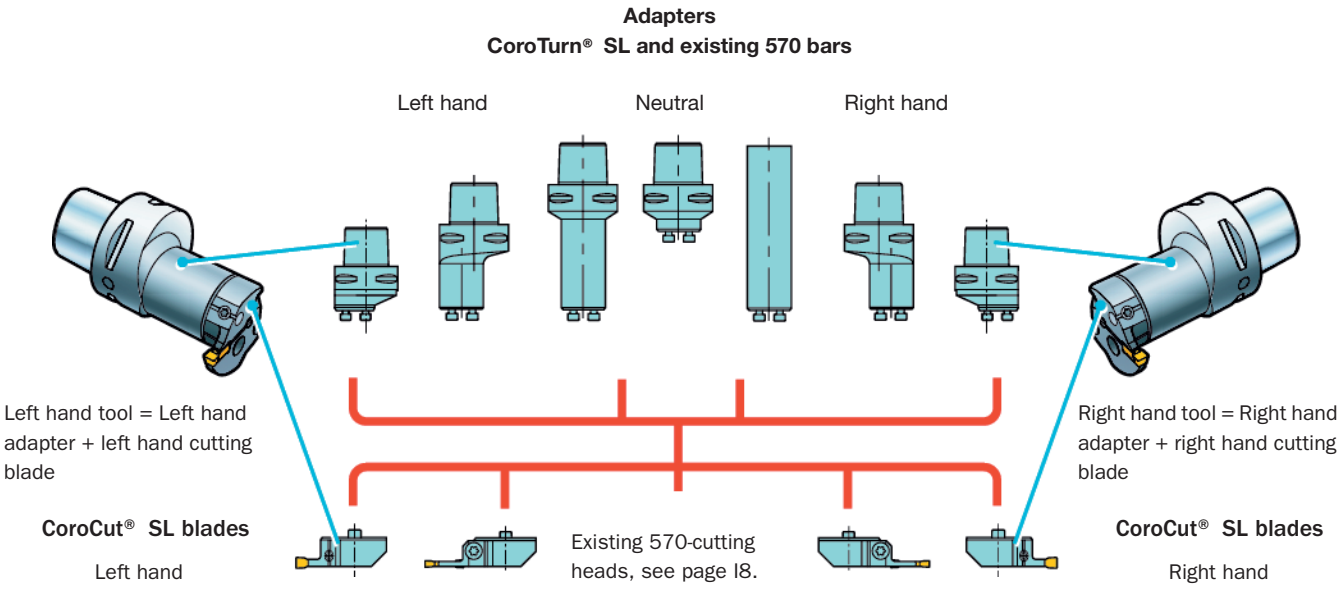
Combine and build your own tool

CoroTurn® SL adapters, together with cutting blades, give you access to the comprehensive assortment of CoroCut® 1-2 edge solutions for all types of grooving, turning, profiling and parting operations. The system also allows you to use the T-Max Q-Cut® 151.2 system for deep grooving and parting and the T-Max Q-Cut® 151.3 system for internal and face grooving applications.

External machining

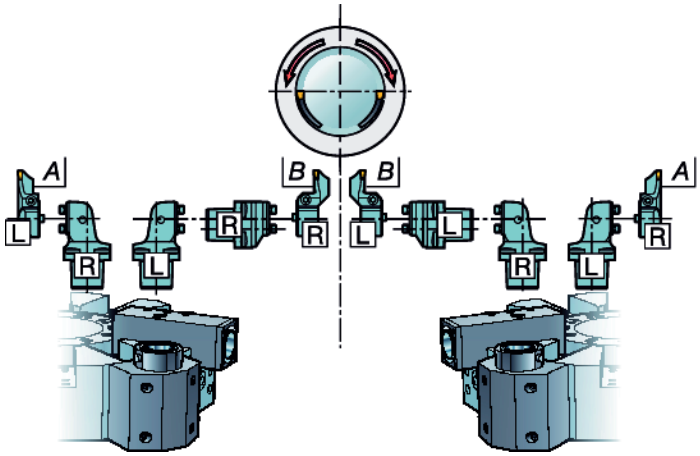


Internal machining



How to choose the right tool for facegrooving

The diagram helps you to choose the right type of tool for your face grooving application.



R = right hand tool
L = left hand tool
A = A curve
B = B curve

Recommendations when choosing CoroCut® SL cutting blades

CoroCut® 1-2 SL cutting blades with a screw clamp design is the first choice for all types of grooving and parting operations. Using the CoroCut® 1-2 edge solution gives you access to insert geometries and grades for all types of operations and workpiece materials.
The T-Max Q-Cut® –SL 151.2 system with a spring clamp design is a good choice for deep grooving and parting operations.

The T-Max Q-Cut® –SL 151.3 system with its new screw clamp design is an option for internal operations especially in small bores.
CoroCut® XS SL is designed for sliding head machines with guaranteed precision in external parting-off, grooving, threading and turning.
CoroCut® 3 SL with 3 cutting edges and screw clamp design is the economical system for shallow parting-off and grooving.

		Parting & grooving			Shallow grooving		Small part machining
•• = Recommended tool • = Alternative tool - = Not recommended Right hand blade shown.		**CoroCut® SL 123**	**Q-Cut® SL 151.2**	**Q-Cut® SL 151.3**	**CoroCut® SL 123**	**CoroCut® 3 SL 123**	**CoroCut® XS SL SMAL**
							
	Clamping system	Screw clamp	Spring clamp	Screw clamp	Screw clamp	Screw clamp	Screw clamp
Min. bore, mm (inch)		96-147 (3.76 - 5.79)	-	36-55 (1.41 - 2.15)	-		
Parting	Normal	••	•	-	•	•	••
	Deep	•	••	-	-	-	-
Grooving		••	•	-	•	•	••
Profiling		••	-	-	-	-	-
Turning		••	-	-	-	-	••
Face grooving		-	-	-	•	-	
Internal	Grooving/Profiling	•	-	••	-	-	-

		Face grooving (Available with A and B sweep)	
		CoroCut® SL 123	**Q-Cut® SL 151.3**
			
	Clamping system	Screw clamp	Screw clamp
First cut diameter, inch		40 (1.575)	24 (.945)
Face grooving		••	••

For more information, see overview page B4.

CoroCut® SL blades

Parting and grooving

570	–	25	R	123	D	12	B
1		2	3	4	5	6	7

Face grooving

570	–	32	R	123	F	12	B	040	B
1		2	3	4	5	6	7	8	9

T-Max Q-Cut® SL blades

Parting and grooving

570	–	25	R	151	.21	–	06	–	20
1		2	3	4	7		6		5

Face grooving

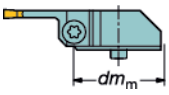
570	–	32	R	151	.3	–	018	B	25
1		2	3	4	7		8	9	5

1 Coupling type

570/CoroTurn® SL

2 Coupling size

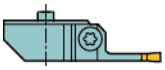
dm_m, in mm



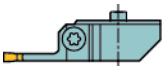
To correspond with coupling size, dm_m, on adapter/bar.

3 Hand of blade

R = Right hand style



L = Left hand style



4 Type of insert

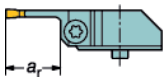
123	= CoroCut®
151	= T-Max Q-Cut®
SMAL	= CoroCut® XS

5 Insert seat size

CoroCut® 1-2 D, E, F, G, H, J, K	CoroCut® 3 T, U
Q-Cut® 20, 25, 30, 40, 50, 60	CoroCut® XS 3

To correspond with seat size on insert.

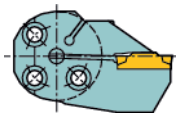
6 Machining limitations



Max cutting depth a_r in mm

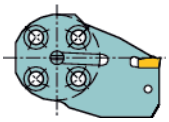
7 Insert clamping system

CoroCut®

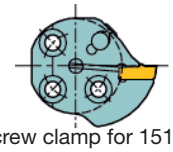


B = Screw clamp
C = Screw clamp for 1-2 insert, shallow grooving

T-Max Q-Cut®



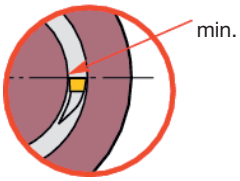
.21 = Screw clamp for 151.2 insert



.3 = Screw clamp for 151.3 insert

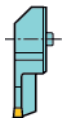
8 Min. diameter for first cut, for facegrooving

Min. diameter for first cut



9 Type of curve, for facegrooving

B = B curve

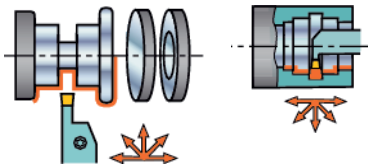


A = A curve

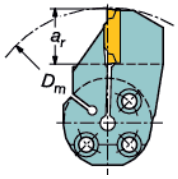
CoroCut® SL

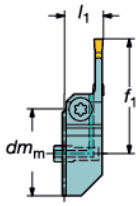
Blade for grooving, parting off, profiling and turning

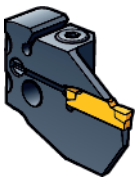
Screw clamp



R/L123







Right hand style shown

First cut diameter, mm, inch				Coupling size	Dimensions, mm, inch			
D_m min	a_r max	Seat size[1]	**Ordering code**	dm_m	f_1	l_1	Gauge inserts	Nm[3]
145	12	D	**570-25R/L123D12B**	25	30.85	14	N123D2-0150- CM	2.0
5.709	*.472*			*.984*	*1.215*	*.551*		
145	12		**570-32R/L123D12B**	32	34.35	14	N123D2-0150- CM	2.0
5.709	*.472*			*1.260*	*1.352*	*.551*		
139	15	E	**570-25R/L123E15B**[2]	25	33.85	14	N123E2-0200- GM	2.0
5.472	*.591*			*.984*	*1.333*	*.551*		
139	15		**570-32R/L123E15B**[2]	32	37.35	14	N123E2-0200- GM	2.0
5.472	*.591*			*1.260*	*1.470*	*.551*		
143	15	F	**570-25R/L123F15B**[2]	25	33.85	14	N123F2-0250- GM	2.0
5.630	*.591*			*.984*	*1.333*	*.551*		
139	15		**570-32R/L123F15B**[2]	32	37.35	14	N123F2-0250- GM	2.0
5.472	*.591*			*1.260*	*1.470*	*.551*		
147	18	G	**570-25R/L123G18B**[2]	25	37.6	14	N123G2-0300- GM	3.0
5.787	*.709*			*.984*	*1.480*	*.551*		
147	18		**570-32R/L123G18B**[2]	32	41.1	14	N123G2-0300- GM	3.0
5.787	*.709*			*1.260*	*1.618*	*.551*		
147	18		**570-40R/L123G18B**[2]	40	45.1	14	N123G2-0300- GM	3.0
5.787	*.709*			*1.575*	*1.776*	*.551*		
95	23	H	**570-32R/L123H23B**	32	46.1	18	N123H2-0400- GM	3.0
3.740	*.906*			*1.260*	*1.815*	*.709*		
95	23		**570-40R/L123H23B**	40	50.1	18	N123H2-0400- GM	3.0
3.740	*.906*			*1.575*	*1.972*	*.709*		
95	18	J	**570-32R/L123J18B**	32	41.1	18	N123J2-0500- GM	4.0
3.740	*.709*			*1.260*	*1.618*	*.709*		
95	18		**570-40R/L123J18B**	40	45.1	18	N123J2-0500- GM	3.0
3.740	*.709*			*1.575*	*1.776*	*.709*		
95	18	K	**570-40R/L123K18B**	40	45.1	18	N123K2-0600-GM	4.0
3.740	*.709*			*1.575*	*1.776*	*.709*		

1) To correspond with seat size on insert.

R = Right hand, L = Left hand

2) When using an insert with -GF geomery, min. hole diameter (D_m) is 130 mm (5.12 inch).

3) Insert tightening torque, Nm. Use torque wrench, see page I105.

Main spare parts

Seat size	Coupling size	Clamping screw	Key (Torx Plus)	Coolant tube
D, E, F	25	3212 012-259	5680 043-14 (20 IP)	5691 041-01
D, E, F	32	3212 012-260	5680 043-14 (20 IP)	5691 041-01
G	25	3212 012-309	5680 043-15 (25 IP)	5691 041-01
G	32	3212 012-310	5680 043-15 (25 IP)	5691 041-01
G	40	3212 012-311	5680 043-15 (25 IP)	5691 041-01
H, J	32	3212 012-310	5680 043-15 (25 IP)	5691 041-02
H, J, K	40	3212 012-311	5680 043-15 (25 IP)	5691 041-02
K	40	3212 012-311	5680 043-15 (25 IP)	5691 041-02


B6


I116


B2


I68


I56

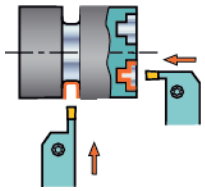

J2

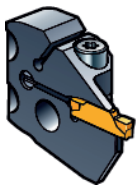
SANDVIK Coromant

CoroCut® SL

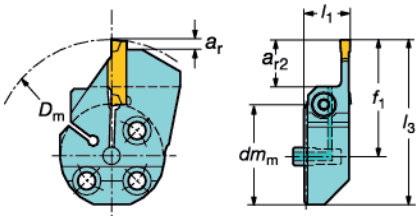
Blade for shallow grooving and face grooving

Screw clamp





R/L123



Right hand style shown

First cut diameter, mm, inch					Coupling size	Dimensions, mm, inch				
D_m min[1]	a_r	a_{r2}	Seat size[2]	**Ordering code**	dm_m	f_1	l_1	l_3	Gauge inserts	Nm[3]
147	3.5	13	G	**570-25R/L123G13C**	25	32.6	14	44.1	N123G2-0300-CM	3.0
5.787	*.138*	*.512*			*.984*	*1.284*	*.551*	*1.736*		
147	3.5	13		**570-32R/L123G13C**	32	36.1	14	51.1	N123G2-0300-CM	2.5
5.787	*.138*	*.512*			*1.260*	*1.421*	*.551*	*2.012*		
147	3.5	12		**570-40R/L123G12C**	40	39.1	14	58.1	N123G2-0300-CM	2.0
5.787	*.138*	*.472*			*1.575*	*1.539*	*.551*	*2.287*		
88	4.5	18	J	**570-32R/L123J18C**	32	41.1	14	56.1	N123J2-0500- CM	3.0
3.465	*.177*	*.709*			*1.260*	*1.618*	*.551*	*2.209*		
92	4.5	17	K	**570-40R/L123K17C**	40	44.1	18	63.1	N123K2-0600-CR	2.5
3.622	*.177*	*.669*			*1.575*	*1.736*	*.709*	*2.484*		

1) By using geometry -GF, D_m can be reduced down to 49 mm (1.929 inch) for G seat size, 58 mm (2.283 inch) for J seat size and 65 mm (2.559 inch) for K seat size.

2) To correspond with seat size on insert.

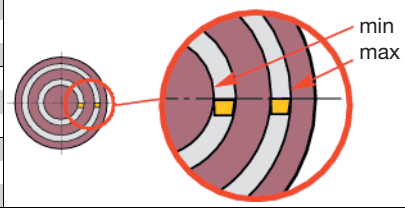
3) Insert tightening torque, Nm. Use torque wrench, see page I105.

R = Right hand, L = Left hand

Shallow grooving holders can take several insert sizes. Holders with seat size G can take insert sizes E, F and G. Holders with seat sizes J or K can take insert sizes H, J and K. Please note f_1 and l_3 dimensions above are valid when using the gauge insert.

Please note f_1 and l_3 dimensions above are valid when using the gauge insert.

Shallow grooving holder for face grooving

Holder seat size	When used with insert seat size	First cut diameter min.- max. mm	First cut diameter min.- max. inch	Max cutting depth min.- max. mm	Max cutting depth min.- max. inch	First cut diameters 123-GM, -TF, -CM, -RM, -TM
G	E	100 - ∞	3.937 - ∞	3.5	.138	
	F	83 - ∞	3.268 - ∞	3.5	.138	
	G	57 - ∞	2.244 - ∞	3.5	.138	
J	H	46 - ∞	1.811 - ∞	4.5	.177	
	J	46 - ∞	1.811 - ∞	4.5	.177	
	K	46 - ∞	1.811 - ∞	4.5	.177	
K	H	46 - ∞	1.811 - ∞	4.5	.177	
	J	46 - ∞	1.811 - ∞	4.5	.177	
	K	46 - ∞	1.811 - ∞	4.5	.177	

Main spare parts

Seat size	Coupling size	CoroCut® SL blades	Clamping screw	Key (Torx Plus)	Coolant tube
G	25	570-25R/L123G13C	3212 012-309	5680 043-15 (25IP)	5691 041-01
G	32	570-32R/L123G13C	3212 012-310	5680 043-15 (25IP)	5691 041-01
G	40	570-40R/L123GC13	3212 012-311	5680 043-15 (25IP)	5691 041-01
J	32	570-32R/L123J18C	3212 012-310	5680 043-15 (25IP)	5691 041-02
K	40	570-40R/L123K17C	3212 012-311	5680 043-15 (25IP)	5691 041-02


B6

I116

B2

I68

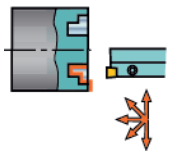
I56

J2

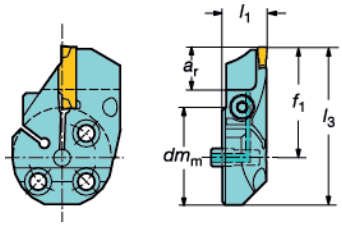
CoroCut® SL

Blade for face grooving

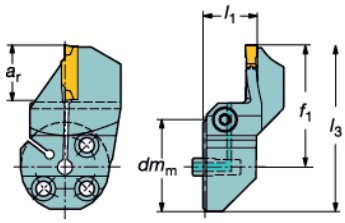
Screw clamp



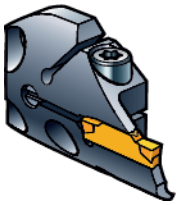
R/L123...A
A curve



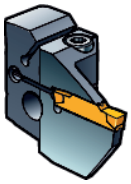
R/L123...B
B curve



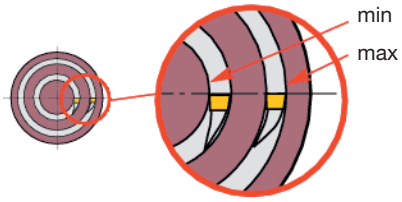
A curve



B curve



First cut diameter



Right hand style shown

First cut diameter, mm, inch				A curve	B curve	Coupling size	Dimensions, mm, inch				
min	max	a_r max	Seat size[1]	Ordering code	Ordering code	dm_m	f_1	l_1	l_3	Gauge inserts	Nm[2]
40	56	12	F	570-32R/L123F12B040A	570-32R/L123F12B040B	32	34.4	14	49.35	N123F2-0250- CM	2.0
1.575	*2.205*	*.472*				*1.260*	*1.354*	*.551*	*1.943*		
54	70	12		570-32R/L123F12B054A	570-32R/L123F12B054B	32	34.4	14	49.35	N123F2-0250- CM	2.0
2.126	*2.756*	*.472*				*1.260*	*1.354*	*.551*	*1.943*		
68	98	15		570-32R/L123F15B068A	570-32R/L123F15B068B	32	37.4	14	52.35	N123F2-0250- CM	2.0
2.677	*3.858*	*.591*				*1.260*	*1.472*	*.551*	*2.061*		
90	140	15		570-32R/L123F15B090A	570-32R/L123F15B090B	32	37.4	14	52.35	N123F2-0250- CM	2.0
3.543	*5.512*	*.591*				*1.260*	*1.472*	*.551*	*2.061*		
130	300	15		570-32R/L123F15B130A	570-32R/L123F15B130B	32	37.4	14	52.35	N123F2-0250- CM	2.0
5.118	*11.81*	*.591*				*1.260*	*1.472*	*.551*	*2.061*		
34	44	12	G	570-32R/L123G12B034A	570-32R/L123G12B034B	32	35.1	18	50.1	N123G2-0300-CM	2.5
1.339	*1.732*	*.472*				*1.260*	*1.382*	*.709*	*1.972*		
42	60	15		570-32R/L123G15B042A	570-32R/L123G15B042B	32	38.1	14	53.1	N123G2-0300-CM	3.0
1.654	*2.362*	*.591*				*1.260*	*1.500*	*.551*	*2.091*		
54	75	15		570-32R/L123G15B054A	570-32R/L123G15B054B	32	38.1	14	53.1	N123G2-0300-CM	3.0
2.126	*2.953*	*.591*				*1.260*	*1.500*	*.551*	*2.091*		
67	100	18		570-32R/L123G18B067A	570-32R/L123G18B067B	32	41.1	14	56.1	N123G2-0300-CM	3.0
2.638	*3.937*	*.709*				*1.260*	*1.618*	*.551*	*2.209*		
90	160	18		570-32R/L123G18B090A	570-32R/L123G18B090B	32	41.1	14	56.1	N123G2-0300-CM	3.0
3.543	*6.299*	*.709*				*1.260*	*1.618*	*.551*	*2.209*		
130	300	18		570-32R/L123G18B130A	570-32R/L123G18B130B	32	41.1	14	56.1	N123G2-0300-CM	3.0
5.118	*11.81*	*.709*				*1.260*	*1.618*	*.551*	*2.209*		
40	60	18	H	570-32R/L123H18B040A	570-32R/L123H18B040B	32	41.1	18	56.1	N123H2-0400- CM	3.0
1.575	*2.362*	*.709*				*1.260*	*1.618*	*.709*	*2.209*		
52	72	18		570-32R/L123H18B052A	570-32R/L123H18B052B	32	41.1	18	56.1	N123H2-0400- CM	3.0
2.047	*2.835*	*.709*				*1.260*	*1.618*	*.709*	*2.209*		
64	100	18		570-32R/L123H18B064A	570-32R/L123H18B064B	32	41.1	18	56.1	N123H2-0400- CM	3.0
2.520	*3.937*	*.709*				*1.260*	*1.618*	*.709*	*2.209*		
92	140	18		570-32R/L123H18B092A	570-32R/L123H18B092B	32	41.1	18	56.1	N123H2-0400- CM	3.0
3.622	*5.512*	*.709*				*1.260*	*1.618*	*.709*	*2.209*		
132	230	18		570-32R/L123H18B132A	570-32R/L123H18B132B	32	41.1	18	56.1	N123H2-0400- CM	3.0
5.197	*9.055*	*.709*				*1.260*	*1.618*	*.709*	*2.209*		
220	500	18		570-32R/L123H18B220A	570-32R/L123H18B220B	32	41.1	18	56.1	N123H2-0400- CM	3.0
8.661	*19.68*	*.709*				*1.260*	*1.618*	*.709*	*2.209*		
300		18		570-32R/L123H18B300A	570-32R/L123H18B300B	32	41.1	18	56.1	N123H2-0400- CM	3.0
11.81		*.709*				*1.260*	*1.618*	*.709*	*2.209*		

[1] To correspond with seat size on insert.

[2] Insert tightening torque, Nm. Use torque wrench, see page I105.

R = Right hand, L = Left hand

Continued ...

 B6
 I116
 B2
 I68
 I56
 J2

CoroCut® SL

Blade for face grooving

Screw clamp

... Continued

First cut diameter, mm, inch				A curve	B curve	Coupling size	Dimensions, mm, inch				
min	max	a_r max	Seat size[1]	Ordering code	Ordering code	dm_m	f_1	l_1	l_3	Gauge inserts	Nm[2]
40	70	18	J	570-32R/L123J18B040A	570-32R/L123J18B040B	32	41.1	18	56.1	N123J2-0500- CM	3.5
1.575	2.756	.709				1.260	1.618	.709	2.209		
60	95	18		570-32R/L123J18B060A	570-32R/L123J18B060B	32	41.1	18	56.1	N123J2-0500- CM	3.5
2.362	3.740	.709				1.260	1.618	.709	2.209		
85	130	18		570-32R/L123J18B085A	570-32R/L123J18B085B	32	41.1	18	56.1	N123J2-0500- CM	3.5
3.346	5.118	.709				1.260	1.618	.709	2.209		
120	180	18		570-32R/L123J18B120A	570-32R/L123J18B120B	32	41.1	18	56.1	N123J2-0500- CM	3.5
4.724	7.087	.709				1.260	1.618	.709	2.209		
175	500	18		570-32R/L123J18B175A	570-32R/L123J18B175B	32	41.1	18	56.1	N123J2-0500- CM	3.5
6.890	19.68	.709				1.260	1.618	.709	2.209		
180		18		570-32R/L123J18B180A	570-32R/L123J18B180B	32	41.1	18	56.1	N123J2-0500- CM	3.5
7.087		.709				1.260	1.618	.709	2.209		
40	70	18	K	570-32R/L123K18B040A	570-32R/L123K18B040B	32	41.1	18	56.1	N123K2-0600-CR	4.0
1.575	2.756	.709				1.260	1.618	.709	2.209		
58	100	18		570-32R/L123K18B058A	570-32R/L123K18B058B	32	41.1	18	56.1	N123K2-0600-CR	4.0
2.284	3.937	.709				1.260	1.618	.709	2.209		
88	180	18		570-32R/L123K18B088A	570-32R/L123K18B088B	32	41.1	18	56.1	N123K2-0600-CR	4.0
3.465	7.087	.709				1.260	1.618	.709	2.209		
168	400	18		570-32R/L123K18B168A	570-32R/L123K18B168B	32	41.1	18	56.1	N123K2-0600-CR	4.0
6.614	15.74	.709				1.260	1.618	.709	2.209		
220		18		570-32R/L123K18B220A	570-32R/L123K18B220B	32	41.1	18	56.1	N123K2-0600-CR	4.0
8.661		.709				1.260	1.618	.709	2.209		

[1] To correspond with seat size on insert.

R = Right hand, L = Left hand

[2] Insert tightening torque, Nm. Use torque wrench, see page I105.

Main spare parts

Seat size	Coupling size	Screw	Key (Torx Plus)	Coolant tube
F	32	3212 012-260	5680 043-14 (20IP)	5691 041-01
G		3212 012-310	5680 043-15 (25IP)	5691 041-01
H, J, K		3212 012-310	5680 043-15 (25IP)	5691 041-02


B6


I116


B2


I68


I56

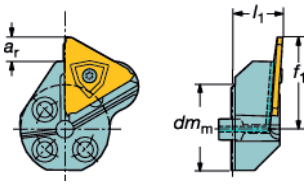

J2

CoroCut® 3 SL

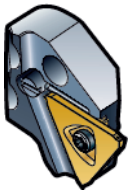
Blade for shallow parting

Screw clamp design

R/L123 U/T



Left hand tool with right hand insert (T) shown



a_r max mm	a_r max in.	Seat size[1]	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[2]
6.4	.252	T	**570-25L123T06B**	25	26	1.024	14	.551	N123T3-0150- CM	3.0
6.4	.252		**570-32L123T06B**	32	28.5	1.122	14	.551	N123T3-0150- CM	3.0
6.4	.252		**570-40L123T06B**	40	32.5	1.280	14	.551	N123T3-0150- CM	3.0
6.4	.252	U	**570-25R123U06B**	25	26	1.024	14	.551	N123U3-0150- CM	3.0
6.4	.252		**570-32R123U06B**	32	28.5	1.122	14	.551	N123U3-0150- CM	3.0
6.4	.252		**570-40R123U06B**	40	32.5	1.280	14	.551	N123U3-0150- CM	3.0

1) To correspond with seat size on insert.

2) Insert tightening torque, Nm. Use torque wrench, see page I105.

T = Right hand cutting insert, U = Left hand

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

Main spare parts

Coupling size	Screw	Key (Torx Plus)	Screwdriver	Coolant tube
25-40	5513 020-62	5680 049-02 (15IP)	5680 046-01 (8IP)	5691 041-01

Min. hole diameter on internal grooving with CoroCut 3

1 mm (.039 inch) insert width

1.5 & 2 mm (.059 & .079 inch) insert width

Cutting depth, mm, inch

Cutting depth, mm, inch


B6


I117


B2


I68

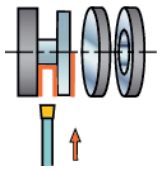

I56

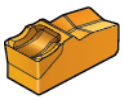

J2

T-Max Q-Cut® SL

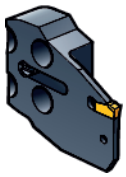
Blade for grooving and parting

Spring clamp



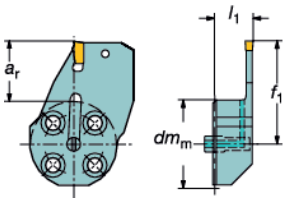


151.2-4E



These T-Max Q-Cut® SL blades can only accept the 151.2 inserts.

R/L151.21



For deep grooves

Right hand style shown.

a_r max mm	a_r max in.	Seat size[1]	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts
20	.787	20	**570-25R/L151.21-20-20**	25	34.1	1.342	14	.551	N151.2-200- 5E
20	.787		**570-32R/L151.21-20-20**	32	37.6	1.480	14	.551	N151.2-200- 5E
20	.787	25	**570-25R/L151.21-20-25**	25	34.1	1.342	14	.551	N151.2-250- 5E
20	.787		**570-32R/L151.21-20-25**	32	37.6	1.480	14	.551	N151.2-250- 5E
30	1.181	30	**570-25R/L151.21-30-30**	25	44.1	1.736	14	.551	N151.2-300- 5E
30	1.181		**570-32R/L151.21-30-30**	32	47.6	1.874	14	.551	N151.2-300- 5E
32	1.260	40	**570-32R/L151.21-32-40**	32	47.6	1.953	14	.551	N151.2-400- 5E
32	1.260		**570-40R/L151.21-32-40**	40	53.6	2.110	14	.551	N151.2-400- 5E
32	1.260	50	**570-32R/L151.21-32-50**	32	49.6	1.953	14	.551	N151.2-500- 5E
32	1.260		**570-40R/L151.21-32-50**	40	53.6	2.110	14	.551	N151.2-500- 5E

[1] To correspond with seat size on insert.

R = Right hand, L = Left hand

Main spare parts

Seat size	Coolant tube	Insert key[1]
20, 25, 30	5691 041-01	5680 057-021
40, 50	5691 041-03	5680 057-011

[1] Delivery to separate order


B6


I117


B2


I68

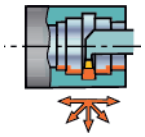

I4


J2

T-Max Q-Cut® SL (Type 151.3)

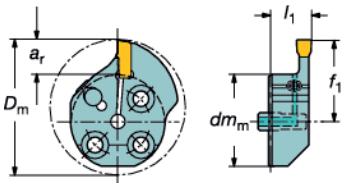
Blade for internal grooving and profiling

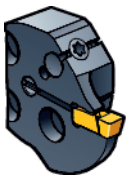
Screw clamp



151.3-4G

R/L151.3





These T-Max Q-Cut® SL blades can only accept the 151.3 inserts

Right hand style shown.

D_m min mm	D_m min in.	a_r max mm	a_r max in.	Seat size[1]	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[2]
35.6	1.402	8	.315	20	**570-25R/L151.3-08-20**	25	22.1	.870	14	.551	N151.3-200-20- 4G	3.0
42.6	1.677	8	.315		**570-32R/L151.3-08-20**	32	25.6	1.008	14	.551	N151.3-200-20- 4G	3.0
40	1.575	8	.315	25	**570-25R/L151.3-08-25**	25	22.1	.870	14	.551	N151.3-300-25- 7G	3.0
41.6	1.638	7	.276		**570-32R/L151.3-07-25**	32	24.6	.968	14	.551	N151.3-300-25- 7G	3.0
40.7	1.602	8	.315	30	**570-25R/L151.3-08-30**	25	22.1	.870	14	.551	N151.3-300-30- 4G	3.0
42.6	1.677	8	.315		**570-32R/L151.3-08-30**	32	25.6	1.008	14	.551	N151.3-300-30- 4G	3.0
48.6	1.913	6	.236		**570-40R/L151.3-06-30**	40	27.6	1.087	14	.551	N151.3-300-30- 4G	3.0
48	1.890	10	.394	40	**570-32R/L151.3-10-40**	32	27.6	1.087	14	.551	N151.3-500-40- 7G	3.0
51.6	2.031	9	.354		**570-40R/L151.3-09-40**	40	30.6	1.205	14	.551	N151.3-500-40- 7G	3.0
48.8	1.921	10	.394	50	**570-32R/L151.3-10-50**	32	27.6	1.087	14	.551	N151.3-600-50- 7G	3.0
51.6	2.031	9	.354		**570-40R/L151.3-09-50**	40	30.6	1.205	14	.551	N151.3-600-50- 7G	3.0
47.6	1.874	13	.512	60	**570-32R/L151.3-13-60**	32	30.6	1.205	14	.551	N151.3-800-60- 4G	3.0
54.6	2.150	12	.472		**570-40R/L151.3-12-60**	40	33.6	1.323	14	.551	N151.3-800-60- 4G	3.0

[1] To correspond with seat size on insert.

[2] Insert tightening torque, Nm. Use torque wrench, see page I105.

R = Right hand, L = Left hand

Main spare parts

Seat size	Clamping screw	Key (Torx Plus)	Clamping nut	Coolant tube
20, 25	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-01
30, 40, 50, 60	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-03


B6


I117


B2


I68

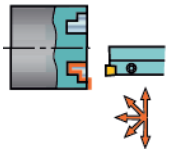

I56


J2

T-Max Q-Cut® SL (Type 151.3)

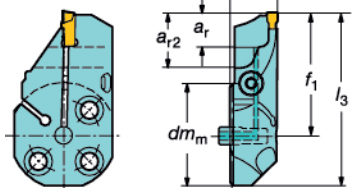
Blade for face grooving

Screw clamp

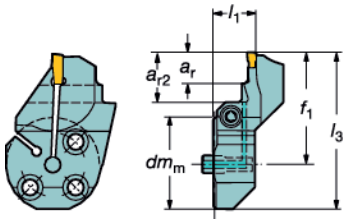


151.3-4G

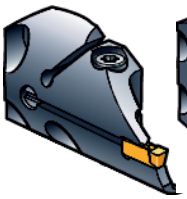
R/L151.3...A
A curve



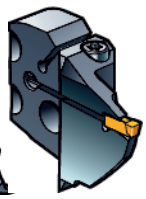
R/L151.3...B
B curve



A curve

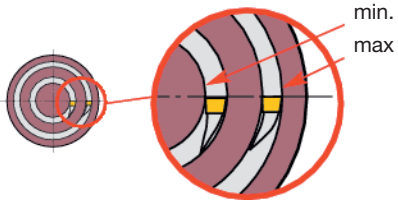


B curve



These T-Max Q-Cut® SL blades can only accept the 151.3 inserts

First cut diameter



Right hand style shown

First cut diameter, mm, inch												
min	max	a_r max	a_{r2} max	Seat size[1]	**A curve** Ordering code	**B curve** Ordering code	Coupling size dm_m	Dimensions, mm, inch f_1	l_1	l_3	Gauge inserts	Nm[2]
24	35	8.686	15	25	570-32R/L151.3-024A25	570-32R/L151.3-024B25	32	37.4	14	52.35	N151.3-300-25- 7G	2.0
.945	*1.378*	*.342*	*.591*				*1.260*	*1.472*	*.551*	*2.061*		
29	40	8.686	15		570-32R/L151.3-029A25	570-32R/L151.3-029B25	32	37.4	14	52.35	N151.3-300-25- 7G	2.0
1.142	*1.575*	*.342*	*.591*				*1.260*	*1.472*	*.551*	*2.061*		
27	45	8.686	20	30	570-32R/L151.3-027A30	570-32R/L151.3-027B30	32	43.1	14	58.1	N151.3-400-30- 7G	3.5
1.063	*1.772*	*.342*	*.787*				*1.260*	*1.697*	*.551*	*2.287*		
32	50	8.686	20		570-32R/L151.3-032A30	570-32R/L151.3-032B30	32	43.1	14	58.1	N151.3-400-30- 7G	3.5
1.260	*1.968*	*.342*	*.787*				*1.260*	*1.697*	*.551*	*2.287*		
25	45	10.69	20	40	570-32R/L151.3-025A40	570-32R/L151.3-025B40	32	43.1	18	58.1	N151.3-500-40- 7G	3.5
.984	*1.772*	*.421*	*.787*				*1.260*	*1.697*	*.709*	*2.287*		
30	55	10.69	20		570-32R/L151.3-030A40	570-32R/L151.3-030B40	32	43.1	18	58.1	N151.3-500-40- 7G	3.5
1.181	*2.165*	*.421*	*.787*				*1.260*	*1.697*	*.709*	*2.287*		
23	45	18.00	18	50	570-32R/L151.3-023A50	570-32R/L151.3-023B50	32	41.1	18	56.1	N151.3-600-50- 7G	4.0
.906	*1.772*	*.709*	*.709*				*1.260*	*1.618*	*.709*	*2.209*		
38	70	18.00			570-32R/L151.3-038A50	570-32R/L151.3-038B50	32	41.1	18	56.1	N151.3-600-50- 7G	4.0
1.496	*2.756*	*.709*					*1.260*	*1.618*	*.709*	*2.209*		

[1] To correspond with seat size on insert.

[2] Insert tightening torque, Nm. Use torque wrench, see page I105.

R = Right hand, L = Left hand

Main spare parts

Seat size	Screw	Key (Torx Plus)	Coolant tube
25	3212 012-260	5680 043-14 (20IP)	5691 041-01
30	3212 012-310	5680 043-15 (25IP)	5691 041-03
40	3212 012-310	5680 043-15 (25IP)	5691 041-02
50	3212 012-310	5680 043-15 (25IP)	5691 041-02


B6


I117


B2

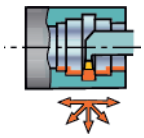

I68


I56

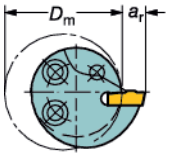

J2

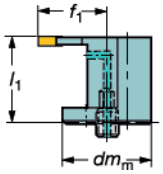
T-Max Q-Cut® SL (Type 151.3)

Cutting head for grooving and profiling



R/LAG551.31





These T-Max Q-Cut® SL blades can only accept the 151.3 inserts

Right hand style shown

D_m min mm	D_m min in.	a_r max mm[1]	a_r max in.[1]	Seat size[2]	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts
25	.984	8.5	.335	20	**R/LAG551.31-160808-20**	16	16.5	.650	8	.315	N151.3-200-20- 4G
20	.787	3.5	.138		**R/LAG551.31-161603-20**	16	11.5	.453	16	.630	N151.3-200-20- 4G
22	.866	5.6	.220	25	**R/LAG551.31-161605-25**	16	13.6	.535	15.9	.626	N151.3-265-25- 4G
32	1.260	11.6	.457		**R/LAG551.31-201011-25**	20	21.6	.850	9.9	.390	N151.3-265-25- 4G
25	.984	4.6	.181		**R/LAG551.31-202004-25**	20	14.6	.575	19.9	.784	N151.3-265-25- 4G
25	.984	4.5	.177	30	**R/LAG551.31-202004-30**	20	14.5	.571	19.5	.768	N151.3-300-30- 4G
40	1.575	14.5	.571		**R/LAG551.31-251214-30**	25	27	1.063	12	.472	N151.3-300-30- 4G
32	1.260	6.5	.256		**R/LAG551.31-252506-30**	25	19	.748	24.5	.965	N151.3-300-30- 4G
32	1.260	6.6	.260	40	**R/LAG551.31-252506-40**	25	19.15	.754	24.5	.965	N151.3-400-40- 4G
50	1.968	17.6	.693		**R/LAG551.31-321617-40**	32	33.65	1.325	15.5	.610	N151.3-400-40- 4G
40	1.575	7.6	.299		**R/LAG551.31-323207-40**	32	23.65	.931	31.5	1.240	N151.3-400-40- 4G
40	1.575	7.5	.295	50	**R/LAG551.31-323207-50**	32	23.5	.925	31.5	1.240	N151.3-500-50- 4G
60	2.362	19.5	.768		**R/LAG551.31-402019-50**	40	39.5	1.555	19.5	.768	N151.3-500-50- 4G
50	1.968	9.5	.374		**R/LAG551.31-404009-50**	40	29.5	1.161	39.5	1.555	N151.3-500-50- 4G
50	1.968	9.5	.374	60	**RAG551.31-404009-60**	40	29.5	1.161	40	1.575	N151.3-800-60- 4G

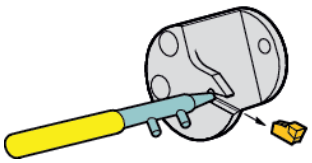
1) For max stability choose a holder with shortest possible a_r.

2) To correspond with seat size on insert.

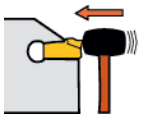
R = Right hand, L = Left hand

Spare part

Delivery to separate order



Insert key
5680 057-021



No pivot holes are provided in the T-Max Q-Cut® SL cutting heads (R/LAG 551.31) or the smaller MBS blades for parting or face grooving. For these items a small rubber hammer should be used to tap the insert into its final position. The tip of the yellow key should be used to extract the insert.


B6


I116


I56

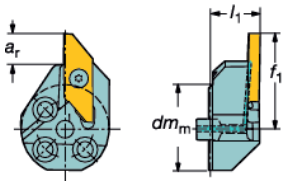

J2

CoroCut® XS SL

Blade for grooving, parting off, profiling and turning

Screw clamp

R/LSMAL



Right hand style shown

a_r max mm	a_r max in.	Seat size[1]	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[2]
8.2	.323	3	**570-25R/LSMAL3**	25	26.8	1.055	14	.551	MAxR 3..	1.2
8.2	.323		**570-32R/LSMAL3**	32	30.5	1.201	14	.551	MAxR 3..	1.2

[1] To correspond with seat size on insert.

R = Right hand, L = Left hand

[2] Insert tightening torque, Nm. Use torque wrench, see page I105.

Main spare parts

Seat size	Screw	Key (Torx Plus)	Coolant tube
3	5513 027-01	5680 046-01 (8IP)	5691 041-01


B6


B2


I68


I56


J2

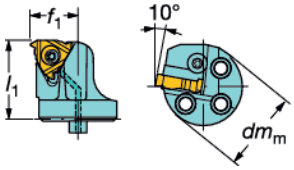
CoroThread® 266 SL

Cutting head for external threading

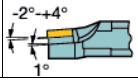
Screw clamp design

266 R/LG

SL-266R/LFG

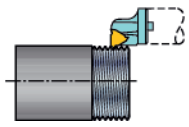


△	*iC*	
16	3/8	Angle of inclination from –2° to +4° with different shims, see page C45.



x and z, see infeed tables on pages C70.

Right hand style shown

Main application	Insert size △	*iC*	Pitch range mm	TPI	**Ordering code**	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) f_1 mm	f_1 in.	l_1 mm	l_1 in.	Nm[1]
	16	3/8	0.5-3.0	32-6	**SL-266R/LFG-252517-16**	25	17.0	.6693	25.0	.984	3.0
					SL-266R/LFG-323222-16	32	22.0	.8661	32.0	1.260	3.0
					SL-266R/LFG-403227-16	40	27.0	1.063	32.0	1.260	3.0

[1] Insert tightening torque, Nm.

R = Right hand, L = Left hand

When using an external CoroThread 266 SL cutting head the right hand head uses a left hand external insert and left hand head uses a right hand external insert.

Main spare parts

Insert size △	*iC*	Insert screw	Key (Torx Plus)	Shim for right hand external toolholder[1] Inclination angle +1°	Shim for left hand external toolholder[1] Inclination angle +1°	Shim screw
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 389-11	5322 390-11	5512 032-05

[1] For optional shims, see page C45.

 I118
 G6
 B2
 J2

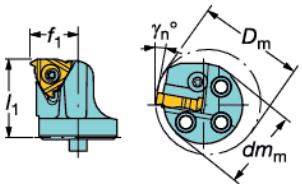
CoroThread® 266 SL

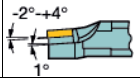
Cutting head for internal threading

Screw clamp design

266 R/LL

SL-266R/LKF

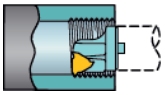


△	*iC*	Angle of inclination from –2° to +4° with different shims, see page C45.
16	3/8	

x and z, see infeed tables on pages C70.

Internal cutting fluid supply

Right hand style shown

Main application	Insert size △	*iC*	Pitch range mm	TPI	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	γ_n	Nm[1]
	16	3/8	0.5-3.0	32-6	**SL-266R/LKF-252517-16**	25	32	1.260	17.0	.6693	25.0	.984	-15°	3.0
					SL-266R/LKF-323222-16	32	40	1.575	22.0	.8661	32.0	1.260	-15°	3.0
					SL-266R/LKF-403227-16	40	50	1.968	27.0	1.063	32.0	1.260	-15°	3.0
	22	1/2	2.5-7.0	11.5-4	**SL-266R/LKF-323222-22**	32	40	1.575	21.9	.8622	32.0	1.260	-15°	5.0
					SL-266R/LKF-403227-22	40	50	1.968	26.9	1.059	32.0	1.260	-15°	5.0
	27	5/8	8.0	5-3	**SL-266R/LKF-403627-27**	40	50	1.968	26.9	1.059	36.0	1.417	-10°	7.5

[1] Insert tightening torque, Nm.

266R = Right hand, 266L = Left hand

Main spare parts

Insert size △	*iC*	Insert screw	Key (Torx Plus)	Shim for right hand internal tool holder[1] Inclination angle +1°	Shim for left hand internal tool holder[1] Inclination angle +1°	Shim screw
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 390-11	5322 389-11	5512 032-05
22	1/2	5513 020-26	5680 043-14 (20IP)	5322 380-11	5322 379-11	5512 032-04
27	5/8	5513 020-66	5680 043-15 (25IP)	5322 388-11	5322 387-11	5512 032-03

[1] For optional shims, see page C45.

 I118

 G6

 B2

 J2

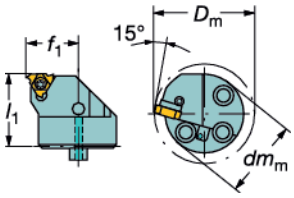
T-Max U-Lock® SL

Cutting head for internal threading

Screw clamp design

166.0L,
154.0G[1)]

R566.4KFC

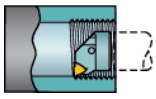


△	*iC*	
11	1/4	No shims used

x and z, see infeed tables on pages C70.

Internal cutting fluid supply

Right hand style shown

Main application	Insert size △	*iC*	Pitch range mm	TPI	Ordering code	Coupling size dm_m	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Nm[1)]
	11	1/4	0.5-2.0	32-12	**R/L566.0KFC-162012-11**	16	20	.787	12.0	.4724	20.0	.787	0.9
					R/L566.0KFC-202014-11	20	25	.984	14.0	.5512	20.0	.787	0.9

[1)] Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size △	*iC*	Insert screw	Key (Torx Plus)
11	1/4	5513 020-03	5680 051-02 (7IP)

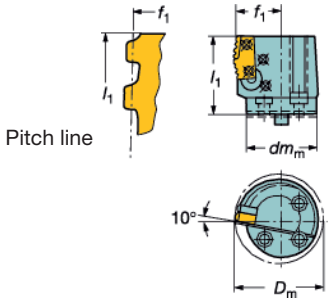
Twin-Lock® SL

Cutting head for oil pipe threading

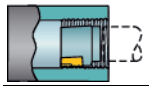
Lever clamp design

R166.39G/L

R 566.39KF



Right hand style shown

Main application	Pitch range TPI	Ordering code	Coupling size dm_m	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.
	10-5	**R566.39KF-404527-24[1)]**	40	60.3	2.374	25.8	1.016	44.2	1.740

[1)] Only for API Round Vee inserts, 8 and 10 TPI.

R = Right hand

Main spare parts

	Lever	Screw	Key (mm)	Shim
R566.39KF	5432 005-01	174.3-820M	170.3-860 (2.5)	5321 111-01

 C4

 I56

 C68

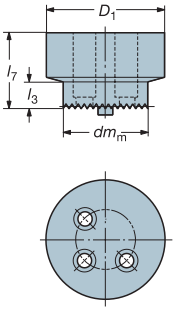
 C2

 J2

Cutting heads with CoroTurn® SL coupling

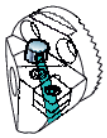
Blanks

R/L570-



Right hand style shown

Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_1 mm	D_1 in.	l_3 mm	l_3 in.	l_7 mm	l_7 in.
R/L570-162513B	16	26	1.024	7.0	.276	25.0	.984
R/L570-202517B	20	34	1.339	7.0	.276	25.0	.984
R/L570-252517B	25	34	1.339	7.0	.276	25.0	.984
R/L570-324022B	32	44	1.732	11.0	.433	40.0	1.575
R/L570-404527B	40	54	2.126	11.0	.433	45.0	1.772
R/L570-504535B	50	70	2.756	16.0	.630	45.0	1.772
R/L570-604543B	60	86	3.386	16.0	.630	45.0	1.772



Coolant nozzles, see page A308.

Main spare parts

Coupling size, dm_m	Locating tube
16	5552 058-01
20-25	5552 058-02
32-40	5638 031-01
50	5638 031-02
60	5638 031-03

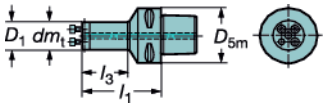

I56

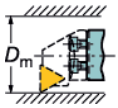

J2

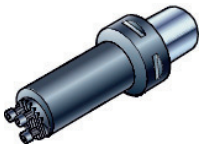
CoroTurn® SL

Coromant Capto® boring bars

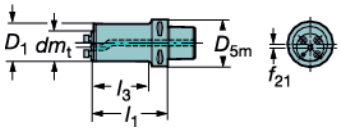
C..-570-2C







C..-570-2C...-40R/L
Bars with reduction dia (1.969-1.575, 2.362-1.575 inch)



With internal coolant supply
Right hand style shown

	Bar dia. mm		Coupling size	Dimensions, millimeter, inch (mm, in.)										
	D_1	**Ordering code**	dm_t	D_m min, mm	D_m min in.	D_{5m} mm	D_{5m} in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	l_3 mm	l_3 in.	kg
	16	**C3-570-2C 16 045**	16	20.0	.787	32	1.260			45.0	1.772	28.0	1.102	0.2
	20	**C3-570-2C 20 050**	20	25.0	.984	32	1.260			50.0	1.968	33.0	1.299	0.2
	25	**C3-570-2C 25 064**	25	32.0	1.260	32	1.260			64.0	2.520	48.0	1.890	0.3
	32	**C3-570-2C 32 053**	32	40.0	1.575	32	1.260			53.0	2.087	53.0	2.087	0.4
	16	**C4-570-2C 16 048**	16	20.0	.787	40	1.575			48.0	1.890	25.0	.984	0.3
	20	**C4-570-2C 20 058**	20	25.0	.984	40	1.575			58.0	2.284	35.0	1.378	0.4
	25	**C4-570-2C 25 064**	25	32.0	1.260	40	1.575			64.0	2.520	42.0	1.654	0.4
	32	**C4-570-2C 32 074**	32	40.0	1.575	40	1.575			74.0	2.913	53.0	2.087	0.6
	40	**C4-570-2C 40 073**	40	50.0	1.968	40	1.575			73.0	2.874	73.0	2.874	0.8
	16	**C5-570-2C 16 052**	16	20.0	.787	50	1.968			52.0	2.047	28.0	1.102	0.5
	20	**C5-570-2C 20 059**	20	25.0	.984	50	1.968			59.0	2.323	35.0	1.378	0.6
	25	**C5-570-2C 25 067**	25	32.0	1.260	50	1.968			67.0	2.638	44.0	1.732	0.6
	32	**C5-570-2C 32 075**	32	40.0	1.575	50	1.968			75.0	2.953	53.0	2.087	0.8
	40	**C5-570-2C 40 094**	40	50.0	1.968	50	1.968			94.0	3.701	73.0	2.874	1.2
	16	**C6-570-2C 16 056**	16	20.0	.787	63	2.480			56.0	2.205	28.0	1.102	0.9
	20	**C6-570-2C 20 068**	20	25.0	.984	63	2.480			67.0	2.638	40.0	1.575	1.0
	25	**C6-570-2C 25 082**	25	32.0	1.260	63	2.480			82.0	3.228	55.0	2.165	1.0
	32	**C6-570-2C 32 081**	32	40.0	1.575	63	2.480			81.0	3.189	55.0	2.165	1.2
	40	**C6-570-2C 40 092**	40	50.0	1.968	63	2.480			92.0	3.622	67.0	2.638	1.5
	40	**C8-570-2C 40 105**	40	50.0	1.968	80	3.150			105.0	4.134	77.0	3.032	2.4
	50	**C5-570-2C 50 098-40R/L**	40	60.0	2.362	50	1.968	5.0	.197	98.0	3.858	98.0	3.858	1.7
	50	**C6-570-2C 50 124-40R/L**	40	60.0	2.362	63	2.480	5.0	.197	124.0	4.882	98.0	3.858	2.4
	60	**C6-570-2C 60 148-40R/L**	40	72.0	2.835	63	2.480	10.0	.394	148.0	5.827	123.0	4.842	3.5
	50	**C8-570-2C 50 125-40R/L**	40	60.0	2.362	80	3.150	5.0	.197	125.0	4.921	96.0	3.780	3.2
	60	**C8-570-2C 60 150-40R/L**	40	72.0	2.835	80	3.150	10.0	.394	150.0	5.906	123.0	4.842	4.3

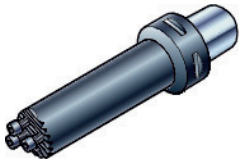
A reduction adapter can be used to build tools such as:
C5 dm_t 16 mm (.630 inch)
C6 dm_t 16-25 mm (.630-.984 inch)
C8 dm_t 16-60 mm (.630-2.362 inch)
See page G28.

R = Right hand, L = Left hand

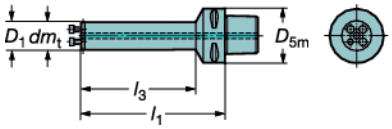
 I113  G6  J2

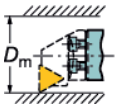
CoroTurn® SL

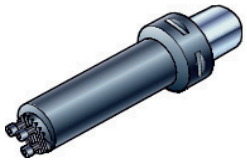
Coromant Capto® dampened boring bars



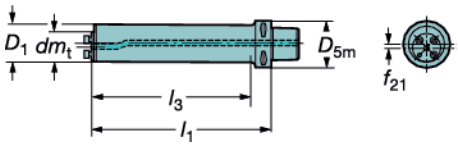
C..-570-3C





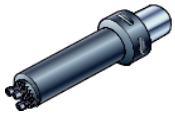


C..-570-3C...-40R/L
Bars with reduction dia



Silent Tools®

With internal coolant supply
Right hand style shown

	Bar dia. mm		Coupling size	Dimensions, millimeter, inch (mm, in.)										
	D_1	Ordering code	dm_t	D_m min, mm	D_m min in.	D_{5m} mm	D_{5m} in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	l_3 mm	l_3 in.	kg
	16	C3-570-3C 16 082	16	20.0	.787	32	1.260			82.0	3.228	65.0	2.559	0.3
	20	C3-570-3C 20 101	20	25.0	.984	32	1.260			102.0	4.016	85.0	3.346	0.4
	25	C3-570-3C 25 125	25	32.0	1.260	32	1.260			125.0	4.921	110.0	4.331	0.6
	32	C3-570-3C 32 133	32	40.0	1.575	32	1.260			133.0	5.236	133.0	5.236	1.0
	16	C4-570-3C 16 088	16	20.0	.787	40	1.575			88.0	3.465	65.0	2.559	0.4
	20	C4-570-3C 20 107	20	25.0	.984	40	1.575			107.0	4.213	85.0	3.346	0.5
	25	C4-570-3C 25 132	25	32.0	1.260	40	1.575			132.0	5.197	110.0	4.331	0.8
	32	C4-570-3C 32 154	32	40.0	1.575	40	1.575			154.0	6.063	133.0	5.236	1.3
	40	C4-570-3C 40 173	40	50.0	1.968	40	1.575			173.0	6.811	173.0	6.811	1.8
	16	C5-570-3C 16 085	16	20.0	.787	50	1.968			84.0	3.307	60.0	2.362	0.6
	20	C5-570-3C 20 109	20	25.0	.984	50	1.968			109.0	4.291	85.0	3.346	0.7
	25	C5-570-3C 25 133	25	32.0	1.260	50	1.968			133.0	5.236	110.0	4.331	1.0
	25	C5-570-3C 25 230	25	32.0	1.260	50	1.968			230.0	9.055	206.0	8.110	1.4
	32	C5-570-3C 32 154	32	40.0	1.575	50	1.968			154.0	6.063	133.0	5.236	1.5
	32	C5-570-3C 32 288	32	40.0	1.575	50	1.968			288.0	11.339	265.0	10.433	2.4
	40	C5-570-3C 40 194	40	50.0	1.968	50	1.968			194.0	7.638	173.0	6.811	2.5
	40	C5-570-3C 40 368	40	50.0	1.968	50	1.968			368.0	14.488	346.0	13.622	4.1
	50	C5-570-3C 50 215	50	60.0	2.362	50	1.968			215.0	8.465	215.0	8.465	3.5
	16	C6-570-3C 16 088	16	20.0	.787	63	2.480			88.0	3.465	60.0	2.362	1.0
	20	C6-570-3C 20 108	20	25.0	.984	63	2.480			108.0	4.252	80.0	3.150	1.0
	25	C6-570-3C 25 132	25	32.0	1.260	63	2.480			132.0	5.197	105.0	4.134	1.4
	25	C6-570-3C 25 230	25	32.0	1.260	63	2.480			230.0	9.055	203.0	7.992	1.7
	32	C6-570-3C 32 159	32	40.0	1.575	63	2.480			159.0	6.260	133.0	5.236	1.9
	32	C6-570-3C 32 288	32	40.0	1.575	63	2.480			288.0	11.339	262.0	10.315	2.7
	40	C6-570-3C 40 198	40	50.0	1.968	63	2.480			198.0	7.795	173.0	6.811	2.6
	40	C6-570-3C 40 368	40	50.0	1.968	63	2.480			368.0	14.488	343.0	13.504	4.2
	50	C6-570-3C 50 239	50	60.0	2.362	63	2.480			239.0	9.409	215.0	8.465	4.2
	60	C6-570-3C 60 287	60	80.0	3.150	63	2.480			287.0	11.299	265.0	10.433	6.6
	25	C8-570-3C 25 147	25	32.0	1.260	80	3.150			147.0	5.787	110.0	4.331	2.3
	32	C8-570-3C 32 172	32	40.0	1.575	80	3.150			172.0	6.772	136.0	5.354	2.8
	40	C8-570-3C 40 224	40	50.0	1.968	80	3.150			224.0	8.819	189.0	7.441	3.7
	40	C8-570-3C 40 368	40	50.0	1.968	80	3.150			368.0	14.488	334.0	13.150	5.4
	50	C5-570-3C 50 223-40R/L	40	60.0	2.362	50	1.968	5.0		223.0	8.780	223.0	8.780	3.6
	50	C6-570-3C 50 247-40R/L	40	60.0	2.362	63	2.480	5.0	.197	247.0	9.724	221.0	8.701	4.2
	50	C6-570-3C 50 468-40R/L	40	60.0	2.362	63	2.480	5.0	.197	468.0	18.425	444.0	17.480	7.4
	60	C6-570-3C 60 295-40R/L	40	72.0	2.835	63	2.480	10.0	.394	295.0	11.614	267.0	10.512	6.8
	60	C6-570-3C 60 568-40R/L	40	72.0	2.835	63	2.480	10.0	.394	568.0	22.362	545.0	21.457	12.2
	50	C8-570-3C 50 297-40R/L	40	60.0	2.362	80	3.150	5.0	.197	297.0	11.693	263.0	10.354	5.8
	50	C8-570-3C 50 468-40R/L	40	60.0	2.362	80	3.150	5.0	.197	468.0	18.425	436.0	17.165	8.3
	60	C8-570-3C 60 355-40R/L	40	72.0	2.835	80	3.150	10.0	.394	355.0	13.976	322.0	12.677	8.9
	60	C8-570-3C 60 568-40R/L	40	72.0	2.835	80	3.150	10.0	.394	568.0	22.362	535.0	21.063	12.4

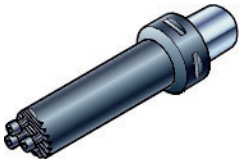
A reduction adapter can be used to build tools such as:
C5 dm_t 16 mm (.630 inch)
C6 dm_t 16-25 mm (.630-.984 inch)
C8 dm_t 16-60 mm (.630-2.362 inch)
See page G28.

R = Right hand, L = Left hand

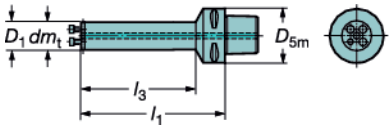
 I112
 G6
 J2

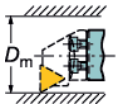
CoroTurn® SL

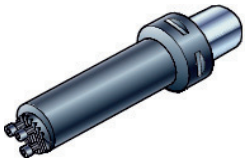
Coromant Capto® short dampened boring bars



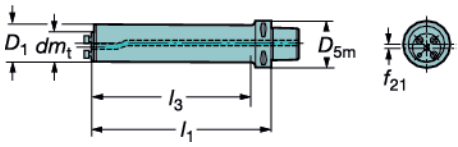
C..-570-4C







C..-570-4C...-40R/L
Bars with reduction dia



Silent Tools®

With internal coolant supply
Right hand style shown

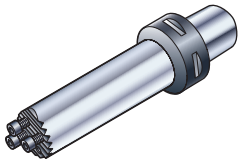
	Bar dia. mm		Coupling size	Dimensions, millimeter, inch (mm, in.)										
	D_1	**Ordering code**	dm_t	D_m min, mm	D_m min in.	D_{5m} mm	D_{5m} in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	l_3 mm	l_3 in.	kg
	40	**C4-570-4C 40 120**	40	50.0	1.968	40	1.575			120.0	4.724			1.4
	40	**C5-570-4C 40 120**	40	50.0	1.968	50	1.968			120.0	4.724	98.7	3.886	1.6
	40	**C6-570-4C 40 120**	40	50.0	1.968	63	2.480			120.0	4.724	94.9	3.736	1.9
	50	**C5-570-4C 50 150-40R/L**	40	60.0	2.362	50	1.968	5.0	.197	150.0	5.906			2.5
	50	**C6-570-4C 50 150-40R/L**	40	60.0	2.362	63	2.480	5.0	.197	150.0	5.906	121.7	4.791	2.8
	60	**C6-570-4C 60 180-40R/L**	40	72.0	2.835	63	2.480	10.0	.394	180.0	7.087	157.6	6.205	3.8
	60	**C8-570-4C 60 180-40R/L**	40	72.0	2.835	80	3.150	10.0	.394	180.0	7.087	147.3	5.799	4.7

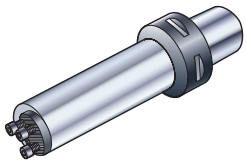
I112 G6 J2

CoroTurn® SL

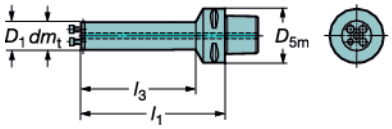
Dampened carbide reinforced boring bars

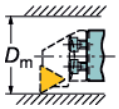
Coromant Capto®



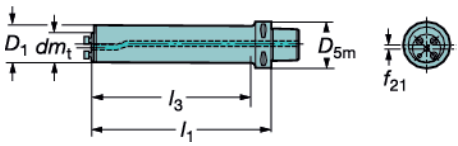


Cx-SL3C...CR





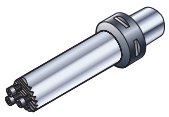
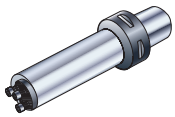
Cx-SL3C...CR-40R/L



Bars with reduction dia

Silent Tools®

With internal coolant supply
Short design. Max overhang 10-12 x dm_m
Long design. Max overhang 14 x dm_m

	Bar dia. mm D_1	Ordering code	Coupling size dm_t	Dimensions, millimeter, inch (mm, in.) D_m min, mm	D_m min in.	D_{5m} mm	D_{5m} in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	l_3 mm	l_3 in.	kg
	25	C6-SL3C25280CR	25	32.0	1.260	63	2.480			280.0	11.024	245.0	9.646	2.0
	32	C6-SL3C32352CR	32	40.0	1.575	63	2.480			352.0	13.858	317.0	12.480	3.5
	40	C6-SL3C40448CR	40	50.0	1.968	63	2.480			448.0	17.638	416.0	16.378	4.6
	25	C8-SL3C25280CR	25	32.0	1.260	80	3.150			280.0	11.024	245.0	9.646	3.0
	32	C8-SL3C32352CR	32	40.0	1.575	80	3.150			352.0	13.858	317.0	12.480	4.5
	40	C8-SL3C40448CR	40	50.0	1.968	80	3.150			448.0	17.638	416.0	16.378	6.3
	50	C8-SL3C50568CR-40R/L	40	60.0	2.362	80	3.150	5.0	.197	568.0	22.362	525.0	20.669	10.8
	60	C8-SL3C60688CR-40R/L	40	80.0	3.150	80	3.150	10.0	.394	688.0	27.087	648.0	25.512	17.5

 I112

 G6

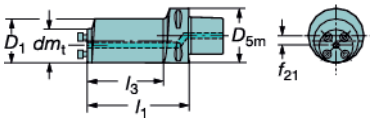
 J2

CoroTurn® SL

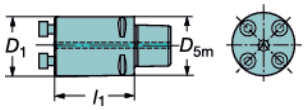
Coromant Capto® boring bars

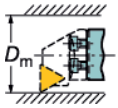
Short version

Bars with reduction dia
C..-570-2C...R40

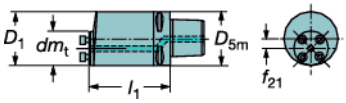


C..-570-2C

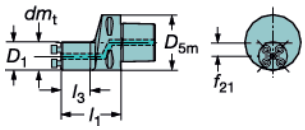




C..-570-2C...-40R



C..-570-2C...R



With internal coolant supply
Right hand style shown

	Bar dia. mm		Coupling size	Dimensions, millimeter, inch (mm, in.)										
	D_1	Ordering code	dm_t	D_m min, mm	D_m min in.	D_{5m} mm	D_{5m} in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	l_3 mm	l_3 in.	kg
	50	C6-570-2C 50 097R/L40	40	60.0	2.362	63	2.480	12.0	.472	97.0	3.819	68.0	2.677	2.0
	60	C6-570-2C 60 112R/L40	40	70.0	2.756	63	2.480	10.0	.394	112.0	4.409	88.0	3.465	2.7
	50	C8-570-2C 50 102R/L40	40	60.0	2.362	80	3.150	20.0	.787	102.0	4.016	68.0	2.677	2.8
	60	C8-570-2C 60 119R/L40	40	70.0	2.756	80	3.150	20.0	.787	119.0	4.685	88.0	3.465	3.6
	32	C3-570-2C 32 037	32	40.0	1.575	32	1.260			37.0	1.457			0.3
	40	C4-570-2C 40 053	40	50.0	1.968	40	1.575			53.0	2.087			0.6
	50	C5-570-2C 50 073-40R/L	40	60.0	2.362	50	1.968	5.0	.197	73.0	2.874			1.3
	16	C3-570-2C 16 033R/L	16	20.0	.787	32	1.260	8.0	.315	33.0	1.299	12.0	.472	0.2
	20	C3-570-2C 20 040R/L	20	25.0	.984	32	1.260	6.0	.236	40.0	1.575	20.0	.787	0.2
	25	C3-570-2C 25 044R/L	25	32.0	1.260	32	1.260	3.5	.138	44.0	1.732	25.0	.984	0.2
	16	C4-570-2C 16 041R/L	16	20.0	.787	40	1.575	12.0	.472	41.0	1.614	12.0	.472	0.3
	20	C4-570-2C 20 047R/L	20	25.0	.984	40	1.575	10.0	.394	47.0	1.850	20.0	.787	0.4
	25	C4-570-2C 25 051R/L	25	32.0	1.260	40	1.575	7.5	.295	51.0	2.008	25.0	.984	0.4
	32	C4-570-2C 32 056R/L	32	40.0	1.575	40	1.575	4.0	.157	56.0	2.205	32.0	1.260	0.5
	16	C5-570-2C 16 040R	16	20.0	.787	50	1.968	12.0	.472	40.0	1.575	12.0	.472	0.5
	20	C5-570-2C 20 050R	20	25.0	.984	50	1.968	15.0	.591	50.0	1.968	20.0	.787	0.6
	25	C5-570-2C 25 054R/L	25	32.0	1.260	50	1.968	12.5	.492	54.0	2.126	25.0	.984	0.6
	32	C5-570-2C 32 061R/L	32	40.0	1.575	50	1.968	9.0	.354	61.0	2.402	32.0	1.260	0.8
	40	C5-570-2C 40 075R/L	40	50.0	1.968	50	1.968	5.0	.197	75.0	2.953	48.0	1.890	1.0
	16	C6-570-2C 16 045R	16	20.0	.787	63	2.480	23.5	.925	45.0	1.772	12.0	.472	0.9
	20	C6-570-2C 20 052R	20	25.0	.984	63	2.480	21.5	.846	52.0	2.047	20.0	.787	1.0
	25	C6-570-2C 25 056R/L	25	32.0	1.260	63	2.480	19.0	.748	56.0	2.205	25.0	.984	1.0
	32	C6-570-2C 32 066R/L	32	40.0	1.575	63	2.480	15.5	.610	66.0	2.598	32.0	1.260	1.2
	40	C6-570-2C 40 080R/L	40	50.0	1.968	63	2.480	11.5	.453	80.0	3.150	48.0	1.890	1.5
	40	C8-570-2C 40 081R/L	40	50.0	1.968	80	3.150	20.0	.787	81.0	3.189	48.0	1.890	2.2

A reduction adapter can be used to build tools such as:
C5 dm_t 16 mm (.630 inch)
C6 dm_t 16-25 mm (.630-.984 inch)
C8 dm_t 16-60 mm (.630-2.362 inch)
See page G28.

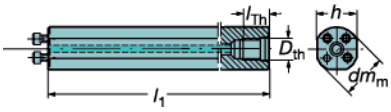
R = Right hand, L = Left hand

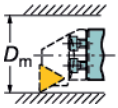
 I113
 G6
 A2
 J2

CoroTurn® SL

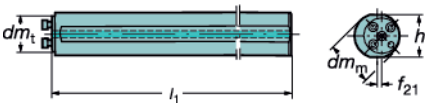
Boring bars

570-2C
EasyFix for 16-25 mm (.625-1.000 inch)





570-2C.....-40
Bars with reduction dia



With internal coolant supply
Max recommended overhang 4 x dm_m

Note! Bars in diameter 16-25 mm (.625 - 1.000 inch) with groove for EasyFix sleeves.

Metric version

	Bar dia. mm dm_m	Max overhang	Ordering code	Coupling size dm_t	Dimensions D_m min	f_{21}	h	l_1	l_{Th}	D_{th}	KG
	16	4 x dmm	570-2C 16 105	16	20		15	105	12	G1/8"	0.1
	20	4 x dmm	570-2C 20 140	20	25		18	140	15	G1/4"	0.3
	25	4 x dmm	570-2C 25 200	25	32		23	200	15	G1/4	0.7
	32	4 x dmm	570-2C 32 218	32	40		30	218	19	G3/8"	1.1
	40	4 x dmm	570-2C 40 283	40	50		37	283	23	G1/2"	2.4
	50	4 x dmm	570-2C 50 368-40	40	60	5	47	368	23	G1/2"	5.1
	60	4 x dmm	570-2C 60 468-40	40	72	10	57	468	23	G1/2"	9.2

Inch version

	Bar dia. inch dm_m	Max overhang	Ordering code	Coupling size dm_t	Dimensions, inch D_m min	f_{21}	h	l_1	l_{Th}	D_{th}	Lbs
	.625	4 x dmm	A570-2C D10 04-16	16	.787		.560	4.210	.470	G1/8	0.3
	.750	4 x dmm	A570-2C D12 05-20	20	.984		.710	5.200	.590	G1/4	0.6
	1.000	4 x dmm	A570-2C D16 07-25	25	1.260		.910	7.200	.590	G1/4"	1.4
	1.250	4 x dmm	A570-2C D20 09-32	32	1.575		1.180	8.740	.590	G3/8"	2.5
	1.500	4 x dmm	A570-2C D24 11-40	40	1.969		1.370	10.750	.910	G1/2"	4.5
	1.750	4 x dmm	A570-2C D28 13-40	40	2.000	.088	1.624	12.992			7.8
	2.000	4 x dmm	A570-2C D32 15-40	40.01	2.165	.213	1.870	14.720	.910	G1/2	11.9
	2.500	4 x dmm	A570-2C D40 19-40	40.01	2.519	.463	2.380	18.740	.910	G1/2	23.4

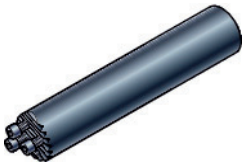
 I112

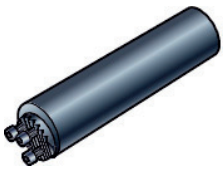
 G6

 J2

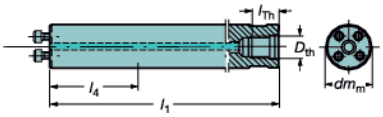
CoroTurn® SL

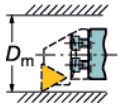
Dampened boring bars, cylindrical



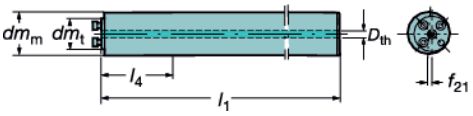


570-3C





570-3C-40
Bars with reduction dia



Silent Tools®

With internal coolant supply
Short design. Max overhang 7 x dm_m
Long design. Max overhang 10 x dm_m

Note! Bars in diameter 16-25 mm with groove for Easyfix sleeves.

Metric version

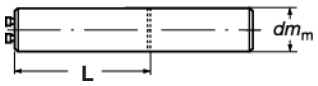
	Bar dia. mm dm_m	Max overhang	Ordering code	Coupling size dm_t	Dimensions D_m min	f_{21}	l_1	l_4 [1]	l_{fh}	D_{th}	kg
	16	7 x dmm	**570-3C 16 156**	16	20		156	55	12	G1/8"	0.2
	20	7 x dmm	**570-3C 20 200**	20	25		200	70	15	G1/4"	0.5
	25	10 x dmm	**570-3C 25 330**	25	32		330	115	15	G1/4"	1.2
	25	7 x dmm	**570-3C 25 255**	25	32		255	85	15	G1/4"	0.9
	32	10 x dmm	**570-3C 32 416**	32	40		416	140	19	G3/8"	2.6
	32	7 x dmm	**570-3C 32 320**	32	40		320	100	19	G3/8"	2.0
	40	10 x dmm	**570-3C 40 528**	40	50		528	165	23	G1/2"	5.1
	40	7 x dmm	**570-3C 40 408**	40	50		408	120	23	G1/2"	3.5
	50	10 x dmm	**570-3C 50 668-40**	40	60	5	668	200	23	G1/2"	9.3
	60	10 x dmm	**570-3C 60 808-40**	40	72	10	808	250	28	G3/4"	16.5
	50	7 x dmm	**570-3C 50 518-40**	40	60	5	518	165	23	G1/2"	7.3
	60	7 x dmm	**570-3C 60 628-40**	40	72	10	628	200	28	G3/4"	12.7

1) Do not clamp in this area.

Modifying of standard bars

Bar diameter	**L, min length after cut off**	
dm_m	Short design 7 x dm_m	Long design 10 x dm_m
mm	mm	mm
16	100	155
20	125	200
25	155	255
32	190	320
40	240	410
50	305	520
60	380	630

We recommend a min. clamping length of 4 x dm_m.



Min length after cut off

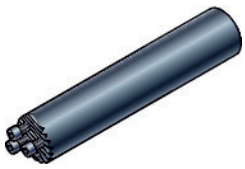
 I112

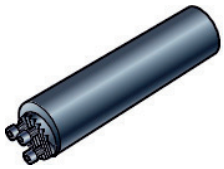
 G6

 J2

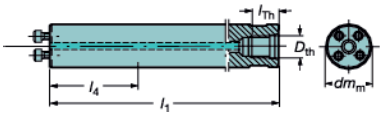
CoroTurn® SL

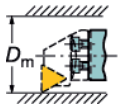
Dampened boring bars, cylindrical



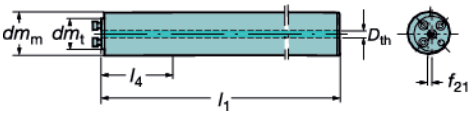


570-3C





570-3C-40
Bars with reduction dia



Silent Tools®

With internal coolant supply
Short design. Max overhang 7 x dm_m
Long design. Max overhang 10 x dm_m

Note! Bars in diameters .625 - 1.000 inch with groove for EasyFix sleeves.

Inch version

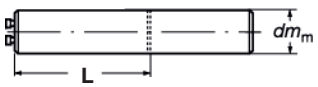
	Bar dia. inch dm_m	Max overhang	Ordering code	Coupling size dm_t	Dimensions, inch D_m min	f_{21}	l_1	l_4 1)	l_{th}	D_{th}	Lbs
	.625	7 x dmm	A570-3C D10 06-16	16	.787		6.140	2.170	.470	G1/8"	0.5
	.750	7 x dmm	A570-3C D12 08-20	20	.984		7.870	2.760	.590	G1/4"	0.9
	1.000	7 x dmm	A570-3C D16 10-25	25	1.260		10.200	3.350	.590	G1/4"	2.1
	1.000	10 x dmm	A570-3C D16 13-25	25	1.260		13.210	4.530	.590	G1/4"	2.9
	1.250	7 x dmm	A570-3C D20 12-32	32	1.575		12.490	3.940	.740	G3/8"	4.1
	1.250	10 x dmm	A570-3C D20 16-32	32	1.575		16.240	5.510	.750	G3/8"	5.7
	1.500	7 x dmm	A570-3C D24 15-32	32	1.969	.120	15.260	4.720	.910	G1/2"	6.7
	1.500	10 x dmm	A570-3C D24 20-32	32	1.969	.120	19.800	6.500	.910	G1/2"	9.7
	1.750	7 x dmm	A570-3C D28 17-40	40	2.000	.088	17.008	4.213	.910	G1/2"	9.4
	1.750	10 x dmm	A570-3C D28 23-40	40	2.000	.088	22.992	9.331	.910	G1/2"	13.3
	2.000	7 x dmm	A570-3C D32 21-40	40	2.402	.213	20.740	6.811	.910	G1/2"	17.0
	2.000	10 x dmm	A570-3C D32 27-40	40	2.402	.213	26.730	12.519	.910	G1/2"	21.9
	2.500	7 x dmm	A570-3C D40 26-40	40	2.953	.463	26.240	8.789	1.100	G3/4"	34.0
	2.500	10 x dmm	A570-3C D40 34-40	40	2.953	.463	33.720	15.276	1.100	G3/4"	44.0

1) Do not clamp in this area.

Modifying of standard bars

Bar diameter	L, min length after cut off	
dm_m	Short design 7 x dm_m	Long design 10 x dm_m
inch	inch	inch
.625	4	7
.750	5	8
1.000	7	11
1.250	8	13
1.500	10	17
1.750	10.4	18
2.000	12	21
2.500	15	25

We recommend a min. clamping length of 4 x dm_m.



Min length after cut off

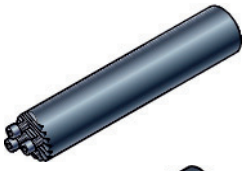
 I112

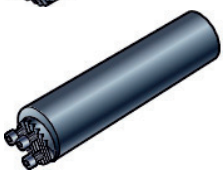
 G6

 J2

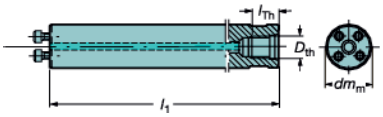
CoroTurn® SL

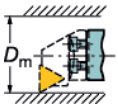
Short dampened boring bars, cylindrical



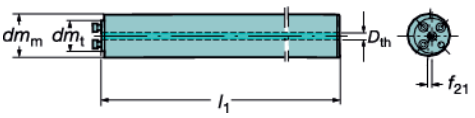


570-4C





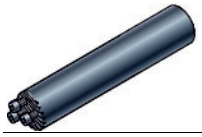
570-4C-40
Bars with reduction dia



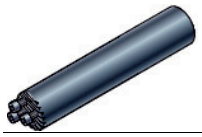
Silent Tools®

With internal coolant supply

Metric version

	Bar dia. mm dm_m	Max overhang	Ordering code	Coupling size dm_t	Dimensions D_m min	f_{21}	l_1	l_{Th}	D_{th}	kg
	40	5 x dmm	**570-4C 40 330**	40	50		330	23	G1/2"	3.1
	50	5 x dmm	**570-4C 50 430-40**	40	60	5	430	23	G1/2"	6.0
	60	5 x dmm	**570-4C 60 510-40**	40	72	10	510	28	G3/4"	9.8

Inch version

	Bar dia. inch dm_m	Max overhang	Ordering code	Coupling size dm_t	Dimensions, inch D_m min	f_{21}	l_1	l_{Th}	D_{th}	Lbs
	1.500	5 x dmm	**A570-4C D24 13-32**	32	1.772	.120	13.150	.910	G1/2"	7.7
	1.750	5 x dmm	**A570-4C D28 15-40**	40	2.000	.088	14.921	.910	G1/2"	9.0
	2.000	5 x dmm	**A570-4C D32 17-40**	40	2.402	.213	17.165	.910	G1/2"	13.9
	2.500	5 x dmm	**A570-4C D40 22-40**	40	2.953	.463	22.047	1.100	G3/4"	27.6

Modifying of standard bars

Bar diameter		**L, min length after cut off**	
dm_m			
mm	inch	mm	inch
-	1.500	152	6.000
-	1.750	178	7.000
-	2.000	203	8.000
-	2.500	254	10.000
40	-	160	6.299
50	-	200	7.874
60	-	240	9.449

Min length after cut off

We recommend a min. clamping length of 4 x dm_m.
Clamping over the dampening mechanism is allowed.

 I112

 G6

 J2

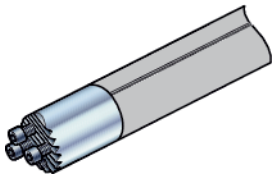
CoroTurn® SL

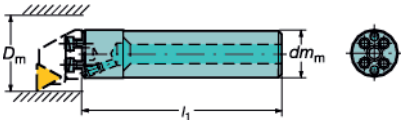
Carbide boring bars

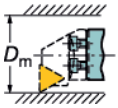
Cylindrical

With groove for EasyFix sleeve

570-2C CR



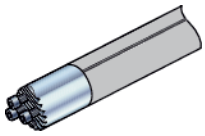




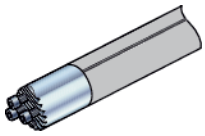
With internal coolant supply
Max recommended overhang 6 x dm_m

Note! Bars in diameter 16-25 mm (.625 - 1.000 inch) with groove for EasyFix sleeves.

Metric version

	Bar dia. mm		Coupling size	Dimensions		
	dm_m	**Ordering code**	dm_t	D_m min	l_1	kg
	16	**570-2C 16 170 CR**	16	20	170	0.4
	20	**570-2C 20 200 CR**	20	25	200	0.8
	25	**570-2C 25 250 CR**	25	32	250	1.6

Inch version

	Bar dia. inch		Coupling size	Dimensions, inch	
	dm_m	**Ordering code**	dm_t	D_m min	l_1
	.625	**A570-2C D10 07-16 CR**	16	.787	7.087
	.750	**A570-2C D12 08-20 CR**	20	.984	8.071
	1.000	**A570-2C D16 10-25 CR**	25	1.260	10.039

 I112

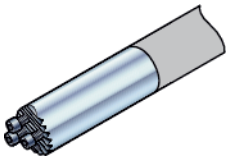
 G6

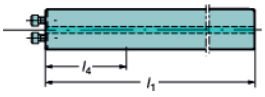
 J2

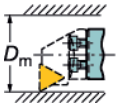
CoroTurn® SL

Dampened reinforced boring bar

570-3C CR



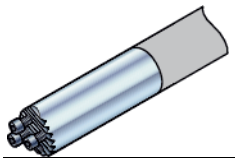




With internal coolant supply
Max recommended overhang 10 x dm_m

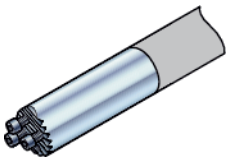
Silent Tools®

Metric version



Bar dia. mm dm_m	Ordering code	Coupling size dm_t	Dimensions D_m min	l_1	l_4 1)	kg
16	570-3C 16 204 CR	16	20	204	75	0.4
20	570-3C 20 260 CR	20	25	260	91	0.9

Inch version



Bar dia. inch dm_m	Ordering code	Coupling size dm_t	Dimensions, inch D_m min	l_1	l_4 1)	Lbs
.625	A570-3C D10 08-16 CR	16	.787	8.030	3.150	2.1
.750	A570-3C D12 10-20 CR	20	.984	10.240	4.000	3.0

1) Do not clamp in this area.


I112


G6

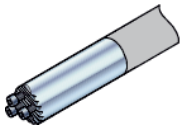

J2

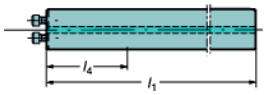
CoroTurn® SL

Dampened carbide reinforced boring bars

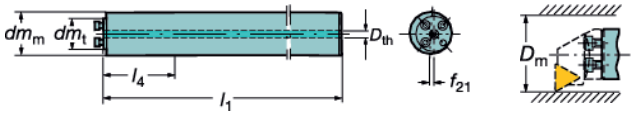
Cylindrical with groove for EasyFix sleeve

570-3C-CR





570-3C-40CR



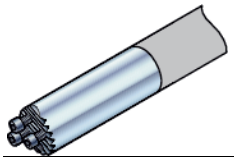
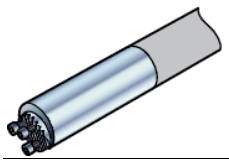
Bars with reduction dia

Silent Tools®

With internal coolant supply
Short design. Max overhang 12 x dm_m
Long design. Max overhang 14 x dm_m

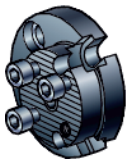
Note! Bars in diameter 16-25 mm (.625 - 1.000 inch) with groove for EasyFix sleeves.

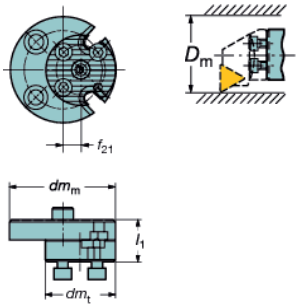
Metric version

	Bar dia. mm dm_m	Max overhang	Ordering code	Coupling size dm_t	Dimensions D_m min	f_{21}	l_1	l_4 [1]	l_{th}	D_{th}	kg
	25	12 x dmm	**570-3C 25 380 CR**	25	32		380	156	12	G1/8"	1.7
	25	14 x dmm	**570-3C 25 430 CR**	25	32		430	130	12	G1/8"	1.9
	32	12 x dmm	**570-3C 32 480 CR**	32	40		480	192	15	G1/4"	3.8
	32	14 x dmm	**570-3C 32 544 CR**	32	40		544	182	15	G1/4"	4.2
	40	12 x dmm	**570-3C 40 608 CR**	40	50		608	248	19	G3/8"	6.8
	40	14 x dmm	**570-3C 40 688 CR**	40	50		688	248	19	G3/8"	7.8
	50	12 x dmm	**570-3C 50 760-40 CR**	40	60	5	760	311	23	G1/2"	12.5
	60	12 x dmm	**570-3C 60 920-40 CR**	40	72	10	920	380	29	G3/4"	21.0
	50	14 x dmm	**570-3C 50 861-40 CR**	40	60	5	861	311	23	G1/2"	15.4
	60	14 x dmm	**570-3C 60 1040-40 CR**	40	72	10	1040	380	29	G3/4"	25.8

[1] Do not clamp in this area.

Reduction adapters for CoroTurn® SL boring bars





With internal coolant supply

Metric version

Bar dia. mm dm_m	Ordering code	Reduction to coupling size dm_t	Dimensions D_m min	f_{21}	l_1	kg
50	**570-40 22-32**	32	55	8	22	0.1
50	**570-50 23-32**	32	60	9	22.35	0.2
50	**570-50 23-40**	40	65	10	23.35	0.3
60	**570-60 23-40**	40	72	10	23.35	0.4

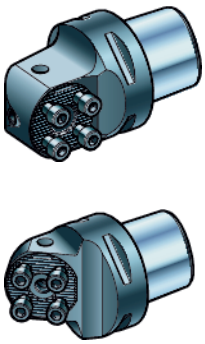
 I112

 G6

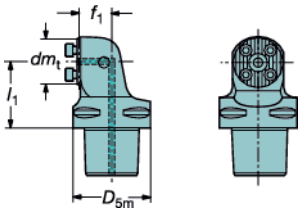
 J2

CoroTurn® SL

Coromant Capto® adapter

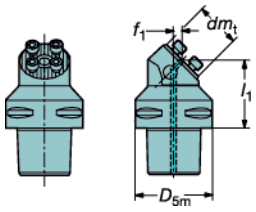


Shank style 0°
570-R/LF

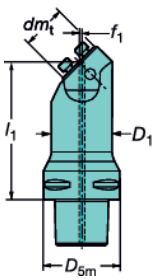


Right hand

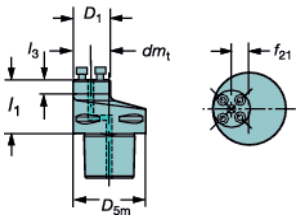
Shank style 45°
570-R/LX



Left hand style



Shank style 90°
570-R/L/N



Neutral style

Ordering code	Shank style	Coupling size dm_t [1]	Dimensions, millimeter, inch (mm, in.) D_1 mm	D_1 in.	D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	l_3 mm	l_3 in.	kg
C3-570-25-R/LF	0°	25			32	1.260	8	.315			33.5	1.319			0.2
C4-570-25-R/LF	0°	25			40	1.575	13	.512			37	1.457			0.4
C4-570-32-R/LF		32			40	1.575	13	.512			43.5	1.713			0.5
C4-570-40-R/LF		40			40	1.575	13	.512			48.5	1.909			0.6
C5-570-25-R/LF	0°	25			50	1.968	21	.827			36	1.417			0.6
C5-570-32-R/LF		32			50	1.968	21	.827			42	1.654			0.7
C5-570-40-R/LF		40			50	1.968	21	.827			46	1.811			0.9
C6-570-25-R/LF	0°	25			63	2.480	31	1.220			34	1.339			0.9
C6-570-32-R/LF		32			63	2.480	31	1.220			38.5	1.516			1.0
C6-570-40-R/LF		40			63	2.480	31	1.220			42.5	1.673			1.2
C8-570-32-R/LF	0°	32			80	3.150	41	1.614			46	1.811			2.0
C8-570-40-R/LF		40			80	3.150	41	1.614			50	1.968			2.3
C5-570-25-R/LX-045	45°	25			50	1.968	8	.315			34.5	1.358			0.5
C5-570-32-R/LX-045		32			50	1.968	6	.236			34	1.339			0.5
C5-570-32-RX-045-L1		32	40	1.575	50	1.968	2	.079			90	3.543			1.1
C6-570-25-R/LX-045	45°	25			63	2.480	14.5	.571			36	1.417			0.8
C6-570-32-R/LX-045		32			63	2.480	12.5	.492			37.5	1.476			0.9
C6-570-32-RX-045-L1		32	45	1.772	63	2.480	2	.079			100	3.937			1.7
C6-570-40-RX-045-L1		40	45	1.772	63	2.480	2	.079			100	3.937			1.8
C8-570-40-RX-045-L1	45°	40			80	3.150	5	.197			135	5.315			3.7
C3-570-32-NG	90°	32	32	1.260	32	1.260					22	.866			0.3
C4-570-32-NG	90°	32	32	1.260	40	1.575					32	1.260	8	.315	0.4
C5-570-32-R/LG	90°	32	32	1.260	50	1.968			9	.354	42	1.654	15	.591	0.6
C5-570-40-NG		40	40	1.575	50	1.968					42	1.654	17	.669	0.6
C6-570-32-R/LG	90°	32	32	1.260	63	2.480			15.5	.610	47	1.850	14	.551	1.0
C6-570-40-NG		40	40	1.575	63	2.480					47	1.850	16	.630	1.1
C8-570-32-R/LG	90°	32			80	3.150	24	.945			62	2.441			1.9

[1] To correspond with coupling size, dm_m for respective CoroCut® SL and T-Max Q-Cut® SL blades.
Right 0° fits left hand blade, right 45° fits right hand blade.
Left and right 90° fit both left and right hand blade.
Neutral 90° fits both left and right hand blade.

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

Main spare parts

Coromant Capto®	Screw	Key (mm)	Plug	Thread size	O-ring
Cx-570-32-R/LG	3212 010-308	3021 010-040 (4.0)	5643 012-03	6 mm	3671-010-113
Cx-570-40-R/LG	3212 010-358	3021 010-050 (5.0)	5643 012-03	6 mm	3671-010-113
Cx-570-32-NG	3212 010-308	3021 010-040(4.0)	–	6 mm	3671 010-113
Cx-570-40-NG	3212 010-358	3021 010-050 (5.0)	–	6 mm	3671-010-113
Cx-570-25-R/LF	3212 010-258	174.1-864 (3.0)	5643 045-01	M8x1.0	–
Cx-570-32-R/LF	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0	–
Cx-570-40-R/LF	3212 010-358	3021 010-050 (5.0)	5643 045-01	M8x1.0	–
Cx-570-25-R/LX-045	3212 010-258	174.1-864 (3.0)	5643 045-01	M8x1.0	–
Cx-570-32-R/LX-045	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0	–
Cx-570-32-RX-045L1	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0	–
Cx-570-40-RX-045L1	3212 010-358	3021 010-050 (5.0)	5643 045-01	M8x1.0	–

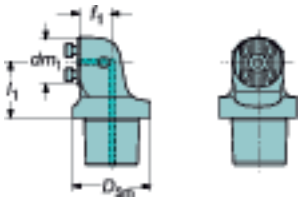

G6


J2

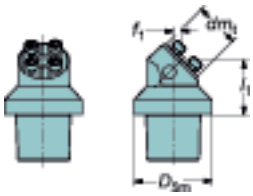
CoroTurn® SL

Coromant Capto® Short

Shank style 0°
570-R/LF-T



Shank style 45°
570-R/LX-T



Ordering code	Shank style	Coupling size dm_1 [1]	Dimensions, millimeter, inch (mm, in.) D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	kg
C3-570-25-R/LF-T	0°	25	32	1.260	17	.669	23.5	.925	0.2
C3-570-32-R/LF-T		32	32	1.260	17	.669	27	1.063	0.3
C4-570-32-R/LF-T	0°	32	40	1.575	20	.787	27	1.063	0.4
C4-570-40-R/LF-T		40	40	1.575	20	.787	31	1.220	0.5
C5-570-32-R/LF-T	0°	32	50	1.968	27	1.063	27	1.063	0.6
C5-570-40-R/LF-T		40	50	1.968	27	1.063	31	1.220	0.7
C4-570-32-R/LX-045-T	45°	32	40	1.575	1	.039	22	.866	0.3

[1] To correspond with coupling size, dm_m for respective CoroCut® SL and T-Max Q-Cut® SL blades.
Right 0° fits left hand blade, right 45° fits right hand blade.
Left and right 90° fit both left and right hand blade.
Neutral 90° fits both left and right hand blade.

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

Main spare parts

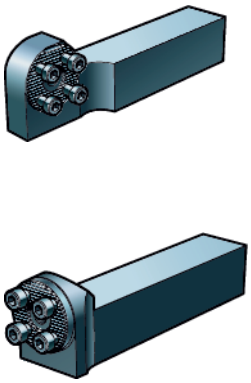
Coromant Capto®	Screw	Key (mm)	Plug	Thread size
Cx-570-25-R/LF-T	3212 010-258	174.1-864 (3.0)	5643 045-01	M8x1.0
Cx-570-32-R/LF-T	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0
Cx-570-40-R/LF-T	3212 010-358	3021 010-050 (5.0)	5643 045-01	M8x1.0
Cx-570-32-R/LX-045-T	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0


G6

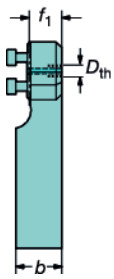

J2

CoroTurn® SL

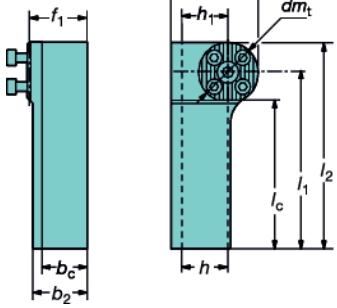
Shank adapter



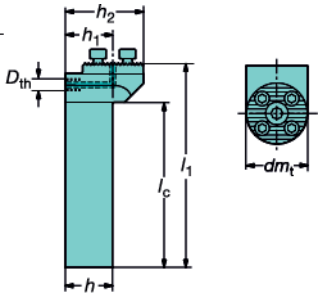
Shank style 0°
570-RL



Shank style 0°
570-R/LF - J/N



Shank style 90°
570-NG



Right hand style shown when nothing else is stated

Neutral

Metric version

Ordering code	Shank style	Coupling size dm_t [1]	Dimensions b	b_2	D_{th}	h	h_1	h_2	f_1	l_1	l_2	l_c
570-25R/LF-2020	0°	25	20		G1/8"	20	20		15	94.15	106.65	82.65
570-25R/LF-2525		25	25		G1/8"	25	25		18	119.15	131.65	107.65
570-32R/LF-2020		32	20		G1/8"	20	20		18	97.65	113.65	82.65
570-32R/LF-2525		32	25		G1/8"	25	25		18	115.65	131.65	100.65
570-32R/LF-3232		32	32		G1/8"	32	32		26	135.65	151.65	120.65
570-40R/LF-3232		40	32		G1/8"	32	32		26	134	154	115
570-32R/LF-2020J	0°	32	20	27	G1/8"	20	20	36	27.5	97.33	113.65	82.33
570-32R/LF-2525N		32	25	32	G1/8"	25	25	47.32	32.5	119.65	135.65	104.33
570-25NG-2020	90°	25	20		G1/8"	20	20	32.6	9.98	111		91
570-25NG-2525		25	25		G1/8"	25	25	37.6	12.48	132		112
570-32NG-2020		32	20		G1/8"	20	20	36.2	9.98	103		83
570-32NG-2525		32	25		G1/8"	25	25	37.6	12.48	132		112
570-32NG-3232		32	32		G1/8"	32	32	48.2	15.98	152		132
570-40NG-3232		40	32		G1/8"	32	32	52.2	15.98	152		132

Inch version

Ordering code	Shank style	Coupling size dm_t [1]	Dimensions, inch b	b_2	D_{th}	h	h_1	h_2	f_1	l_1	l_2	l_c
570-25R/LF-12	0°	25	.750		G1/8"	.750	.750		.591	3.785	4.278	3.333
570-25R/LF-16		25	1.000		G1/8"	1.000	1.000		.709	4.803	5.276	4.331
570-32R/LF-12		32	.750		G1/8"	.750	.750	1.301	.709	3.844	4.475	3.333
570-32R/LF-16		32	1.000		G1/8"	1.000	1.000	1.630	.709	4.648	5.278	4.058
570-32R/LF-20		32	1.250		G1/8"	1.250	1.250		1.024	5.648	6.278	5.057
570-32R/LF-12J		32	.750	1.026	G1/8"	.750	.750	1.629	1.045	3.923	4.553	3.320
570-32R/LF-16N		32	1.000	1.275	G1/8"	1.000	1.000	1.879	1.295	4.648	5.278	4.045
570-40R/LF-20		40	1.250		G1/8"	1.250	1.2598		1.024	5.382	6.169	4.634
570-25NG-12	90°	25	.750		G1/8"	.750	.750	1.248	.374	4.449		3.661
570-25NG-16		25	1.000		G1/8"	1.000	1.000	1.504	.499	5.276		4.488
570-32NG-12		32	.750		G1/8"	.750	.750	1.386	.374	4.120		3.333
570-32NG-16		32	1.000		G1/8"	1.000	1.000	1.638	.499	5.291		4.504
570-32NG-20		32	1.250		G1/8"	1.250	1.250	2.047	.625	6.291		5.504
570-40NG-20		40	1.250		G1/8"	1.250	1.250	2.047	.625	6.094		5.110

[1] To correspond with coupling size, dm_m for respective CoroCut® SL and T-Max Q-Cut® SL blades.
Right 0° fits left hand blade, right 45° fits right hand blade.
Left and right 90° fit both left and right hand blade.

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

[2] J or N in code = reinforced adapter with increased support areas. No coolant through possible.


I118


G6


J2

CoroTurn® SL quick change

Adapters and exchangable cutting heads for coupling sizes 32 and 40 mm

For bores from 40 mm (1.575 inch) and overhangs up to 14 x bar diameter

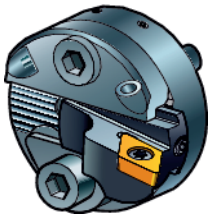
Quick change function

Reduced setup times resulting in increased output. Easy to change cutting head.

Silent Tools®

Light head design

For improved performance of the Silent tool function, reducing vibration.



Adjustable f_1 dimension

More flexibility in production. Easy to adjust cutting head sideways for other bores or applications and lock into position with adjustment screw.

Cutting heads are available in different entering angles for V (35°) and D (55°) inserts, and both adapters use cutting heads in coupling size 32. To facilitate the production of the tip seat to your own specifications, right and left hand cutting head blanks are available.

To be used with CoroTurn SL boring bars with coupling sizes 32 and 40 mm

The CoroTurn® SL assortment includes:
- Both Coromant Capto® and conventional shank design
- Solid steel bars and dampened Silent Tools
- All bars have through coolant supply.

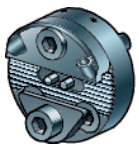
See page I56.

Advantages of the CoroTurn® SL quick change system:

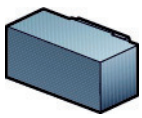
- Increased output due to reduced setup times
- Very good chip evacuation
- Coolant directed to the cutting edge

Cutting heads with integrated tip seat

Cutting head for finishing/ profiling

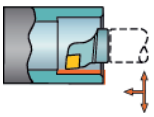
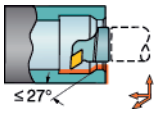
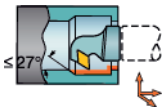
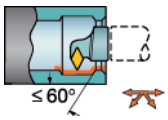


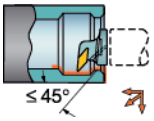
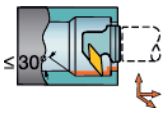
Adapter for CoroTurn® SL boring bars

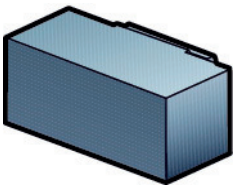
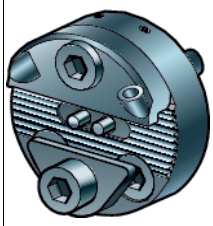


Pre-machined blanks to enable production of tip seat to own specification

Cutting heads with CoroTurn® SL coupling for positive basic shape inserts

CoroTurn® 107 screw clamp design	Entering angle (Lead angle)		Back boring	
	κ_r 95° (-5°)	κ_r 93° (-3°)	κ_r 93° (-3°)	κ_r 62.5° (27.5°)
				
				
	SL-SCLCR	**SL-SDUCR**	**SL-SDUCR-X**	**SL-SDXCR**
Insert size, mm (*iC*, inch)	09 (3/8)	11 (3/8)	11 (3/8)	11 (3/8)
Coupling size, mm	32	32	32	32
Page	I73	I74	I74	I74

	Entering angle (Lead angle)	Back boring
	κ_r 95° (-5°)	κ_r 95° (-5°)
		
		
	SL-SVLBR	**SL-SVLBR-X**
Insert size, mm (*iC*, inch)	16 (3/8)	16 (3/8)
Coupling size, mm	32	32
Page	I75	I75

	Blanks for CoroTurn® SL quick change cutting heads	CoroTurn® SL quick change adapter for cutting heads
		
Coupling size		
Machine side	32	32-40
Tool side	-	32
Page	I76	I76

For CoroTurn® SL boring bars with coupling sizes 32-40, see page I56.

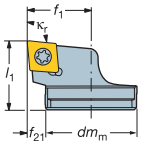
Cutting heads with CoroTurn® SL quick change

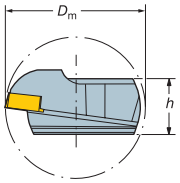
CoroTurn® 107 screw clamp design

SL-SCLCR

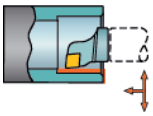
Entering angle: κ_r 95°
Lead angle: -5°

CCMT, CCGT
CCGX, CCET
CCMW





For f_1 range and $D_m$dimensions, see CoroTurn® SL quick change adapter on page I76.
Right hand style shown when nothing else is stated

Main application	□	*iC*	**Ordering code**	Coupling size *dm*$_m$	Dimensions, millimeter, inch (mm, in.) *h* mm	*h* in.	*l*$_1$ mm	*l*$_1$ in.	γ[1]	λ$_s$[2]	Gauge inserts ISO	ANSI	Nm[3]
	09	3/8	**SL-SCLCR-32-09-QC**	32	14.7	.579	22.0	.866	0°	-6°	CCMT 09 T3 08	CCMT 3(2.5)2	3.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size □	*iC*	Insert screw (thread)	Key (Torx Plus)	Adjustment screw	Key (mm)	Locating tube
09	3/8	5513 020-10 (M3.5)	5680 049-01 (15IP)	5514 060-10	170.3-864 (1.98)	5638 031-01

 A9
 A2
 I4
 J2

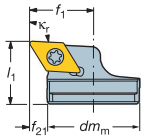
Cutting heads with CoroTurn® SL quick change

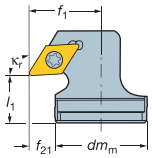
CoroTurn® 107 screw clamp design

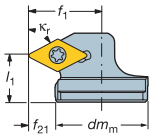
	SL-SDUCR	SL-SDUCR-X	SL-SDXCR-X
Entering angle:	κ_r 93°	κ_r 93°	κ_r 62.5°
Lead angle:	-3°	-3°	27.5°

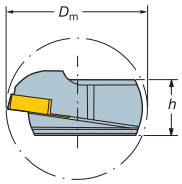
DCMT, DCMX
DCGT, DCGX, DCET

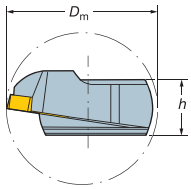
DCMW

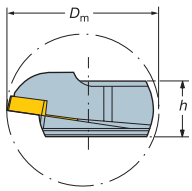






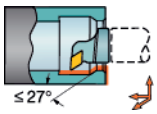
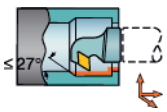
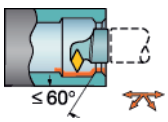






Back boring

For f_1 range and D_m dimensions, see CoroTurn® SL quick change adapter on page I76.
Right hand style shown when nothing else is stated

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_{5m} mm	D_{5m} in.	h mm	h in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts ISO	ANSI	Nm[3]
	11	3/8	**SL-SDUCR-32-11-QC**	32	32	1.260	14.7	.579	20.0	.787	0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
	11	3/8	**SL-SDUCR-32-11X-QC**	32	32	1.260	14.7	.579	15.0	.591	0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0
	11	3/8	**SL-SDXCR-32-11-QC**	32	32	1.260	14.7	.579	15.0	.591	0°	-8°	DCMT 11 T3 08	DCMT 3(2.5)2	3.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size		Insert screw (thread)	Key (Torx Plus)	Adjustment screw	Key (mm)	Locating tube
iC						
11	3/8	5513 020-10	5680 049-01 (15IP)	5514 060-10	170.3-864 (1.98)	5638 031-01

 A9

 A2

 I4

 J2

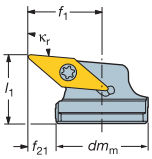
Cutting heads with CoroTurn® SL quick change

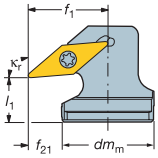
CoroTurn® 107 screw clamp design

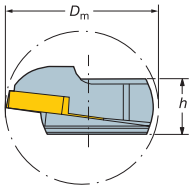
VBMT, VBGT
VCGX, VCEX,
VCGT, VCET

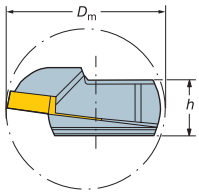
VBMW, VCMW

	SL-SVLBR	SL-SVLBR-X
Entering angle:	κ_r 95°	κ_r 95°
Lead angle:	-5°	-5°



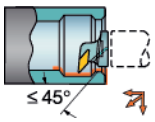
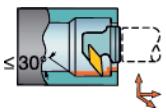






Back boring

For f_1 range and $D_m$dimensions, see CoroTurn® SL quick change adapter on page I76.
Right hand style shown when nothing else is stated

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) D_{5m} mm	D_{5m} in.	h mm	h in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
 ≤45°	16	3/8	SL-SVLBR-32-16-QC	32	32	1.260	14.7	.579	22.0	.866	0°	-6.5°	VBMT 16 04 08	VBMT 332	3.0
 ≤30°	16	3/8	SL-SVLBR-32-16X-QC	32	32	1.260	14.7	.579	14.0	.551	0°	-6.5°	VBMT 16 04 08	VBMT 332	3.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size		Insert screw (thread)	Key (Torx Plus)	Adjustment screw	Key (mm)	Locating tube
iC						
16	3/8	5513 020-10	5680 049-01 (15IP)	5514 060-10	170.3-864 (1.98)	5638 031-01

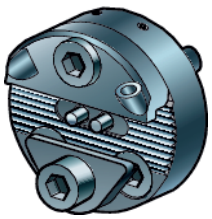
 A9

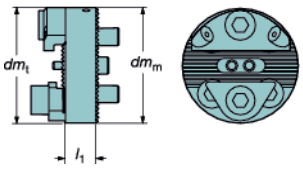
 A2

 I4

 J2

CoroTurn® SL quick change adapter for cutting heads

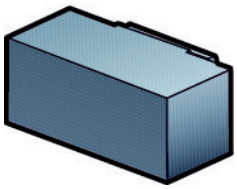


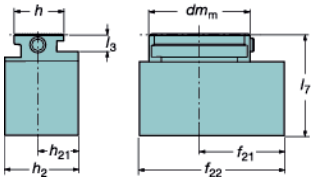


Bar dia. mm	Coupling size		Dimensions, millimeter, inch (mm, in.)						
dm_m	dm_t	**Ordering code**	l_1 mm	l_1 in.	f_1 min. mm	f_1 min. in.	f_1 max. mm	f_1 max. in.	KG
32	32	**SL-32 11-32-QC**	11	.433	23	.906	30	1.181	0.1
40	32	**SL-40 12-32-QC**	12	.472	23	.906	31	1.220	0.1

1) For bar dia.

Blanks for CoroTurn® SL quick change cutting heads





Right hand style shown.

Coupling size		Dimensions, millimeter, inch (mm, in.)												
dm_m	**Ordering code**	f_{21} mm	f_{21} in.	h mm	h in.	h_2 mm	h_2 in.	h_{21} mm	h_{21} in.	l_3 mm	l_3 in.	l_7 mm	l_7 in.	KG
32	**SL-32 305025R/L**	25	.984	14.7	.579	22	.866	12	.472	6.0	.236	30.0	1.181	0.2


A10


A2


I4


J2

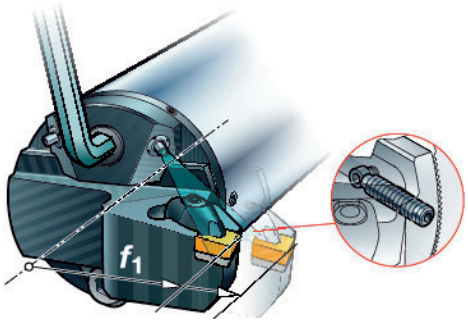
CoroTurn® SL quick change

Boring bars and exchangeable cutting heads

For vibration-free internal machining in large diameter bores

Quick change function

Reduced setup times resulting in increased output. Easy to change cutting head.



Adjustable f_1 dimension

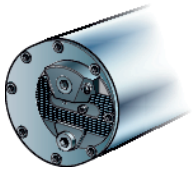
More flexibility in production. Easy to adjust cutting head sideways for other bores or applications and lock into position with adjustment screw.

Silent Tools®

Light head design

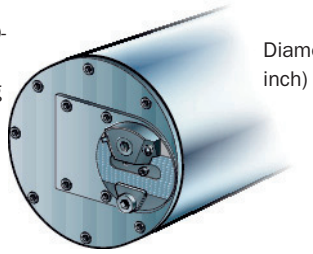
For improved performance of the Silent tool function, reducing vibration.

Diameter 80 - 100 mm (3.150 - 3.937 inch)



Diameter up to 200 mm (7.874 inch)

For bars of 200 mm (7.874 inch) and over, a manual Coromant Capto clamping unit C6-R/LC2090-42060, makes it possible to use all types of Coromant Capto cutting units. See chapter G.



Diameter over 200 mm (7.874 inch)

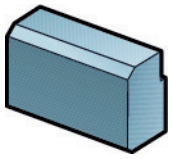
Dampened Silent Tools bars with CoroTurn SL quick change function in 80-250 mm diameter (to 600 mm as special) for up to 10 x bar diameter overhang. Carbide reinforced dampened Silent Tools bars with CoroTurn SL quick change function in 80-100 mm diameter for up to 14 x bar diameter overhang

Cutting heads with integrated tip seat

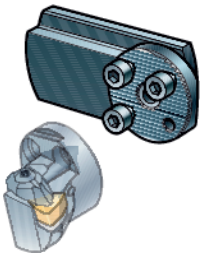
Cutting head for roughing, CoroTurn® RC

Cutting head for finishing/profiling, CoroTurn® 107

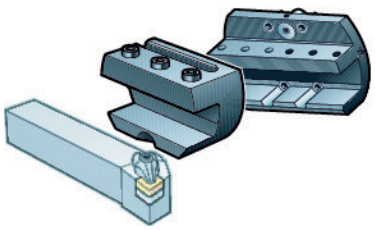
Cutting head for threading, CoroThread® 266



Pre-machined blanks to enable production of tip seat to own specification

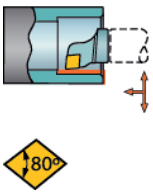
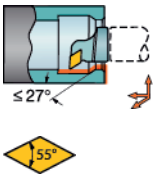
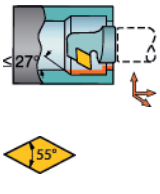
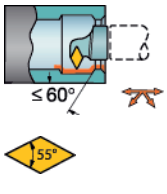
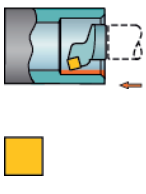


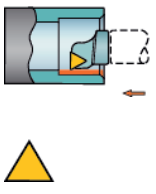
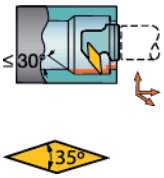
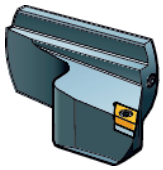
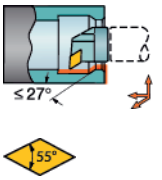
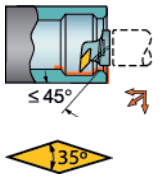
Adapter for CoroTurn® SL (570) cutting heads

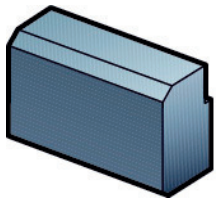


Adapter for shank tools

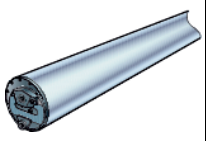
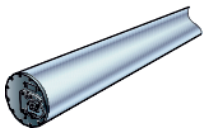
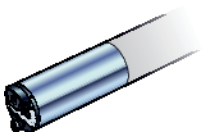
Cutting heads with CoroTurn® SL quick change

CoroTurn® RC rigid clamp design	Entering angle (Lead angle)		Back boring		
	κ_r 95° (-5°)	κ_r 93° (-3°)	κ_r 93° (-3°)	κ_r 62.5° (27.5°)	κ_r 75° (15°)
					
	570-DCLNR/L	570-DDUNR/L	570-DDUNR/L-X	570-DDXNR/L	570-DSKNR/L
Insert size, mm (*iC*, inch)	12-16 (1/2-5/8)	15 (1/2)	15 (1/2)	15 (1/2)	12-19 (1/2-3/4)
Coupling size, mm	80	80	80	80	80
Page	I80	I81	I81	I81	I82

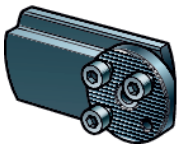
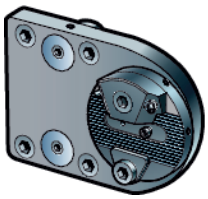
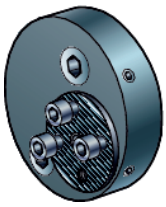
CoroTurn® RC rigid clamp design	Entering angle (Lead angle)	Back boring	CoroTurn® 107 screw clamp design	Entering angle (Lead angle)	
	κ_r 91° (-1°)	κ_r 93° (-3°)		κ_r 93° (-3°)	κ_r 95° (-5°)
						
	570-DTFNR/L	570-DVUNR/L-X		570-SDUCR	570-SVLBR
Insert size, mm (*iC*, inch)	16-22 (3/8-1/2)	16 (3/8)	Insert size, mm (*iC*, inch)	11 (3/8)	16 (3/8)
Coupling size, mm	80	80	Coupling size	80	80
Page	I83	I84	Page	I85	I85

CoroThread® 266 screw clamp design for threading	Blanks for CoroTurn® SL quick change cutting heads
	
SL-266RKF	570
Insert size, mm (*iC*, inch) 22-27 (1/2-5/8))	
Coupling size, mm 80	80
Page I86	I86

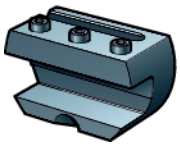
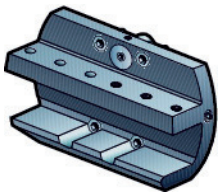
Dampened boring bars with CoroTurn® SL quick change

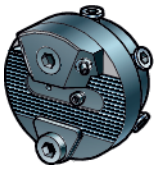
	Dampened boring bar			Dampened reinforced boring bar	Coromant Capto® dampened boring bars
	Silent Tools®  570-3C/A570-3C			Silent Tools® 	
Max overhang	7 x dm_m	10 x dm_m	10 x dm_m	12-14 x dm_m	7 x dm_m
Bar diameter, mm (inch)	80-100 (3.000-4.000)	120-150 (5.000-6.000)	200-250 (8.000-10.000)	80-100 (3.000-4.000)	80 (3.150)
Coupling size	80	80	80	80	80
Page	I89	I88	I88	I90	I87

CoroTurn® SL quick change adapter for cutting heads

For SL cutting heads		From diameter 200 mm (7.874 inch)	CoroTurn® SL quick change adapter for cutting heads	
				
Coupling size			Bar diameter, mm (inch)	80-100 (3.150-3.937)
Machine side	40			
Tool side		80	Coupling size	40
Page	I90	I90	Page	I92

CoroTurn® SL quick change adapter for shank tools

For square shank tools		From diameter 200 mm (7.874 inch)
		
Shank dim., mm	2020	2525-4040
Page	I91	I91

Conversion from 580 coupling to CoroTurn® SL quick change	
	
Coupling size	
Machine side	65
Tool side	80
Page	I93

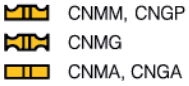
CoroTurn® SL quick change adapter for SL70 cutting heads	 -RG	 -RF
Bar diameter, mm (inch)	80 (3.150)	80 (3.150)
Coupling size	70	70
Page	I92	I92

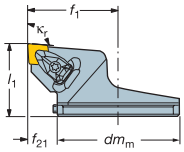
Cutting heads with CoroTurn® SL quick change

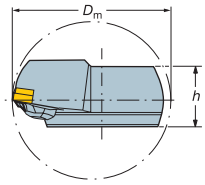
CoroTurn® RC rigid clamp design

570-DCLNR/L

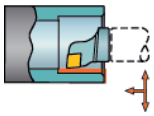
Entering angle: κ_r 95°
Lead angle: -5°







For f_1 range and D_m dimensions, see CoroTurn® SL quick change boring bars on page I87.
Right hand style shown

Main application	□	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
	12	1/2	**570-DCLNR/L-80-12**	80	37.5	1.476	45.0	1.772	-6°	-8°	CNMG 12 04 08	CNMG 432	3.9
	16	5/8	**570-DCLNR/L-80-16**	80	37.5	1.476	45.0	1.772	-6°	-9°	CNMG 16 06 12	CNMG 543	6.4

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size □	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	Adjustment screw	Key (mm)
12	1/2	5513 020-02	5322 236-03	5680 049-01 (15IP)	5412 028-021	5680 049-01 (15IP)	5514 060-12	174.1-863 (2.5)
16	5/8	5513 020-07	5322 234-03	5680 043-14 (20IP)	5412 028-031	5680 043-14 (20IP)	5514 060-12	174.1-863 (2.5)


A9

A2

I4

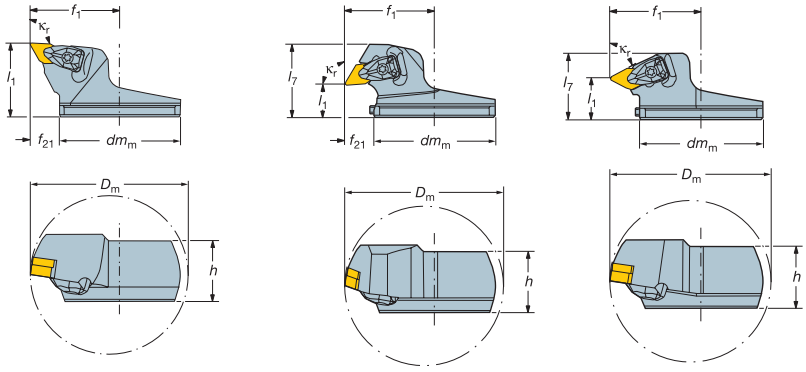
J2

Cutting heads with CoroTurn® SL quick change

CoroTurn® RC rigid clamp design

DNMM, DNGP, DNMX
DNMG
DNMA, DNGA

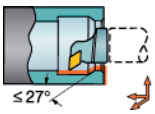
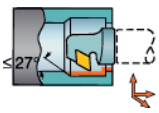
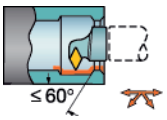
	570-DDUNR/L	570-DDUNR/L-X	570-DDXNR/L
Entering angle:	κ_r 93°	κ_r 93°	κ_r 62.5°
Lead angle:	-3°	-3°	27.5



Back boring

For f_1 range and $D_m$dimensions, see CoroTurn® SL quick change boring bars on page I87.

Right hand style shown

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts ISO	ANSI	Nm[3]
	15	1/2	**570-DDUNR/L-80-15**	80	37.5	1.476	45.0	1.772	-6°	-8°	DNMG 15 06 08	DNMG 442	3.9
			570-DDUNR/L-80-15-G[4]	80	37.5	1.476	45.0	1.772	-6°	-8°	DNMG 15 06 08	DNMG 442	3.9
	15	1/2	**570-DDUNR/L-80-15X**	80	37.5	1.476	20.0	.787	6°	-8°	DNMG 15 06 08	DNMG 442	3.9
	15	1/2	**570-DDXNR/L-80-15**	80	37.5	1.476	25.0	.984	0°	-8°	DNMG 15 06 08	DNMG 442	3.9

R = Right hand, L = Left hand

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.
4) Extended f_1 dimension

Main spare parts

Insert size		Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	Adjustment screw	Key (mm)
iC								
15	1/2	5513 020-02	5322 266-02	5680 049-01 (15IP)	5412 028-021	5680 049-01 (15IP)	5514 060-12	174.1-863 (2.5)

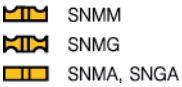
 A10
 A2
 I4
 J2

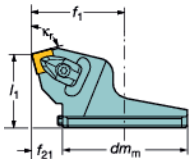
Cutting heads with CoroTurn® SL quick change

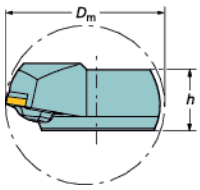
CoroTurn® RC rigid clamp design

570-DSKNR/L

Entering angle: κ_r 75°
Lead angle: 15°

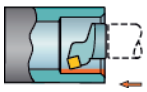






For f_1 range and $D_m$dimensions, see CoroTurn® SL quick change boring bars on page I87.

Right hand style shown

Main application	□	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	l_1 mm	l_1 in.	γ[1]	λ_s[2]	Gauge inserts ISO	ANSI	Nm[3]
	12	1/2	**570-DSKNR/L-80-12**	80	37.5	1.476	45.0	1.772	-6°	-8°	SNMG 12 04 08	SNMG 432	3.9
	15	5/8	**570-DSKNR/L-80-15**	80	37.5	1.476	45.0	1.772	-6°	-8°	SNMG 15 06 12	SNMG 543	6.4
	19	3/4	**570-DSKNR/L-80-19**	80	37.5	1.476	45.0	1.772	-6°	-9°	SNMG 19 06 12	SNMG 643	6.4

R = Right hand, L = Left hand

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

Main spare parts

Insert size □	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	Adjustment screw	Key (mm)
12	1/2	5513 020-02	5322 426-02	5680 049-01 (15IP)	5412 028-021	5680 049-01 (15IP)	5514 060-12	174.1-863 (2.5)
15	5/8	5513 020-07	5322 425-03	5680 049-01 (15IP)	5412 028-031	5680 049-01 (15IP)	5514 060-12	174.1-863 (2.5)
19	3/4	5513 020-07	5322 425-04	5680 043-14 (20IP)	5412 028-041	5680 043-14 (20IP)	5514 060-12	174.1-863 (2.5)

 A10
 A2
 I4
 J2

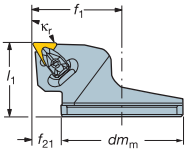
Cutting heads with CoroTurn® SL quick change

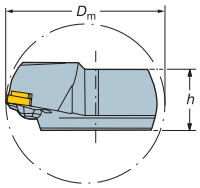
CoroTurn® RC rigid clamp design

570-DTFNR/L

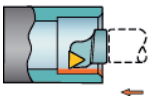
Entering angle: κ_r 91°
Lead angle: -1°

TNMM, TNMX
TNMG
TNMA, TNGA





For f_1 range and $D_m$dimensions, see CoroTurn® SL quick change boring bars on page I87.
Right hand style shown

Main application	△	iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
	16	3/8	**570-DTFNR/L-80-16**	80	37.5	1.476	45.0	1.772	-8°	-6°	TNMG 16 04 08	TNMG 332	1.7
	22	1/2	**570-DTFNR/L-80-22**	80	37.5	1.476	45.0	1.772	-8°	-6°	TNMG 22 04 08	TNMG 432	1.7

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size △	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	Adjustment screw	Key (mm)
16	3/8	5513 020-04	5322 316-01	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)	5514 060-12	174.1-863 (2.5)
22	1/2	5513 020-02	5322 315-04	5680 049-01 (15IP)	5412 028-021	5680 049-01 (15IP)	5514 060-12	174.1-863 (2.5)

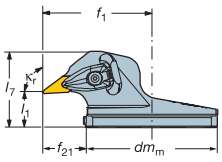
 A10
 A2
 I4
 J2

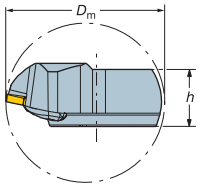
Cutting heads with CoroTurn® SL quick change

CoroTurn® RC rigid clamp design

570-DVUNR/L-X

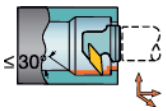
Entering angle: κ_r 93°
Lead angle: -3°





Back boring

For f_1 range and D_m dimensions, see CoroTurn® SL quick change boring bars on page I87.
Right hand style shown

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	γ 1)	λ_s 2)	Gauge inserts ISO	ANSI	Nm 3)
	16	3/8	**570-DVUNR/L-80-16X**	80	37.5	1.476	25.5	1.004	20.0	.787	-6°	-8°	VNMG 16 04 08	VNMG 332	3.0

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

R = Right hand, L = Left hand

Main spare parts

Insert size	iC	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Adjustment screw	Key (mm)
16	3/8	5513 020-09	5322 269-01	5680 049-01 (15IP)	5412 028-061	5514 060-12	174.1-863 (2.5)

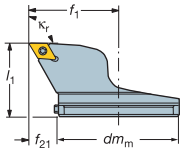
 A10
 A2
 I4
 J2

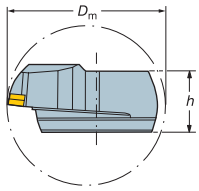
Cutting heads with CoroTurn® SL quick change

CoroTurn® 107 screw clamp design

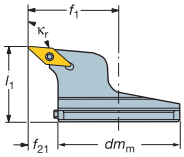
	570-SDUCR/L	570-SVLBR/L
Entering angle:	κ_r 93°	κ_r 95°
Lead angle:	-3°	-5°

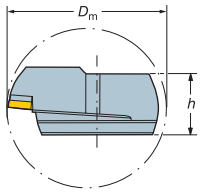
DCMT, DCMX
DCGT, DCGX, DCET
DCMW





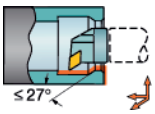
VBMT, VBGT
VCGX, VCEX,
VCGT, VCET
VBMW, VCMW

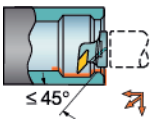




For f_1 range and $D_m$dimensions, see CoroTurn® SL quick change boring bars on page I87.

Right hand style shown

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts ISO	ANSI	Nm3)
	11	3/8	**570-SDUCR/L-80-11**	80	37.5	1.476	45.7	1.799	0°	-4°	DCMT 11 T3 08	DCMT 3(2.5)2	3.9

Main application		iC	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	l_1 mm	l_1 in.	$\gamma^{1)}$	$\lambda_s^{2)}$	Gauge inserts ISO	ANSI	Nm3)
	16	3/8	**570-SVLBR/L-80-16**	80	37.5	1.476	45.7	1.799	0°	-4°	VBMT 16 04 08	VBMT 332	3.9
			SL-SVLBR-32-16-QC	32	14.7	.579	22.0	.866	0°	-6.5°	VBMT 16 04 08	VBMT 332	3.0

1) γ = Rake angle.
2) λ_s = Angle of inclination.
3) Insert tightening torque, Nm.

R = Right hand, L = Left hand

Main spare parts

Insert size DCM.	iC	VBM.	iC	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	Adjustment screw	Key (mm)
11	3/8			5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 263-01	5512 090-01	5680 049-01 (3.5)	5514 060-12	174.1-863 (2.5)
		16	3/8	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)	5514 060-12	174.1-863 (2.5)

 A10
 A10
 I4
 J2

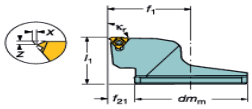
Cutting heads with CoroTurn® SL quick change

CoroThread® 266 screw clamp design for threading

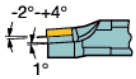
SL-266RKF

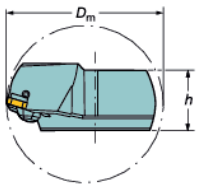
266 R/LL

x and z, see infeed tables on pages C70.

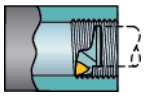


Angle of inclination from –2° to +4° with different shims, see page C45.





For f_1 range and $D_m$dimensions, see CoroTurn® SL quick change boring bars on page I87.
Right hand style shown

Main application	□	iC	Pitch range mm	Pitch range TPI	Ordering code	Coupling size dm_m	Dimensions, millimeter, inch (mm, in.) h mm	h in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	Gauge inserts	Nm[1]
	16	3/8	2.5-7.0	11.5-4	**SL-266R/LKF-80-16-QC**	80	37.5	1.476	18.5	.728	45.0	1.772	266.LL-16..	3.0
	22	1/2	2.5-7.0	11.5-4	**SL-266RKF-80-22-QC**	80	37.5	1.476	18.5	.728	45.0	1.772	266.RL-22..	5.0
	27	5/8	8.0	5-3	**SL-266RKF-80-27-QC**	80	37.5	1.476	18.5	.728	45.0	1.772	266.RL-27..	7.5

[1] Insert tightening torque, Nm.

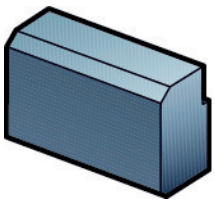
R = Right hand

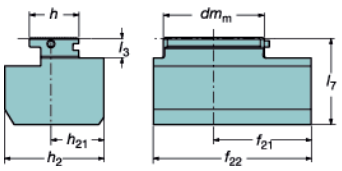
Main spare parts

Insert size □	iC	Insert screw	Key (Torx Plus)	Shim for right hand internal tool holder[1] Inclination angle +1°	Shim for left hand internal tool holder[1] Inclination angle +1°	Shim screw
16	3/8	5513 020-13	5680 049-05 (15IP/10IP)	5322 390-11	5322 389-11	5512 032-05
22	1/2	5513 020-26	5680 043-14 (20IP)	5322 380-11	5322 379-11	5512 032-04
27	5/8	5513 020-66	5680 043-15 (25IP)	5322 388-11	5322 387-11	5512 032-03

[1] For optional shims, see page C45.

Blanks for CoroTurn® SL quick change cutting heads





Right hand style shown.

Coupling size dm_m	Ordering code	Dimensions, millimeter, inch (mm, in.) f_{21} mm	f_{21} in.	f_{22} mm	f_{22} in.	h mm	h in.	h_2 mm	h_2 in.	h_{21} mm	h_{21} in.	l_3 mm	l_3 in.	l_7 mm	l_7 in.
80	**570-80 6512074R/L**	74	2.913	120	4.724	37.5	1.476	75	2.953	40	1.575	14.7	.579	65.0	2.559


C11

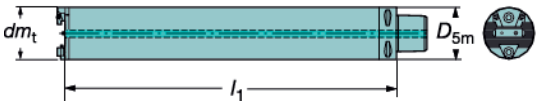

A2

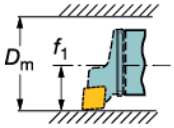

I90


J2

CoroTurn® SL quick change

Coromant Capto® dampened boring bars

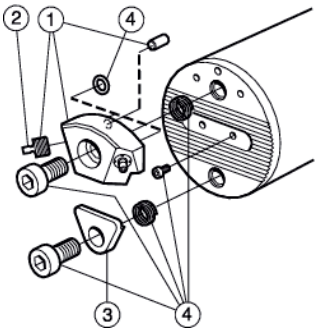




Silent Tools®

With internal coolant supply

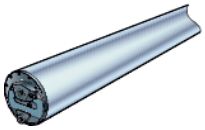
	Coupling size		Dimensions, millimeter, inch (mm, in.)										
	dm_t	**Ordering code**	D_m min mm	D_m min in.	D_{5m} mm	D_{5m} in.	l_1 mm	l_1 in.	f_1 min. mm	f_1 min. in.	f_1 max. mm	f_1 max. in.	kg
	80	**C6-570-3C 80 355**	100	3.937	63	2.480	355	13.976	55	2.165	74	2.913	9.0
	80	**C8-570-3C 80 475**	100	3.937	80	3.150	475	18.701	55	2.165	74	2.913	17.1



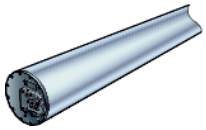
	1	2	3	4
Boring bar	Clamp set	Nozzle	Clamp	Screw set
C6-570-3C 80 355	5412 052-011	5691 029-10	5412 053-01	5473 051-01
C8-570-3C 80 475	5412 052-011	5691 029-10	5412 053-01	5473 051-01

 A11
 A2
 I90
 J2

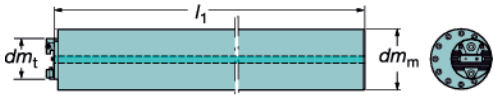
Dampened boring bars with CoroTurn® SL quick change

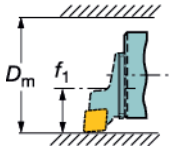


Bar dia. mm (inch)
120-150 (5.000-6.000)



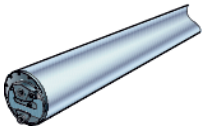
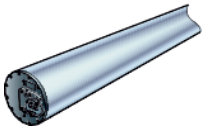
Bar dia. mm (inch)
200-250 (8.000-10.000)



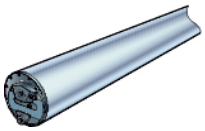
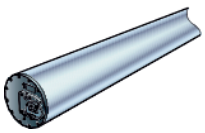


With internal coolant supply
Max overhang 10 x dm_m
All bar sizes use cutting heads in coupling size dm_t 80.

Metric version

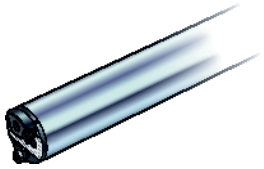
	Bar dia. mm dm_m	Ordering code	Coupling size dm_t	Dimensions D_m min	l_1	f_1 min.	f_1 max.	kg
	120	570-3C 120 1900R/L	80	140	1900	75	94	133.7
	150	570-3C 150 2400R/L	80	170	2400	90	109	252.4
	200	570-3C 200 3200R/L	80	220	3200	115	134	603.9
	250	570-3C 250 4000R/L	80	275	4000	140	159	980.1

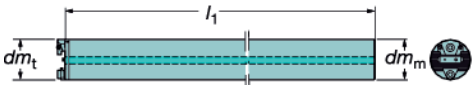
Inch version

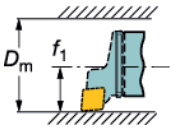
	Bar dia. inch dm_m	Ordering code	Coupling size dm_t	Dimensions, inch D_m min	l_1	f_1 min.	f_1 max.	Lbs
	5.000	A570-3C D80 75R/L	80	5.500	75	2.835	3.701	338.8
	6.000	A570-3C D96 95R/L	80	6.800	95	3.543	4.291	579.9
	8.000	A570-3C D128 126R/L	80	8.800	126	4.528	5.276	1386.5
	10.000	A570-3C D160 157R/L	80	11.000	157	5.512	6.260	2270.7

 I114
 A2
 G6
 J2

Dampened boring bars with CoroTurn® SL quick change

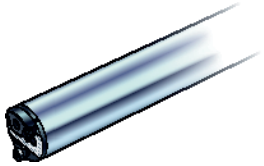






With internal coolant supply
Short design. Max overhang 12 x dm_m
Long design. Max overhang 14 x dm_m

Metric version

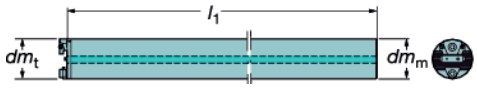
Type	Bar dia. dm_m	Ordering code	Max overhang	Coupling size dm_t	Dimensions D_m min	D_{th}	h	l_1	l_{th}	f_1 min.	f_1 max.	kg
	80	**570-3C 80 880**	7 x dmm	80	100	G3/4"	37.5	880	28	55	74	31.3
	80	**570-3C 80 1200**	10 x dmm	80	100	G3/4"	37.5	1200	28	55	74	43.4
	100	**570-3C 100 1100**	7 x dmm	80	120	G3/4"	37.5	1100	28	67	88	63.1
	100	**570-3C 100 1500**	10 x dmm	80	120	G3/4"	37.5	1500	28	67	88	86.6

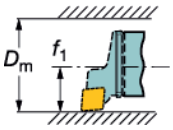
Inch version

Type	Bar dia. inch dm_m	Ordering code	Max overhang	Coupling size dm_t mm	Dimensions, inch D_m min	h	l_1	f_1 min.	f_1 max.	Lbs
	3.000	**A570-3C D48 33**	7 x dmm	80	3.937	1.476	33	2.165	2.913	61.4
	3.000	**A570-3C D48 45**	10 x dmm	80	3.937	1.476	45	2.165	2.913	83.6
	4.000	**A570-3C D64 44**	7 x dmm	80	4.724	1.476	44	2.638	3.465	146.2
	4.000	**A570-3C D64 60**	10 x dmm	80	3.937	1.476	60	2.638	3.465	200.7

 I114
 A2
 G6
 J2

Dampened carbide reinforced boring bars with CoroTurn® SL quick change





Short design. Max overhang 7 x dm_m
Long design. Max overhang 10 x dm_m

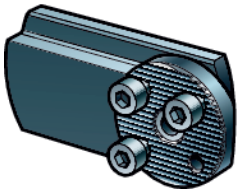
Silent Tools®

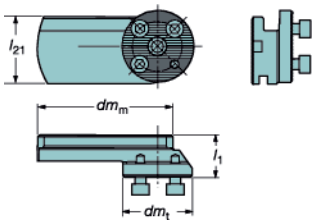
With internal coolant supply
All bar sizes use cutting heads in coupling size dm_t 80 mm.

Metric version

Type	Bar dia. mm dm_m	Ordering code	Max overhang	Coupling size dm_t	Dimensions D_m min	l_1	f_1 min.	f_1 max.	kg
	80	570-3C 80 1240 CR	12 x dmm	80	100	1240	55	74	50.4
	80	570-3C 80 1400 CR	14 x dmm	80	100	1400	55	74	63.0
	100	570-3C 100 1560 CR	12 x dmm	80	120	1560	67	88	101.7
	100	570-3C 100 1760 CR	14 x dmm	80	120	1760	67	88	129.1

CoroTurn® SL quick change adapter for SL cutting heads, adjustable



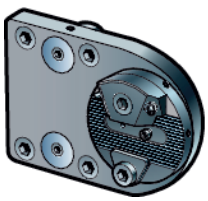


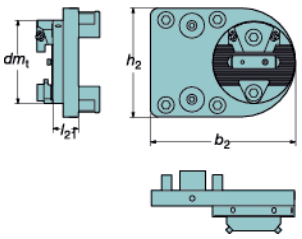
Right hand style shown.

Coupling size, tool side dm_t	Coupling size, machine side dm_m	Ordering code	Dimensions, millimeter, inch (mm, in.) l_1 mm	l_1 in.	l_{21} mm	l_{21} in.	kg
40	80	570-80 23-40R/L	23.0	.906	37.5	1.476	0.18

R = Right hand, L = Left hand

The adapter fits all boring bars from diameter 200 mm (7.874 inch)





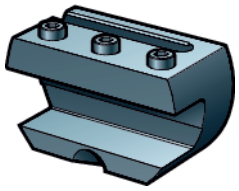
Right hand style shown.

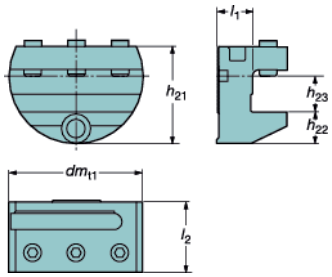
Coupling size dm_t	Ordering code	Dimensions, millimeter, inch (mm, in.) b_2 mm	b_2 in.	h_2 mm	h_2 in.	l_{21} mm	l_{21} in.
80	570-80 200R/L	139	5.472	104	4.094	25	.984

R = Right hand, L = Left hand

 I114
 A2
 G6
 J2

CoroTurn® SL quick change adapter for square shank tools

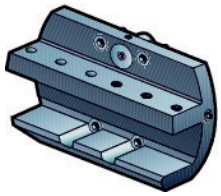


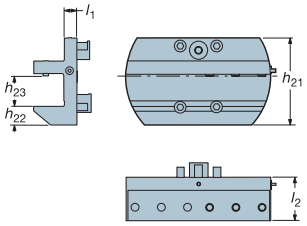


For shank size, mm (bxh)	Coupling size dm_m	Ordering code	Dimensions, millimeter, inch (mm, in.) h_{21} mm	h_{21} in.	h_{22} mm	h_{22} in.	h_{23} mm	h_{23} in.	l_1 mm	l_1 in.	l_2 mm	l_2 in.
20 x 20	80	**570-80 20 2020R**	54.5	2.146	18	0.709	20	0.787	20	0.787	40	1.575

R = Right hand

The adapter fits all boring bars from diameter 200 mm (7.874 inch)

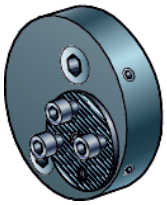


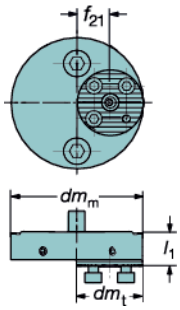


For shank size, mm (bxh)	Ordering code	Dimensions, millimeter, inch (mm, in.) h_{21} mm	h_{21} in.	h_{22} mm	h_{22} in.	h_{23} mm	h_{23} in.	l_1 mm	l_1 in.	l_2 mm	l_2 in.
25 x 25	**570-200 2525-M**	110	4.331	33	1.299	25	0.984	26	1.024	50	1.968
32 x 32	**570-200 3232-M**	115	4.528	31	1.220	32	1.260	26	1.024	55	2.165
40 x 40	**570-200 4040-M**	125	4.921	33	1.299	40	1.575	35	1.378	65	2.559

 I114
 G6
 A2
 J2

CoroTurn® SL quick change adapter for SL cutting heads





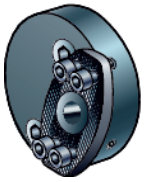
With internal coolant supply

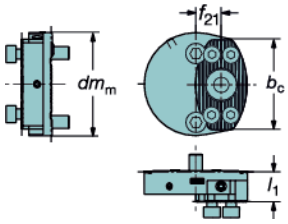
Right hand style shown.

For bar dia.		Coupling size		Dimensions, millimeter, inch (mm, in.)				
dm_m mm	dm_m in.	dm_t	**Ordering code**	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	kg
80	3.15	40	**570-80 20 20-40R**	20.0	.787	20.0	.787	0.7
100	3.937	40	**570-100 20 30-40R**	30.0	1.181	20.0	.787	1.0

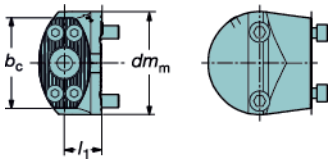
CoroTurn® SL quick change adapter for SL70 cutting heads

SL70-80 23-RG





SL70-80 40-RF



With internal coolant supply

Right hand style shown

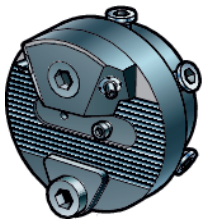
Coupling size, tool side	Coupling size, machine side		Dimensions, millimeter, inch (mm, in.)				
b_c	dm_m	**Ordering code**	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	kg
70	80	**SL70-80 23-RG**	20.0	.787	23.0	.906	0.8
70	80	**SL70-80 40-RF**			28.0	1.102	1.2

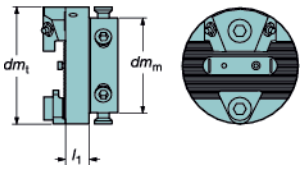
1) Coupling size, mm

I114 G6 A2 J2

580 boring bar adapter

Conversion from 580 coupling to CoroTurn® SL quick change





Internal coolant supply

Coupling size, tool side	Coupling size, machine side		Dimensions, millimeter, inch (mm, in.)	
dm_t	dm_m	**Ordering code**	l_1 mm	l_1 in.
80	65	**570-80 17-580-80**	17.0	.669

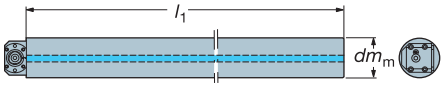

I114

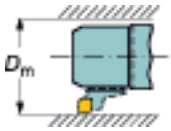

G6


A2

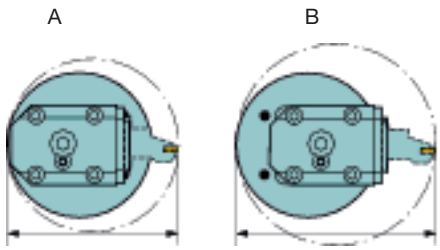

J2

Coromant Capto® dampened boring bars with clamping units





1) Different mounting possibilities



With internal coolant supply
Max overhang 10 x dm_m

Silent Tools®

Metric version

Ordering code	Bar dia. dm_m	Coupling size	Dimensions D_m min1	D_m min2	l_1	kg
CU-3C801200-C3	80	C3	120	-	1200	46.0
CU-3C1001500-C3[1)]	100	C3	120	150	1500	90.0
CU-3C1001500-C4	100	C4	145	-	1500	90.0

Inch version

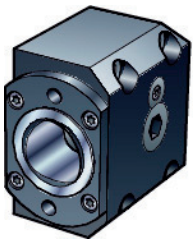
Ordering code	Bar dia. dm_m	Coupling size	Dimensions, inch D_m min1	D_m min2	l_1	Lbs
CU-3CD4845-C3	3.000	C3	4.724	-	45.591	90.4
CU-3CD6460-C3[1)]	4.000	C3	4.724	5.906	60.787	207.2
CU-3CD6460-C4	4.000	C4	5.709	-	60.787	207.2

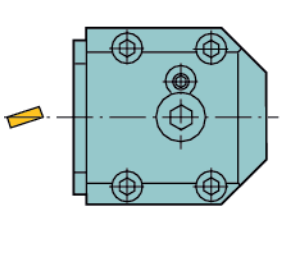
1) Different mounting possibilities

Manually operated clamping units

Camshaft activated

Type 2090





Note: Maximum coolant pressure is 80 bar (PSI 1160)

Right hand style shown.

Metric version

Turret type h, size, mm	Coupling size	Ordering code	Dimensions b_2	h_2	h_{21}	l_{1x}	l_{1z}	l_{tz}
54	C3	C3-R/LC2090-19039M	73	54	30	39	19	38
77	C4	C4-R/LC2090-24043A	86	77	38	43	24	48

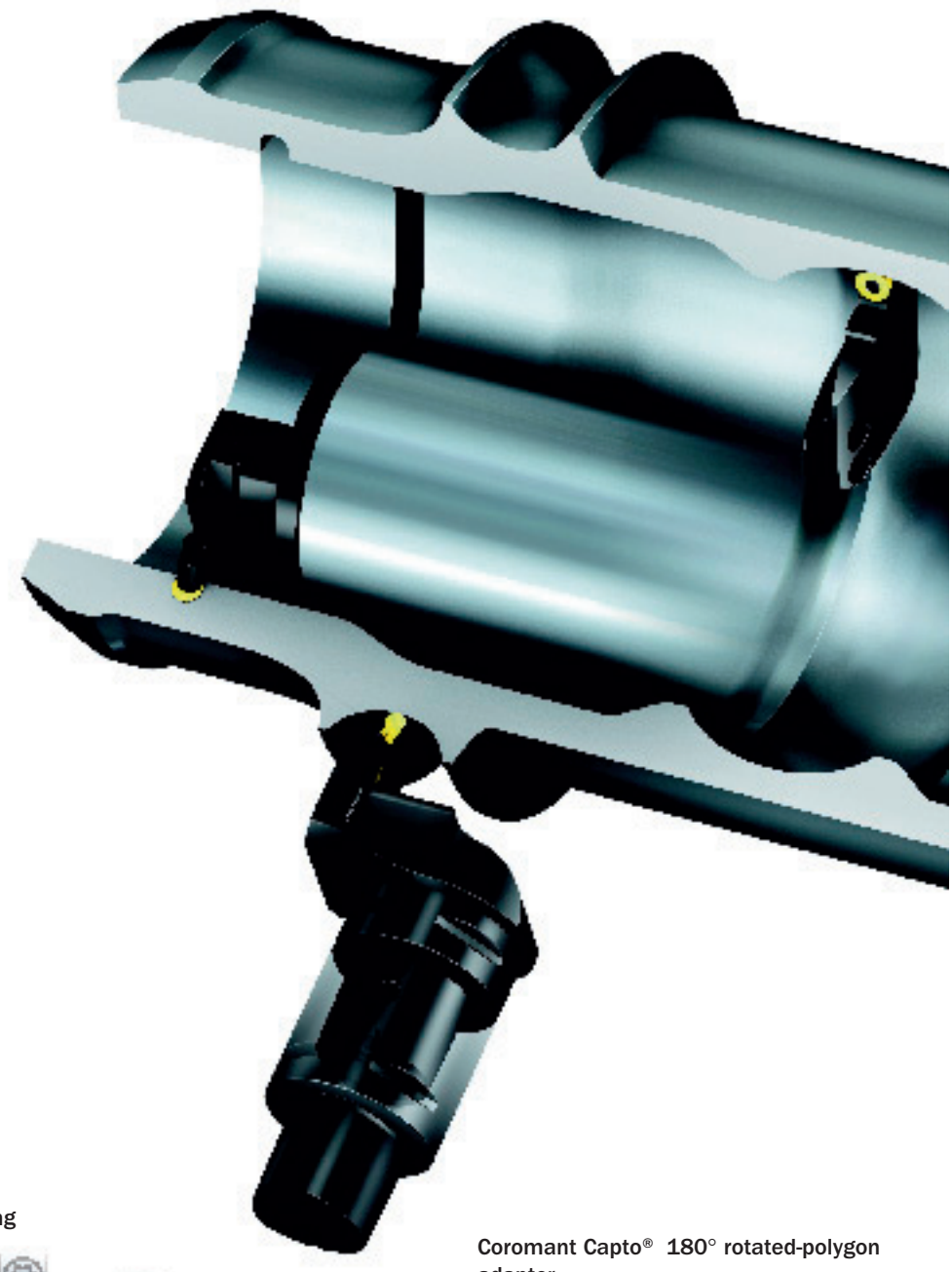
 I114
 G6
 A2
 J2


SANDVIK
Coromant

CoroTurn® SL70

One standard assortment of blades and adapters for profiling and pocketing in complex components.

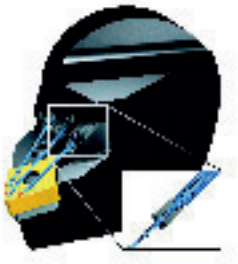
The CoroTurn SL70 oval coupling provides sufficient clearances for machining in turbine disks and other components with limited accessibility.



SilentTools

CoroTurn SL quick change

Adapters for Silent Tools boring bars
See page I92



CoroTurn® HP

A standard feature for many SL70 blades.

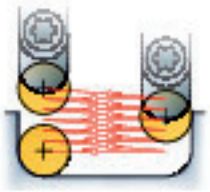
- Improved chip control
- Higher cutting speeds
- Ideal for difficult materials

Coromant Capto® 180° rotated-polygon adapter

See page G30

Trochoidal turning

Ramping



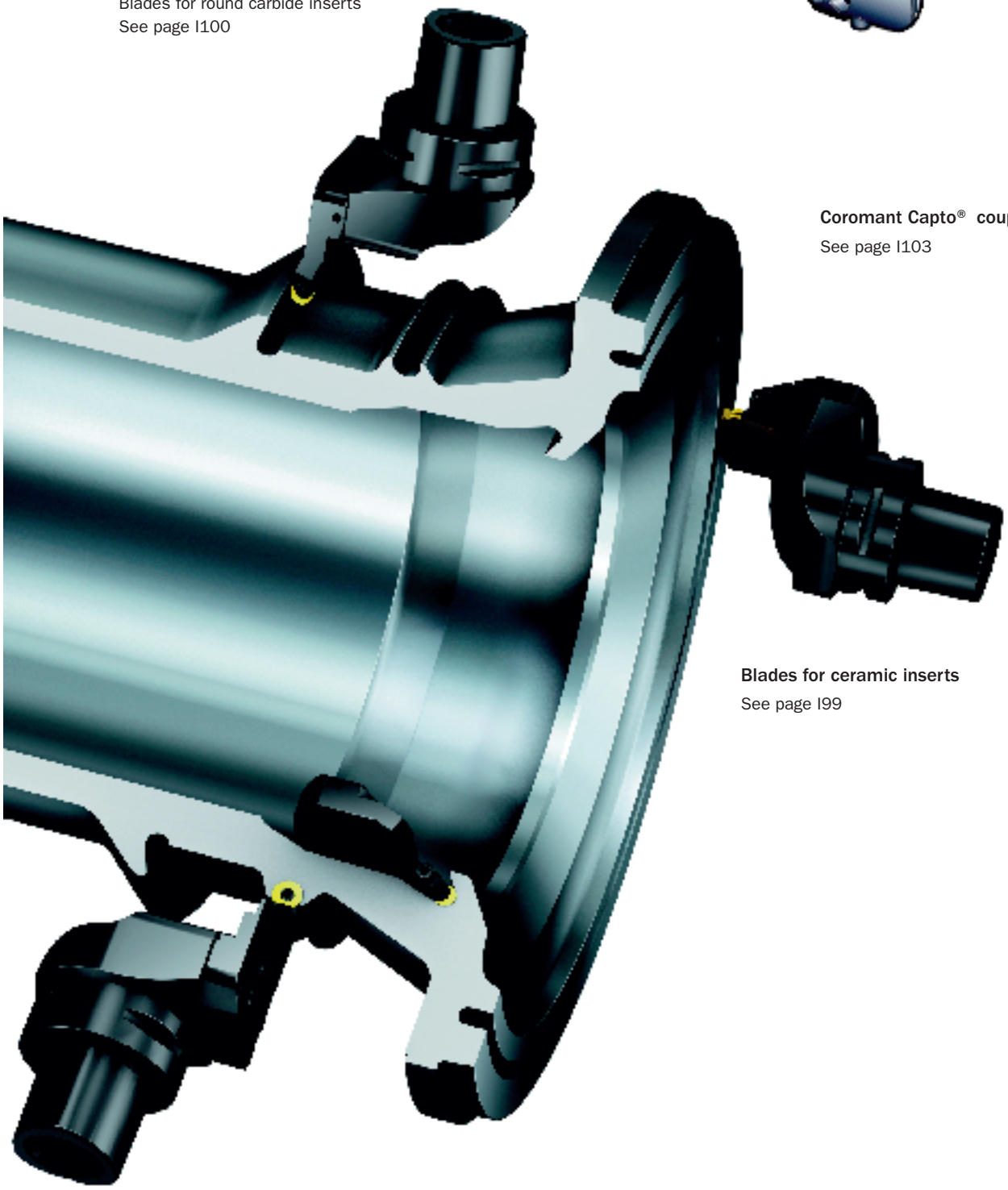
Advanced application techniques

Double productivity with improved security and tool life in difficult materials.

SANDVIK Coromant

CoroTurn® 107
Blades for round carbide inserts
See page I100

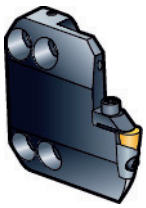
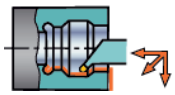
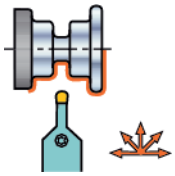
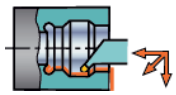
CoroCut® SL70
Blade for face grooving
Seat size H
See page I102

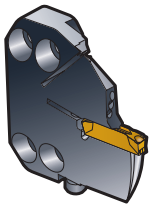
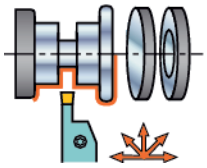
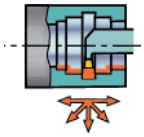
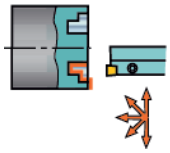


Coromant Capto® coupling
See page I103

Blades for ceramic inserts
See page I99

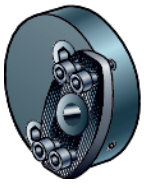
Cutting heads with CoroTurn® SL70 coupling

CoroTurn® SL70	Grooving, parting off, profiling and turning	Internal grooving and profiling	Grooving, parting off, profiling and turning	Internal grooving and profiling
				
	SL70-CRDCR / SL70-CRSCR-HP		**SL70-SRDCR-HP**	
Insert size, mm (*iC*, inch)	09-12 (3/8-1/2)		10-12 (1/2)	
SL70 coupling size	70		70	
Page	I99		I100	

CoroCut® SL70	Grooving and parting	Internal grooving and profiling	Face grooving
			
	SL70-R/L123		**SL70-R/L123**
Insert width, inch	3-16		4-6
Insert width, inch	.118-.590		.157-.236
SL70 coupling size	70		70
Page	I101		I102

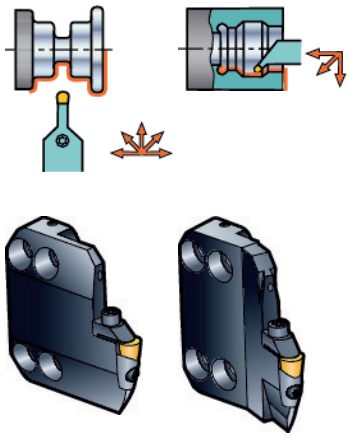
Adapters

Coromant Capto® adapters	0°	5°	45°	90°
				
Coromant Capto® size	C5-C8	C6	C6	C5-C8
SL70 coupling size	70	70	70	70
Page	I103	I103	I103	I103

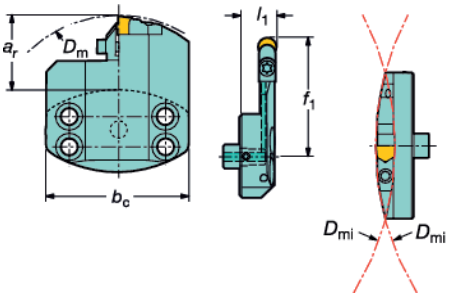
CoroTurn SL® quick change adapter for SL70 cutting heads		
		
Coupling size		
Machine side	80	80
Tool side	70	70
Page	I92	I92

Cutting heads with CoroTurn® SL70 coupling

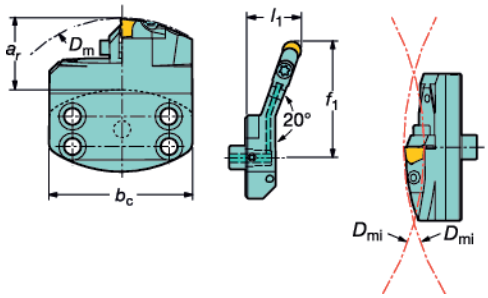
For round inserts, top clamp



SL70-CRDCR/L



SL70-CRSCR/L



Right hand style shown when nothing else is stated

First cut diameter, millimeter, inch (mm, in.)		Insert size			Coupling size	Dimensions, millimeter, inch (mm, in.)									
D_{mi} mm	D_{mi} in.	○	*iC*	**Ordering code**	b_c	a_r mm	a_r in.	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[1]
270	10.630	09	3/8	**SL70-CRDCR/L-18-09**	70	18	.738	125.0	4.921	39.0	1.535	18.0	.709	RCGX 09 07 00	7.5
270	10.630			**SL70-CRDCR/L-35-09**	70	35	1.407	125.0	4.921	56.0	2.205	18.0	.709	RCGX 09 07 00	7.5
270	10.630			**SL70-CRSCR/L-35-09**	70	35	1.378	130.0	5.118	55.0	2.165	26.7	1.051	RCGX 09 07 00	7.5
500	19.684			**SL70-CRDCR/L-50-09**	70	50	1.998	125.0	4.921	71.0	2.795	16.5	.650	RCGX 09 07 00	7.5
270	10.630	12	1/2	**SL70-CRDCR/L-35-12**	70	35	1.407	180.0	7.087	56.0	2.205	18.0	.709	RCGX 12 07 00	7.5
270	10.630			**SL70-CRDCR/L-50-12**	70	50	1.998	180.0	7.087	71.0	2.795	18.0	.709	RCGX 12 07 00	7.5
320	12.598			**SL70-CRDCR/L-75-12**	70	75	2.982	180.0	7.087	96.0	3.780	18.0	.709	RCGX 12 07 00	7.5

[1] Insert tightening torque, Nm. Use torque wrench, see page I105.

R = Right hand, L = Left hand

Main spare parts

Insert size		1.	2.	3.	4.	5.	6.	7.
○	*iC*	Clamp	Clamp screw	Key	Seat	Seat screw	Key	Guide bush
09	3/8	5412 100-01	3212 035-452	5680 043-16 (27IP)	5321 067-01	3212 106-352	5680 043-12 (10IP)	5552 058-04
12	1/2	5412 100-02	3212 106-504	5680 043-16 (27IP)	5321 067-02	3212 105-453	5680 043-15 (25IP)	5552 058-04


C11


I56


I122

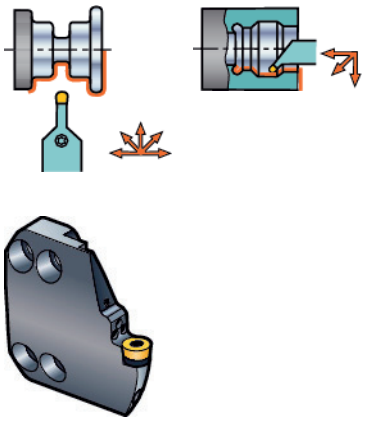

A2


J2

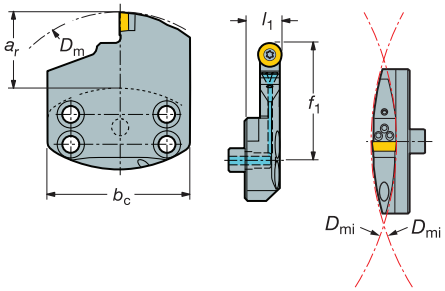
Cutting heads with CoroTurn® SL70 coupling

CoroTurn® 107 screw clamp design

With high pressure coolant



SL70-SRDCR/L...HP



Right hand style shown when nothing else is stated

Metric version

First cut diameter, inch			Coupling size	Dimensions					
D_{mi}		**Ordering code**	b_c	a_r	D_m min	f_1	l_1	Gauge inserts	Nm[1]
250	10	**SL70-SRDCR/L-20-10HP**	70	20	120	41	17	RCMT 10 T3 M0	3.0
250		**SL70-SRDCR/L-35-10HP**	70	35	120	56	17	RCMT 10 T3 M0	3.0
300	12	**SL70-SRDCR/L-35-12HP**	70	35	120	56	18	RCMT 12 04 M0	3.0
300		**SL70-SRDCR/L-50-12HP**	70	50	120	71	18	RCMT 12 04 M0	3.0
300		**SL70-SRDCR/L-75-12HP**	70	75	120	96	18	RCMT 12 04 M0	3.0

Inch version

First cut diameter, inch			Coupling size	Dimensions, inch					
D_{mi}	*iC*	**Ordering code**	b_c	a_r	D_m min	f_1	l_1	Gauge inserts	ft-lbs[1]
10.236	1/2	**SL70A-SRDCR/L-125-4HP**	70	1.250	4.724	2.205	.669	RCMT 12 04 00	2.2
10.236		**SL70A-SRDCR/L-200-4HP**	70	2.000	4.724	2.795	.709	RCMT 12 04 00	2.2
10.236		**SL70A-SRDCR/L-300-4HP**	70	3.000	4.724	2.205	.709	RCMT 12 04 00	2.2

[1] Insert tightening torque, Nm. Use torque wrench, see page I105.

R = Right hand, L = Left hand

Main spare parts

Insert size		1.	2.	3.	4.	5.	6.	7.	8.
	iC	Insert screw	Key (Torx Plus)	Shim	Shim screw	Torque wrench	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
10	.394	5513 020-10	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 100-06 (15IP)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5)
12	.472	5513 020-01	5680 049-01 (15IP)	5322 110-02	5512 090-01	5680 105-05 (15IP)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5)

Insert size		1.	3.	5.	6.	7.	8.
	iC	Insert screw	Shim	Torque wrench	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
12.7	1/2	5513 020-01	5322 120-02	5680 049-01	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)

Optional nozzles (to be ordered separately)

Ordering code	Hole diameter, mm
5691 026-01	0.6
5691 026-02	0.8
5691 026-04	1.2
5691 026-05	1.4


C11

I56

I122

A2

J2

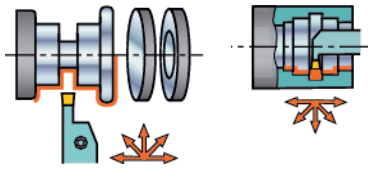
SANDVIK Coromant

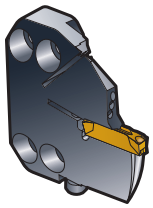
Cutting heads with CoroTurn® SL70 coupling

Blade for grooving, profiling and turning

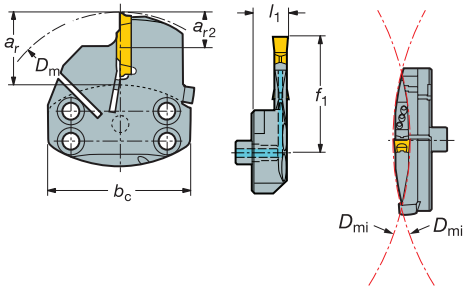
CoroCut® 1-2, screw clamp design

With high pressure coolant





SL70-R/L123



Right hand style shown

First cut diameter, millimeter, inch (mm, in.)								Coupling size	Dimensions, millimeter, inch (mm, in.)					
D_{mi} mm	D_{mi} in.	D_m min mm	D_m min in.	a_r max mm	a_r max in.	a_{r2}[1] mm	a_{r2}[1] in.	Seat size[2]	**Ordering code**	b_c	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[3]
800	31.496	100	3.937	15	.591			G	**SL70-R/L123G15A-HP**	70	48	1.890	15.5	.610	N123G2-0300- GM	2.0
800	31.496	100	3.937	30	1.181			H	**SL70-R/L123H30A-HP**	70	56	2.205	16	.630	N123H2-0400- GM	5.0
320	12.598	120	4.724	15	.591			K	**SL70-R/L123K15A-HP**	70	36	1.417	18	.709	N123K2-0600-GM	2.0
320	12.598	120	4.724	30	1.181				**SL70-R/L123K30A-HP-M**	70	55	2.165	17	.669	N123K2-0600-GM	6.0
320	12.598	120	4.724	45	1.772				**SL70-R/L123K45A-HP**	70	71	2.795	18	.709	N123K2-0600-GM	6.0
270	10.630	90	3.543	35	1.378			L	**SL70-R/L123L35A-HP-M**	70	61	2.402	18	.709	N123L2-0800- GM	6.5
340	13.386	105	4.134	50	1.968				**SL70-R/L123L50A-HP**	70	81	3.189	18	.709	N123L2-0800- GM	6.5
450	17.716	100	3.937	50	1.968	25	.984	M	**SL70-R/L123M50A-HP**	70	71	2.795	17.5	.689	N123M1-1100-GM	5.0
500	19.685	125	4.921	65	2.560			R	**SL70-R/L123R65A-HP**	70	71	2.795	16.5	.650	N123R1-1500-GR	6.5

1) To correspond with seat size on insert.

2) Insert tightening torque, Nm. Use torque wrench, see page I105.

3) a_{r2} = max face grooving depth

Main spare parts

Ordering code	Screw	Key	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
SL70-R/L123G15A-HP	3212 010-312	3021 010-040 (4.0)	5691 026-23 (1.0)	5552 058-04	3021 012-013 (1.3 mm)
SL70-R/L123H30A-HP	3212 010-312	3021 010-040 (4.0)	5691 026-23 (1.0)	5552 058-04	3021 012-013 (1.3 mm)
SL70-R/L123K15A-HP	3214 010-306	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123K30A-HP	3212 010-314	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123K45A-HP	3212 010-313	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123L35A-HP	3212 010-314	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123L50A-HP	3212 010-313	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123M50A-HP	3212 010-314	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123R65A-HP	3212 010-365	3021 010-050 (5.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)

Optional nozzles (to be ordered separately)

Ordering code	Hole diameter, mm
5691 026-11	0.6
5691 026-12	0.8
5691 026-14	1.2
5691 026-15	1.4

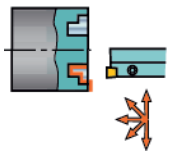
 C11
 I56
 I123
 C2
 J2

Cutting heads with CoroTurn® SL70 coupling

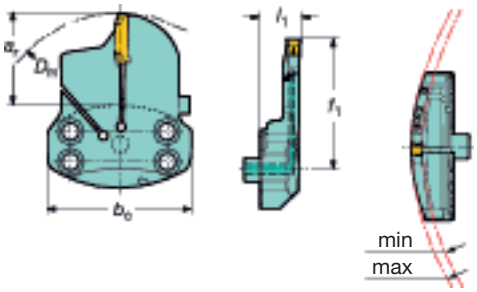
Blade for face grooving

CoroCut® 1-2, screw clamp design

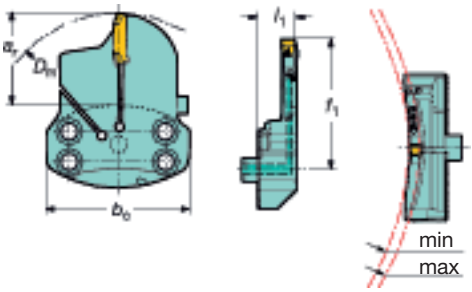
With high pressure coolant



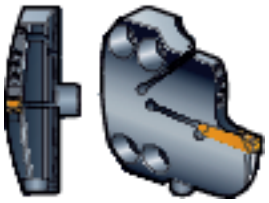
SL70-R/L123...A-HP
A curve



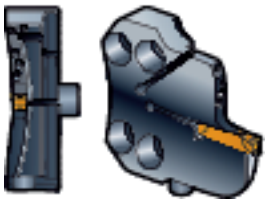
SL70-R/L123...B-HP
B curve



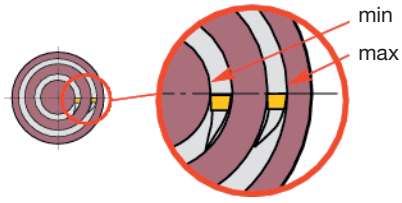
A curve



B curve



First cut diameter



Right hand style shown

A curve

First cut diameter, millimeter, inch (mm, in.)							**A curve**		Dimensions, millimeter, inch (mm, in.)					
min mm	min in.	max mm	max in.	a_p max mm	a_p max in.	Seat size[1]	**Ordering code**	b_c[3]	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[2]
290	11.417	500	19.685	40	1.575	H	**SL70-R/L123H40B290A-HP**	70	66	2.598	17	.669	N123H2-0400- TF	5.6
290	11.417	500	19.685	40	1.575	J	**SL70-R/L123J40B290A-HP**	70	66	2.598	17.5	.689	N123J2-0500- TF	5.6
168	6.614	300	11.811	40	1.575	K	**SL70-R/L123K40B168A-HP**	70	66	2.598	20	.709	N123K2-0600- TF	5.6
288	11.339	500	19.685	40	1.575		**SL70-R/L123K40B288A-HP**	70	66	2.598	18	.709	N123K2-0600- TF	5.5

B curve

First cut diameter, millimeter, inch (mm, in.)							**B curve**		Dimensions, millimeter, inch (mm, in.)					
min mm	min in.	max mm	max in.	a_p max mm	a_p max in.	Seat size[1]	**Ordering code**	b_c[3]	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[2]
80	3.150	130	5.118	15	.591	H	**SL70-R/L123H15B080B-HP**	70	53	2.087	15	.591	N123H2-0400- TF	4.0
120	4.724	200	7.874	15	.591		**SL70-R/L123H15B120B-HP**	70	53	2.087	15	.591	N123H2-0400- TF	4.0
190	7.480	300	11.811	15	.591		**SL70-R/L123H15B190B-HP**	70	53	2.087	15	.591	N123H2-0400- TF	4.0
290	11.417	500	19.685	40	1.575		**SL70-R/L123H40B290B-HP**	70	66	2.598	17	.669	N123H2-0400- TF	5.6
290	11.417	500	19.685	40	1.575	J	**SL70-R/L123J40B290B-HP**	70	66	2.598	17.5	.689	N123J2-0500- TF	5.6
168	6.614	300	11.811	40	1.575	K	**SL70-R/L123K40B168B-HP**	70	66	2.598	20	.709	N123K2-0600- TF	5.6
288	11.339	500	19.685	40	1.575		**SL70-R/L123K40B288B-HP**	70	66	2.598	18	.709	N123K2-0600- TF	5.5

1) To correspond with seat size on insert.
2) Insert tightening torque, Nm. Use torque wrench, see page I105.
3) Coupling size, mm

R = Right hand, L = Left hand

Main spare parts

Seat size	Screw	Key	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
H	3212 010-312	3021 010-040(4.0)	5691 026-23 (1.0)	5552 058-04	3021 012-013 (1.3 mm)
J, K	3212 010-313	3021 010-040(4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)

Optional

Ordering code	Hole diameter, mm
5691 026-11	0.6
5691 026-12	0.8
5691 026-14	1.2
5691 026-15	1.4


C11


I56


I123


A2

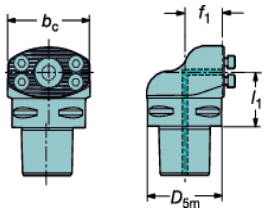

J2

SANDVIK Coromant

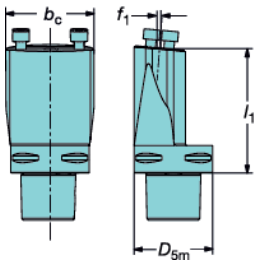
CoroTurn® SL70

Coromant Capto® adapter

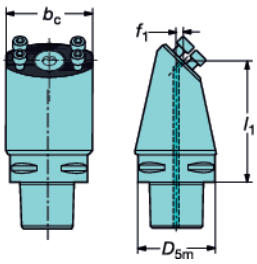
Shank style 0°
SL70-LF



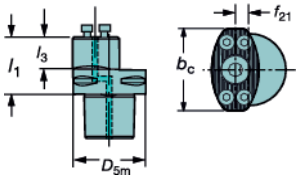
Shank style 5°
SL70-RX



Shank style 45°
SL70-RX



Shank style 90°
SL70-RG



Right hand style shown when nothing else is stated

	Ordering code	Shank style	Coupling size b_c	D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	f_{21} mm	f_{21} in.	l_1 mm	l_1 in.	l_3 mm	l_3 in.	KG
	C5-SL70-R/LF-043	0°	70	50	1.968	33	1.299			43	1.693			1.3
	C6-SL70-R/LF-043		70	63	2.480	33	1.299			43	1.693			1.7
	C8-SL70-R/LF-051		70	80	3.150	41.5	1.634			51	2.008			3.1
	C6-SL70-RX-005-100	5°	70	63	2.480					100	3.937			2.0
	C5-SL70-R/LX-045-050	45°	70	50	1.968	5	.197			50	1.968			1.0
	C6-SL70-R/LX-045-050		70	63	2.480	5	.197			50	1.968			1.4
	C8-SL70-R/LX-045-090		70	80	3.150	5	.197			90	3.543			3.2
	C5-SL70-R/LG-050	90°	70	50	1.968			11.5	.453	50	1.968	30.5	1.201	1.0
	C6-SL70-R/LG-050		70	63	2.480			11.5	.453	50	1.968	28.5	1.122	1.2
	C8-SL70-R/LG-090		70	80	3.150			35	1.378	90	3.543	61	2.402	3.0

Main spare parts

Ordering code	Screw	Key (mm)	O-ring
C5-SL70-R/LF-043	3212 010-409	3021 010-060 (6.0)	3671 010-119
C5-SL70-R/LG-050	3212 010-409	3021 010-060 (6.0)	3671 010-119
C5-SL70-R/LX-045-050	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-R/LF-043	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-RX-005-100	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-R/LX-045-050	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-RX-045-100	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-R/LG-050	3212 010-409	3021 010-060 (6.0)	3671 010-119
C8-SL70-R/LF-051	3212 010-409	3021 010-060 (6.0)	3671 010-119
C8-SL70-R/LG-090	3212 010-409	3021 010-060 (6.0)	3671 010-119
C8-SL70-R/LX-045-090	3212 010-409	3021 010-060 (6.0)	3671 010-119

 I56

 A2

 J2

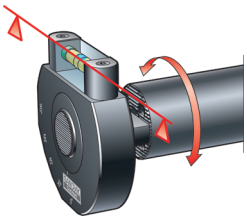
Center height setting tool

A new setting tool can be used to set the correct center height of the cutting edge for cylindrical CoroTurn® SL boring bars.

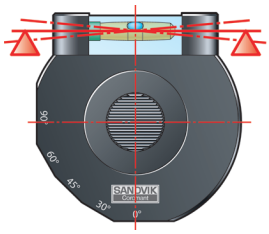
Procedure for correct usage:

- Attach setting tool to serrated edge of cylindrical boring bar
- Twist the boring bar to the right position
- When the bubble is in the center position, the bar is parallel and ready to use.

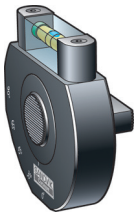
The easy-to-use setting tool offers a quick and simple method to achieve the correct setting of large boring bars over 25 mm (.984 inch) diameter. This setting tool can also be used for bars in multi-task machines.

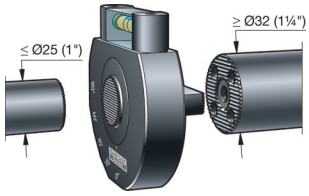


Attach to bar using serrated edge.

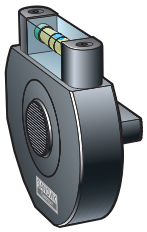


Twist bar to achieve the correct center height.





When the bubble is in the correct position, the bar is parallel.



Ordering code
SL-CHS-01

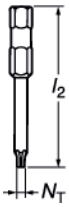
Torque wrenches for correct insert clamping

Information

To get the best performance out of our tools, especially in parting and grooving, it is of great importance to have the correct insert tightening torque.
In the Sandvik Coromant assortment, four metric and four inch torque wrenches, using bits for different Torx Plus sizes, are available.

Sizes -01, -02, -03, -04

Sizes -05, -06, -07, -08



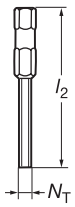
Torque wrench	Torque range Nm	In-lbs	Handle
5680 105-01	0.3 - 1.2		Straight
5680 105-02	1.2 - 3.0		Straight
5680 105-05	3.0 - 6.0		Angled
5680 105-06	4.0 - 8.8		Angled
5680 105-03		2.5 - 11.5	Straight
5680 105-04		11.0 - 26.0	Straight
5680 105-07		26.0 - 55.0	Angled
5680 105-08		35.4 - 78.0	Angled

Torx Plus bits

Bit	l_2 mm	inch	N_T Torx Plus
5680 084-01	50	1.969	8IP
5680 084-02	50	1.969	15IP
5680 084-03	89	3.504	15IP
5680 084-04	50	1.969	7IP
5680 084-05	50	1.969	9IP
5680 084-06	50	1.969	10IP
5680 084-07	50	1.969	20IP
5680 084-08	89	3.504	20IP
5680 084-09	89	3.504	25IP
5680 084-10	89	3.504	30IP
5680 084-11	50	1.969	6IP
5680 084-12	80	3.150	27IP

Hexagon bits for CoroTurn SL70 cutting heads

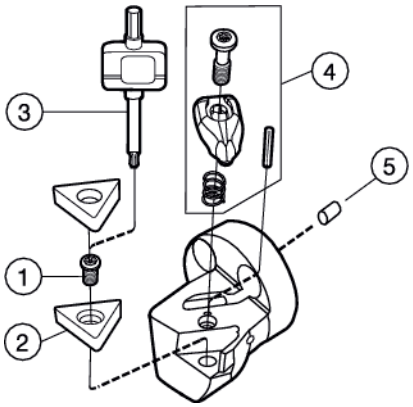
Hexagon bits are now available to set the correct insert tightening torque for CoroTurn SL70 heads.
All bits are available in one box, which includes all of the required sizes.
One metric and one inch box is available.



Hexagon bits

Bit	l_2 mm	Inch	Metric box N_T mm	Inch box N_T Inch
5680 110-01	50	1.969	1.5, 2.0, 2.5, 3.0, 4.0, 5.0, 6.0	
5680 111-01	50	1.969		1/16”, 5/64”, 3/32”, 7/64”, 1/8”, 9/64”, 5/32”, 3/16”, 7/32”, 1/4”

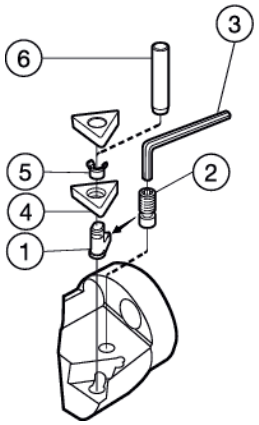
CoroTurn® RC rigid clamp design



Cutting heads	1 Shim screw	2 Shim (For insert thickness)	3 Key (Torx Plus/mm)	4 Complete clamp set	5 Locating tube
					
570-DCLNR/L-32-09	5513 020-04	5322 236-04	5680 051-03 (9IP)	5412 028-011[1]	5638 031-01
570-DCLNR/L-32-12-L 570-DCLNR/L-40-12-L	5513 020-02	5322 236-03	5680 049-01 (15IP)	5412 028-021[1] 5412 034-021[2] 5412 032-021[3]	5638 031-01
570-DCLNR/L-40-16-L	5513 020-07	5322 234-03	5680 043-14 (20IP)	5412 028-031	5638 031-01
570-DCLNR/L-40-19-L	5513 020-07	5322 236-01	5680 043-14 (20IP)	5412 028-041	5638 031-01
					
570-DDUNR/L-32-11 570-DDUNR/L-32-11X	5513 020-04	5322 267-01	5680 051-03 (9IP)	5412 028-011[1]	5638 031-01
570-DDUNR/L-40-15 570-DDUNR/L-40-15X 570-DDUNR/L-40-15X	5513 020-02	5322 266-02 (.250) 5322 266-01 (.187)[4]	5680 049-01 (15IP)	5412 028-021[1] 5412 034-021[2] 5412 032-021[3]	5638 031-01
570-DDXNR/L-32-11	5513 020-04	5322 267-01	5680 051-03 (9IP)	5412 028-011[1]	5638 031-01
570-DDXNR/L-40-15-L	5513 020-02	5322 266-02 (.250) 5322 266-01 (.187)[4]	5680 049-01 (15IP)	5412 028-021[1] 5412 034-021[2] 5412 032-021[3]	5638 031-01
					
570-DTFNR/L-32-16-L 570-DTFNR/L-40-16-L	5513 020-04	5322 316-01	5680 051-03 (9IP)	5412 028-011[1]	5638 031-01
					
570-DWLNR/L-32-06	5513 020-04	5322 328-01	5680 051-03 (9IP)	5412 028-011[1]	5638 031-01
570-DWLNR/L-32-08-LE 570-DWLNR/L-40-08-L	5513 020-02	5322 331-12	5680 049-01 (15IP)	5412 028-021[1] 5412 034-021[2] 5412 032-021[3]	5638 031-01

1) For clamp set parts, see page A359.
2) Clamp sets for ceramic inserts without hole.
3) Clamp sets for ceramic inserts with hole.
4) Optional part delivered to separate order.

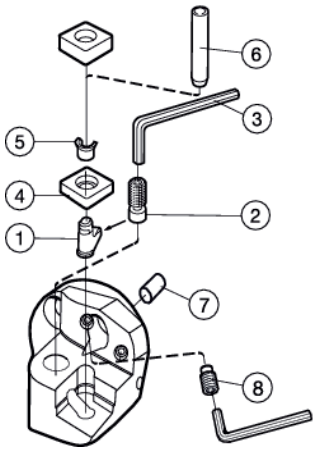
T-Max P lever design



Cutting heads	1 Lever	2 Screw	3 Key (mm)	4 Shim	For insert thickness (radius)	5 Shim pin	6 Shim pin punch
80°							
R/L 571.31C-323222-12	174.3-848M	174.3-858	174.1-864 (3.0)	171.31-850M	.188 (.016-.063)	174.3-861	174.3-871
R/L 571.31C-403227-12	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M	.188 (.016-.063)	174.3-861	174.3-871
R/L 571.31C-504035-16	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852	.250 (.016-.094)	174.3-864	174.3-873
R/L 571.31C-604043-16							
55°							
R/L 571.35C-403227-15	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	.250 (.016-.031)	174.3-861	174.3-871
				171.35-850M[1)]	.250 (.047-.063)		
R/L 571.35C-504035-15				171.35-856[1)]	.188 (.016-.031)		
R/L 571.35C-604043-15				171.35-855[1)]	.188 (.047-.063)		

1) Delivery to separate order

CoroTurn® HP lever design

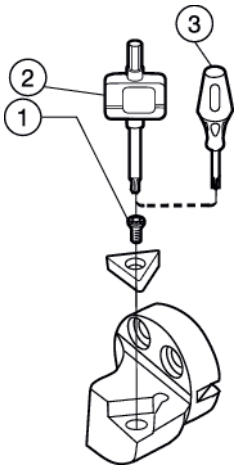


	1 Lever	2 Screw	3 Key (mm)	4 Shim	5 Shim pin	6 Shim pin punch	7 Location tube	8 Nozzle (hole diameter, mm)
SL-PCLNR-25-09HP-G	174.3-845-1	174.3-829	170.3-864 (1.98)	-	-	-	5552 058-02	5691 026-13 (1.0)
SL-PCLNR/L-32-12HP	174.3-848	174.3-858M	174.1-864 (3.0)	171.31-850M	174.3-861	174.3-871	5638 031-01	5691 026-03 (1.0)
SL-PCLNR/L-40-12HP	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M	174.3-861	174.3-871	5638 031-01	5691 026-03 (1.0)
SL-PCLNR/L-40-16HP	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852	174.3-864	174.3-873	5638 031-01	5691 026-03 (1.0)
SL-PDUNR/L-25-11HP-G	5432 015-021	438.3-830	174.1-870 (1.98)	-	-	-	5552 058-02	5691 026-13 (1.0)
SL-PDUNR/L-32-11HP	5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01	174.3-860	174.3-870	5638 031-01	5691 026-03 (1.0)
SL-PDUNR/L-40-15HP	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M	174.3-861	174.3-871	5638 031-01	5691 026-03 (1.0)
SL-PTFNR/L-32-16HP	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M	174.3-860	174.3-870	5638 031-01	5691 026-03 (1.0)
SL-PTFNR/L-40-16HP	174.3-840M	174.3-820M	170.3-860 (2.5)	179.3-850M	174.3-860	174.3-870	5638 031-01	5691 026-03 (1.0)

Optional nozzles (to be ordered separately)

Ordering code	Hole diameter, mm
5691 026-01	0.6
5691 026-02	0.8
5691 026-04	1.2
5691 026-05	1.4

CoroTurn® 111/107 screw clamp design

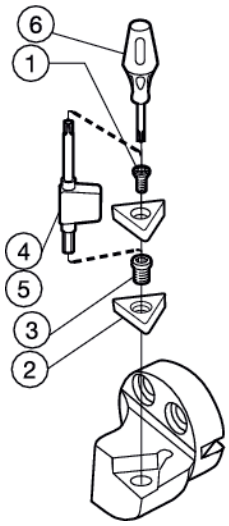


Cutting heads	1 Insert screw (thread)	2 Key (Torx Plus)	3[1)] Screwdriver (Torx Plus)
 570-SCLPR/L-16-06	5513 020-46 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
 570-SDUPR/L-16-07 570-SDUPR/L-20-07	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
570-SDUPR/L-25-11	5513 020-09 (M3.5)	5680 049-01 (15IP)	
570-SDXPR/L-16-07-E 570-SDXPR/L-20-07-E 570-SDXPR/L-25-07-E	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
570-SDXPR/L-16-07-EX 570-SDXPR/L-20-07-EX 570-SDXPR/L-25-07-EX	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
 570-STFPR/L-16-11 570-STFPR/L-20-11 570-STFPR/L-25-11	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
CoroTurn® 107  570-SVQCR/L-20-11-E 570-SVQCR/L-25-11-D	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
570-SVUCR/L-20-11-E 570-SVUCR/L-25-11-D	5513 020-03 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)
CoroTurn® 111  570-SWLPR/L-16-04	5513 020-46 (M2.5)	5680 051-02 (7IP)	5680 046-03 (7IP)

Magnetic sleeve, see page A371.

1) Optional part delivered to separate order.

CoroTurn® 107 screw clamp design

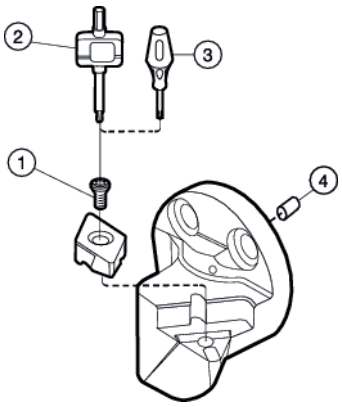


Cutting heads	1 Insert screw (thread)	2 Shim	For insert thickness (radius)	3 Shim screw (thread)	4/5 Key (Torx Plus/mm)	6[2] Screwdriver (Torx Plus)
80°						
570-SCLCR/L-16-06	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
570-SCLCR/L-20-09	5513 020-09 (M3.5)	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-SCLCR/L-25-09	5513 020-10 (M3.5)	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
55°						
570-SDUCR/L-16-07 570-SDUCR/L-16-07EX 570-SDUCR/L-20-07EX 570-SDUCR/L-25-07DX 570-SDXCR/L-16-07-E 570-SDXCR/L-20-07-E 570-SDXCR/L-25-07-E	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
570-SDUCR/L-20-11	5513 020-09 (M3.5)	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-SDUCR/L-25-11	5513 020-10 (M3.5)	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-SDUCR/L-32-11 570-SDUCR/L-32-11X 570-SDUCR/L-40-11 570-SDUCR/L-40-11X	5513 020-01 (M3.5/)	5322 263-01 5322 263-02[1]	.156 (.016-.031) .156 (.047)	5512 090-01	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-SDXCL-32-11X 570-SDXCL-32-11X	5513 020-01 (M3.5)	5322 263-01 5322 263-02[1]	.156 (.016-.031) .156 (.047)	5512 090-01	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-SDXCL-40-11X 570-SDXCL-40-11X	5513 020-01 (M3.5)	5322 263-01 5322 263-02[1]	.156 (.016-.031) .156 (.047)	5512 090-01	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-STFCR/L-16-09	5513 020-05 (M2.2)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
570-STFCR/L16-11-B1[3] 570-STFCR/L-20-11-B1[3] 570-STFCR/L-25-11-B1[3]	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
570-STFCR/L-32-16	5513 020-01 (M3.5)	5322 320-01	.156 (.016-.047)	5512 090-01	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-STFCR/L-40-16	5513 020-01 (M3.5)	5322 320-01	.156 (.016-.047)	5512 090-01	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
35°						
570-SVLBR/L-25-16-LF	5513 020-10	–	–	–	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570-SVLBR/L-32-16 570-SVLBR/L-40-16 570-SVPBR/L-32-16-L 570-SVPBR/L-40-16-L	5513 020-10	5322 270-01		5512 090-01	5680 049-01 (15IP/3.5)	5680 046-02 (15IP)
570C-SVUBR/L-20-2 570C-SVUBR/L-25-2	5513 020-03 (M2.5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)

1) Optional parts must be ordered separately.
2) Optional part delivered to separate order.
3) B1 = For insert with thickness 2 = 1/8".

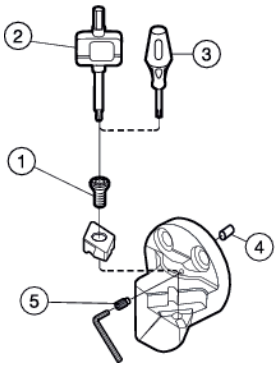
Magnetic sleeve, see page A371.
Note: CoroTurn® 107 cutting heads type SVQPR/L on page I108.

CoroTurn® TR screw clamp design



Cutting heads	1 Insert screw	2 Key (Torx Plus/mm)	3 Torx wrench	4 Locating tube
55°				
TR-SL-DI3UCR/L-25 TR-SL-D13UCR/L-25X TR-SL-D13XCR/L-25	5513 020-01	5680 049-01(15IP)	5680 100-06	5552 058-02
TR-SL-D13UCR/L-32 TR-SL-D13UCR/L-40 TR-SL-D13UCR/L-32X TR-SL-D13UCR/L-40X TR-SL-D13XCR/L-32 TR-SL-D13XCR/L-40	5513 020-01	5686 049-01(15IP)	5680 100-06	5638 031-01
35°				
TR-SL-V13PBR/L-25 TR-SL-V13LBR/L-25	5513 020-64	5680 049-04(10IP)	5680 100-05	5552 058-02
TR-SL-V13PBR/L-32 TR-SL-V13PBR/L-40 TR-SL-V13LBR/L-32 TR-SL-V13LBR/L-40	5513 020-64	5680 049-04(10IP)	5680 100-05	5638 031-01

CoroTurn® TR screw clamp design with high pressure coolant



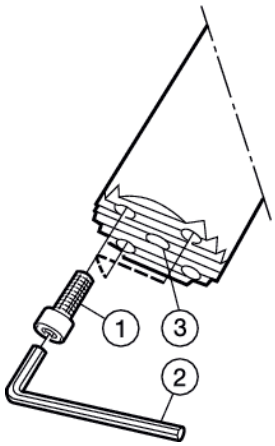
Optional nozzles (to be ordered separately)

Ordering code	Hole diameter, mm
5691 026-01	0.6
5691 026-02	0.8
5691 026-04	1.2
5691 026-05	1.4

Internal	1 Insert screw	2 Key (Torx Plus)	3 Torx wrench	4 Location tube	5 Nozzle (hole diameter, mm)
55°					
TR-SL-D13UCR/L-32HP TR-SL D13UCR/L-40HP	5513 020-01	5680 049-01 (15IP)	5680 100-06	5638 031-01	5691 026-03 (1.0)
TR-SL-V13LBR/L-32HP TR-SL-V13LBR-40HP	5513 020-64	5680 049-04 (10IP)	5680 100-05	5638 031-01	5691 026-03 (1.0)
External					
55°					
TR-SL-D13JCR/L-32HP-X TR-SL-D13JCR/L-40HP-X	5513 020-01	5680 049-01 (15IP)	5680 100-06	5638 031-01	5691 026-03 (1.0)
TR-SL-V13JBR/L-32HP-X	5513 020-64	5680 049-01 (10IP)	5680 100-05	5638 031-01	5691 026-03 (1.0)

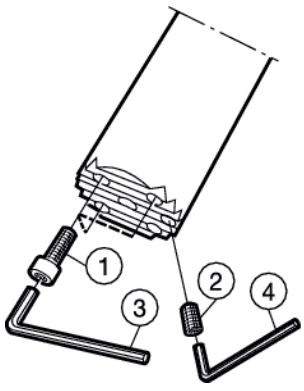
CoroTurn® SL

CoroTurn® SL boring bars, inch style



	1	2	3
Shank holders	Screw	Key (Size)	O-ring
A570-2C D10 04-16	3212 030-301	265.2-818 (3/32)	–
A570-2C D12 05-20	3212 030-351	3021 011-764 (7/64)	–
A570-2C D16 07-25	3212 030-402	3021 011-964 (9/64)	–
A570-2C D20 09-32	3212 030-452	3021 011-532 (5/32)	3671 010-113
A570-2C D24 11-40	3212 030-502	3021 011-316 (3/16)	3671 010-113
A570-2C D32 14-50	3212 030-553	3021 011-140 (1/4)	3671 010-115
A570-2C D32 15-40	3212 030-502	3021 011-316 (3/16)	3671 010-113
A570-2C D40 18-60	3212 030-553	3021 011-140 (1/4)	3671 010-119
A570-2C D40 19-40	3212 030-502	3021 011-316 (3/16)	3671 010-113
A570-3C D10 06-16 A570-3C D10 08-16 CR	3212 030-301	265.2-818 (3/32)	–
A570-3C D12 08-20 A570-3C D12 10-20 CR	3212 030-351	3021 011-764 (7/64)	–
A570-3C D16 10-25 A570-3C D16 13-25	3212 030-402	3021 011-964 (9/64)	–
A570-3C D20 12-32 A570-3C D20 16-32 A570-3C D24 15-32 A570-3C D24 20-32	3212 030-452	3021 011-532 (5/32)	3671 010-113
A570-3C D28 17-40 A570-3C D28 23-40	3212 030-553	3021 011-140 (1/4)	3671 010-115
A570-3C D32 20-50 A570-3C D32 26-50	3212 030-553	3021 011-140 (1/4)	3671 010-115
A570-3C D32 21-40 A570-3C D32 27-40	3212 030-502	3021 011-316 (3/16)	3671 010-113
A570-3C D40 26-60 A570-3C D40 33-60	3212 030-553	3021 011-140 (1/4)	3671 010-119
A570-3C D40 26-40 A570-3C D40 34-40	3212 030-502	3021 011-316 (3/16)	3671 010-113

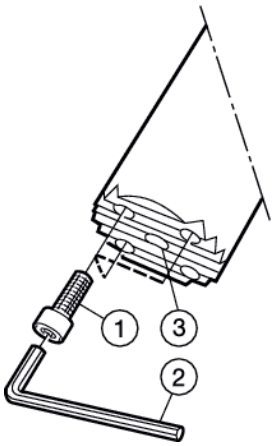
Type A570CC, 570-2C carbide reinforced bars



	1	2	3	4
Shank holders	Screw	Coolant stop	Key (mm)	Key
Inch				
A570CC-D10 09-16	3212 030-301	3214 010-203	265.2-818 (1.5)	3021 012-015 (3/32)
A570CC-D12 09-20	3212 030-301	3214 010-203	265.2-818 (1.5)	3021 012-015 (3/32)
A570CC-D16 11-25	3212 010-258	3214 010-255	5880 010-05 (3.0)	174.1-870 (5/64)
A570-2C D10 07-16CR	3212 030-301	3214 010-203	265.2-818 (2.38)	3021 012-015 (1.5)
A570-2C D12 08-20CR	3212 030-351	3214 010-203	3021 011-764 (2.75)	3021 012-015 (1.5)
A570-2C D16 10-25CR	3212 010-258	3214 010-255	5680 010-05 (3.0)	174.1-870 (1.98)
Metric				
570-2C 16 170 CR	3212 030-301	3214 010-203	265.2-818 (2.38)	3021 012-015 (1.5)
570-2C 20 200 CR	3212 030-351	3214 010-203	3021 011-764 (2.78)	3021 012-015 (1.5)
570-2C 25 250 CR	3212 010-258	3214 010-255	5680 010-05 (3.0)	174.1-870 (1.98)

CoroTurn® SL

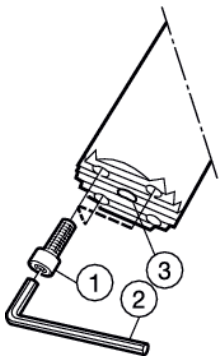
Boring bars and adapters, metric style



		1	2	3
Shank holders	Coromant Capto®	Screw	Key (mm)	O-ring
570-2C 16 105	C3-570-2C 16 045 C4-570-2C 16 048 C5-570-2C16 052 C6-570-2C 16 056	3212 030-301	265.2-818 (2.38)	–
570-2C 20 140	C3-570-2C 20 050 C4-570-2C 20 058 C5-570-2C 20 059 C6-570-2C 20 068	3212 030-351	3021 011-764 (2.78)	–
570-2C 25 200	C3-570-2C 25 064 C4-570-2C 25 064 C5-570-2C 25 067 C6-570-2C 25 082	3212 010-258	174.1-864 (3.0)	–
570-2C 32 218	C3-570-2C 32 053 C4-570-2C 32 074 C5-570-2C 32 075 C6-570-2C 32 081	3212 010-308	3021 010-040(4.0)	3671 010-113
570-2C 40 283 570-2C 50 368-40 570-2C 60 468-40	C4-570-2C 40 073 C5-570-2C 40 094 C5-570-2C 50 098-40R/L C6-570-2C 40 092 C6-570-2C 50 124-40R/L C8-570-2C 40 105 C6-570-2C 60 148-40R/L C8-570-2C 50 125-40R/L C8-570-2C 60 150-40R/L	3212 010-358	3021 010-050 (5.0)	3671 010-113
570-2C 50 360	C5-570-2C 50 090 C6-570-2C 50 114 C8-570-2C 50 115	3212 010-409	3021 010-060 (6.0)	3671 010-115
570-2C 60 460	C6-570-2C 60 137 C8-570-2C 60 140	3212 010-409	3021 010-060 (6.0)	3671 010-119
570-3C 16 156 570-3C 16 204 CR	C3-570-3C 16 082 C4-570-3C 16 088 C5-570-3C 16 085 C6-570-3C 16 088	3212 030-301	265.2-818 (2.38)	–
570-3C 20 200 570-3C 20 260 CR	C3-570-3C 20 101 C4-570-3C 20 107 C5-570-3C 20 109 C6-570-3C 20 108	3212 030-351	3021 011-764 (2.78)	–
570-3C 25 255 570-3C 25 330 570-3C 25 380 CR 570-3C 25 430 CR	C3-570-3C 25 125 C4-570-3C 25 132 C5-570-3C 25 133 C5-570-3C 25 230 C6-570-3C 25 132 C6-570-3C 25 230 C8-570-3C 25 147	3212 010-258	174.1-864 (3.0)	3671 010-113
570-3C 32 320 570-3C 32 416 570-3C 32 480 CR 570-3C 32 544 CR	C3-570-3C 32 133 C4-570-3C 32 154 C5-570-3C 32 154 C5-570-3C 32 288 C6-570-3C 32 159 C6-570-3C 32 288 C8-570-3C32 172	3212 010-308	3021 010-040 (4.0)	3671 010-113
570-3C 40 408 570-3C 40 528 570-3C 50 518-40 570-3C 60 628-40 570-3C 50 668-40 570-3C 60 808-40 570-3C 40 608 CR 570-3C 40 688 CR 570-3C 50 760-40 CR 570-3C 50 861-40 CR 570-3C 60 920-40 CR 570-3C 60 1040-40 CR	C4-570-3C 40 173 C5-570-3C 40 194 C5-570-3C 40 368 C5-570-3C50 223-40R/L C6-570-3C 40 198 C6-570-3C 40 368 C6-570-3C 50 247-40R/L C6-570-3C 60 295-40R/L C6-570-3C 50 468-40 R/L C6-570-3C 60 568-40 R/L C8-570-3C 40 224 C8-570-3C 50 297-40R C8-570-3C 60 355-40R C8-570-3C 40 368 C8-570-3C 50 468-40 R/L C8-570-3C 60 568-40 R/L	3212 010-358	3021 010-050 (5.0)	3671 010-113
570-3C 50 510 570-3C 50 660	C5-570-3C 50 215 C6-570-3C 50 239	3212 010-409	3021 010-060 (6.0)	3671 010-115
570-3C 60 620 570-3C 60 800	C6-570-3C 60 287	3212 010-409	3021 010-060 (6.0)	3671 010-119

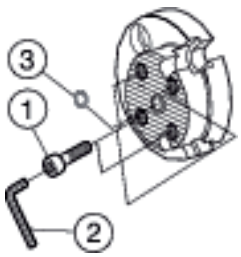
CoroTurn® SL

Short version



Coromant Capto®	1 Screw	2 Key (mm)	3 O-ring
C3-570-2C 16 033R/L	3212 030-301	265.2-818 (2.38)	-
C3-570-2C 20 040R/L	3212 030-351	3021 011-764 (2.78)	-
C3-570-2C 25 044R/L	3212 010-258	174.1-864 (3.0)	-
C3-570-2C 32 037	3212 010-308	3021 010-040 (4.0)	3671 010-113
C4-570-2C 16 041R/L	3212 030-301	265.2-818 (2.38)	-
C4-570-2C 20 047R/L	3212 030-351	3021 011-764 (2.78)	-
C4-570-2C 25 051R/L	3212 020-258	174.1-864 (3.0)	-
C4-570-2C 32 056R/L	3212 010-308	3021 010-040 (4.0)	3671 010-113
C4-570-2C 40 053	3212 010-358	3021 010-050 (5.0)	3671 010-113
C5-570-2C 16 040R	3212 030-301	265.2-818 (2.38)	-
C5-570-2C 20 050R	3212 030-351	3021 011-764 (2.78)	-
C5-570-2C 25 054R/L	3212 010-258	174.1-864 (3.0)	-
C5-570-2C 32 061R/L	3212 010-308	3021 010-040 (4.0)	3671 010-113
C5-570-2C 40 075R/L	3212 010-358	3021 010-050 (5.0)	3671 010-113
C5-570-2C 50 073-40R/L	3212 010-358	3021 010-050 (5.0)	3671 010-113
C6-570-2C 16 045R	3212 030-301	265.2-818 (2.38)	-
C6-570-2C 20 052R	3212 030-351	3021 011-764 (2.78)	-
C6-570-2C 25 056R/L	3212 010-258	174.1-864 (3.0)	-
C6-570-2C 32 066R/L	3212 010-308	3021 010-040 (4.0)	3671 010-113
C6-570-2C 40 080R/L	3212 010-358	3021 010-050 (5.0)	3671 010-113
C6-570-2C 50 097R/L40	3212 010-358	3021 010-050 (5.0)	3671 010-117
C6-570-2C 60 112R/L40	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-570-2C 40 081R/L	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-570-2C 50 102R/L40	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-570-2C 60 119R/L40	3212 010-358	3021 010-050 (5.0)	3671 010-113

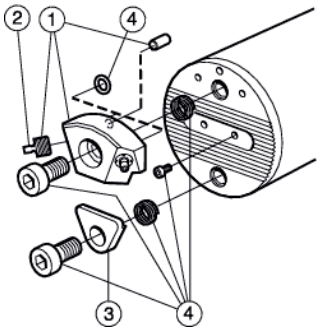
Reduction adapters for bars



Shank holders	1 Screw	2 Key (mm)	3 O-ring
570-40 22-32	3212 010-308	3021 010-040 (4.0)	3671 010-113
570-50 23-32	3212 010-308	3021 010-040 (4.0)	3671 010-113
570-50 23-40	3212 010-358	3021 010-050 (5.0)	3671 010-113
570-60 23-40	3212 010-358	3021 010-050 (5.0)	3671 010-113

CoroTurn® SL quick change

Diameter 80 mm



Boring bar

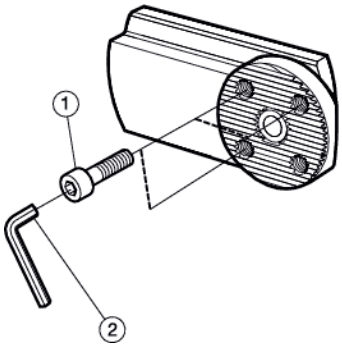
	1	2	3	4
Boring bar	Clamp set[1]	Nozzle	Clamp	Screw set[2]
570-3C 80 880	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 80 1200	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 80 1240 CR	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 80 1400 CR	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 120 1900R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 150 2400R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 200 3200R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 250 4000R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01
570-3C 100 1100	5412 052-021	5691 029-10	5412 053-01	5473 051-01
570-3C 100 1500	5412 052-021	5691 029-10	5412 053-01	5473 051-01
570-3C 100 1560 CR	5412 052-021	5691 029-10	5412 053-01	5473 051-01
570-3C 100 1760 CR	5412 052-021	5691 029-10	5412 053-01	5473 051-01
A570-3C D48 33	5412 052-011	5691 029-10	5412 053-01	5473 051-01
A570-3C D48 45	5412 052-011	5691 029-10	5412 053-01	5473 051-01
A570-3C D64 44	5412 052-011	5691 029-10	5412 053-01	5473 051-01
A570-3C D64 60	5412 052-011	5691 029-10	5412 053-01	5473 051-01
A570-3C D80 75R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01
A570-3C D96 95R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01
A570-3C D128 126R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01
A570-3C D160 157R/L	5412 052-011	5691 029-10	5412 053-01	5473 051-01

580 boring bar adapter

	1	2	3	4
Adapter code	Clamp set[1]	Nozzle	Clamp	Screw set[2]
570-80 17-580-80	5412 052-011	5691 029-10	5412 053-01	5473 051-01

1) Includes clamp 1, nozzle and pin.

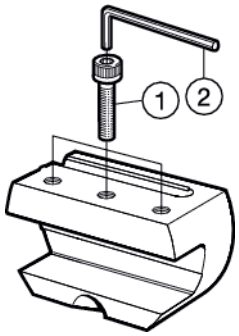
2) Includes screw x 3, key, springs and O-rings.

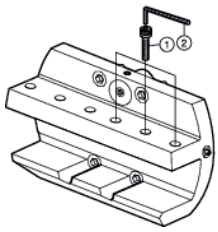


Adapter for CoroTurn SL cutting heads

	1	2
Adapter code	Screw	Key (mm)
570-80 23-40R/L	3212 010-358	3021 010-050 (5.0)
570-80 200R/L	3212 010-358	3021 010-050 (5.0)

CoroTurn® SL quick change





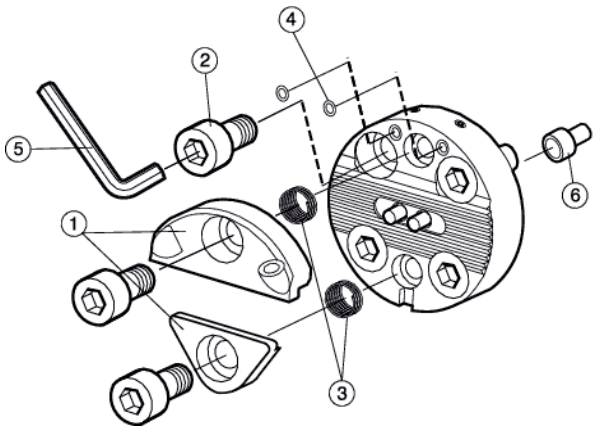
Adapter for square shank tools

	1	2
Adapter code	Screw	Key (mm)
570-80 20 2020R	3214 040-460	3021 010-050 (5.0)

Adapter for square shank tools for bars < 200 mm

	1	2
Adapter code	Screw	Key (mm)
Inch		
A570-3C D4833 A570-3C D4845 A570-3C D6444 A570-3C D6460		
Metric		
570-200 2525	3214 040-460	3021 012-050 (5.0)
570-200 3232	3214 040-460	3021 012-050 (5.0)
570-200 4040	3214 040-462	3021 012-060 (6.0)

Diameter 32 mm

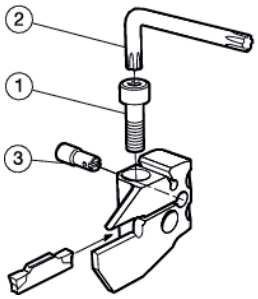


Adapter

	1	2	3	4	5	6
Adapter code	Clamp set	Screw	Compression spring	O-ring	Key	Locating tube
SL-32 11-32-QC	5412 054-011	3212 010-308	5561 006-01	5641 005-83	3021 010-040	5638 031-01
SL-40 12-32-QC	5412 054-013	3212 010-358	5561 006-02	5641 005-83	3021 010-050	5638 031-01

CoroCut® SL

Blade



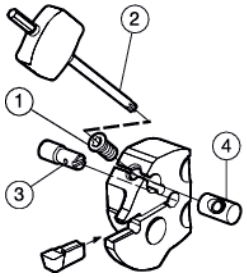
Blade	1 Clamping screw	2 Key (Torx Plus)	3 Coolant tube
570-25R/L123D12B 570-25R/L123E15B	3212 012-259	5680 043-14 (20IP)	5691 041-01
570-32R/L123D12B 570-32R/L123E15B	3212 012-260	5680 043-14 (20IP)	5691 041-01
570-32R/L123F12B040A/B 570-32R/L123F12B054A/B 570-32R/L123F15B068A/B 570-32R/L123F15B090A/B 570-32R/L123F15B130A/B	3212 012-260	5680 043-14 (20IP)	5691 041-01
570-25R/L123F15B	3212 012-259	5680 043-14 (20IP)	5691 041-01
570-32R/L123F15B	3212 012-260	5680 043-14 (20IP)	5691 041-01
570-32R/L123G12B034A/B 570-32R/L123G15B042A/B 570-32R/L123G15B054A/B 570-32R/L123G18B067A/B 570-32R/L123G18B090A/B 570-32R/L123G18B130A/B	3212 012-310	5680 043-15 (25IP)	5691 041-01
570-25R/L123G13C	3212 012-309	5680 043-15 (25IP)	5691 041-01
570-32R/L123G13C	3212 012-310	5680 043-15 (25IP)	5691 041-01
570-40R/L123G13C	3212 012-311	5680 043-15 (25IP)	5691 041-01
570-25R/L123G18B	3212 012-309	5680 043-15 (25IP)	5691 041-01
570-32R/L123G18B	3212 012-310	5680 043-15 (25IP)	5691 041-01
570-40R/L123G18B	3212 012-311	5680 043-15 (25IP)	5691 041-01
570-32R/L123H18B040A/B 570-32R/L123H18B052A/B 570-32R/L123H18B064A/B 570-32R/L123H18B092A/B 570-32R/L123H18B132A/B 570-32R/L123H18B220A/B 570-32R/L123H18B300A/B	3212 012-310	5680 043-15 (25IP)	5691 041-02
570-32R/L123H23B	3212 012-310	5680 043-15 (25IP)	5691 041-02
570-40R/L123H23B	3212 012-311	5680 043-15 (25IP)	5691 041-02
570-32R/L123J18B040A/B 570-32R/L123J18B060A/B 570-32R/L123J18B085A/B 570-32R/L123J18B120A/B 570-32R/L123J18B175A/B 570-32R/L123J18B180A/B	3212 012-310	5680 043-15 (25IP)	5691 041-02
570-32R/L123J18B	3212 012-310	5680 043-15 (25IP)	5691 041-02
570-40R/L123J18B	3212 012-311	5680 043-15 (25IP)	5691 041-02
570-32R/L123J18C	3212 012-310	5680 043-15 (25IP)	5691 041-02
570-40R/L123K17C 570-40R/L123K18B	3212 012-311	5680 043-15 (25IP)	5691 041-01
570-32R/L123K18B040A/B 570-32R/L123K18B058A/B 570-32R/L123K18B088A/B 570-32R/L123K18B168A/B 570-32R/L123K18B220A/B	3212 012-310	5680 043-15 (25IP)	5691 041-02

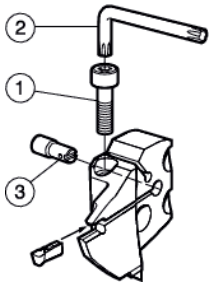
T-Max Q-Cut® SL

151.3

Blade

Screw clamp



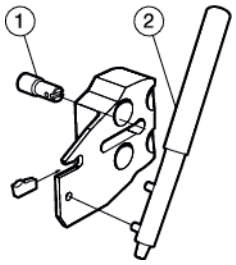


Blade	1 Clamping screw	2 Key (Torx Plus)	3 Clamping nut	4 Coolant tube
570-25R/L151.3-08-20 570-32R/L151.3-08-20	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-01
570-25R/L151.3-08-25 570-32R/L151.3-07-25	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-01
570-32R/L151.3-024A25/B25 570-32R/L151.3-029A25/B25	3212 012-260	5680 043-14 (20IP)	–	5691 041-01
570-25R/L151.3-08-30 570-32R/L151.3-08-30 570-40R/L151.3-06-30	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-03
570-32R/L151.3-027A30/B30 570-32R/L151.3-032A30/B30	3212 012-310	5680 043-15 (25IP)	–	5691 041-03
570-25R/L151.3-08-40 570-32R/L151.3-10-40 570-40R/L151.3-09-40	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-03
570-32R/L151.3-025A40/B40 570-32R/L151.3-030A40/B40	3212 012-310	5680 043-15 (25IP)	–	5691 041-02
570-32R/L151.3-10-50 570-40R/L151.3-09-50	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-03
570-32R/L151.3-023A50/B50 570-32R/L151.3-038A50/B50	3212 012-310	5680 043-15 (25IP)	–	5691 041-02
570-32R/L151.3-13-60 570-40R/L151.3-12-60	5513 017-02	5680 049-02 (15IP)	5534 021-01	5691 041-03

151.2

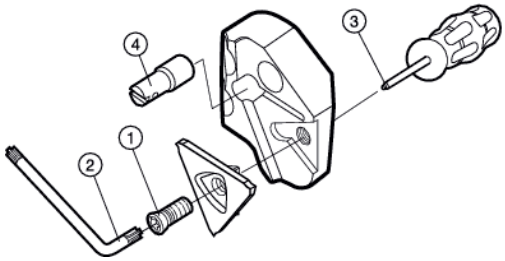
Blade

Spring clamp



Blade	1 Coolant tube	2 Insert key
570-25R/L151.21-20-20	5691 041-01	5680 057-021
570-32R/L151.21-20-20	5691 041-01	5680 057-021
570-25R/L151.21-20-25	5691 041-01	5680 057-021
570-32R/L151.21-20-25	5691 041-01	5680 057-021
570-25R/L151.21-30-30	5691 041-01	5680 057-021
570-32R/L151.21-30-30	5691 041-01	5680 057-021
570-32R/L151.21-32-40	5691 041-03	5680 057-011
570-40R/L151.21-32-40	5691 041-03	5680 057-011
570-32R/L151.21-32-50	5691 041-03	5680 057-011
570-40R/L151.21-32-50	5691 041-03	5680 057-011

CoroCut® 3 SL

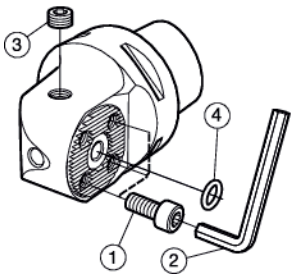


Blade	1 Clamping screw	2 Key (Torx Plus)	3[1)] Screwdriver	4 Coolant tube
570-25L123T06B	5513 020-062	5680 049-02(15IP)	5680 041-06(8IP)	5691 041-01
570-32L123T06B	5513 020-062	5680 049-02(15IP)	5680 041-06(8IP)	5691 041-01
570-40L123T06B	5513 020-062	5680 049-02(15IP)	5680 041-06(8IP)	5691 041-01
570-25R123U06B	5513 020-062	5680 049-02(15IP)	5680 041-06(8IP)	5691 041-01
570-32R123U06B	5513 020-062	5680 049-02(15IP)	5680 041-06(8IP)	5691 041-01
570-40R123U06B	5513 020-062	5680 049-02(15IP)	5680 041-06(8IP)	5691 041-01

[1)] Optional part, to be ordered separately.

CoroTurn® SL

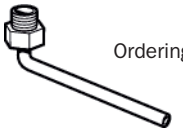
Coromant Capto® adapter



Coromant Capto®	1	2	3		4
	Screw	Key (mm)	Plug	Thread size	O-ring
Cx-570-32-R/LG	3212 010-308	3021 010-040 (4.0)	5643 012-03	6 mm	3671-010-113
Cx-570-40-R/LG	3212 010-358	3021 010-050 (5.0)	5643 012-03	6 mm	3671-010-113
Cx-570-32-NG	3212 010-308	3021 010-040(4.0)	–	6 mm	3671 010-113
Cx-570-40-NG	3212 010-358	3021 010-050 (5.0)	–	6 mm	3671-010-113
Cx-570-25-R/LF	3212 010-258	174.1-864 (3.0)	5643 045-01	M8x1.0	–
Cx-570-32-R/LF	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0	–
Cx-570-40-R/LF	3212 010-358	3021 010-050 (5.0)	5643 045-01	M8x1.0	–
Cx-570-25-R/LX-045	3212 010-258	174.1-864 (3.0)	5643 045-01	M8x1.0	–
Cx-570-32-R/LX-045	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0	–
Cx-570-32-RX-045L1	3212 010-308	3021 010-040 (4.0)	5643 045-01	M8x1.0	–
Cx-570-40-RX-045L1	3212 010-358	3021 010-050 (5.0)	5643 045-01	M8x1.0	–

Accessory

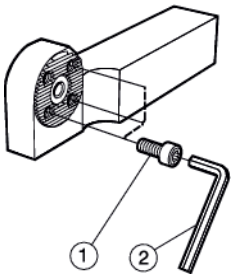
Coolant tube to be ordered separately



Ordering code: 5692 023-01

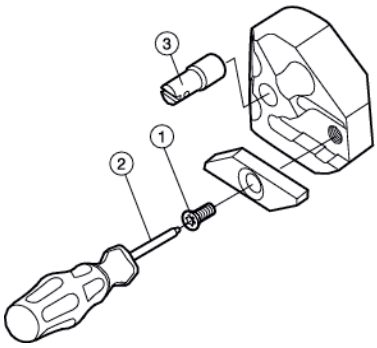
Thread size M8x1.0

Shank adapter



Shank holders		1	2
Metric	Inch	Screw	Key (mm)
570-25-R/LF-2020	570-25-R/LF-12	3212 010-258	174.1-864 (3.0)
570-32-R/LF-2020	570-32-R/LF-12	3212 010-308	3021 010-040 (4.0)
570-25-R/LF-2525	570-25-R/LF-16	3212 010-258	174.1-864 (3.0)
570-32-R/LF-2525	570-32-R/LF-16	3212 010-308	3021 010-040 (4.0)
570-32-R/LF-3232	570-32-R/LF-20	3212 010-308	3021 010-040 (4.0)
570-40-R/LF-3232	570-40-R/LF-20	3212 010-358	3021 010-050 (5.0)
570-32R/LF-2020J	570-32-R/LF-12J	3212 010-308	3021 010-040 (4.0)
570-32R/LF-2525J	570-32-R/LF-16N	3212 010-308	3021 010-040 (4.0)
570-25-NG-2020	570-25-NG-12	3212 010-258	174.1-864 (3.0)
570-32-NG-2020	570-32-NG-12	3212 010-308	3021 010-040 (4.0)
570-25-NG-2525	570-25-NG-16	3212 010-258	174.1-864 (3.0)
570-32-NG-2525	570-32-NG-16	3212 010-308	3021 010-040 (4.0)
570-32-NG-3232	570-32-NG-20	3212 010-308	3021 010-040 (4.0)
570-40-NG-3232	570-40-NG-20	3212 010-358	3021 010-050 (5.0)

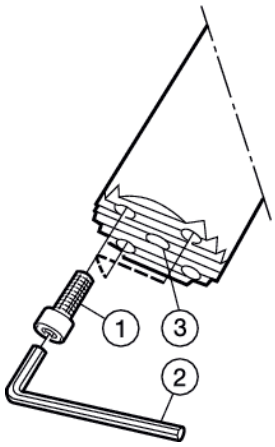
CoroCut® XS SL



		1	2	3
Insert size	Coupling size	Screw	Key (Torx Plus)	Coolant tube
3	25-32	5513 027-01	5680 046-01 (8IP)	5691 041-01

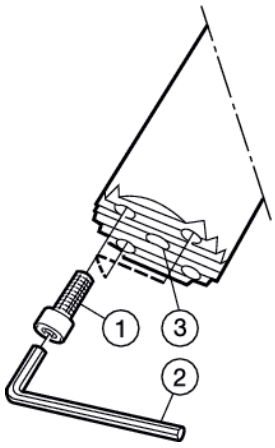
CoroTurn® SL

Coromant Capto® short dampened boring bars



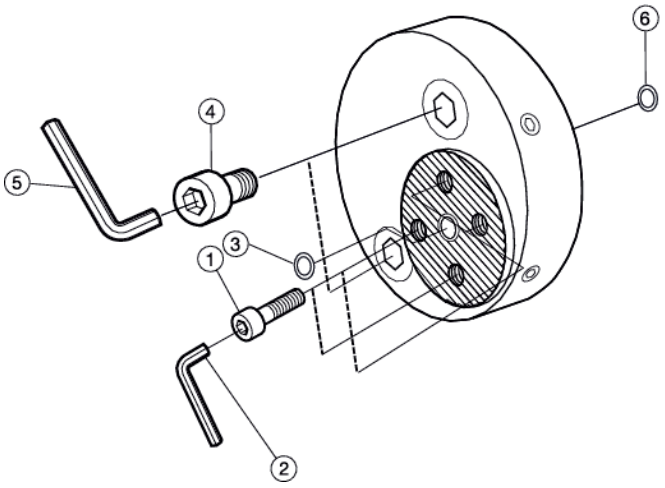
Coromant Capto®	1 Screw	2 Key (mm)	3 O-ring
C4-570-4C 40 120 C5-570-4C 40 120 C5-570-4C 50 150-40R/L C6-570-4C 40 120 C6-570-4C 50 150-40R/L C6-570-4C 60 180-40R/L C8-570-4C 60 180-40 R/L	3212 010-358	3021 010-050 (5.0)	3671 010-113
Boring bars			
Metric			
570-4C 40 330 570-4C 50 430-40 570-4C 60 510-40	3212010-358	3021 010-050 (5.0)	3671 010-113
Inch			
A570-4C D24 13-32	3212 030-452	3021 011-532 (5/32)	3671 010-113
A570-4C D28 15-40	3212 030-502	3021 011-316	3671 010-113
A570-4C D32 17-40 A570-4C D40 22-40		(3/16)	

CoroTurn® SL dampened carbide reinforced boring bars



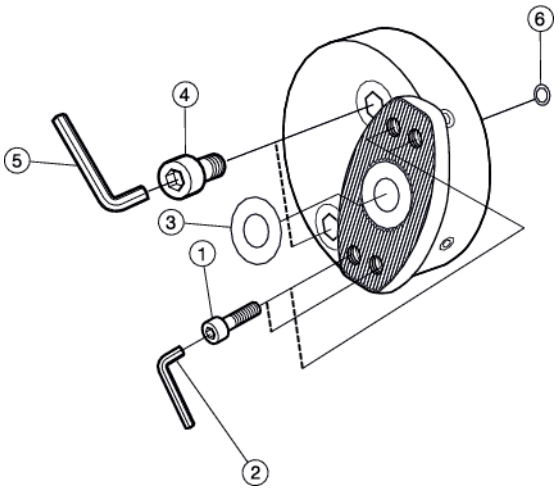
Coromant Capto®	1 Screw	2 Key (mm)	3 O-ring
C6-SL3C25280CR	3212 010-258	174.1-864 (3.0)	-
C6-SL3C32352CR	3212 010-308	3021 010-040 (4.0)	3671 010-113
C6-SL3C40448CR	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-SL3C25280CR	3212 010-258	174.1-864 (3.0)	-
C8-SL3C32352CR	3212 010-308	3021 010-040 (4.0)	3671 010-113
C8-SL3C40448CR	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-SL3C50568CR-40R	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-SL3C50568CR-40L	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-SL3C60688CR-40R	3212 010-358	3021 010-050 (5.0)	3671 010-113
C8-SL3C60688CR-40L	3212 010-358	3021 010-050 (5.0)	3671 010-113

CoroTurn® SL quick change adapter for cutting heads



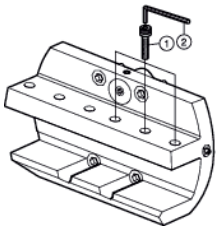
	1	2	3	4	5	6
Adapter code	Screw	Key (mm)	O-ring	Screw	Key (mm)	O-ring
570-80 20 20-40R	3212 010-358	3021 010-050 (5.0)	3671 010-113	3212 010-460	3021 010-080 (8.0)	3671 010-113
570-100 20 30-40R	3212 010-358	3021 010-050 (5.0)	3671 010-113	3212 010-460	3021 010-080 (8.0)	3671 010-113

CoroTurn® SL quick change adapter for SL cutting heads



	1	2	3	4	5	6
Adapter code	Screw	Key (mm)	O-ring	Screw	Key (mm)	O-ring
SL70-80 23-RG	3212 010-409	3021 010-060 (6.0)	3671 010-119	3212 010-460	3021 010-080 (8.0)	3671 010-113
SL70-80 40-RF	3212 010-409	3021 010-060 (6.0)	3671 010-119	3212 010-460	3021 010-080 (8.0)	3671 010-113

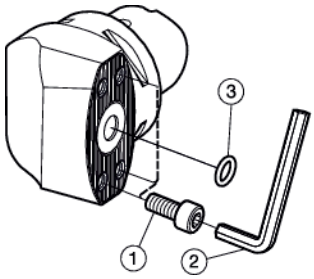
CoroTurn® SL quick change adapter for square shank tools



	1	2
Adapter code	Screw	Key (mm)
570-200 2525-M	3214 040-460	3021 012-050 (5.0)
570-200 3232-M	3214 040-460	3021 012-050 (5.0)
570-200 4040-M	3214 040-462	3021 012-060 (6.0)

CoroTurn® SL70

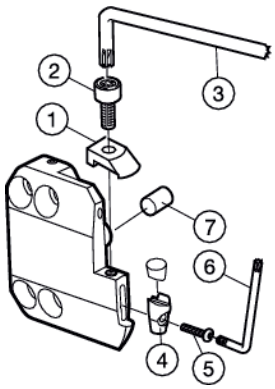
Coromant Capto® adapter



	1	2	3
Ordering code	Screw	Key (mm)	O-ring
C5-SL70-LF-043	3212 010-409	3021 010-060 (6.0)	3671 010-119
C5-SL70-RG-050	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-LF-043	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-RX-005-100	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-RX-045-100	3212 010-409	3021 010-060 (6.0)	3671 010-119
C6-SL70-RG-050	3212 010-409	3021 010-060 (6.0)	3671 010-119
C8-SL70-LF-051	3212 010-409	3021 010-060 (6.0)	3671 010-119
C8-SL70-RG-090	3212 010-409	3021 010-060 (6.0)	3671 010-119

Cutting heads with CoroTurn® SL70 coupling

For round inserts

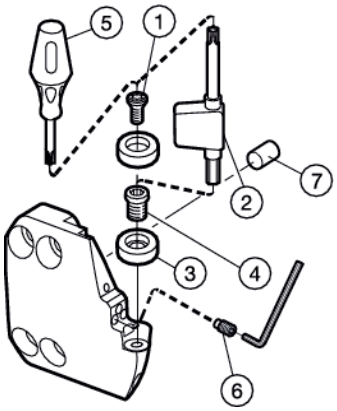


Insert size		1.	2.	3.	4.	5.	6.	7.
⬡	*iC*	Clamp	Clamp screw	Key	Seat	Seat screw	Key	Guide bush
09	3/8	5412 100-01	3212 035-452	5680 043-16 (27IP)	5321 067-01	3212 106-352	5680 043-12 (10IP)	5552 058-04
12	1/2	5412 100-02	3212 106-504	5680 043-16 (27IP)	5321 067-02	3212 105-453	5680 043-15 (25IP)	5552 058-04

Cutting heads with CoroTurn® SL70 coupling

CoroTurn® 107 screw clamp

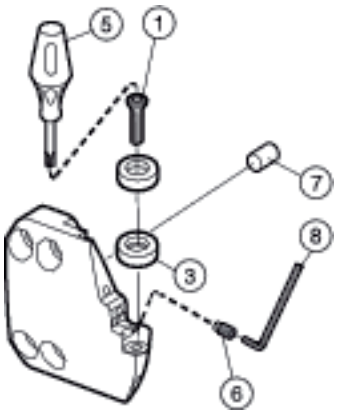
With high pressure coolant



Insert size		1.	2.	3.	4.	5.	6.	7.	8.
○	*iC*	Insert screw	Key (Torx Plus)	Shim	Shim screw	Torque wrench	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
10	.394	5513 020-10	5680 049-01 (15IP)	5322 110-01	5512 090-01	5680 100-06 (15IP)	5691 026-13 (1.0)	5552 058-04	174.1-870 (2mm)
12	.472	5513 020-01	5680 049-01 (15IP)	5322 110-02	5512 090-01	5680 105-05 (15IP)	5691 026-13 (1.0)	5552 058-04	174.1-872 (1.5mm)

Optional nozzles (to be ordered separately)

Ordering code	Hole diameter, mm
5691 026-01	0.6
5691 026-02	0.8
5691 026-04	1.2
5691 026-05	1.4



Insert size		1.	3.	5.	6.	7.	8.
○	*iC*	Insert screw	Shim	Torque wrench	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
12.7	1/2	5513 020-01	5322 120-02	5680 049-01	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)

Optional nozzles (to be ordered separately)

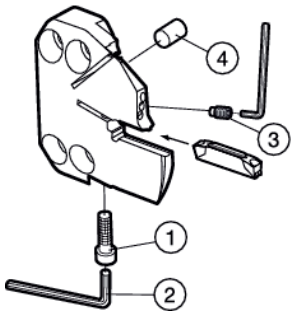
Ordering code	Hole diameter, mm
5691 026-01	0.6
5691 026-02	0.8
5691 026-04	1.2
5691 026-05	1.4

CoroCut® SL70

Blade for grooving, profiling and turning

Screw clamp

With high pressure coolant



	1.	2.	3.	4.	5.
Ordering code	Screw	Key	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
SL70-R/L123G15A-HP	3212 010-312	3021 010-040 (4.0)	5691 026-23 (1.0)	5552 058-04	3021 012-013 (1.3 mm)
SL70-R/L123H30A-HP	3212 010-312	3021 010-040 (4.0)	5691 026-23 (1.0)	5552 058-04	3021 012-013 (1.3 mm)
SL70-R/L123K15A-HP	3214 010-306	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123K30A-HP	3212 010-314	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123K45A-HP	3212 010-313	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123L35A-HP	3212 010-314	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123L50A-HP	3212 010-313	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123M50A-HP	3212 010-314	3021 010-040 (4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)
SL70-R/L123R65A-HP	3212 010-365	3021 010-050 (5.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)

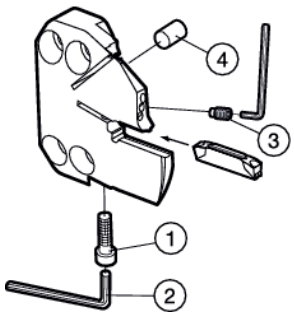
Optional nozzles (to be ordered separately)

Ordering code	Hole diameter, mm
5691 026-11	0.6
5691 026-12	0.8
5691 026-14	1.2
5691 026-15	1.4

Blade for face grooving

Screw clamp

With high pressure coolant

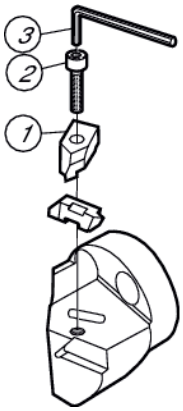


	1.	2.	3.	4.	5.
Seat size	Screw	Key	Nozzle (hole diameter, mm)	Guide bush	Coolant nozzle key
H	3212 010-312	3021 010-040(4.0)	5691 026-23 (1.0)	5552 058-04	3021 012-013 (1.3 mm)
J, K	3212 010-313	3021 010-040(4.0)	5691 026-13 (1.0)	5552 058-04	174.1-862 (1.5 mm)

Optional nozzles (to be ordered separately)

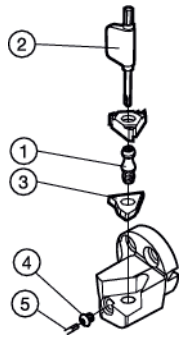
Ordering code	Hole diameter, mm
5691 026-11	0.6
5691 026-12	0.8
5691 026-14	1.2
5691 026-15	1.4

Top-Lok® internal screw clamp tools



Tool type and size	1		2	3
	Clamp		Clamping screw	
Shank holders	Right hand	Left hand	Thread	Key (inch)
570C-TLER/L-20-2 570C-TLER/L-25-2 570C-TLER/L-32-2	C2L	C2R	10440 (6-32)	3021 011-764 (7/64)
570C-TLER/L-32-3 570C-TLER/L-40-3 570C-TLER/L-50-3 570C-TLER/L-60-3	C3L	C3R	10090 (10-32)	3021 010-040 (5/32)
570C-TLER/L-40-4 570C-TLER/L-50-4 570C-TLER/L-60-4	C4L	C4R	10090 (10-32)	3021 010-040 (5/32)
570C-TLER/L-40-6 570C-TLER/L-50-6 570C-TLER/L-60-6	C6L	C6R	10090 (10-32)	3021 010-040 (5/32)

Cutting heads, type SL, for external threading

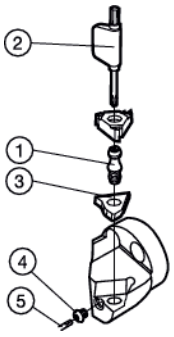


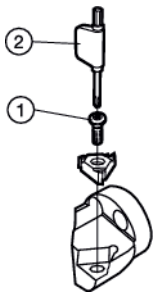
SL cutting heads	1 Insert screw (thread)	2[2)] Key (Torx Plus)	3 Shims[1)] Inclination angle +1°	4 Shim screw	5 Key (Torx Plus)
R/L566.4FGC-202514-16	5513 026-05	5680 049-03 (9IP)	–	–	–
R/L566.4FGC-252517-16	5513 026-01	–	5322 361-11	5512 032-01	5680 049-03 (9IP)
R/L566.4FGC-323222-16	5513 026-01	–	5322 361-11	5512 032-01	5680 049-03 (9IP)
R/L566.4FGC-403227-16	5513 026-01	–	5322 361-11	5512 032-01	5680 049-03 (9IP)

1) For optional shims, see page C45.

2) Optional part delivered to separate order.

T-Max U-Lock®





SL cutting heads	1 Insert screw (thread)	2[2)] Key (Torx Plus)	3 Shims[1)] Inclination angle +1°	4 Shim screw	5 Key (Torx Plus)	6 Key (size, mm)
R/L 566.0KFC-162012-11 R/L 566.0KFC-202014-11	5513 020-03 (M2.5)	5680 051-02 (7IP)	–		–	–
R/L 566.4KFC-252517-16 R/L 566.4KFC-233222-16 R/L 566.4KFC-403227-16 R/L 566.4KFC-504035-16 R/L 566.4KFC-604043-16	5513 026-01 (M4) 5513 020-13[2)]	5680 051-03 (9IP)	5322 361-11	5512 032-01	5680 051-03 (9IP)	–
R/L 566.4KFC-252819-22	5513 026-06 (M5) 5513 020-07[2)]	5680 049-02 (15IP)	–	–	–	–
R/L 566.4KFC-323222-22 R/L 566.4KFC-403227-22 R/L 566.4KFC-504035-22 R/L 566.4KFC-604043-22	5513 026-02 (M5) 5513 020-26[2)]	5680 049-02 (15IP)	5322 365-11	5512 032-02	5680 049-02 (15IP)	–
R 566.4KFC-403227-27 R 566.4KFC-504435-27 R 566.4KFC-604343-27	5513 020-14 (M5)	5680 043-15 (25IP)	5322 383-11	5512 090-08	–	3021 010-060 (6.0)

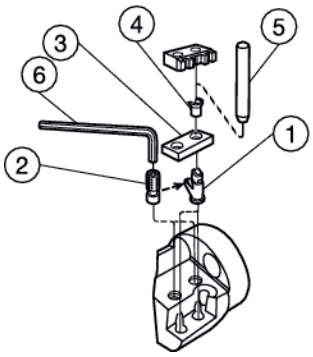
1) For optional shims, see page C45.

2) Optional part delivered to separate order.

Ordering example: 10 pieces 5322 361-11

T-Max Twin-Lock®

SL cutting heads



Cutting head	1 Lever	2 Screw	3 Shim	4 Shim pin	5 Shim pin punch	6 Key (mm)
R566.39KF-404527-24	5432 005-01	174.3-820M	5321 111-01	174.3-860	174.3-870	170.3-860 (2.5)