


# Supplement

– TO TURNING TOOLS AND ROTATING TOOLS CATALOGUES



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## General turning



CoroTurn® Prime

### Tool holder extension

Tool holders for multi-task and vertical lathe machines which will help increase machining possibilities. These new tool holders save time, reduce inventory and improve accessibility.

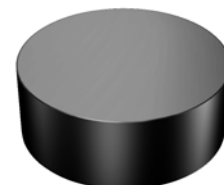


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CC6220 and CC6230

### New high speed ceramics

Two new ceramic high speed machining grades for HRSA material in intermediate stage, especially for demanding powder metallurgical material that are difficult to machine with whisker ceramics and SiAlONs.

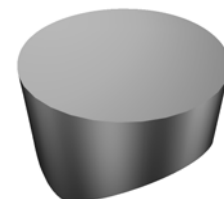


See page 10

CC6160

### Extension of ceramic grade

Complement to existing round inserts program with inserts for machining into corners and wide grooves. High metal removal in challenging applications.



See page 10

## Parting and grooving

CoroCut® QD

### Y-axis parting

A completely new way of parting off. The insert pocket is rotated 90 degrees for a much more beneficial direction of the cutting force. More than six times higher blade stiffness, which allows for significantly higher feed and longer overhang without losing stability.



See page 18

## Turning tool adaptors



Coromant Capto®

### Left-hand offset reduction adaptor

A new left-handed version of the offset reduction adaptor is now available. This adaptor allows access to a larger cutting unit program with the same RAM clearance. Sizes available: C6 and C8.



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CoroTurn® SL

### Aerospace

Adaptors mainly designed for aerospace applications. These new adaptors include:

- Neutral adaptors that offer improved accessibility for multi-task machine magazines
- Five-degree adaptors which reduce the need for engineered cutting heads where clearance is required for trailing edge



See page 21

CoroPlex™

### Twin-tool

CoroPlex™ Twin-tool (TT) holder has two inserts in the holder allowing for the quick changing of boring bars to save production time for multi-task machining.

Benefits:

- Spend less time on tool change outside the machine
- Save space in the tool magazine



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Coromant Capto®

### SL Quick Change

A Coromant Capto® quick change adaptor installed on the Silent Tools bar giving it a quick change interface to be used with CoroTurn® SL cutting heads. Available in sizes: SL-QC 80 and SL-QC 100.



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# Milling

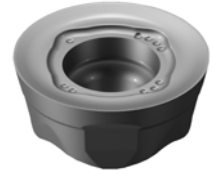


GC1130

## Profile milling

Extension of the insert assortment for CoroMill 200, CoroMill 300 and CoroMill 600. PVD coating produced with Zertivo™, which prolongs tool life and gives greater edge line security. Designed to function well in difficult machining conditions.

See page 27



CoroMill® 325

## Thread whirling

Extension of thread whirling rings to cover a broader range of thread whirling units.

See page 31



CoroMill® Plura

## High Feed Side Milling

Three solid end mill families, optimized for ISO S, High Feed Side Milling (HFS): One solid solution each for titanium and nickel base alloys, and one solution with internal coolant and cooling booster for titanium machining.

See page 33



CoroMill® Plura

## Thread milling

New thread mills for MJ threads.

See page 39



## Drilling



CoroDrill® 880

### CVD diamond-coated inserts

Specifically designed for demanding drilling operations in non-ferrous materials. That is where the insert coating combines the super-hardness of a real crystalline diamond providing long insert tool life. These inserts guarantee a superior performance in all ISO N materials.



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B

## Tapping

CoroTap™

### ISO S

- CoroTap™ 200 SM: through hole solution for titanium
- CoroTap™ 300 SM: blind hole solution for titanium
- CoroTap™ 300 SD: blind hole solution for nickel alloys



See chapter F

C

D

## Accessories

EasyFix

### Sleeves

An extension of eight new metallic-sealed EasyFix sleeves that offer optimal performance when using high-pressure coolant.



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# General turning



## External tools

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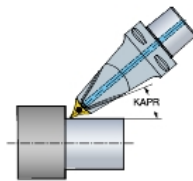
I

# CoroTurn® Prime cutting unit for turning

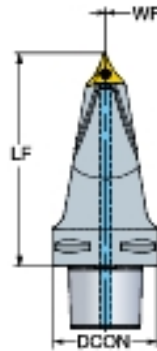
Multi-task tool for multi-task machines



KAPR  
PSIR



30.0°  
60.0°

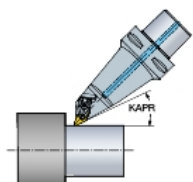


## Screw clamp design

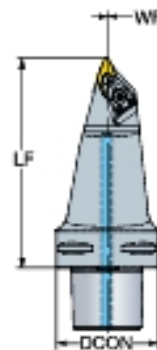
SSC	CZC <sub>MS</sub>	APMX	RMPX	CNSC	Ordering code	Dimensions, mm, inch						MIID	
						DCON	LF	WF	BAR PSI	NM	KG		
	CP-A	C5	3.0	15°	3	<b>C5-CP-75AL00115-11C</b>	50	115.0	0.0	150	3.0	1.20	CP-A1108
			.118				1.969	4.528	.000	2175			
		C6	3.0	15°	3	<b>C6-CP-75AL00130-11C</b>	63	130.0	0.0	150	3.0	2.05	CP-A1108
			.118				2.480	5.118	.000	2175			
		C8	3.0	15°	3	<b>C8-CP-75AL00160-11C</b>	80	160.0	0.0	150	3.0	4.20	CP-A1108
			.118				3.150	6.299	.000	2175			



KAPR  
PSIR



25.0°  
65.0°



## Rigid clamp design

SSC	CZC <sub>MS</sub>	APMX	RMPX	CNSC	Ordering code	Dimensions, mm, inch						MIID	
						DCON	LF	WF	BAR PSI	NM	KG		
	CP-B	C5	4.0	23°	3	<b>C5-CP-70BL00115-11B</b>	50	115.0	0.0	150	3.0	1.15	CP-B1108
			.157				1.969	4.528	.000	2175			
		C6	4.0	23°	3	<b>C6-CP-70BL00130-11B</b>	63	130.0	0.0	150	3.0	1.97	CP-B1108
			.157				2.480	5.118	.000	2175			
		C8	4.0	23°	3	<b>C8-CP-70BL00160-11B</b>	80	160.0	0.0	150	3.0	4.13	CP-B1108
			.157				3.150	6.299	.000	2175			

CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on holder



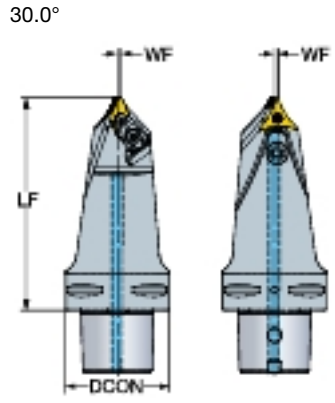
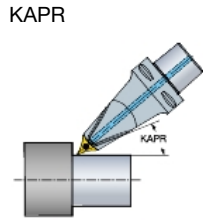


# CoroTurn® Prime cutting unit for turning



Twin-tool for multi-task machines

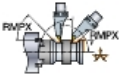
B



C

CP-A CP-B

D



							Dimensions, mm, inch							
SSC	CZC <sub>MS</sub>	APMX	RMPX	OHX	CNSC	Ordering code	DCON	LF <sub>1</sub>	WF <sub>1</sub>	HF	BAR PSI	NM	KG	MIID
CP-A	C6	3.0	15°	130.0	3	<b>C6-T-A11B11L-130</b>	63	130.0	2.0	20.0	80	3.0	2.28	CP-A1108
		.118		5.118			2.480	5.118	.079	.787	1160			
CP-B	C6	4.0	23°	130.0	3		63	130.0	2.0	20.0	80	3.0	2.28	CP-B1108
		.157		5.118			2.480	5.118	.079	.787	1160			
CP-A	C8	3.0	15°	160.0	3	<b>C8-T-A11B11L-160</b>	80	160.0	2.0	25.0	80	3.0	4.60	CP-A1108
		.118		6.299			3.150	6.299	.079	.984	1160			
CP-B	C8	4.0	23°	160.0	3		80	160.0	2.0	25.0	80	3.0	4.60	CP-B1108
		.157		6.299			3.150	6.299	.079	.984	1160			

E

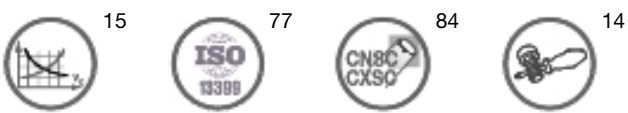
CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on holder

F

G

H

I



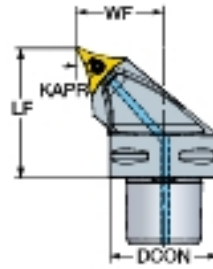
# CoroTurn® Prime cutting unit for turning

Axial tool for vertical lathes



KAPR  
PSIR

30.0°  
60.0°

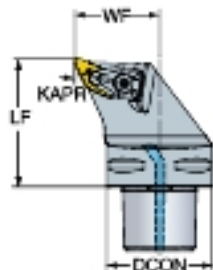


## Screw clamp design

							Dimensions, mm, inch						
SSC	CZC <sub>MS</sub>	APMX	RMPX	CNSC	Ordering code	DCON	LF	WF	BAR PSI	NM	KG	MIID	
	CP-A	C5	3.0	15°	3	C5-CP-A-30AR/L40060-11C	50	60.0	40.0	150	3.0	0.68	CP-A1108
			.118				1.969	2.362	1.575	2175			
		C6	3.0	15°	3	C6-CP-A-30AR/L50065-11C	63	65.0	50.0	150	3.0	1.17	CP-A1108
			.118				2.480	2.559	1.969	2175			

KAPR  
PSIR

25.0°  
65.0°



## Rigid clamp design

							Dimensions, mm, inch						
SSC	CZC <sub>MS</sub>	APMX	RMPX	CNSC	Ordering code	DCON	LF	WF	BAR PSI	NM	KG	MIID	
	CP-B	C5	4.0	23°	3	C5-CP-A-25BR/L40060-11B	50	60.0	40.0	150	3.0	0.67	CP-B1108
			.157				1.969	2.362	1.575	2175			
		C6	4.0	23°	3	C6-CP-A-25BR/L50065-11B	63	65.0	50.0	150	3.0	1.21	CP-B1108
			.157				2.480	2.559	1.969	2175			

CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on holder

R = Right hand, L = Left hand



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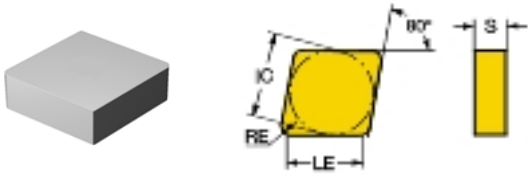


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# T-Max® insert for turning



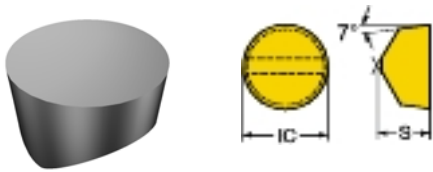
B




C

					ISO CODE	S	ANSI CODE		
Medium	E	12	1/2	11.7	7.94	1.19	CNGN120712E	6160	★ CNGN453A
				.460	.313	.047			

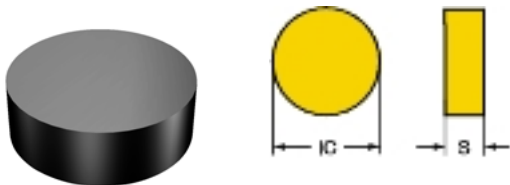
D




E

				ISO CODE	S	ANSI CODE		
Medium	E	06	1/4	6.35	3.18	RCGX060600E	6160	★ RCGX24A
				.250	.125			

F



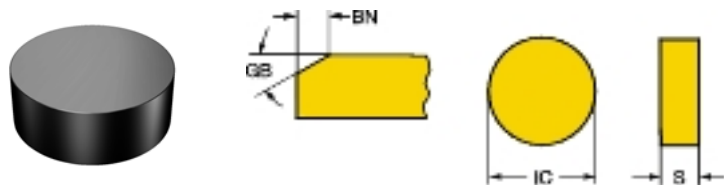
G

				ISO CODE	S	ANSI CODE		
Medium	E	12	1/2	7.94	6.35	RNGN120700E	6220	★ ☆ RNG45A
				.313	.250		6230	

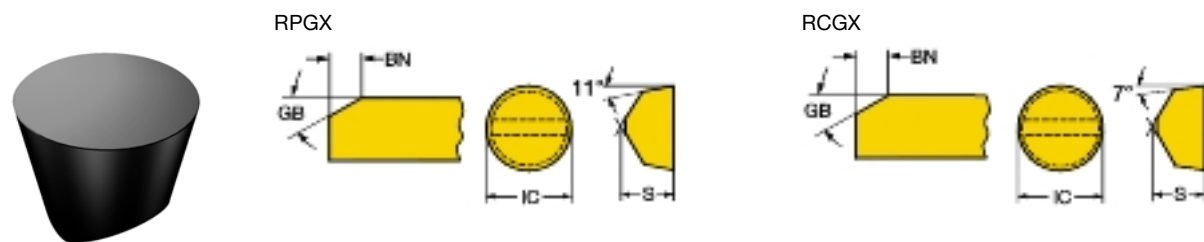
H



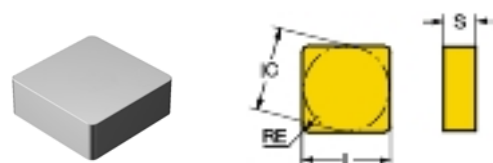
# T-Max® insert for turning



Medium			S	ISO CODE	ANSI CODE				
	IC	S							
Medium	12	1/2	7.94	6.35	20°	0.10	RNGN120700T01020	★ ☆	RNG45T0320
			.313	.250	20°	.004			



Medium			S	ISO CODE	ANSI CODE				
	IC	S							
Medium	06	1/4	6.35	3.18	20°	0.10	RCGX060600T01020	★ ☆	RCGX24T0320
			.250	.125	20°	.004			
	09	3/8	7.94	4.76	20°	0.10	RCGX090700T01020	★ ☆	RCGX35T0320
			.313	.187	20°	.004			
	12	1/2	7.94	6.35	20°	0.10	RCGX120700T01020	★ ☆	RCGX45T0320
			.313	.250	20°	.004			
Medium	09	3/8	7.94	4.76	20°	0.10	RPGX090700T01020	★ ☆	RPGX35T0320
			.313	.187	20°	.004			
	12	1/2	7.94	6.35	20°	0.10	RPGX120700T01020	★ ☆	RPGX45T0320
		.313	.250	20°	.004				



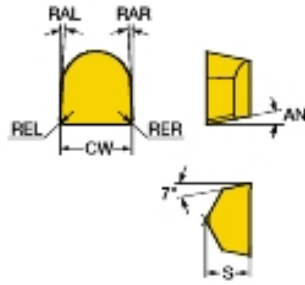
Medium	E			S	ISO CODE	ANSI CODE			
		LE	S						
Medium	E	12	1/2	11.5	7.94	1.19	SNGN120712E	★	SNG453A
				.453	.313	.047			
				11.1	7.94	1.59	SNGN120716E	★	SNG454A
				.437	.313	.062			
		19	3/4	17.4	7.94	1.59	SNGN190716E	★	SNG654A
				.687	.313	.062			
		16.7	7.94	2.38	SNGN190724E	★	SNG656A		
		.656	.313	.094					



# T-Max® insert for grooving



B



C

						s Dimensions, mm, inch						
				6160		AN	S	RAR	RAL			
D	Medium	SSC	CW	REL	RER	Ordering code	★	11°	7.924	2	2	
						CSGX060608E			.312	.079	.079	
						CSGX090708E				.312	.079	.079
						CSGX120708E				.312	.079	.079
										.312	.079	.079
										.312	.079	.079

SSC = To correspond with SSC on holder.

E

F

G

H

I

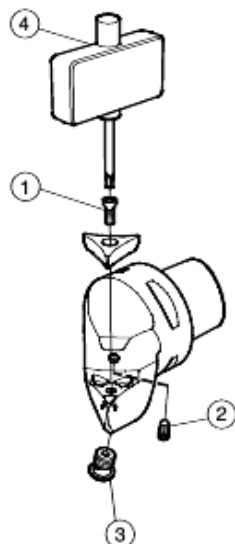


16

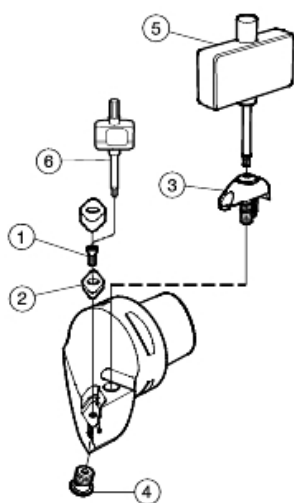


77

## CoroTurn® Prime cutting unit for turning

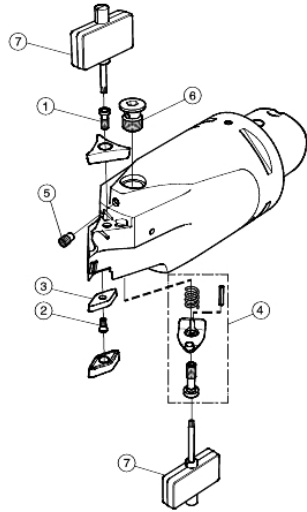


	Spare parts			Included parts
	1	2	3	4
Ordering code	Insert screw	Nozzle	Coolant screw	Key
C5-CP-75AL00115-11C	5513 020-10	5691 026-03	3213 010-256	5680 073-07
C5-CP-A-30AR/L40060-11C	5513 020-10	5691 026-03	3213 010-256	5680 073-07
C6-CP-75AL00130-11C	5513 020-10	5691 026-03	3213 010-256	5680 073-07
C6-CP-A-30AR/L50065-11C	5513 020-10	5691 026-03	3213 010-256	5680 073-07
C8-CP-75AL00160-11C	5513 020-10	5691 026-03	3213 010-256	5680 073-07



	Spare parts				Included parts	Accessories
	1	2	3	4	5	6
Ordering code	Shim screw	Shim	Clamp set	Coolant screw	Key	Key
C5-CP-70BL00115-11B	5513 020-04	5322 610-01	5412 028-021	3213 010-256	5680 073-07	5680 049-03
C5-CP-A-25BR/L40060-11B	5513 020-04	5322 610-01	5412 028-021	3213 010-256	5680 073-07	5680 049-03
C6-CP-70BL00130-11B	5513 020-04	5322 610-01	5412 028-021	3213 010-256	5680 073-07	5680 049-03
C6-CP-A-25BR/L50065-11B	5513 020-04	5322 610-01	5412 028-021	3213 010-256	5680 073-07	5680 049-03
C8-CP-70BL00160-11B	5513 020-04	5322 610-01	5412 028-021	3213 010-256	5680 073-07	5680 049-03

# CoroTurn® Prime cutting unit for turning



D

	Spare parts						Included parts
	1	2	3	4	5	6	7
Ordering code	Insert screw	Shim screw	Shim	Clamp set	Nozzle	Coolant screw	Key
C6-T-A11B11L-130	5513 020-10	5513 020-04	5322 610-01	5412 028-021	5691 026-03	5512 104-01	5680 073-07
C8-T-A11B11L-160	5513 020-10	5513 020-04	5322 610-01	5412 028-021	5691 026-03	5512 104-01	5680 073-07

E

F

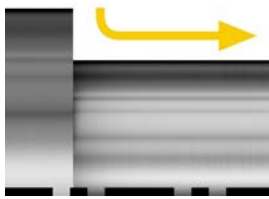
G

H

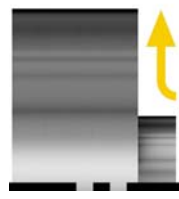
I

## Cutting data

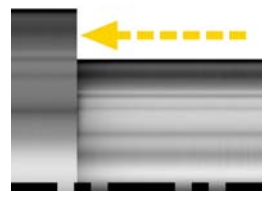
CoroTurn® Prime



SBW = Side backward



EBW = End backward



SFW = Side forward



EFW = End forward

## A-type inserts with screw clamp design on holder

			SBW	EBW	SFW	EFW
	$f_n$ min	mm (inch)	0.2 (.0079)	0.2 (.0079)	0.1 (.0039)	0.1 (.0039)
	$f_n$ rec	mm (inch)	0.4 (.0157)	0.4 (.0157)	0.2 (.0079)	0.2 (.0079)
	$f_n$ max	mm (inch)	0.5 (.0197)	0.5 (.0197)	0.25 (.0098)	0.25 (.0098)
	$a_p$ min	mm (inch)	0.25 (.010)	0.25 (.010)	0.25 (.010)	0.25 (.010)
	$a_p$ rec	mm (inch)	1.5 (.059)	1.5 (.059)	1.0 (.039)	1.0 (.039)
	$a_p$ max	mm (inch)	3.0 (.118)	2.5 (.098)	1.5 (.059)	1.5 (.059)
	KAPR		30°	25°	115°	120°
	RMPX		15°	10°	15°	10°
	$D$ min3	mm (inch)		30 (1.181)		0 (.000)

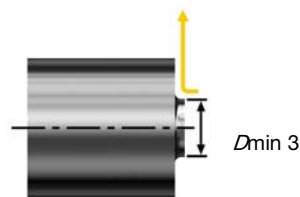
 $f_n$  = feed per revolution

## B-type inserts with rigid clamp design on holder

			SBW	EBW	SFW	EFW
	$f_n$ min	mm (inch)	0.3 (.0118)	0.3 (.0118)	0.2 (.0079)	0.2 (.0079)
	$f_n$ rec	mm (inch)	0.6 (.0236)	0.6 (.0236)	0.35 (.0138)	0.3 (.0118)
	$f_n$ max	mm (inch)	1.2 (.0472)	1.2 (.0472)	0.6 (.0236)	0.6 (.0236)
	$a_p$ min	mm (inch)	0.5 (.020)	0.5 (.020)	0.5 (.020)	0.5 (.020)
	$a_p$ rec	mm (inch)	2.0 (.079)	1.0 (.039)	2.0 (.079)	2.0 (.079)
	$a_p$ max	mm (inch)	4.0 (.157)	1.5 (.059)	3.0 (.118)	3.0 (.118)
	KAPR		25°	25°	95°	95°
	RMPX		23°	23°	23°	23°
	$D$ min3	mm (inch)		40 (1.575)		0 (.000)

 $f_n$  = feed per revolution

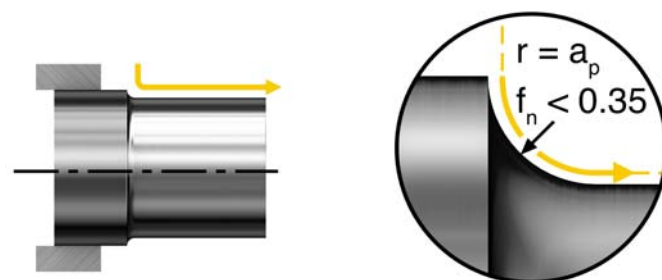
## Minimum diameter



## Cutting speed

Material	$v_c$ m/min
P	250-350
M	100-250
S	40-120

## Feed reduction and radial entry required





# Cutting speed recommendations



The recommendations are valid for use with cutting fluid.

## Metric values

ISO S	CMC No.	Heat resistant material	Specific cutting force $k_{c1}$	Hardness Brinell	<<<< WEAR RESISTANCE			
					CC6160	CC6220	CC6230	
MC No.	Material	N/mm <sup>2</sup>	HB	$h_{ex}$ , mm = feed $f_n$ , mm/r				
				0.1-0.2-0.3				
					Cutting speed ( $v_c$ ), m/min			
		<b>Heat resistant super alloys</b>						
		<b>Iron base</b>						
S1.0.U.AN	20.11	Annealed or solution treated	2400	200	-			
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	-			
		<b>Nickel base</b>						
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	400-325-270	430-340-275	420-345-285	
S2.0.Z.AG	20.22	Aged or solution treated and aged	2900	350	300-235-190	350-285-240	340-295-245	
S2.0.C.NS	20.24	Cast or cast and aged	3000	320	240-205-175	260-195-150	265-220-180	
		<b>Cobalt alloys</b>						
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	-			
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	-			
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	-			

## Inch values

ISO S	CMC No.	Heat resistant material	Specific cutting force $k_{c1}$	Hardness Brinell	<<<< WEAR RESISTANCE			
					CC6160	CC6220	CC6230	
MC No.	Material	lbs/in <sup>2</sup>	HB	$h_{ex}$ , inch = feed $f_n$ inch/rev. at 0° to -5° lead				
				.004-.008-.012				
					Cutting speed $v_c$ , ft/min			
		<b>Heat resistant super alloys</b>						
		<b>Iron base</b>						
S1.0.U.AN	20.11	Annealed or solution treated	348,000	200	-			
S1.0.U.AG	20.12	Aged or solution treated and aged	359,000	280	-			
		<b>Nickel base</b>						
S2.0.Z.AN	20.21	Annealed or solution treated	383,000	250	1300-1050-880	1410-1115-900	1375-1130-935	
S2.0.Z.AG	20.22	Aged or solution treated and aged	420,500	350	980-770-620	1145-935-785	1115-965-800	
S2.0.C.NS	20.24	Cast or cast and aged	436,500	320	790-660-570	850-640-490	870-720-590	
		<b>Cobalt alloys</b>						
S3.0.Z.AN	20.31	Annealed or solution treated	391,500	200	-			
S3.0.Z.AG	20.32	Solution treated and aged	432,000	300	-			
S3.0.C.NS	20.33	Cast or cast and aged	450,500	320	-			

# Parting and grooving B

## External tools

CoroCut® QD blade for Y-axis parting 18 B

Spare parts 18

C

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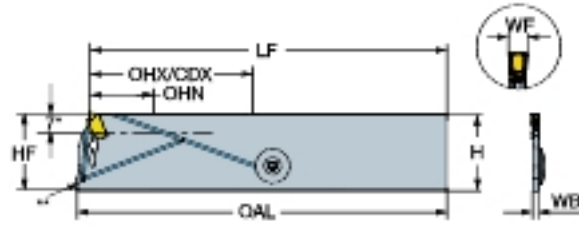
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# CoroCut® QD blade for Y-axis parting

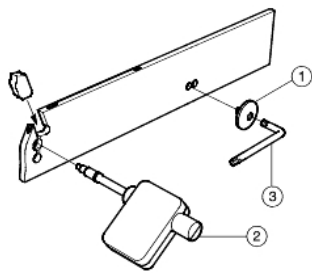


## Spring lock design

						Dimensions, mm, inch									
SSC	CZC <sub>MS</sub>	OHX	OHN	CNSC	Ordering code	H	WB	LF	WF	HF	OAL	BAR PSI	KG	MIID	
G	25	60.0	30.0	2	QD-NN1G60C25AY	31.9	2.4	145.0	2.7	32.0	150.00	70	0.10	QD-NG-0300-0002-CM	
		2.362	1.181			1.256	.093	5.709	.106	1.260	5.906	1015			
H	25	60.0	30.0	2	QD-NN1H60C25AY	31.9	3.4	144.0	3.7	32.0	150.00	70	0.14	QD-NH-0400-0002-CM	
		2.362	1.181			1.256	.132	5.669	.146	1.260	5.906	1015			
	25	90.0	60.0	2	QD-NN1H90C25AY	31.9	3.4	164.0	3.7	32.0	170.00	70	0.15	QD-NH-0400-0002-CM	
		3.543	2.362			1.256	.132	6.457	.146	1.260	6.693	1015			

SSC = To correspond with SSC on insert.

## Spare parts



### Metric version

	Spare parts		Accessories	
	1	2	3	
Ordering code	Coolant plug	Key	Key	
QD-NN1G60C25AY	5643 020-03	5680 075-02	5680 043-13	
QD-NN1H60C25AY	5643 020-03	5680 075-02	5680 043-13	
QD-NN1H90C25AY	5643 020-03	5680 075-02	5680 043-13	

Accessories, must be ordered separately



# Turning tool adaptors



C

## Machine side interface Coromant Capto®

Coromant Capto® reduction adaptor with Quick change	20
Coromant Capto® to CoroTurn® SL70 adaptor	21
Coromant Capto® Mini-Turret for two boring bars	22

B

## Machine side interface CoroTurn® SL

CoroTurn® SL to Coromant Capto® adaptor with Quick change	23
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## Spare parts

24

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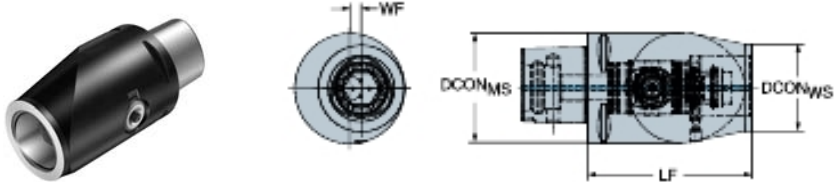
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# Coromant Capto® reduction adaptor with Quick change



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					Dimensions, mm, inch							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	WF	BAR PSI	NM	KG
C6	C5	3	1	2	C6-QC-C5-100L07	63.0	50	100	6.5	150	70	2.120
						2.480	1.969	3.937	.256	2175		
C8	C6	3	1	2	C8-QC-C6-120L09	80.0	63	120	8.5	150	90	4.220
						3.150	2.480	4.724	.335	2175		

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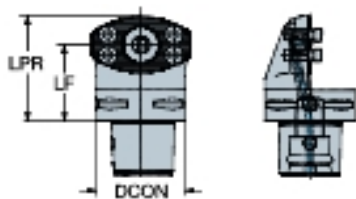
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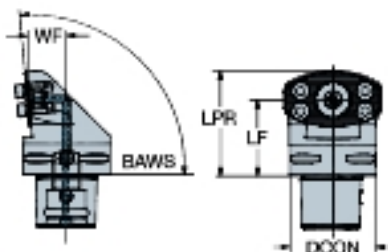


## Coromant Capto® to CoroTurn® SL70 adaptor



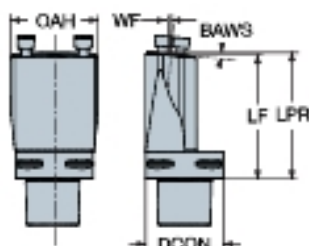
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	Dimensions, mm, inch							
C6	70	3	1	C6-SL70-RF-054-00	DCON	LPR	LF	OAW	BAR PSI	KG		
					63	74	54	70	150	1.312		
					2.480	2.923	2.126	2.776	2.175			

BAWS 95°



CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	Dimensions, mm, inch							
C6	70	3	1	C6-SL70-R/LX-005-055	DCON	LPR	LF	WF	OAW	BAR PSI	KG	
					63	75	55	28.0	70	150	1.681	
					2.480	2.982	2.165	1.102	2.776	2.175		

BAWS 5°



CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	Dimensions, mm, inch							
C6	70	3	1	C6-SL70-LX-005-100	DCON	LPR	LF	WF	OAW	BAR PSI	KG	
					63	102	100	11.0	70	150	2.109	
					2.480	4.016	3.937	.433	2.776	2.175		



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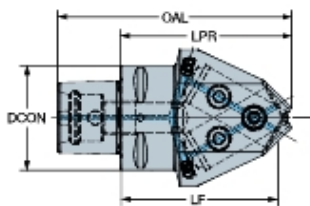
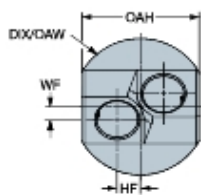
## Coromant Capto® Mini-Turret for two boring bars



ENG

B

BAWS 30°



C

					Dimensions, mm, inch										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON	DCON <sub>MS</sub>	LPR	LF	WF	HF	OAW	OAH	DIX	BAR PSI	KG
C6	25	3	1	C6-ABB-25-2	25	63.0	103	95	8.0	14	82	70	82	80	2.570
					.984	2.480	4.059	3.740	.315	.551	3.228	2.771	3.228	1160	

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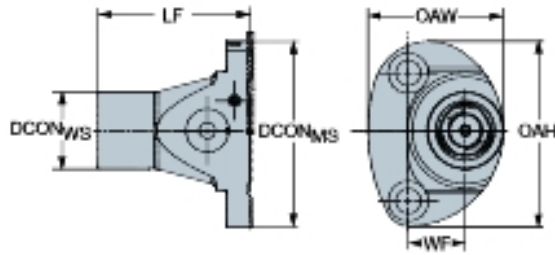


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## CoroTurn® SL to Coromant Capto® adaptor with Quick change



					Dimensions, mm, inch										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	H	LB <sub>1</sub>	LF	WF	OAW	OAH	BAR PSI	NM	KG
80	C3	1	1	C3-QC-SL80-R	80.0	32	37	24	64	24.0	57	77	150	35	0.580
					3.150	1.260	1.476	.965	2.520	.945	2.244	3.047	2175		
100	C3	1	1	C3-QC-SL100-R	100.0	32	37	24	64	34.0	80	76	150	35	0.720
					3.937	1.260	1.476	.965	2.520	1.339	3.150	3.012	2175		



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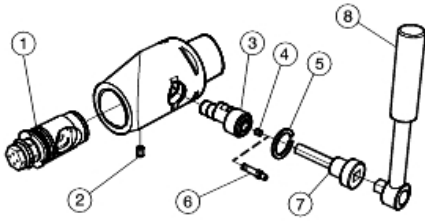
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## Coromant Capto® reduction adaptor with Quick change



B



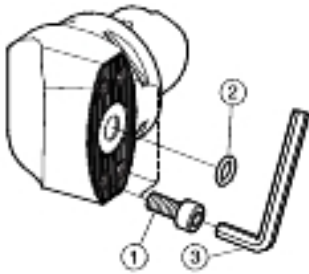
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	Spare parts					Accessories		
	1	2	3	4	5	6	7	8
Ordering code	Draw bar set	Set screw	Cam shaft	Set screw	Circlip	Grease nipple	Key adaptor	Torque wrench
C6-QC-C5-100R/L07	5461 060-031	3214 010-306	5333 060-03	3214 010-355	3421 105-022	5692 012-01	5680 035-07	C-TK-01M
C8-QC-C6-120R/L09	5461 060-041	3214 010-357	5333 060-04	3214 010-355	3421 105-028	5692 012-01	5680 035-07	C-TK-01M

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## Coromant Capto® to CoroTurn® SL70 adaptor

E



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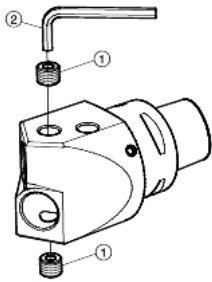
	Spare parts		Accessories
	1	2	3
Ordering code	Screw	O-ring	Key
C6-SL70-R/LX-005-055	3212 010-409	5641 005-05	3021 010-060
C6-SL70-R/LX-005-100	3212 010-409	5641 005-05	3021 010-060
C6-SL70-RF-054-00	3212 010-409	5641 005-05	3021 010-060

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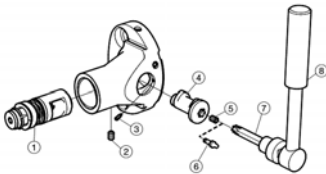
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## Coromant Capto® Mini-Turret for two boring bars



	Spare parts	Accessories
	1	2
Ordering code	Screw	Key
C6-ABB-25-2	416.1-838	3021 010-060

## CoroTurn® SL to Coromant Capto® adaptor with Quick change



	Spare parts					Accessories		
	1	2	3	4	5	6	7	8
Ordering code	Draw bar set	Set screw	Set screw	Cam shaft	Set screw	Grease nipple	Key extension	Torque wrench
C3-QC-SL80-R	5461 060-011	3214 020-204	3214 020-105	5333 060-01	3214 010-255	5692 012-02	5680 035-16	C-TK-01M
C3-QC-SL100-R	5461 060-011	3214 020-204	3214 020-105	5333 060-01	3214 010-255	5692 012-02	5680 035-16	C-TK-01M

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# Milling



D

ENG

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## Profile milling tools

CoroMill® 600 insert for milling	27
CoroMill® 300 insert for milling	28-29
CoroMill® 200 insert for milling	30

## Thread milling tools

CoroMill® 325 Thread whirling cutter	31-32
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## Solid milling tools

CoroMill® Plura solid carbide square shoulder end mill	33-38
CoroMill® Plura solid carbide end mill for thread milling	39

<b>Cutting data</b>	40
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<b>Spare parts</b>	51
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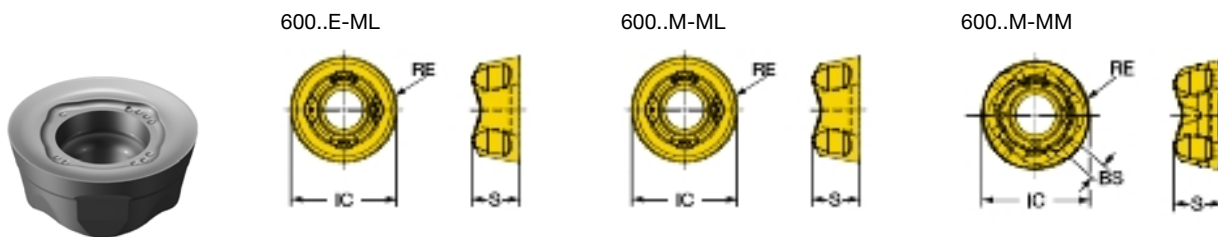
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# CoroMill® 600 insert for milling



			P	M	S	Dimensions, mm, inch			
						IC	S	BS	BSR
		RE	1130	1130	1130				
		Ordering code	★	☆	☆				
Light	ML	10 5.00 600-1045E-ML	★	☆	☆	10.0	4.50		
		.197				.394	.177		
		5.00 600-1045M-ML	★	☆	☆	10.0	4.50		
		.197				.394	.177		
		12 6.00 600-1252E-ML	★	☆	☆	12.0	5.20		
		.236				.472	.205		
Medium	MM	10 5.00 600R-1045M-MM	★	☆	☆	10.0	4.50	0.8	100.0
		.197				.394	.177	.031	3.937
		12 6.00 600R-1252M-MM	★	☆	☆	12.0	5.20	1.0	15.0
		.236				.472	.205	.039	.591



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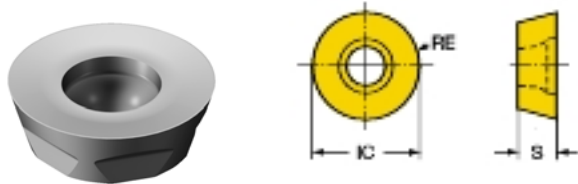


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# CoroMill® 300 insert for milling



B



C

## Metric version

				P	M	N	S	H	Dimensions, mm, inch	
		RE	Ordering code	1130	1130	1130	1130	1130	IC	S
Light	PL	08 4.00	R300-0828E-PL	★	☆	☆	☆	☆	8.0	2.78
		.157							.315	.109
		10 5.00	R300-1032E-PL	★	☆	☆	☆	☆	10.0	3.18
		.197							.394	.125
		12 6.00	R300-1240E-PL	★	☆	☆	☆	☆	12.0	3.97
		.236							.472	.156
Medium	PM	16 8.00	R300-1648E-PL	★	☆	☆	☆	☆	16.0	4.76
		.315							.630	.187
		20 10.00	R300-2060E-PL	★	☆	☆	☆	☆	20.0	6.48
		.394							.787	.255
		08 4.00	R300-0828E-PM	★	☆	☆	☆	☆	8.0	2.78
		.157							.315	.109
		4.00	R300-0828M-PM	★	☆	☆	☆	☆	8.0	2.78
		.157							.315	.109
		10 5.00	R300-1032E-PM	★	☆	☆	☆	☆	10.0	3.18
		.197							.394	.125
		5.00	R300-1032M-PM	★	☆	☆	☆	☆	10.0	3.18
		.197							.394	.125
12 6.00	R300-1240E-PM	★	☆	☆	☆	☆	12.0	3.97		
.236							.472	.156		
6.00	R300-1240M-PM	★	☆	☆	☆	☆	12.0	3.97		
.236							.472	.156		
16 8.00	R300-1648E-PM	★	☆	☆	☆	☆	16.0	4.76		
.315							.630	.187		
8.00	R300-1648M-PM	★	☆	☆	☆	☆	16.0	4.76		
.315							.630	.187		
20 10.00	R300-2060E-PM	★	☆	☆	☆	☆	20.0	6.48		
.394							.787	.255		
10.00	R300-2060M-PM	★	☆	☆	☆	☆	20.0	6.48		
.394							.787	.255		
Heavy	PH	08 4.00	R300-0828M-PH	★	☆	☆	☆	☆	8.0	2.78
		.157							.315	.109
		10 5.00	R300-1032M-PH	★	☆	☆	☆	☆	10.0	3.18
		.197							.394	.125
		12 6.00	R300-1240M-PH	★	☆	☆	☆	☆	12.0	3.97
		.236							.472	.156
16 8.00	R300-1648M-PH	★	☆	☆	☆	☆	16.0	4.76		
.315							.630	.187		
20 10.00	R300-2060M-PH	★	☆	☆	☆	☆	20.0	6.48		
.394							.787	.255		

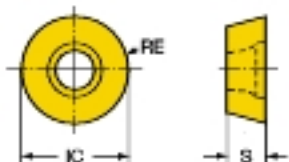
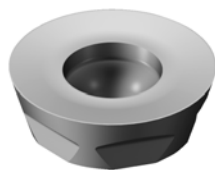
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# CoroMill® 300 insert for milling



## Inch version

		RE	Ordering code	P	M	N	S	H	Dimensions, mm, inch	
				1130	1130	1130	1130	1130	IC	S
Light	PL	13 6.35	R300-1340E-PL	★	☆	☆	☆	☆	12.7	3.97
		.250						.500	.156	
		25 12.70	R300-2570E-PL	★	☆	☆	☆	☆	25.4	7.94
		.500						1.000	.313	
Medium	PM	07 20 3.50	R300-0720E-PM	★	☆	☆	☆	☆	7.0	1.99
		.138						.276	.078	
		07 24 3.50	R300-0724E-PM	★	☆	☆	☆	☆	7.0	2.38
		.138						.276	.094	
		05 2.50	R300-0517E-PM	★	☆	☆	☆	☆	5.0	1.70
		.098						.197	.067	
		09 4.76	R300-0932E-PM	★	☆	☆	☆	☆	9.5	3.18
		.187						.375	.125	
		4.76	R300-0932M-PM	★	☆	☆	☆	☆	9.5	3.18
		.187						.375	.125	
		13 6.35	R300-1340E-PM	★	☆	☆	☆	☆	12.7	3.97
		.250						.500	.156	
6.35	R300-1340M-PM	★	☆	☆	☆	☆	12.7	3.97		
.250						.500	.156			
25 12.70	R300-2570M-PM	★	☆	☆	☆	☆	25.4	7.94		
.500						1.000	.313			
Heavy	PH	13 6.35	R300-1340M-PH	★	☆	☆	☆	☆	12.7	3.97
		.250						.500	.156	
		25 12.70	R300-2570M-PH	★	☆	☆	☆	☆	25.4	7.94
		.500					1.000	.313		

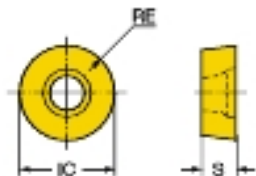
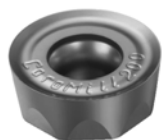


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# CoroMill® 200 insert for milling



## Metric version

				P	M	N	S	H	Dimensions, mm, inch	
		RE		1130	1130	1130	1130	1130	IC	S
Light	PL	10	.394 5.00	★	☆	☆	☆	☆	10.0	3.97
			.197						.394	.156
		12	.472 6.00	★	☆	☆	☆	☆	12.0	4.76
			.236						.472	.187
Medium	PM	16	.630 8.00	★	☆	☆	☆	☆	16.0	6.35
			.315						.630	.250
		20	.787 10.00	★	☆	☆	☆	☆	20.0	6.35
			.394						.787	.250
Heavy	PH	10	.394 5.00	★	☆	☆	☆	☆	10.0	3.97
			.197						.394	.156
		12	.472 6.00	★	☆	☆	☆	☆	12.0	4.76
			.236						.472	.187
	16	.630 8.00	★	☆	☆	☆	☆	16.0	6.35	
		.315						.630	.250	
	20	.787 10.00	★	☆	☆	☆	☆	20.0	6.35	
		.394						.787	.250	

## Inch version

				P	M	N	S	H	Dimensions, mm, inch	
		RE		1130	1130	1130	1130	1130	IC	S
Light	PL	09	3/8 4.76	★	☆	☆	☆	☆	9.5	3.97
			.187						.375	.156
		13	1/2 6.35	★	☆	☆	☆	☆	12.7	4.76
			.250						.500	.187
Medium	PM	19	3/4 9.53	★	☆	☆	☆	☆	19.1	6.35
			.375						.750	.250
		09	3/8 4.76	★	☆	☆	☆	☆	9.5	3.97
			.187						.375	.156
Heavy	PH	13	1/2 6.35	★	☆	☆	☆	☆	12.7	4.76
			.250						.500	.187
		19	3/4 9.53	★	☆	☆	☆	☆	19.1	6.35
			.375						.750	.250

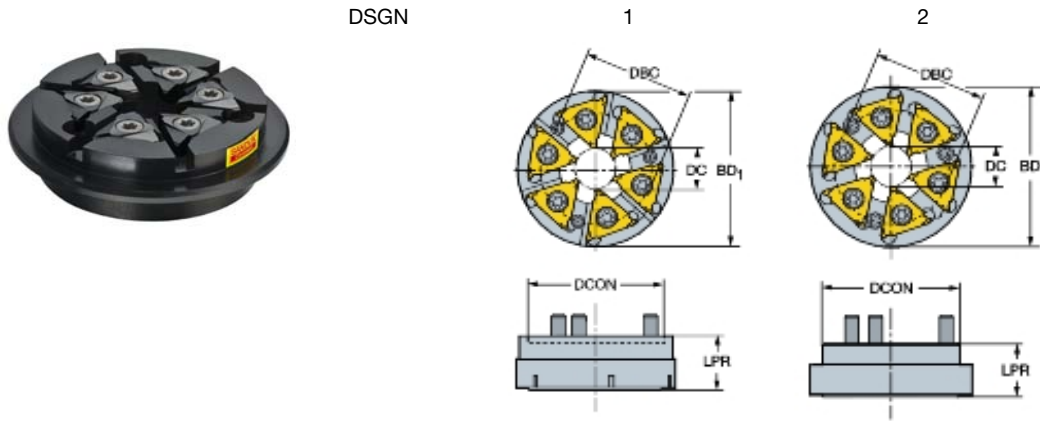


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# CoroMill® 325 Thread whirling cutter



## Citizen-PCM

							Dimensions, mm, inch						
DC	DSGN	CNSC	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	KG	NM	MIID			
16	3/8	6	2	0	6	325-06AP20-16M	20	26	35	15	0.06	6.5	325R16-150HAF01
16	3/8	12	1	0	6	325-12AP40-16M	40	32.5	46	15.5	0.12	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12AP45-16M	45	30	46	18	0.13	6.5	325R16-150HAF01

## Citizen - Jarvis

							Dimensions, mm, inch						
DC	DSGN	CNSC	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	KG	NM	MIID			
16	3/8	12	1	0	6	325-12AQ40-16M	40	32	46	13.5	0.12	6.5	325R16-150HAF01

## Citizen - Citizen

							Dimensions, mm, inch						
DC	DSGN	CNSC	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	KG	NM	MIID			
16	3/8	12	2	0	6	325-12AA33-16M	33	40	46.9	18.5	0.10	6.5	325R16-150HAF01

## Tsugami-Tsugami

							Dimensions, mm, inch						
DC	DSGN	CNSC	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	KG	NM	MIID			
16	3/8	12	2	0	6	325-12CC52-16M	52	42	65	17	0.21	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12CC52-16M-B	52	44	52	10	0.10	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12CC52-16M-C	52	38	54	19	0.23	6.5	325R16-150HAF01
16	3/8	16	2	0	6	325-16CC50-16M	50	40	62	20	0.21	6.5	325R16-150HAF01
16	3/8	20	2	0	6	325-20CC52-16M	52	42	65	17	0.12	6.5	325R16-150HAF01

## Tornos-Tornos

							Dimensions, mm, inch						
DC	DSGN	CNSC	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	KG	NM	MIID			
16	3/8	12	2	0	6	325-12DD50-16M	50	40	67	15.4	0.25	6.5	325R16-150HAF01
16	3/8	12	2	0	6	325-12DD40-16M	40	31	57	15	0.12	6.5	325R16-150HAF01



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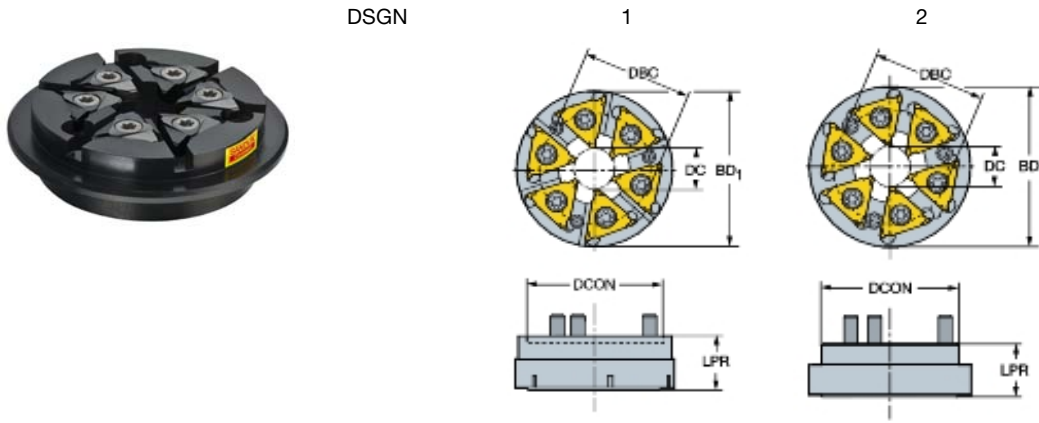
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# CoroMill® 325 Thread whirling cutter



Citizen - Hanwha - Madula

								Dimensions, mm, inch			
16	3/8	DC	DSGN	CNSC	6	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	MIID
16	3/8	12	2	0	6	325-12RR45-16M	45	27	56	15	325R16-150HAF01

DMG - DMG

								Dimensions, mm, inch			
16	3/8	DC	DSGN	CNSC	6	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	MIID
16	3/8	13.5	1	0	6	325-14GG42-16M	42	33	49	14.75	325R16-150HAF01

Star - Star

								Dimensions, mm, inch			
16	3/8	DC	DSGN	CNSC	6	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	MIID
16	3/8	12	2	0	6	325-12BB40-16M	40	32	47	15	325R16-150HAF01

Star, Goodway, Doosan, Hanwha, Nexturn, Tsugami - WTO

								Dimensions, mm, inch			
16	3/8	DC	DSGN	CNSC	6	Ordering code	DCON	DBC	BD <sub>1</sub>	LPR	MIID
16	3/8	20	2	0	6	325-20EE54-16M	54		56.5	13.8	325R16-150HAF01
16	3/8	12	2	0	6	325-12EE32-16M	32	28	43.8	18.2	325R16-150HAF01



# CoroMill® Plura solid carbide square shoulder end mill

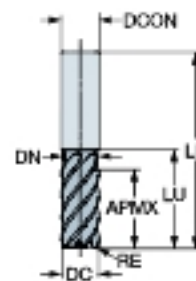
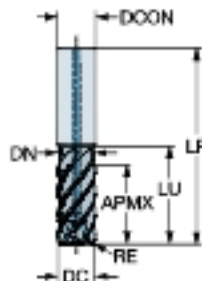
Cylindrical shank

Metric version



CNSC 1  
 CXSC 3  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6

0  
 0  
 42°  
 COROMANT  
 h10  
 h6



## Internal coolant supply

							s	Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZEPF	Ordering code	17/45	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
10.0	10	22.0	32.0	1.00	30.0	6	2F340-1000-100CSC	☆	10.0	72.0	9.5	9.5	30.0	30.4	30°
				2.00			6	2F340-1000-200CSC	☆	10.0	72.0	9.5	9.5	30.0	30.4
12.0	12	26.0	38.0	1.00	36.0	6	2F340-1200-100CSC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
				2.00			6	2F340-1200-200CSC	☆	12.0	83.0	11.4	11.4	36.0	36.5
16.0	16	34.0	44.0	2.00	42.0	6	2F340-1600-200CSC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
				3.00			6	2F340-1600-300CSC	☆	16.0	92.0	15.2	15.2	42.0	42.7
20.0	20	42.0	54.0	3.00	52.0	6	2F340-2000-300CSC	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	6	2F340-2500-400CSC	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°
32.0	32	66.0	90.0	4.00	82.0	6	2F340-3200-400CSC	☆	32.0	150.0	30.4	30.4	82.0	83.4	30°

## No coolant

							s	Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZEPF	Ordering code	17/45	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>	
4.0	6	9.0	21.0	0.50	14.5	4	2F340-0400-050-SC	☆	6.0	57.0	3.8	3.8	14.5	16.4	30°	
5.0	6	11.0	21.0	0.50	16.5	4	2F340-0500-050-SC	☆	6.0	57.0	4.8	4.8	16.5	17.6	30°	
6.0	6	13.0	21.0	0.50	20.0	5	2F340-0600-050-SC	☆	6.0	57.0	5.7	5.7	20.0	20.3	30°	
				1.00			5	2F340-0600-100-SC	☆	6.0	57.0	5.7	5.7	20.0	20.3	30°
8.0	8	18.0	27.0	0.50	25.0	5	2F340-0800-050-SC	☆	8.0	63.0	7.6	7.6	25.0	25.4	30°	
				1.00			5	2F340-0800-100-SC	☆	8.0	63.0	7.6	7.6	25.0	25.4	30°
10.0	10	22.0	32.0	0.50	30.0	6	2F340-1000-050-SC	☆	10.0	72.0	9.5	9.5	30.0	30.4	30°	
				1.00			6	2F340-1000-100-SC	☆	10.0	72.0	9.5	9.5	30.0	30.4	30°
				2.00			6	2F340-1000-200-SC	☆	10.0	72.0	9.5	9.5	30.0	30.4	30°
12.0	12	26.0	38.0	1.00	36.0	6	2F340-1200-100-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°	
				2.00			6	2F340-1200-200-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
				2.50			6	2F340-1200-250-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
				3.00			6	2F340-1200-300-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
16.0	16	34.0	44.0	2.00	42.0	6	2F340-1600-200-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°	
				2.50			6	2F340-1600-250-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
				3.00			6	2F340-1600-300-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
				4.00			6	2F340-1600-400-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
							6									
20.0	20	42.0	54.0	3.00	52.0	6	2F340-2000-300-SC	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°	
				4.00			6	2F340-2000-400-SC	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
				6.35			6	2F340-2000-635-SC	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
							6									
25.0	25	52.0	65.0	3.00	63.0	6	2F340-2500-300-SC	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°	
				4.00			6	2F340-2500-400-SC	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°
				6.35			6	2F340-2500-635-SC	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°
32.0	32	66.0	90.0	4.00	82.0	6	2F340-3200-400-SC	☆	32.0	150.0	30.4	30.4	82.0	83.4	30°	



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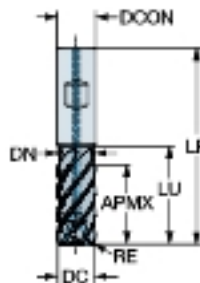
# CoroMill® Plura solid carbide square shoulder end mill



Weldon shank

Metric version

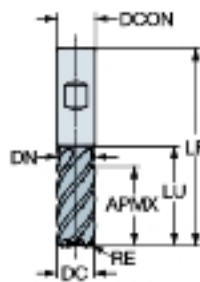
CNSC 1  
 CXSC 3  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6



## Internal coolant supply

							s	Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZEFP	Ordering code	1745	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
16.0	16	34.0	44.0	2.00	42.0	6	2F340-1600-200CSD	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	3.00	42.0	6	2F340-1600-300CSD	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
20.0	20	42.0	54.0	3.00	52.0	6	2F340-2000-300CSD	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	6	2F340-2500-400CSD	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°

CNSC 0  
 CXSC 0  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6



## No coolant

							s	Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZEFP	Ordering code	1745	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
16.0	16	34.0	44.0	2.00	42.0	6	2F340-1600-200-SD	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	3.00	42.0	6	2F340-1600-300-SD	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
20.0	20	42.0	54.0	3.00	52.0	6	2F340-2000-300-SD	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
	20	42.0	54.0	4.00	52.0	6	2F340-2000-400-SD	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	6	2F340-2500-400-SD	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°



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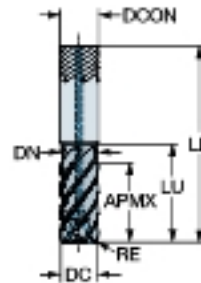
# CoroMill® Plura solid carbide square shoulder end mill



iLock

Metric version

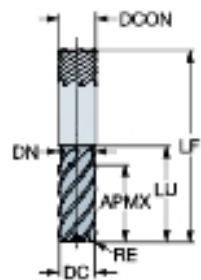
CNSC 1  
 CXSC 3  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6



## Internal coolant supply

							s	Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZFP	Ordering code	17/45	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
16.0	16	34.0	44.0	2.00	42.0	6	2F340-1600-200CSF	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	3.00	42.0	6	2F340-1600-300CSF	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
20.0	20	42.0	54.0	3.00	52.0	6	2F340-2000-300CSF	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	6	2F340-2500-400CSF	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°
32.0	32	66.0	90.0	4.00	82.0	6	2F340-3200-400CSF	☆	32.0	150.0	30.4	30.4	82.0	83.4	30°

CNSC 0  
 CXSC 0  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6



## No coolant

							s	Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZFP	Ordering code	17/45	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
16.0	16	34.0	44.0	3.00	42.0	6	2F340-1600-300-SF	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
20.0	20	42.0	54.0	3.00	52.0	6	2F340-2000-300-SF	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	6	2F340-2500-400-SF	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°
32.0	32	66.0	90.0	4.00	82.0	6	2F340-3200-400-SF	☆	32.0	150.0	30.4	30.4	82.0	83.4	30°



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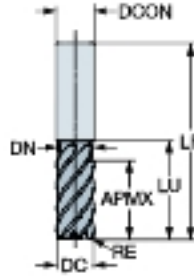
# CoroMill® Plura solid carbide square shoulder end mill



Cylindrical shank

Metric version

CNSC 0  
 CXSC 0  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6



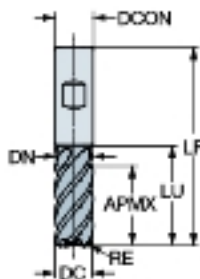
								s	Dimensions, mm						
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZEFP	Ordering code	1710	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
4.0	6	9.0	21.0	0.50	14.5	4	2F341-0400-050-SC	☆	6.0	57.0	3.8	3.8	14.5	16.4	30°
5.0	6	11.0	21.0	0.50	16.5	4	2F341-0500-050-SC	☆	6.0	57.0	4.8	4.8	16.5	17.6	30°
6.0	6	13.0	21.0	0.50	20.0	5	2F341-0600-050-SC	☆	6.0	57.0	5.7	5.7	20.0	20.3	30°
	6	13.0	21.0	1.00	20.0	5	2F341-0600-100-SC	☆	6.0	57.0	5.7	5.7	20.0	20.3	30°
8.0	8	18.0	27.0	0.50	25.0	5	2F341-0800-050-SC	☆	8.0	63.0	7.6	7.6	25.0	25.4	30°
	8	18.0	27.0	1.00	25.0	5	2F341-0800-100-SC	☆	8.0	63.0	7.6	7.6	25.0	25.4	30°
10.0	10	22.0	32.0	0.50	30.0	5	2F341-1000-050-SC	☆	10.0	72.0	9.5	9.5	30.0	30.4	30°
	10	22.0	32.0	1.00	20.0	5	2F341-1000-100-SC	☆	10.0	72.0	9.5	9.5	30.0	30.4	30°
	10	22.0	32.0	2.00	30.0	5	2F341-1000-200-SC	☆	10.0	72.0	9.5	9.5	30.0	30.4	30°
12.0	12	26.0	38.0	1.00	36.0	5	2F341-1200-100-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
	12	26.0	38.0	2.00	36.0	5	2F341-1200-200-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
	12	26.0	38.0	2.00	36.0	5	2F341-1200-300-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
	12	26.0	38.0	2.50	36.0	5	2F341-1200-250-SC	☆	12.0	83.0	11.4	11.4	36.0	36.5	30°
16.0	16	34.0	44.0	2.00	42.0	5	2F341-1600-200-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	2.50	42.0	5	2F341-1600-250-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	3.00	42.0	5	2F341-1600-300-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	4.00	42.0	5	2F341-1600-400-SC	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
20.0	20	42.0	54.0	3.00	52.0	5	2F341-2000-300-SC	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
	20	42.0	54.0	4.00	52.0	5	2F341-2000-400-SC	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
	20	42.0	54.0	6.35	52.0	5	2F341-2000-635-SC	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	5	2F341-2500-400-SC	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°
	25	52.0	65.0	6.35	63.0	5	2F341-2500-635-SC	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°



# CoroMill® Plura solid carbide square shoulder end mill



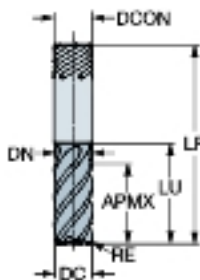
CNSC 0  
 CXSC 0  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6



## Weldon shank

								s	Dimensions, mm						
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZEFP	Ordering code	1710	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
16.0	16	34.0	44.0	3.00	42.0	5	2F341-1600-300-SD	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	4.00	42.0	5	2F341-1600-400-SD	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
20.0	20	42.0	54.0	3.00	52.0	5	2F341-2000-300-SD	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
	20	42.0	54.0	4.00	52.0	5	2F341-2000-400-SD	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	5	2F341-2500-400-SD	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°

CNSC 0  
 CXSC 0  
 FHA 42°  
 BSG COROMANT  
 TCDC h10  
 TCDCON h6



## iLock

								s	Dimensions, mm						
DC	CZC <sub>MS</sub>	APMX	OHX	RE	LU	ZEFP	Ordering code	1710	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>
16.0	16	34.0	44.0	3.00	42.0	5	2F341-1600-300-SF	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
	16	34.0	44.0	4.00	42.0	5	2F341-1600-400-SF	☆	16.0	92.0	15.2	15.2	42.0	42.7	30°
20.0	20	42.0	54.0	3.00	52.0	5	2F341-2000-300-SF	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
	20	42.0	54.0	4.00	52.0	5	2F341-2000-400-SF	☆	20.0	104.0	19.0	19.0	52.0	52.9	30°
25.0	25	52.0	65.0	4.00	63.0	5	2F341-2500-400-SF	☆	25.0	121.0	23.8	23.8	63.0	64.1	30°



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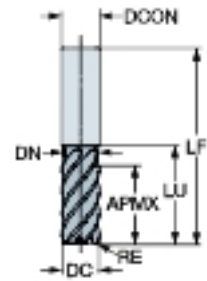
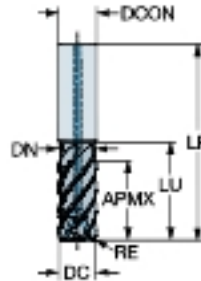
# CoroMill® Plura solid carbide square shoulder end mill



Cylindrical shank

Inch version

CNSC	1	0
CXSC	3	0
FHA	42°	42°
BSG	COROMANT	COROMANT
TCDC	h10	h10
TCDCON	h6	h6



## Internal coolant supply

						s Dimensions, inch									
DC	CZC <sub>MS</sub>	APMX	RE	LU	ZEFP	Ordering code	1745	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>1</sub>	BHTA <sub>2</sub>
.375	3/8	.781	.030	1.156	6	2F340-0953-076CSC	☆	.375	2.750	.356	.356	1.156	1.173	0°	30°
	3/8	.781	.060	1.156	6	2F340-0953-152CSC	☆	.375	2.750	.356	.356	1.156	1.173	0°	30°
.500	1 1/2	1.125	.060	1.438	6	2F340-1270-152CSC	☆	1.500	3.500	.475	.475	1.438	1.459	0°	30°
	1/2	1.125	.090	1.438	6	2F340-1270-228CSC	☆	.500	3.500	.475	.475	1.438	1.459	0°	30°
.625	5/8	1.313	.060	1.563	6	2F340-1588-228CSC	☆	.625	3.500	.594	.594	1.563	1.578	0°	30°
	5/8	1.125	.060	1.563	6	2F340-1588-152CSC	☆	.625	3.500	.594	.594	1.563	1.578	0°	30°
.750	3/4	1.625	.090	1.563	6	2F340-1905-228CSC	☆	.750	4.000	.713	.713	1.563	1.970	0°	30°
	3/4	1.625	.120	1.937	6	2F340-1905-304CSC	☆	.750	4.000	.713	.713	1.937	1.970	0°	30°
1.000	1	2.125	.120	2.656	6	2F340-2540-304CSC	☆	1.000	5.000	.951	.951	2.656	2.699	0°	30°
1.250	1 1/4	2.625	.020	.571	6	2F340-3175-304CSC	☆	1.250	6.000	1.187	1.187	.571	3.305	0°	30°

## No coolant

						s Dimensions, inch									
DC	CZC <sub>MS</sub>	APMX	RE	LU	ZEFP	Ordering code	1745	DCON	LF	DN	BD <sub>1</sub>	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>1</sub>	BHTA <sub>2</sub>
.188	3/16	.438	.030	.625	4	2F340-0476-076-SC	☆	.187	2.000	.178	.178	.625	.633	0°	30°
.250	1/4	.625	.030	.875	5	2F340-0635-076-SC	☆	.250	2.500	.237	.237	.875	.886	0°	30°
	1/4	.625	.060	.875	5	2F340-0635-152-SC	☆	.250	2.500	.237	.237	.875	.886	0°	30°
.375	3/8	.781	.030	1.156	6	2F340-0953-076-SC	☆	.375	2.750	.356	.356	1.156	1.173	0°	30°
	3/8	.781	.060	1.156	6	2F340-0953-152-SC	☆	.375	2.750	.356	.356	1.156	1.173	0°	30°
	3/8	.781	.090	1.156	6	2F340-0953-228-SC	☆	.375	2.750	.356	.356	1.156	1.173	0°	30°
.500	1/2	1.125	.030	1.438	6	2F340-1270-076-SC	☆	.500	3.500	.475	.475	1.438	1.459	0°	30°
	1/2	1.125	.060	1.438	6	2F340-1270-152-SC	☆	.500	3.500	.475	.475	1.438	1.459	0°	30°
	1/2	1.125	.090	1.438	6	2F340-1270-228-SC	☆	.500	3.500	.475	.475	1.438	1.459	0°	30°
	1/2	1.125	.120	1.438	6	2F340-1270-304-SC	☆	.500	3.500	.475	.475	1.438	1.459	0°	30°
	1/2	1.125	.120	1.438	6	2F340-1270-304-SC	☆	.500	3.500	.475	.475	1.438	1.459	0°	30°
.625	5/8	1.313	.030	1.563	6	2F340-1588-076-SC	☆	.625	3.500	.594	.594	1.563	1.578	0°	30°
	5/8	1.313	.060	1.563	6	2F340-1588-152-SC	☆	.625	3.500	.594	.594	1.563	1.578	0°	30°
	5/8	1.313	.090	1.563	6	2F340-1588-228-SC	☆	.625	3.500	.594	.594	1.563	1.578	0°	30°
	5/8	1.313	.120	1.563	6	2F340-1588-304-SC	☆	.625	3.500	.594	.594	1.563	1.578	0°	30°
	5/8	1.313	.120	1.563	6	2F340-1588-304-SC	☆	.625	3.500	.594	.594	1.563	1.578	0°	30°
.750	3/4	1.625	.030	1.937	6	2F340-1905-076-SC	☆	.750	4.000	.713	.713	1.937	1.970	0°	30°
	3/4	1.625	.060	1.937	6	2F340-1905-152-SC	☆	.750	4.000	.713	.713	1.937	1.970	0°	30°
	3/4	1.625	.090	1.937	6	2F340-1905-228-SC	☆	.750	4.000	.713	.713	1.937	1.970	0°	30°
1.000	3/4	1.625	.120	1.937	6	2F340-1905-304-SC	☆	.750	4.000	.713	.713	1.937	1.970	0°	30°
	1	2.125	.030	2.656	6	2F340-2540-076-SC	☆	1.000	5.000	.951	.951	2.656	2.699	0°	30°
	1	2.125	.060	2.656	6	2F340-2540-152-SC	☆	1.000	5.000	.951	.951	2.656	2.699	0°	30°
	1	2.125	.090	2.656	6	2F340-2540-228-SC	☆	1.000	5.000	.951	.951	2.656	2.699	0°	30°
1.250	1	2.125	.120	2.656	6	2F340-2540-304-SC	☆	1.000	5.000	.951	.951	2.656	2.699	0°	30°
	1 1/4	2.625	.030	3.250	6	2F340-3175-076-SC	☆	1.250	6.000	1.187	1.187	3.250	3.305	0°	30°
	1 1/4	2.625	.060	3.250	6	2F340-3175-152-SC	☆	1.250	6.000	1.187	1.187	3.250	3.305	0°	30°
	1 1/4	2.625	.090	3.250	6	2F340-3175-228-SC	☆	1.250	6.000	1.187	1.187	3.250	3.305	0°	30°
	1 1/4	2.625	.120	3.250	6	2F340-3175-304-SC	☆	1.250	6.000	1.187	1.187	3.250	3.305	0°	30°



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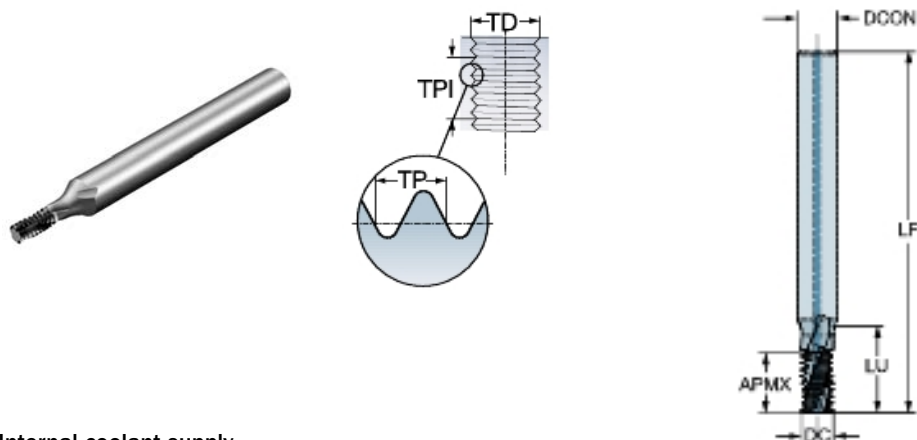
# CoroMill® Plura solid carbide end mill for thread milling

Cylindrical shank

Thread form: MJ



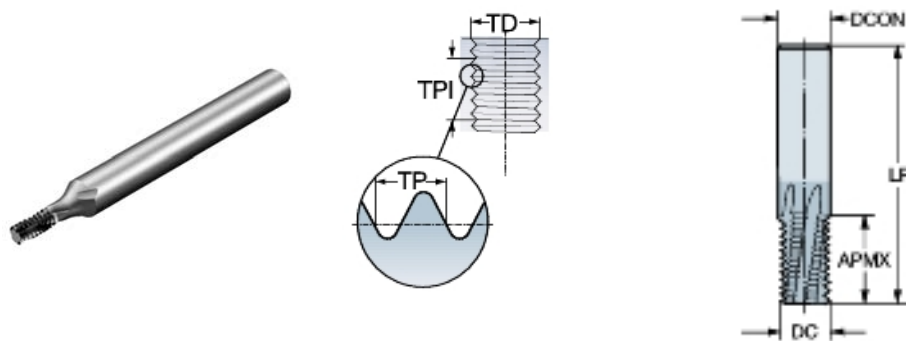
CNSC 1  
 CXSC 1  
 FHA 27°  
 BSG COROMANT  
 TCDCON h8



## Internal coolant supply

							s Dimensions, mm			
FTDZ	TP	DC	CZC <sub>MS</sub>	APMX	ZEFP	Ordering code	1630	DCON	LF	(BAR)
MJ8X1.25	1.25	9.50	8.0	12.50	4	R217.14C063125AC12H	☆	8.00	58.00	20
MJ10X1.5	1.50	7.50	8.0	15.00	4	R217.14C075150AC15H	☆	8.00	58.00	20
MJ12X1.75	1.75	6.30	10.0	19.25	4	R217.14C095175AC19H	☆	10.00	72.00	20

CNSC 0  
 CXSC 0  
 FHA 27°  
 BSG COROMANT  
 TCDCON h8



## No coolant

							s Dimensions, mm			
FTDZ	TP	DC	CZC <sub>MS</sub>	APMX	ZEFP	Ordering code	1630	DCON	LF	
MJ4X0.7	0.70	3.00	6.0	6.30	3	R217.13-030070AC6H	☆	6.00	54.00	
MJ5X0.8	0.80	3.90	6.0	8.00	3	R217.13-039080AC8H	☆	6.00	54.00	
MJ6X1	1.00	4.80	6.0	9.00	3	R217.13-048100AC9H	☆	6.00	54.00	



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# Milling with large engagement, metric values



ISO P		Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	GC1130	
MC No.	CMC No.					Max chip thickness, $h_{ex}$ mm	
						0.05-0.1-0.2	
						Cutting speed $v_c$ , m/min	
		<b>Steel</b>					
		<b>Unalloyed</b>					
P1.1.Z.AN	01.1	C = 0.1-0.25%	1500	125	0.25	375-340-280	
P1.2.Z.AN	01.2	C = 0.25-0.55%	1600	150	0.25	335-305-250	
P1.3.Z.AN	01.3	C = 0.55-0.80%	1700	170	0.25	320-290-235	
P1.3.Z.AN	01.4		1800	210	0.25	275-250-205	
P1.3.Z.HT	01.5		2000	300	0.25	205-185-155	
		<b>Low alloyed (alloying elements ≤ 5%)</b>					
P2.1.Z.AN	02.1	Non-hardened	1700	175	0.25	265-240-195	
P2.5.Z.HT	02.2	Hardened and tempered	1900	300	0.25	170-155-130	
		<b>High alloyed (alloying elements &gt; 5%)</b>					
P3.0.Z.AN	03.11	Annealed	1950	200	0.25	180-165-135	
P3.1.Z.AN	03.13	Hardened tool steel	2150	200	0.25	150-135-110	
P3.0.Z.HT	03.21		2900	300	0.25	130-120-100	
P3.0.Z.HT	03.22		3100	380	0.25	80-75-60	
		<b>Castings</b>					
P1.5.C.UT	06.1	Unalloyed	1400	150	0.25	245-220-180	
P2.6.C.UT	06.2	Low alloyed (alloying elements ≤ 5%)	1600	200	0.25	195-175-145	
P3.0.C.UT	06.3	High alloyed (alloying elements > 5%)	1950	200	0.25	140-130-105	
ISO M		Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	GC1130	
MC No.	CMC No.					Max chip thickness, $h_{ex}$ mm	
						0.05 - 0.1 - 0.2	
						Cutting speed $v_c$ , m/min	
		<b>Stainless steel</b>					
		<b>Ferritic/martensitic</b>					
P5.0.Z.AN	05.11	Non-hardened	1800	200	0.21	255-225-180	
P5.0.Z.PH	05.12	PH-hardened	2850	330	0.21	180-160-130	
P5.0.Z.HT	05.13	Hardened	2350	330	0.21	185-165-135	
		<b>Austenitic</b>					
M1.0.Z.AQ	05.21	Non-hardened	1950	200	0.21	250-225-180	
M1.0.Z.PH	05.22	PH-hardened	2850	330	0.21	170-155-125	
M2.0.Z.AQ	05.23	Super austenitic	2250	200		-	
		<b>Austenitic-ferritic (Duplex)</b>					
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	0.21	205-185-145	
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	0.21	175-155-125	
		<b>Stainless steel - Cast</b>					
		<b>Ferritic/martensitic</b>					
P5.0.C.UT	15.11	Non-hardened	1700	200	0.25	225-200-160	
P5.0.C.PH	15.12	PH-hardened	2450	330	0.25	155-140-115	
P5.0.C.HT	15.13	Hardened	2150	330	0.25	170-155-120	
M1.0.C.UT	15.21	Non hardened	1800	200	0.25	235-210-170	
M1.0C.PH	15.22	PH-hardened	2450	330	0.25	160-140-115	
M2.0.C.AQ	15.23	Super austenitic	2150	200		-	
		<b>Austenitic-ferritic (Duplex)</b>					
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	0.25	195-175-140	
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	0.25	160-145-115	
ISO N		Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	GC1130	
MC No.	CMC No.					Max chip thickness, $h_{ex}$ mm	
						0.1 - 0.15 - 0.2	
						Cutting speed $v_c$ , m/min	
		<b>Aluminium alloys</b>					
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	400	60		990-910-850	
N1.2.Z.AG	30.12	Wrought or wrought and aged	650	100		890-820-760	
		<b>Aluminium alloys</b>					
N1.3.C.UT	30.21	Cast, non-aging	600	75	0.25	990-910-850	
N1.3.C.AG	30.22	Cast or cast and aged	700	90	0.25	990-920-850	
N1.1.Z.UT	30.3	Al >99%	350	30		990-920-850	
		<b>Aluminium alloys</b>					
N1.4.C.NS	30.41	Cast, 13-15% Si	700	130		395-370-340	
N1.4.C.NS	30.42	Cast, 16-22% Si	700	130		300-275-255	
		<b>Copper and copper alloys</b>					
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	550	110	0.25	495-460-425	
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	550	90		495-460-425	
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	1350	100	0.25	345-320-295	



**Conditions:**  
Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

## Milling with large engagement, metric values



ISO S	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	GC1130	
							Max chip thickness, $h_{ex}$ mm	
							0.1 - 0.15 - 0.2	
							Cutting speed $v_c$ , m/min	
S1.0.U.AN S1.0.U.AG	20.11 20.12	<b>Heat resistant super alloys</b>		2400 2500	200 280	0.25 0.25	60 - 55 - 50 45 - 40 - 37	
		<b>Iron base</b>						
		Annealed or solution treated						
		Aged or solution treated and aged						
S2.0.Z.AN S2.0.Z.AG	20.21 20.22	<b>Nickel base</b>		2650 2900	250 350	0.25 0.25	60 - 55 - 50 36 - 33 - 30	
		<b>Iron base</b>						
		Annealed or solution treated						
		Aged or solution treated and aged						
S2.0.C.NS	20.24	Cast or cast and aged		3000	320	0.25	45 - 40 - 36	
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31 20.32 20.33	<b>Cobalt alloys</b>		2700 3000 3100	200 300 320	0.25 0.25 0.25	25 - 22 - 20 18 - 16 - 14 16 - 14 - 13	
		<b>Titanium alloys<sup>1)</sup></b>						
		Commercial pure (99,5% Ti)						
S4.1.Z.UT	23.1	$\alpha$ , near $\alpha$ and $\alpha + \beta$ alloys, annealed		1300	400	0.23	125 - 115 - 105	
S4.2.Z.AN	23.21	$\alpha + \beta$ alloys in aged cond., $\beta$ alloys, annealed or aged		1400	950	0.23	55 - 50 - 45	
S4.3.Z.AG	23.22			1400	1050	0.23	45 - 40 - 36	

ISO H	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	GC1130	
							Max chip thickness, $h_{ex}$ mm	
							0.07-0.12-0.2	
							Cutting speed $v_c$ , m/min	
H1.3.Z.HA	04.1	<b>Extra hard steel</b>		4200	59 HRC	0.25	40-36-29	
		<b>Chilled cast iron</b>						
		Hardened and tempered						
H2.0.C.UT	10.1	Cast or cast and aged		2250	400	0.28	75-70-55	

**Conditions:**

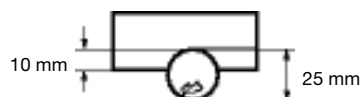
Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

## Milling with small engagement, metric values



ISO P		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			N/mm <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ mm	
							0.05-0.1-0.2	
		Cutting speed $v_c$ , m/min						
		<b>Steel</b>						
		<b>Unalloyed</b>						
P1.1.Z.AN	01.1	C = 0.1-0.25%	1500	125	0.25	405-395-380		
P1.2.Z.AN	01.2	C = 0.25-0.55%	1600	150	0.25	365-355-340		
P1.3.Z.AN	01.3	C = 0.55-0.80%	1700	170	0.25	345-335-320		
P1.3.Z.AN	01.4		1800	210	0.25	300-295-280		
P1.3.Z.HT	01.5		2000	300	0.25	220-220-210		
		<b>Low-alloy (alloying elements ≤5%)</b>						
P2.1.Z.AN	02.1	Non-hardened	1700	175	0.25	285-280-265		
P2.5.Z.HT	02.2	Hardened and tempered	1900	300	0.25	185-180-175		
		<b>High-alloy (alloying elements &gt;5%)</b>						
P3.0.Z.AN	03.11	Annealed	1950	200	0.25	195-190-185		
P3.1.Z.AN	03.13	Hardened tool steel	2150	200	0.25	160-160-150		
P3.0.Z.HT	03.21		2900	300	0.25	140-140-135		
P3.0.Z.HT	03.22		3100	380	0.25	90-85-85		
		<b>Castings</b>						
P1.5.C.UT	06.1	Unalloyed	1400	150	0.25	265-255-245		
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	1600	200	0.25	210-205-195		
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	1950	200	0.25	155-150-145		
ISO M		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			N/mm <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ mm	
							0.05 - 0.1 - 0.2	
		Cutting speed $v_c$ , m/min						
		<b>Stainless steel</b>						
		<b>Ferritic/martensitic</b>						
P5.0.Z.AN	05.11	Non-hardened	1800	200	0.21	275-270-255		
P5.0.Z.PH	05.12	PH-hardened	2850	330	0.21	195-190-180		
P5.0.Z.HT	05.13	Hardened	2350	330	0.21	200-195-190		
		<b>Austenitic</b>						
M1.0.Z.AQ	05.21	Non-hardened	1950	200	0.21	270-265-255		
M1.0.Z.PH	05.22	PH-hardened	2850	330	0.21	190-185-175		
M2.0.Z.AQ	05.23	Super austenitic	2250	200		-		
		<b>Austenitic-ferritic (Duplex)</b>						
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2000	230	0.21	225-220-210		
M3.2.Z.AQ	05.52	Weldable < 0.05%C	2450	260	0.21	190-185-175		
		<b>Stainless steel - Cast</b>						
		<b>Ferritic/martensitic</b>						
P5.0.C.UT	15.11	Non-hardened	1700	200	0.25	245-240-230		
P5.0.C.PH	15.12	PH-hardened	2450	330	0.25	170-170-160		
P5.0.C.HT	15.13	Hardened	2150	330	0.25	185-180-175		
		<b>Austenitic</b>						
M1.0.C.UT	15.21	Austenitic	1800	200	0.25	260-250-240		
M1.0.C.PH	15.22	PH-hardened	2450	330	0.25	170-170-160		
M2.0.C.AQ	15.23	Super austenitic	2150	200		-		
		<b>Austenitic-ferritic (Duplex)</b>						
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	1800	230	0.25	215-205-195		
M3.2.C.AQ	15.52	Weldable < 0.05%C	2250	260	0.25	175-170-165		
ISO N		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			N/mm <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ mm	
							0.1-0.15-0.2	
		Cutting speed $v_c$ , m/min						
		<b>Aluminium alloys</b>						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	400	60		1100-1100-1050		
N1.2.Z.AG	30.12	Wrought or wrought and aged	650	100		1000-980-970		
		<b>Aluminium alloys</b>						
N1.3.C.UT	30.21	Cast, non-aging	600	75	0.25	1100-1100-1050		
N1.3.C.AG	30.22	Cast or cast and aged	700	90	0.25	1100-1100-1100		
N1.1.Z.UT	30.3	Al >99%	350	30		1100-1100-1100		
		<b>Aluminium alloys</b>						
N1.4.C.NS	30.41	Cast, 13-15% Si	700	130		445-440-430		
	30.42	Cast, 16-22% Si	700	130		335-330-325		
		<b>Copper and copper alloys</b>						
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	550	110	0.25	560-550-540		
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	550	90		560-550-540		
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	1350	100	0.25	390-380-375		

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

**Conditions:**

Side milling, cutter dia. 25 mm. Working engagement 10 mm.

## Milling with small engagement, metric values



ISO S	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	GC1130	
							Max chip thickness, $h_{ex}$ mm	
							0.05-0.15-0.2	
							Cutting speed $v_c$ , m/min	
S1.0.U.AN S1.0.U.AG	20.11 20.12	<b>Heat resistant super alloys</b>		2400 2500	200 280	0.25 0.25	70-70-70 55-50-50	
		<b>Iron base</b>						
S2.0.Z.AN S2.0.Z.AG S2.0.C.NS	20.21 20.22 20.24	<b>Nickel base</b>		2650 2900 3000	250 350 320	0.25 0.25 0.25	70-65-65 45-40-40 55-50-50	
		Annealed or solution treated						
		Aged or solution treated and aged						
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31 20.32 20.33	<b>Cobalt alloys</b>		2700 3000 3100	200 300 320	0.25 0.25 0.25	30-29-28 21-20-20 20-19-18	
		Annealed or solution treated						
		Solution treated and aged						
S4.1.Z.UT S4.2.Z.AN S4.3.Z.AG	23.1 23.21 23.22	<b>Titanium alloys<sup>1)</sup></b>		1300 1400 1400	Rm <sup>1)</sup> 400 950 1050	0.23 0.23 0.23	150-145-140 65-65-65 55-50-50	
		Commercial pure (99,5% Ti)						
		$\alpha$ , near $\alpha$ and $\alpha + \beta$ alloys, annealed						
		$\alpha + \beta$ alloys in aged cond., $\beta$ alloys, annealed or aged						

ISO H	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	GC1130	
							Max chip thickness, $h_{ex}$ mm	
							0.07-0.12-0.2	
							Cutting speed $v_c$ , m/min	
H1.3.Z.HA	04.1	<b>Extra hard steel</b> Hardened and tempered		4200	59 HRC	0.25	45-45-45	
H2.0.C.UT	10.1	<b>Chilled cast iron</b> Cast or cast and aged		2250	400	0.28	90-85-85	

1) 45-60° entering angle. Positive cutting geometry and coolant should be used.

**Conditions:**

Side milling, cutter dia. 25 mm. Working engagement 10 mm.

# Milling with large engagement, inch values



ISO P		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			lbs/in <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ inch	
							.002-.004-.008	
					Cutting speed $v_c$ , ft/min			
		<b>Steel</b>						
		<b>Unalloyed</b>						
P1.1.Z.AN	01.1	C = 0.10 - 0.25%	216,500	125	0.25	1250-1100-910		
P1.2.Z.AN	01.2	C = 0.25 - 0.55%	233,000	150	0.25	1100-1000-820		
P1.3.Z.AN	01.3	C = 0.55 - 0.80%	247,000	170	0.25	1050-940-770		
P1.3.Z.AN	01.4		260,500	210	0.25	910-820-670		
P1.3.Z.HT	01.5		291,500	300	0.25	670-610-500		
		<b>Low alloyed (alloying elements ≤ 5%)</b>						
P2.1.Z.AN	02.1	Non-hardened	246,500	175	0.25	860-780-640		
P2.5.Z.HT	02.2	Hardened and tempered	278,500	300	0.25	560-510-415		
		<b>High alloyed (alloying elements &gt; 5%)</b>						
P3.0.Z.AN	03.11	Annealed	282,000	200	0.25	590-540-440		
P3.1.Z.AN	03.13	Hardened tool steel	311,000	200	0.25	490-445-360		
P3.0.Z.HT	03.21		420,000	300	0.25	430-390-315		
P3.0.Z.HT	03.22		448,500	380	0.25	270-245-200		
		<b>Castings</b>						
P1.5.C.UT	06.1	Unalloyed	204,000	150	0.25	800-720-590		
P2.6.C.UT	06.2	Low alloyed (alloying elements ≤ 5%)	230,500	200	0.25	630-570-470		
P3.0.C.UT	06.3	High alloyed (alloying elements > 5%)	283,500	200	0.25	465-420-345		
ISO M		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			lbs/in <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ inch	
							.002-.004-.008	
					Cutting speed $v_c$ , ft/min			
		<b>Stainless steel</b>						
		<b>Ferritic/martensitic</b>						
P5.0.Z.AN	05.11	Non-hardened	262,000	200	0.21	830-740-590		
P5.0.Z.PH	05.12	PH-hardened	411,500	330	0.21	590-520-415		
P5.0.Z.HT	05.13	Hardened	340,000	330	0.21	610-540-430		
		<b>Austenitic</b>						
M1.0.Z.AQ	05.21	Non-hardened	285,000	200	0.21	820-730-580		
M1.0.Z.PH	05.22	PH-hardened	414,000	330	0.21	560-500-400		
M2.0.Z.AQ	05.23	Super austenitic	328,000	200		-		
		<b>Austenitic-ferritic (Duplex)</b>						
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	286,500	230	0.21	670-600-475		
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	0.21	570-510-405		
		<b>Stainless steel - Cast</b>						
		<b>Ferritic/martensitic</b>						
P5.0.C.UT	15.11	Non-hardened	246,500	200	0.25	740-660-520		
P5.0C.PH	15.12	PH-hardened	354,500	330	0.25	520-460-365		
P5.0.C.HT	15.13	Hardened	311,000	330	0.25	560-500-395		
M1.0.C.UT	15.21	Non hardened	261,000	200	0.25	780-690-550		
M1.0C.PH	15.22	PH-hardened	356,000	330	0.25	520-460-365		
M2.0.C.AQ	15.23	Super austenitic	310,500	200		-		
		<b>Austenitic-ferritic (Duplex)</b>						
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	258,000	230	0.25	640-570-450		
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,500	260	0.25	530-475-375		
ISO N		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			lbs/in <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ inch	
							.004-.006-.008	
					Cutting speed $v_c$ , ft/min			
		<b>Aluminium alloys</b>						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	58,000	60		3200-3000-2750		
N1.2.Z.AG	30.12	Wrought or wrought and aged	94,500	100		2900-2700-2500		
		<b>Aluminium alloys</b>						
N1.3.C.UT	30.21	Cast, non-aging	87,000	75	0.25	3250-3000-2750		
N1.3.C.AG	30.22	Cast or cast and aged	101,500	90	0.25	3250-3000-2750		
		<b>Aluminium alloys</b>						
N1.1.Z.UT	30.3	Al >99%	50,500	30		3250-3000-2800		
		<b>Aluminium alloys</b>						
N1.4.C.NS	30.41	Cast, 13-15% Si	101,500	130		1300-1200-1100		
N1.4.C.NS	30.42	Cast, 16-22% Si	101,500	130		970-900-830		
		<b>Copper and copper alloys</b>						
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	79,500	110	0.25	1600-1500-1400		
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	80,000	90		1600-1500-1400		
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	196,000	100	0.25	1150-1050-970		

4.000 inch  
(100mm)



5.000 inch  
(125mm)

**Conditions:**

Cutter, dia. 5.000 inch (125 mm) Working engagement 4.000 inch (100 mm)

## Milling with large engagement, inch values



ISO S	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	GC1130	
							Max chip thickness, $h_{ax}$ inch	Cutting speed $v_c$ , ft/min
				lbs/in <sup>2</sup>	HB		.004-.006-.008	
			<b>Heat resistant super alloys</b>					
			<b>Iron base</b>					
S1.0.U.AN	20.11		Annealed or solution treated	348,000	200	0.25	200-180-160	
S1.0.U.AG	20.12		Aged or solution treated and aged	359,000	280	0.25	150-135-120	
			<b>Nickel base</b>					
S2.0.Z.AN	20.21		Annealed or solution treated	383,000	250	0.25	190-170-155	
S2.0.Z.AG	20.22		Aged or solution treated and aged	420,500	350	0.25	120-105-95	
S2.0.C.NS	20.24		Cast or cast and aged	436,500	320	0.25	150-140-120	
			<b>Cobalt alloys</b>					
S3.0.Z.AN	20.31		Annealed or solution treated	391,500	200	0.25	80-70-65	
S3.0.Z.AG	20.32		Solution treated and aged	432,000	300	0.25	55-50-45	
S3.0.C.NS	20.33		Cast or cast and aged	450,500	320	0.25	50-45-40	
			<b>Titanium alloys<sup>1)</sup></b>		<b>Rm<sup>2)</sup></b>			
S4.1.Z.UT	23.1		Commercial pure (99,5% Ti)	188,500	400	0.23	415-375-340	
S4.2.Z.AN	23.21		$\alpha$ , near $\alpha$ and $\alpha + \beta$ alloys, annealed	203,000	950	0.23	185-165-150	
S4.3.Z.AG	23.22		$\alpha + \beta$ alloys in aged cond., $\beta$ alloys, annealed or aged	203,000	1050	0.23	145-130-120	
ISO H	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	GC1130	
				lbs/in <sup>2</sup>	HB		Max chip thickness, $h_{ax}$ inch	Cutting speed $v_c$ , ft/min
							.003-.005-.008	
			<b>Extra hard steel</b>					
H1.3.Z.HA	04.1		Hardened and tempered	606,500	59 HRC	0.25	130-115-95	
			<b>Chilled cast iron</b>					
H2.0.C.UT	10.1		Cast or cast and aged	326,500	400	0.28	250-215-175	

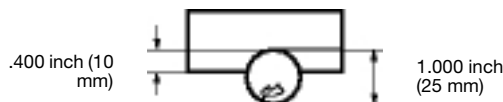
4.000 inch  
(100mm)5.000 inch  
(125mm)**Conditions:**

Cutter, dia. 5.000 inch (125 mm) Working engagement 4.000 inch (100 mm)

# Milling with small engagement, inch values



ISO P		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			lbs/in <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ inch	
							.002-.004-.008	
		Cutting speed $v_c$ , ft/min						
		<b>Steel</b>						
		<b>Unalloyed</b>						
P1.1.Z.AN	01.1	C = 0.10 -0.25%	216,500	125	0.25	1350-1300-1250		
P1.2.Z.AN	01.2	C = 0.25-0.55%	233,000	150	0.25	1200-1150-1100		
P1.3.Z.AN	01.3	C = 0.55-0.80%	247,000	170	0.25	1150-1100-1050		
P1.3.Z.AN	01.4		260,500	210	0.25	980-960-920		
P1.3.Z.HT	01.5		291,500	300	0.25	730-710-680		
		<b>Low-alloy (alloying elements ≤5%)</b>						
P2.1.Z.AN	02.1	Non-hardened	246,500	175	0.25	930-910-870		
P2.5.Z.HT	02.2	Hardened and tempered	278,500	300	0.25	610-590-570		
		<b>High-alloy (alloying elements &gt;5%)</b>						
P3.0.Z.AN	03.11	Annealed	282,000	200	0.25	640-630-600		
P3.1.Z.AN	03.13	Hardened tool steel	311,000	200	0.25	530-520-495		
P3.0.Z.HT	03.21		420,000	300	0.25	465-455-435		
P3.0.Z.HT	03.22		448,500	380	0.25	290-285-270		
		<b>Castings</b>						
P1.5.C.UT	06.1	Unalloyed	204,000	150	0.25	860-840-810		
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	230,500	200	0.25	690-670-640		
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	283,500	200	0.25	500-490-470		
ISO M		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			lbs/in <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ inch	
							.002-.004-.008	
		Cutting speed $v_c$ , ft/min						
		<b>Stainless steel</b>						
		<b>Ferritic/martensitic</b>						
P5.0.Z.AN	05.11	Non-hardened	262,000	200	0.21	910-890-840		
P5.0.Z.PH	05.12	PH-hardened	411,500	330	0.21	640-630-590		
P5.0.Z.HT	05.13	Hardened	340,000	330	0.21	660-650-610		
		<b>Austenitic</b>						
M1.0.Z.AQ	05.21	Non-hardened	285,000	200	0.21	890-870-830		
M1.0.Z.PH	05.22	PH-hardened	414,000	330	0.21	620-600-570		
M2.0.Z.AQ	05.23	Super austenitic	328,000	200		-		
		<b>Austenitic-ferritic (Duplex)</b>						
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	286,500	230	0.21	740-720-680		
M3.2.Z.AQ	05.52	Weldable < 0.05%C	356,500	260	0.21	620-610-580		
		<b>Stainless steel - Cast</b>						
		<b>Ferritic/martensitic</b>						
P5.0.C.UT	15.11	Non-hardened	246,500	200	0.25	810-790-750		
P5.0c.PH	15.12	PH-hardened	354,500	330	0.25	560-550-520		
P5.0.C.HT	15.13	Hardened	311,000	330	0.25	610-590-570		
		<b>Austenitic</b>						
M1.0.C.UT	15.21	Austenitic	261,000	200	0.25	850-830-790		
M1.0c.PH	15.22	PH-hardened	356,000	330	0.25	570-550-520		
M2.0.C.AQ	15.23	Super austenitic	310,500	200		-		
		<b>Austenitic-ferritic (Duplex)</b>						
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	258,000	230	0.25	700-680-650		
M3.2.C.AQ	15.52	Weldable < 0.05%C	326,500	260	0.25	580-560-540		
ISO N		Material	Specific cutting force $k_{c1}$	Hardness Brinell		GC1130		
MC No.	CMC No.			lbs/in <sup>2</sup>	HB	mc	Max chip thickness, $h_{ex}$ inch	
							.004-.006-.008	
		Cutting speed $v_c$ , ft/min						
		<b>Aluminium alloys</b>						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	58,000	60		3650-3600-3500		
N1.2.Z.AG	30.12	Wrought or wrought and aged	94,500	100		3300-3200-3150		
		<b>Aluminium alloys</b>						
N1.3.C.UT	30.21	Cast, non-aging	87,000	75	0.25	3650-3600-3500		
N1.3.C.AG	30.22	Cast or cast and aged	101,500	90	0.25	3650-3600-3500		
N1.1.Z.UT	30.3	Al >99%	50,500	30		3650-3600-3550		
		<b>Aluminium alloys</b>						
N1.4.C.NS	30.41	Cast, 13-15% Si	101,500	130		1450-1450-1400		
	30.42	Cast, 16-22% Si	101,500	130		1100-1100-1050		
		<b>Copper and copper alloys</b>						
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	79,500	110	0.25	1850-1800-1750		
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	80,000	90		1850-1800-1750		
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	196,000	100	0.25	1250-1250-1250		



**Conditions:**  
Side milling, cutter dia. 1.000 inch (25 mm). Working engagement .400 inch (10 mm).

## Milling with small engagement, inch values



ISO S	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ lbs/in <sup>2</sup>	Hardness Brinell HB	mc	GC1130	
							Max chip thickness, $h_{ex}$ inch	
							.002-.006-.008	
							Cutting speed $v_c$ , ft/min	
S1.0.U.AN S1.0.U.AG	20.11 20.12		<b>Heat resistant super alloys</b>					
			<b>Iron base</b>					
			Annealed or solution treated	348,000	200	0.25	235-225-220	
			Aged or solution treated and aged	359,000	280	0.25	175-170-165	
S2.0.Z.AN S2.0.Z.AG S2.0.C.NS	20.21 20.22 20.24		<b>Nickel base</b>					
			<b>Iron base</b>					
			Annealed or solution treated	383,000	250	0.25	225-215-210	
			Aged or solution treated and aged	420,500	350	0.25	140-135-130	
			Cast or cast and aged	436,500	320	0.25	175-165-160	
S3.0.Z.AN S3.0.Z.AG S3.0.C.NS	20.31 20.32 20.33		<b>Cobalt alloys</b>					
			<b>Iron base</b>					
			Annealed or solution treated	391,500	200	0.25	100-95-90	
			Solution treated and aged	432,000	300	0.25	70-65-65	
			Cast or cast and aged	450,500	320	0.25	65-60-60	
S4.1.Z.UT S4.2.Z.AN S4.3.Z.AG	23.1 23.21 23.22		<b>Titanium alloys<sup>1)</sup></b>		<b>Rm<sup>2)</sup></b>			
			<b>Iron base</b>					
			Commercial pure (99,5% Ti)	188,500	400	0.23	495-470-460	
			$\alpha$ , near $\alpha$ and $\alpha + \beta$ alloys, annealed	203,000	950	0.23	220-210-205	
			$\alpha + \beta$ alloys in aged cond., $\beta$ alloys, annealed or aged	203,000	1050	0.23	170-165-160	

ISO H	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ lbs/in <sup>2</sup>	Hardness Brinell HB	mc	GC1130	
							Max chip thickness, $h_{ex}$ inch	
							.003-.005-.008	
							Cutting speed $v_c$ , ft/min	
H1.3.Z.HA	04.1		<b>Extra hard steel</b>					
			<b>Chilled cast iron</b>					
			Hardened and tempered	606,500	59 HRC	0.25	155-150-140	
H2.0.C.UT	10.1		Cast or cast and aged	326,500	400	0.28	295-285-270	

**Conditions:**

Side milling, cutter dia. 1.000 inch (25 mm). Working engagement .400 inch (10 mm).



# Cutting speed recommendations

CoroMill® Plura



High feed side milling									
			$a_e = 0.1 \times DC$			$a_e = 0.4 \times DC$			
			$a_p = 2.0 \times DC$			$a_p = 1.0 \times DC$			
ISO	MC No.	Material	HB	$f_z^*$	$v_c$ m/min	$v_c$ feet/min	$f_z^*$	$v_c$ m/min	$v_c$ feet/min
S	S2.0.Z.AG	Nickel based alloys	350	A	35	115	B	20	66
	S2.0.Z.AN		250	C	50	164	D	30	98
	S4.3.Z.AN	Titanium based alloys	330	E	110	361	F	44	144
	S4.4.Z.AN		410	E	50	164	F	30	98

\*For feed recommendations, compare the  $f_z$  code with the corresponding code on page .

# Cutting feed recommendations

CoroMill® Plura

Metric version

DC	mm	4.000	4.765	5.000	6.000	6.350	8.000	9.525	10.000	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	25.400	31.750	32.000
$f_z$ code																					
A	mm	0.020	0.024	0.025	0.030	0.032	0.040	0.048	0.050	0.060	0.064	0.070	0.079	0.080	0.090	0.095	0.100	0.125			
B	mm	0.013	0.015	0.016	0.019	0.020	0.025	0.030	0.031	0.038	0.040	0.044	0.050	0.050	0.056	0.060	0.063	0.078			
C	mm	0.026	0.031	0.033	0.039	0.041	0.052	0.062	0.065	0.078	0.083	0.091	0.103	0.104	0.117	0.124	0.130	0.163			
D	mm	0.016	0.019	0.020	0.024	0.026	0.033	0.039	0.041	0.049	0.052	0.057	0.064	0.065	0.073	0.077	0.081	0.102			
E	mm	0.028	0.033	0.034	0.041	0.044	0.055	0.065	0.069	0.083	0.087	0.096	0.109	0.111	0.124	0.131	0.138	0.172	0.175	0.218	0.220
F	mm	0.015	0.018	0.019	0.023	0.024	0.030	0.036	0.038	0.045	0.048	0.053	0.060	0.060	0.068	0.071	0.075	0.094	0.095	0.119	0.120

Inch version

DC	inch	.1570	.1880	.1970	.2360	.2500	.3150	.3750	.3940	.4720	.5000	.5610	.6250	.6300	.7090	.7500	.7870	.9840	1.000	1.250	1.260
$f_z$ code																					
A	inch	.0008	.0009	.0010	.0012	.0013	.0016	.0019	.0020	.0024	.0025	.0028	.0031	.0031	.0035	.0038	.0039	.0049			
B	inch	.0005	.0006	.0006	.0007	.0008	.0010	.0012	.0012	.0015	.0016	.0017	.0020	.0020	.0022	.0023	.0025	.0031			
C	inch	.0010	.0012	.0013	.0015	.0016	.0020	.0024	.0026	.0031	.0033	.0036	.0041	.0041	.0046	.0049	.0051	.0064			
D	inch	.0006	.0008	.0008	.0010	.0010	.0013	.0015	.0016	.0019	.0020	.0022	.0025	.0026	.0029	.0030	.0032	.0040			
E	inch	.0011	.0013	.0014	.0016	.0017	.0022	.0026	.0027	.0032	.0034	.0038	.0043	.0043	.0049	.0052	.0054	.0068	.0069	.0086	.0087
F	inch	.0006	.0007	.0007	.0009	.0009	.0012	.0014	.0015	.0018	.0019	.0021	.0023	.0024	.0027	.0028	.0030	.0037	.0038	.0047	.0047

## Profile milling tools



## CoroMill® 600

Ordering code		Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm		Feed per tooth, $f_z$ inch/tooth		Max chip thickness, $h_{ex}$ inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
600-1045E-ML	M	0.2	(0.05-0.35)	0.2	(0.05-0.35)	.008	(.002-.014)	.008	(.002-.014)
600-1045M-ML	M	0.2	(0.05-0.35)	0.2	(0.05-0.35)	.008	(.002-.014)	.008	(.002-.014)
600-1252E-ML	M	0.25	(0.05-0.35)	0.25	(0.05-0.35)	.010	(.002-.014)	.010	(.002-.014)
600-1252M-ML	M	0.25	(0.05-0.35)	0.25	(0.05-0.35)	.010	(.002-.014)	.010	(.002-.014)
600R-1045M-MM	M	0.35	(0.15-0.55)	0.35	(0.15-0.55)	.014	(.006-.022)	.014	(.006-.022)
600R-1252M-MM	M	0.35	(0.15-0.55)	0.35	(0.15-0.55)	.014	(.006-.022)	.014	(.006-.022)


## CoroMill® 300

Ordering code		Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm		Feed per tooth, $f_z$ inch/tooth		Max chip thickness, $h_{ex}$ inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
R300-0517E-PM	P	0.08	(0.05-0.12)	0.08	(0.05-0.12)	.003	(.002-.005)	.003	(.002-.005)
R300-0720E-PM	P	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0724E-PM	P	0.1	(0.05-0.15)	0.1	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0828E-PL	P	0.11	(0.05-0.15)	0.11	(0.05-0.15)	.004	(.002-.006)	.004	(.002-.006)
R300-0828E-PM	P	0.13	(0.05-0.2)	0.13	(0.05-0.2)	.005	(.002-.008)	.005	(.002-.008)
R300-0828M-PH	P	0.15	(0.07-0.25)	0.15	(0.07-0.25)	.006	(.003-.010)	.006	(.003-.010)
R300-0828M-PM	P	0.13	(0.07-0.2)	0.13	(0.07-0.2)	.005	(.003-.008)	.005	(.003-.008)
R300-0932E-PM	P	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-0932M-PH	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-0932M-PM	P	0.15	(0.07-0.23)	0.13	(0.06-0.2)	.006	(.003-.009)	.005	(.002-.008)
R300-1032E-KL	K	0.21	(0.05-0.29)	0.13	(0.04-0.15)	.008	(.002-.011)	.005	(.002-.006)
R300-1032E-PL	P	0.15	(0.05-0.17)	0.13	(0.04-0.15)	.006	(.002-.007)	.005	(.002-.006)
R300-1032E-PM	P	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1032M-PH	P	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1032M-PM	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1240E-PL	P	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-1240E-PM	P	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1240M-KH	K	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1240M-PH	P	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1240M-PM	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1340E-PL	P	0.15	(0.05-0.23)	0.13	(0.04-0.2)	.006	(.002-.009)	.005	(.002-.008)
R300-1340E-PM	P	0.21	(0.05-0.29)	0.18	(0.04-0.25)	.008	(.002-.011)	.007	(.002-.010)
R300-1340M-PH	P	0.23	(0.07-0.35)	0.2	(0.06-0.3)	.009	(.003-.014)	.008	(.002-.012)
R300-1340M-PM	P	0.17	(0.07-0.29)	0.15	(0.06-0.25)	.007	(.003-.011)	.006	(.002-.010)
R300-1648E-PL	P	0.17	(0.05-0.23)	0.15	(0.04-0.2)	.007	(.002-.009)	.006	(.002-.008)
R300-1648E-PM	P	0.23	(0.05-0.35)	0.2	(0.04-0.3)	.009	(.002-.014)	.008	(.002-.012)
R300-1648M-PH	P	0.29	(0.07-0.46)	0.25	(0.06-0.4)	.011	(.003-.018)	.010	(.002-.016)
R300-1648M-PM	P	0.21	(0.07-0.29)	0.18	(0.06-0.25)	.008	(.003-.011)	.007	(.002-.010)
R300-2060E-MM	M	0.35	(0.06-0.57)	0.25	(0.04-0.4)	.014	(.002-.022)	.010	(.002-.016)
R300-2060E-PL	P	0.28	(0.06-0.35)	0.2	(0.04-0.25)	.011	(.002-.014)	.008	(.002-.010)
R300-2060E-PM	P	0.35	(0.06-0.57)	0.25	(0.04-0.4)	.014	(.002-.022)	.010	(.002-.016)
R300-2060M-PH	P	0.49	(0.07-0.78)	0.35	(0.05-0.55)	.019	(.003-.031)	.014	(.002-.022)
R300-2060M-PM	P	0.28	(0.07-0.42)	0.2	(0.05-0.3)	.011	(.003-.017)	.008	(.002-.012)
R300-2570E-PL	P	0.31	(0.06-0.4)	0.22	(0.04-0.28)	.012	(.002-.016)	.009	(.002-.011)
R300-2570M-PH	P	0.57	(0.07-0.85)	0.4	(0.05-0.6)	.022	(.003-.033)	.016	(.002-.024)
R300-2570M-PM	P	0.31	(0.07-0.47)	0.22	(0.05-0.33)	.012	(.003-.019)	.009	(.002-.013)

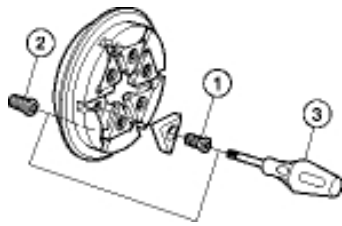
# Profile milling tools



CoroMill® 200

Ordering code		Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm		Feed per tooth, $f_z$ inch/tooth		Max chip thickness, $h_{ex}$ inch	
		Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)	Starting value	(min.- max.)
RCHT09T300-PL	P	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
RCHT10T3M0-PL	P	0.1	(0.08-0.15)	0.1	(0.08-0.15)	.004	(.003-.006)	.004	(.003-.006)
RCHT1204M0-PL	P	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RCHT130400-PL	P	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RCHT1606M0-PL	P	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RCHT190600-PL	P	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RCHT2006M0-PL	P	0.14	(0.08-0.21)	0.1	(0.06-0.15)	.006	(.003-.008)	.004	(.002-.006)
RCKT09T300-PH	P	0.25	(0.1-0.3)	0.25	(0.1-0.3)	.010	(.004-.012)	.010	(.004-.012)
RCKT09T300-PM	P	0.17	(0.1-0.2)	0.17	(0.1-0.2)	.007	(.004-.008)	.007	(.004-.008)
RCKT10T3M0-PH	P	0.25	(0.1-0.3)	0.25	(0.1-0.3)	.010	(.004-.012)	.010	(.004-.012)
RCKT10T3M0-PM	P	0.17	(0.1-0.2)	0.17	(0.1-0.2)	.007	(.004-.008)	.007	(.004-.008)
RCKT1204M0-PH	P	0.35	(0.1-0.42)	0.25	(0.07-0.3)	.014	(.004-.017)	.010	(.003-.012)
RCKT1204M0-PM	P	0.24	(0.1-0.28)	0.17	(0.07-0.2)	.009	(.004-.011)	.007	(.003-.008)
RCKT130400-PH	P	0.35	(0.1-0.42)	0.25	(0.07-0.3)	.014	(.004-.017)	.010	(.003-.012)
RCKT130400-PM	P	0.24	(0.1-0.28)	0.17	(0.07-0.2)	.009	(.004-.011)	.007	(.003-.008)
RCKT1606M0-PH	P	0.35	(0.1-0.42)	0.25	(0.07-0.3)	.014	(.004-.017)	.010	(.003-.012)
RCKT1606M0-PM	P	0.24	(0.1-0.28)	0.17	(0.07-0.2)	.009	(.004-.011)	.007	(.003-.008)
RCKT190600-PH	P	0.35	(0.1-0.42)	0.25	(0.07-0.3)	.014	(.004-.017)	.010	(.003-.012)
RCKT190600-PM	P	0.24	(0.1-0.28)	0.17	(0.07-0.2)	.009	(.004-.011)	.007	(.003-.008)
RCKT2006M0-PH	P	0.35	(0.1-0.42)	0.25	(0.07-0.3)	.014	(.004-.017)	.010	(.003-.012)
RCKT2006M0-PM	P	0.24	(0.1-0.28)	0.17	(0.07-0.2)	.009	(.004-.011)	.007	(.003-.008)

## CoroMill® 325



Ordering code	Spare parts	
	Insert screw	Mounting screw
325-06AP20-16M	5513 020-02	
325-12AA33-16M	5513 020-02	
325-12AP40-16M	5513 039-05	5513 039-05
325-12AP45-16M	5513 020-02	5513 039-02
325-12AQ40-16M	5513 039-05	5513 039-05
325-12BB40-16M	5513 039-05	5513 039-05
325-12CC52-16M	5513 020-02	5513 039-04
325-12CC52-16M-B	5513 020-02	
325-12CC52-16M-C	5513 020-02	
325-12DD40-16M	5513 039-05	5513 039-05
325-12DD50-16M	5513 020-02	5513 039-02
325-12EE32-16M	5513 039-05	5513 039-05
325-12RR45-16M	5513 020-02	5513 039-02
325-14GG42-16M	5513 020-02	
325-16CC50-16M	5513 020-02	5513 039-04
325-20CC52-16M	5513 039-05	5513 020-55
325-20EE54-16M	5513 020-02	

# Drilling



E

ENG

## Indexable drills

CoroDrill® 880 insert for drilling 53

Cutting data 54

B

C

D

E

F

G

H

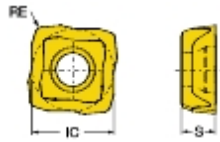
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## CoroDrill® 880 insert for drilling

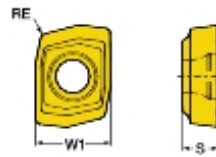
Central insert



880..C-LM



880-01..C-LM

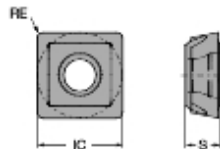


			N	Dimensions, mm, inch				
Medium feed	INSUC	Ordering code	NT34	S	RE	IC	W1	
				01C	C	880-01 02 03H-C-LM	★	2.20 .087
	02C	C	880-02 02 04H-C-LM	★	2.40 .094	0.40 .016	4.9 .193	
	03C	C	880-03 03 05H-C-LM	★	2.60 .102	0.50 .020	5.7 .224	
	04C	C	880-04 03 05H-C-LM	★	2.80 .110	0.50 .020	6.8 .268	
	05C	C	880-05 03 05H-C-LM	★	3.00 .118	0.50 .020	8.4 .331	
	06C	C	880-06 04 06H-C-LM	★	3.50 .138	0.60 .024	10.2 .402	
	07C	C	880-07 04 06H-C-LM	★	4.00 .157	0.60 .024	12.4 .486	
	08C	C	880-08 05 08H-C-LM	★	4.50 .177	0.80 .031	14.9 .585	
	09C	C	880-09 06 08H-C-LM	★	5.50 .217	0.80 .031	17.9 .705	

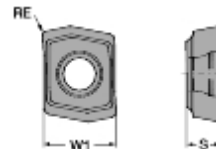
## Peripheral insert



880..P-MS



880-01..P-MS



			N	Dimensions, mm, inch				
Medium feed	INSUC	Ordering code	NT24	S	RE	IC	W1	
				01P	P	880-01 02 W04H-P-MS	★	2.20 .087
	02P	P	880-02 02 W05H-P-MS	★	2.40 .094	0.50 .020	5.1 .201	
	03P	P	880-03 03 W06H-P-MS	★	2.60 .102	0.60 .024	6.0 .236	
	04P	P	880-04 03 W07H-P-MS	★	2.80 .110	0.70 .028	7.4 .291	
	05P	P	880-05 03 W08H-P-MS	★	3.00 .118	0.80 .031	8.9 .350	
	06P	P	880-06 04 W08H-P-MS	★	3.50 .138	0.80 .031	10.7 .419	
	07P	P	880-07 04 W10H-P-MS	★	4.00 .157	1.00 .039	12.7 .498	
	08P	P	880-08 05 W10H-P-MS	★	4.50 .177	1.00 .039	15.5 .608	
	09P	P	880-09 06 W10H-P-MS	★	5.50 .217	1.00 .039	18.6 .732	



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# CoroDrill® 880



## Metric values

ISO	MC No.	Material	Hardness Brinell HB	Grade	Cutting speed (m/min)	Drill diameter DC mm	Geometry / Feed		
							Drill length 2-3xD	Drill length 4xD	Drill length 5xD
							-MS $f_n$ mm/rev.	-MS $f_n$ mm/rev.	-MS $f_n$ mm/rev.
N	N1.2.Z.AG (30.12)	Al. alloys Wrought or wrought and aged	30-150	N124	75-90	12.00-13.99	0.08-0.18	0.08-0.14	0.08-0.12
						14.00-16.49	0.08-0.18	0.08-0.14	0.08-0.12
						16.50-19.99	0.09-0.19	0.09-0.15	0.09-0.13
						20.00-23.99	0.10-0.20	0.10-0.16	0.10-0.13
						24.00-29.99	0.11-0.21	0.11-0.17	0.11-0.14
						30.00-35.99	0.12-0.23	0.12-0.18	0.12-0.15
						36.00-43.99	0.12-0.25	0.12-0.20	0.12-0.17
						44.00-52.99	0.12-0.28	0.12-0.22	0.12-0.19
						53.00-63.50	0.12-0.28	0.12-0.22	0.12-0.19
							N1.3.C.UT (30.21)	Cast. non aging	40-100
14.00-16.49	0.06-0.14	0.06-0.11	0.06-0.09						
16.50-19.99	0.06-0.15	0.06-0.12	0.06-0.10						
20.00-23.99	0.06-0.18	0.06-0.14	0.06-0.12						
24.00-29.99	0.10-0.20	0.10-0.16	0.10-0.13						
30.00-35.99	0.10-0.22	0.10-0.18	0.10-0.15						
36.00-43.99	0.10-0.24	0.10-0.19	0.10-0.16						
44.00-52.99	0.12-0.26	0.12-0.21	0.12-0.17						
53.00-63.50	0.12-0.26	0.12-0.21	0.12-0.17						
	N1.3.C.AG (30.22)	Cast or cast and aged	70-140	N124	250-600				
						14.00-16.49	0.06-0.15	0.06-0.12	0.06-0.09
						16.50-19.99	0.06-0.16	0.06-0.13	0.06-0.10
						20.00-23.99	0.06-0.18	0.06-0.14	0.06-0.12
						24.00-29.99	0.10-0.20	0.10-0.16	0.10-0.13
						30.00-35.99	0.10-0.22	0.10-0.18	0.10-0.15
						36.00-43.99	0.10-0.24	0.10-0.19	0.10-0.17
						44.00-52.99	0.12-0.26	0.12-0.21	0.12-0.19
						53.00-63.50	0.12-0.26	0.12-0.21	0.12-0.19
							N3.3.U.UT (33.1)	Copper and copper alloys	70-160
14.00-16.49	0.06-0.14	0.06-0.11	0.06-0.09						
16.50-19.99	0.06-0.15	0.06-0.12	0.06-0.10						
20.00-23.99	0.06-0.18	0.06-0.14	0.06-0.12						
24.00-29.99	0.10-0.20	0.10-0.16	0.10-0.13						
30.00-35.99	0.10-0.23	0.10-0.18	0.10-0.15						
36.00-43.99	0.10-0.25	0.10-0.20	0.10-0.17						
44.00-52.99	0.12-0.28	0.12-0.22	0.12-0.19						
53.00-63.50	0.12-0.28	0.12-0.22	0.12-0.19						
	N3.2.C.UT (33.2)	Brass and leaded alloys (Pb < 1%)	50-200	N124	180-240				
						14.00-16.49	0.06-0.14	0.06-0.11	0.06-0.09
						16.50-19.99	0.06-0.15	0.06-0.12	0.06-0.10
						20.00-23.99	0.06-0.18	0.06-0.14	0.06-0.12
						24.00-29.99	0.10-0.20	0.10-0.16	0.10-0.13
						30.00-35.99	0.10-0.23	0.10-0.18	0.10-0.15
						36.00-43.99	0.10-0.25	0.10-0.20	0.10-0.17
						44.00-52.99	0.12-0.28	0.12-0.22	0.12-0.19
						53.00-63.50	0.12-0.28	0.12-0.22	0.12-0.19

First choice for central grade is N134

## CoroDrill® 880



## Inch values

ISO	MC No.	Material	Hardness Brinell HB	Grade	Cutting speed (ft/min)	Drill diameter DC inch	Geometry / Feed		
							Drill length 2-3xD	Drill length 4xD	Drill length 5xD
							-MS $f_n$ inch/rev.	-MS $f_n$ inch/rev.	-MS $f_n$ inch/rev.
N	N1.2.Z.AG (30.12)	Al. alloys Wrought or wrought and aged	30-150	N124	245-295	.472-.550	.003-.007	.003-.006	.003-.005
						.551-.649	.003-.007	.003-.006	.003-.005
						.650-.787	.004-.007	.004-.006	.004-.005
						.788-.944	.004-.008	.004-.006	.004-.005
						.945-1.181	.004-.008	.004-.007	.004-.006
						1.182-1.417	.005-.009	.005-.007	.005-.006
						1.418-1.732	.005-.010	.005-.008	.005-.007
						1.733-2.086	.005-.011	.005-.009	.005-.007
	2.087-2.500	.005-.011	.005-.009	.005-.007					
	N1.3.C.UT (30.21)	Cast. non aging	40-100	N124	820-1315	.472-.550	.002-.006	.002-.004	.002-.004
						.551-.649	.002-.006	.002-.004	.002-.004
						.650-.787	.002-.006	.002-.005	.002-.004
						.788-.944	.002-.007	.002-.006	.002-.005
						.945-1.181	.004-.008	.004-.006	.004-.005
						1.182-1.417	.004-.009	.004-.007	.004-.006
						1.418-1.732	.004-.009	.004-.007	.004-.006
						1.733-2.086	.005-.010	.005-.008	.005-.007
	2.087-2.500	.005-.010	.005-.008	.005-.007					
	N1.3.C.AG (30.22)	Cast or cast and aged	70-140	N124	820-1970	.472-.550	.002-.006	.002-.005	.002-.004
						.551-.649	.002-.006	.002-.005	.002-.004
.650-.787						.002-.006	.002-.005	.002-.004	
.788-.944						.002-.007	.002-.006	.002-.005	
.945-1.181						.004-.008	.004-.006	.004-.005	
1.182-1.417						.004-.009	.004-.007	.004-.006	
1.418-1.732						.005-.009	.004-.007	.004-.007	
1.733-2.086						.005-.010	.005-.008	.005-.007	
2.087-2.500	.005-.010	.005-.008	.005-.007						
N3.3.U.UT (33.1)	Copper and copper alloys	70-160	N124	820-1315	.472-.550	.002-.006	.002-.004	.002-.004	
					.551-.649	.002-.006	.002-.004	.002-.004	
					.650-.787	.002-.006	.002-.005	.002-.004	
					.788-.944	.002-.007	.002-.006	.002-.005	
					.945-1.181	.004-.008	.004-.006	.004-.005	
					1.182-1.417	.004-.009	.004-.007	.004-.006	
					1.418-1.732	.004-.010	.004-.008	.004-.007	
					1.733-2.086	.005-.011	.005-.009	.005-.007	
2.087-2.500	.005-.011	.005-.009	.005-.007						
N3.2.C.UT (33.2)	Brass and leaded alloys (Pb < 1%)	50-200	N124	590-790	.472-.550	.002-.006	.002-.004	.002-.004	
					.551-.649	.002-.006	.002-.004	.002-.004	
					.650-.787	.002-.006	.002-.005	.002-.004	
					.788-.944	.002-.007	.002-.006	.002-.005	
					.945-1.181	.004-.008	.004-.006	.004-.005	
					1.182-1.417	.004-.009	.004-.007	.004-.006	
					1.418-1.732	.004-.010	.004-.008	.004-.007	
					1.733-2.086	.005-.011	.005-.009	.005-.007	
2.087-2.500	.005-.011	.005-.009	.005-.007						

First choice for central grade is N134



# Tapping F

## Cutting taps

CoroTap™ 200 cutting tap with spiral point	57-59
CoroTap™ 300 cutting tap with spiral flutes	60-70

<b>Cutting data</b>	71
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B

C

D

E

F

G

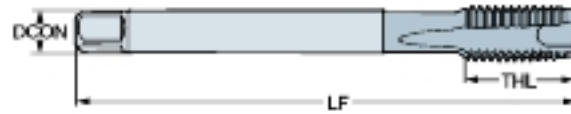
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## CoroTap™ 200 cutting tap with spiral point



THCHT B  
 THBTP 1  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



Thread form: Metric

						s Dimensions, mm, inch						
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D15	DCON	TD	LF	THL	NOF	BSG
M 2	0.40	8.00	2.80 x 2.10	6HX	T200-SM100DA-M2	☆	2.8	2.00	45.0	8.0	2	DIN 371
		.315					.110	.079	1.772	.315		
M 2.5	0.45	9.00	2.80 x 2.10	6HX	T200-SM100DA-M2.5	☆	2.8	2.50	50.0	9.0	2	DIN 371
		.354					.110	.098	1.969	.354		
M 3	0.50	10.00	3.50 x 2.70	6HX	T200-SM100DA-M3	☆	3.5	3.00	56.0	10.0	2	DIN 371
		.394					.138	.118	2.205	.394		
M 3.5	0.60	12.00	4.00 x 3.00	6HX	T200-SM100DA-M3.5	☆	4.0	3.50	56.0	12.0	3	DIN 371
		.472					.157	.138	2.205	.472		
M 4	0.70	13.00	4.50 x 3.40	6HX	T200-SM100DA-M4	☆	4.5	4.00	63.0	13.0	3	DIN 371
		.512					.177	.157	2.480	.512		
M 5	0.80	16.00	4.50 x 3.40	6HX	T200-SM100DA-M5	☆	4.5	5.00	70.0	16.0	3	DIN 371
		.630					.177	.197	2.756	.630		
M 6	1.00	23.00	6.00 x 4.90	6HX	T200-SM100DA-M6	☆	6.0	6.00	80.0	15.0	3	DIN 371
		.906					.236	.236	3.150	.591		
M 8	1.25	29.50	6.00 x 4.90	6HX	T200-SM100DA-M8	☆	6.0	8.00	90.0	18.0	3	DIN 371
		1.161					.236	.315	3.543	.709		
M 10	1.50	33.50	10.00 x 8.00	6HX	T200-SM101DA-M10	☆	10.0	10.00	100.0	20.0	3	DIN 371
		1.319					.394	.394	3.937	.787		
M 12	1.75	83.00	8.00 x 6.20	6HX	T200-SM101DA-M12	☆	8.0	12.00	110.0	23.0	4	DIN 376
		3.268					.315	.472	4.331	.906		
M 16	2.00	68.00	12.00 x 9.00	6HX	T200-SM101DA-M16	☆	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					.472	.630	4.331	.984		
M 20	2.50	95.00	16.00 x 12.00	6HX	T200-SM101DA-M20	☆	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					.630	.787	5.512	1.181		



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# CoroTap™ 200 cutting tap with spiral point



THCHT B  
 THBTP 1  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



Thread form: Metric fine

						s Dimensions, mm, inch						
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D15	DCON	TD	LF	THL	NOF	BSG
MF 6x0.75	0.75	23.00 .906	6.00 x 4.90	6HX	T200-SM100DB-M6X075	☆	6.0	6.00	80.0	15.0	3	DIN 371
MF 8x0.75	0.75	29.50 1.161	8.00 x 6.20	6HX	T200-SM100DB-M8X075	☆	8.0	8.00	90.0	18.0	3	DIN 371
MF 8x1	1.00	29.50 1.161	8.00 x 6.20	6HX	T200-SM100DB-M8X100	☆	8.0	8.00	90.0	18.0	3	DIN 371
MF 10x1	1.00	33.50 1.319	10.00 x 8.00	6HX	T200-SM100DB-M10X100	☆	10.0	10.00	100.0	20.0	3	DIN 371
MF 12x1	1.00	73.00 2.874	9.00 x 7.00	6HX	T200-SM100DB-M12X100	☆	9.0	12.00	100.0	21.0	4	DIN 374
MF 12x1.5	1.50	73.00 2.874	9.00 x 7.00	6HX	T200-SM100DB-M12X150	☆	9.0	12.00	100.0	21.0	4	DIN 374
MF 14x1.5	1.50	71.00 2.795	11.00 x 9.00	6HX	T200-SM100DB-M14X150	☆	11.0	14.00	100.0	21.0	4	DIN 374

THCHT B  
 THBTP 1  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



Thread form: MJ

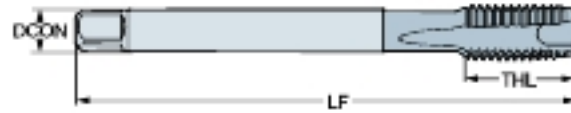
						s Dimensions, mm, inch						
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D15	DCON	TD	LF	THL	NOF	BSG
MJ4	0.70	13.00 .512	4.50 x 3.40	4H	T200-SM100DC-MJ4	☆	4.5	4.00	63.0	13.0	3	DIN 371
MJ5	0.80	16.00 .630	4.50 x 3.40	4H	T200-SM100DC-MJ5	☆	4.5	5.00	70.0	16.0	3	DIN 371
MJ6	1.00	23.00 .906	6.00 x 4.90	4H	T200-SM100DC-MJ6	☆	6.0	6.00	80.0	15.0	3	DIN 371
MJ8	1.25	29.50	6.00 x 4.90	4H	T200-SM100DC-MJ8	☆	6.0	8.00	90.0	18.0	3	DIN 371



## CoroTap™ 200 cutting tap with spiral point



THCHT B  
 THBTP 1  
 CNCS 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



Thread form: UNJF

					S							
					Dimensions, mm, inch							
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D115	DCON	TD	LF	THL	NOF	BSG
UNJF #10-32	32.00	16.00	6.00 x 4.90	3B	T200-SM100DI-10-32	☆	6.0	4.83	70.0	16.0	3	DIN 2184-1
		.630					.236	.190	2.756	.630		
UNJF 1/4-28	28.00	25.00	7.00 x 5.50	3B	T200-SM100DI-1/4	☆	7.0	6.35	80.0	15.0	3	DIN 2184-1
		.984					.276	.250	3.150	.591		
UNJF 5/16-24	24.00	29.50	8.00 x 6.20	3B	T200-SM100DI-5/16	☆	8.0	7.94	90.0	18.0	3	DIN 2184-1
		1.161					.315	.313	3.543	.709		
UNJF 3/8-24	24.00	33.50	10.00 x 8.00	3B	T200-SM100DI-3/8	☆	10.0	9.53	100.0	20.0	3	DIN 2184-1
		1.319					.394	.375	3.937	.787		



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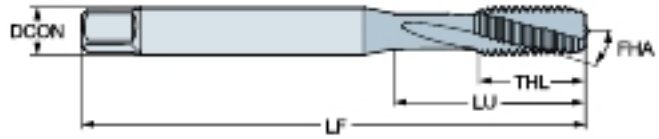


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# CoroTap™ 300 cutting tap with spiral flutes



THCHT C  
 THBTP 1  
 FHA 10°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING UNCOAT



Thread form: Metric

						s Dimensions, mm, inch						
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	DCON	TD	LF	THL	NOF	BSG	
M 3	0.50	8.00	3.50 x 2.70	6HX	T300-SD100DA-M3	3.5	3.00	56.0	8.0	3	DIN 371	
		.315				.138	.118	2.205	.315			
M 4	0.70	10.50	4.50 x 3.40	6HX	T300-SD100DA-M4	4.5	4.00	63.0	10.5	3	DIN 371	
		.413				.177	.157	2.480	.413			
M 5	0.80	13.00	6.00 x 4.90	6HX	T300-SD100DA-M5	6.0	5.00	70.0	13.0	3	DIN 371	
		.512				.236	.197	2.756	.512			
M 6	1.00	16.00	6.00 x 4.90	6HX	T300-SD100DA-M6	6.0	6.00	80.0	16.0	3	DIN 371	
		.630				.236	.236	3.150	.630			
M 8	1.25	20.50	8.00 x 6.20	6HX	T300-SD100DA-M8	8.0	8.00	90.0	20.5	3	DIN 371	
		.807				.315	.315	3.543	.807			
M 10	1.50	25.50	10.00 x 8.00	6HX	T300-SD100DA-M10	10.0	10.00	100.0	25.5	3	DIN 371	
		1.004				.394	.394	3.937	1.004			
M 12	1.75	30.50	12.00 x 9.00	6HX	T300-SD100DA-M12	12.0	12.00	110.0	30.5	4	DIN 371	
		1.201				.472	.472	4.331	1.201			
M 16	2.00	39.50	16.00 x 12.00	6HX	T300-SD100DA-M16	16.0	16.00	110.0	39.5	4	DIN 371	
		1.555				.630	.630	4.331	1.555			



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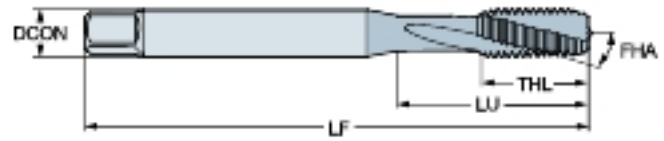


84

## CoroTap™ 300 cutting tap with spiral flutes



THCHT C  
 THBTP 1  
 FHA 10°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD TiN



## Thread form: Metric

TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	Dimensions, mm, inch			NOF	BSG				
						P	N	S						
M 3	0.50	8.00	3.50 x 2.70	6HX	T300-SD101DA-M3	D125	D125	D125	DCON	TD	LF	THL		
		.315				☆	☆	☆	3.5	3.00	56.0	8.0	3	DIN 371
M 4	0.70	10.50	4.50 x 3.40	6HX	T300-SD101DA-M4	☆	☆	☆	.138	.118	2.205	.315		
		.413							4.5	4.00	63.0	10.5	3	DIN 371
M 5	0.80	13.00	6.00 x 4.90	6HX	T300-SD101DA-M5	☆	☆	☆	.177	.157	2.480	.413		
		.512							6.0	5.00	70.0	13.0	3	DIN 371
M 6	1.00	16.00	6.00 x 4.90	6HX	T300-SD101DA-M6	☆	☆	☆	.236	.197	2.756	.512		
		.630							6.0	6.00	80.0	16.0	3	DIN 371
M 8	1.25	20.50	8.00 x 6.20	6HX	T300-SD101DA-M8	☆	☆	☆	.236	.236	3.150	.630		
		.807							8.0	8.00	90.0	20.5	3	DIN 371
M 10	1.50	25.50	10.00 x 8.00	6HX	T300-SD101DA-M10	☆	☆	☆	.315	.315	3.543	.807		
		1.004							10.0	10.00	100.0	25.5	3	DIN 371
M 12	1.75	30.50	12.00 x 9.00	6HX	T300-SD101DA-M12	☆	☆	☆	.394	.394	3.937	1.004		
		1.201							12.0	12.00	110.0	30.5	4	DIN 371
M 16	2.00	39.50	16.00 x 12.00	6HX	T300-SD101DA-M16	☆	☆	☆	.472	.472	4.331	1.201		
		1.555							16.0	16.00	110.0	39.5	4	DIN 371
									.630	.630	4.331	1.555		



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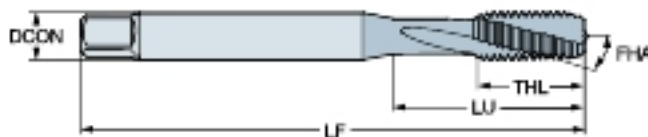


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# CoroTap™ 300 cutting tap with spiral flutes



THCHT C  
 THBTP 1  
 FHA 10°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING UNCOAT



Thread form: Metric fine

						S	Dimensions, mm, inch					
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D150	DCON	TD	LF	THL	NOF	BSG
MF 8x1	1.00	20.00	8.00 x 6.20	6HX	T300-SD100DB-M8X100	★	8.0	8.00	90.0	20.0	3	DIN 374
		.787				★	.315	.315	3.543	.787		
MF 10x1	1.00	24.00	10.00 x 8.00	6HX	T300-SD100DB-M10X100	★	10.0	10.00	90.0	24.0	3	DIN 374
		.945				★	.394	.394	3.543	.945		
MF 10x1.25	1.25	24.50	10.00 x 8.00	6HX	T300-SD100DB-M10X125	★	10.0	10.00	100.0	24.5	3	DIN 374
		.965				★	.394	.394	3.937	.965		
MF 12x1	1.00	28.00	12.00 x 9.00	6HX	T300-SD100DB-M12X100	★	12.0	12.00	100.0	28.0	4	DIN 374
		1.102				★	.472	.472	3.937	1.102		
MF 12x1.25	1.25	28.50	12.00 x 9.00	6HX	T300-SD100DB-M12X125	★	12.0	12.00	100.0	28.5	4	DIN 374
		1.122				★	.472	.472	3.937	1.122		
MF 12x1.5	1.50	29.50	12.00 x 9.00	6HX	T300-SD100DB-M12X150	★	12.0	12.00	100.0	29.5	4	DIN 374
		1.161				★	.472	.472	3.937	1.161		

THCHT C  
 THBTP 1  
 FHA 10°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING UNCOAT



Thread form: MJ

						P	N	S	Dimensions, mm, inch					
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D150	D150	D150	DCON	TD	LF	THL	NOF	BSG
MJ 3	0.50	8.00	3.50 x 2.70	4H	T300-SD100DC-MJ3	★	★	★	3.5	3.00	56.0	8.0	3	DIN 371
		.315				★	★	★	.138	.118	2.205	.315		
MJ 4	0.70	10.50	4.50 x 3.40	4H	T300-SD100DC-MJ4	★	★	★	4.5	4.00	63.0	10.5	3	DIN 371
		.413				★	★	★	.177	.157	2.480	.413		
MJ 5	0.80	13.00	6.00 x 4.90	4H	T300-SD100DC-MJ5	★	★	★	6.0	5.00	70.0	13.0	3	DIN 371
		.512				★	★	★	.236	.197	2.756	.512		
MJ 6	1.00	15.50	6.00 x 4.90	4H	T300-SD100DC-MJ6	★	★	★	6.0	6.00	80.0	15.5	3	DIN 371
		.610				★	★	★	.236	.236	3.150	.610		



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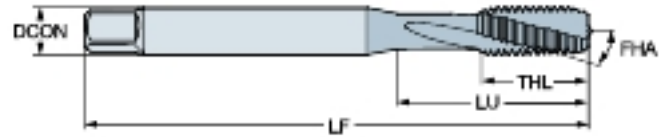


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## CoroTap™ 300 cutting tap with spiral flutes



THCHT C  
 THBTP 1  
 FHA 10°  
 CNCS 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING UNCOAT



Thread form: UNC

						s Dimensions, mm, inch						
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D150	DCON	TD	LF	THL	NOF	BSG
UNC #3-48	48.00	9.00	2.80 x 2.10	2B	T300-SD100DE-3-48	☆	2.8	2.51	50.0	9.0	3	DIN 2184-1
		.354					.110	.099	1.969	.354		
UNC #2-56	56.00	9.00	2.80 x 2.10	2B	T300-SD100DE-2-56	☆	2.8	2.18	45.0	9.0	3	DIN 2184-1
		.354					.110	.086	1.772	.354		
UNC #4-40	40.00	10.00	3.50 x 2.70	2B	T300-SD100DE-4-40	☆	3.5	2.84	56.0	10.0	3	DIN 2184-1
		.394					.138	.112	2.205	.394		
UNC #6-32	32.00	12.00	4.00 x 3.00	2B	T300-SD100DE-6-32	☆	4.0	3.51	56.0	12.0	3	DIN 2184-1
		.472					.157	.138	2.205	.472		
UNC #8-32	32.00	13.00	4.50 x 3.40	2B	T300-SD100DE-8-32	☆	4.5	4.17	63.0	13.0	3	DIN 2184-1
		.512					.177	.164	2.480	.512		
UNC #10-24	24.00	16.00	6.00 x 4.90	2B	T300-SD100DE-10-24	☆	6.0	4.83	70.0	16.0	3	DIN 2184-1
		.630					.236	.190	2.756	.630		
UNC 1/4-20	20.00	25.00	7.00 x 5.50	2B	T300-SD100DE-1/4	☆	7.0	6.35	80.0	15.0	3	DIN 2184-1
		.984					.276	.250	3.150	.591		
UNC 5/16-18	18.00	29.50	8.00 x 6.20	2B	T300-SD100DE-5/16	☆	8.0	7.94	90.0	18.0	3	DIN 2184-1
		1.161					.315	.313	3.543	.709		
UNC 3/8-16	16.00	33.50	10.00 x 8.00	2B	T300-SD100DE-3/8	☆	10.0	9.53	100.0	20.0	4	DIN 2184-1
		1.319					.394	.375	3.937	.787		



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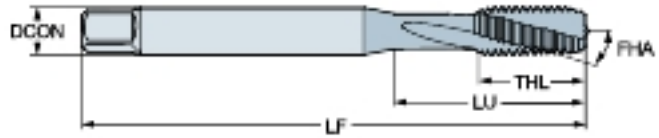
84



# CoroTap™ 300 cutting tap with spiral flutes



B	THCHT	C
	THBTP	1
	ULDR	1.5
	FHA	10°
	CNSC	0
	CXSC	0
	SUBSTRATE	HSS-E-PM
	COATING	UNCOAT



Thread form: UNF

						s Dimensions, mm, inch						
						Ordering code	D <small>CON</small>	TD	LF	THL	NOF	BSG
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR								
UNF #6-40	40.00	12.00	4.00 x 3.00	3B	T300-SD100DF-6-40	☆	4.0	3.51	56.0	12.0	3	DIN 2184-1
		.472					.157	.138	2.205	.472		
UNF #8-36	36.00	42.00	4.50 x 3.40	3B	T300-SD100DF-8-36	☆	4.5	4.17	63.0	13.0	3	DIN 2184-1
		1.654					.177	.164	2.480	.512		
UNF #10-32	32.00	16.00	6.00 x 4.90	3B	T300-SD100DF-10-32	☆	6.0	4.83	70.0	16.0	3	DIN 2184-1
		.630					.236	.190	2.756	.630		
UNF #12-28	28.00	23.00	6.00 x 4.90	3B	T300-SD100DF-12-28	☆	6.0	5.49	80.0	15.0	3	DIN 2184-1
		.906					.236	.216	3.150	.591		
UNF 1/4-28	28.00	25.00	7.00 x 5.50	3B	T300-SD100DF-1/4	☆	7.0	6.35	80.0	15.0	3	DIN 2184-1
		.984					.276	.250	3.150	.591		
UNF 5/16-24	24.00	29.50	8.00 x 6.20	3B	T300-SD100DF-5/16	☆	8.0	7.94	90.0	18.0	3	DIN 2184-1
		1.161					.315	.313	3.543	.709		
UNF 3/8-24	24.00	33.50	10.00 x 8.00	3B	T300-SD100DF-3/8	☆	10.0	9.53	100.0	20.0	4	DIN 2184-1
		1.319					.394	.375	3.937	.787		

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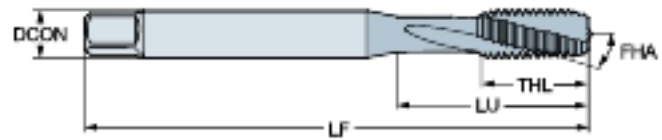
I



## CoroTap™ 300 cutting tap with spiral flutes



THCHT C  
 THBTP 1  
 FHA 10°  
 CNCS 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING UNCOAT



Thread form: UNJC

						s Dimensions, mm, inch						
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D150	DCON	TD	LF	THL	NOF	BSG
UNJC #10-24	24.00	13.50	6.00 x 4.90	3B	T300-SD100DH-10-24	☆	6.0	4.83	70.0	13.5	3	DIN 2184-1
		.531					.236	.190	2.756	.531		
UNJC 1/4-20	20.00	17.50	7.00 x 5.50	3B	T300-SD100DH-1/4	☆	7.0	6.35	80.0	17.5	3	DIN 2184-1
		.689					.276	.250	3.150	.689		
UNJC 3/8-16	16.00	25.00	10.00 x 8.00	3B	T300-SD100DH-3/8	☆	10.0	9.53	100.0	25.0	3	DIN 2184-1
		.984					.394	.375	3.937	.984		
UNJC 5/16-18	18.00	21.00	8.00 x 6.20	3B	T300-SD100DH-5/16	☆	8.0	7.94	90.0	21.0	3	DIN 2184-1
		.827					.315	.313	3.543	.827		
UNJC #4-40	40.00	8.00	3.50 x 2.70	3B	T300-SD100DH-4-40	☆	3.5	2.84	56.0	8.0	3	DIN 2184-1
		.315					.138	.112	2.205	.315		
UNJC #6-32	32.00	10.00	4.00 x 3.00	3B	T300-SD100DH-6-32	☆	4.0	3.51	56.0	10.0	3	DIN 2184-1
		.394					.157	.138	2.205	.394		
UNJC #8-32	32.00	11.00	4.50 x 3.40	3B	T300-SD100DH-8-32	☆	4.5	4.17	63.0	11.0	3	DIN 2184-1
		.433					.177	.164	2.480	.433		



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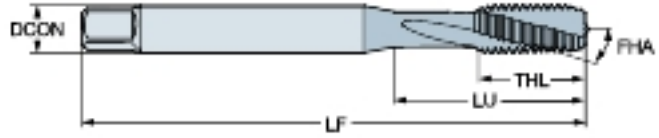


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# CoroTap™ 300 cutting tap with spiral flutes



B	THCHT	C
	THBTP	1
	FHA	10°
	CNSC	0
	CXSC	0
	SUBSTRATE	HSS-E-PM
	COATING	UNCOAT



Thread form: UNJF

						s Dimensions, mm, inch						
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR	Ordering code	Di	DCON	TD	LF	THL	NOF	BSG
UNJF #6-40	40.00	9.50	4.00 x 3.00	3B	T300-SD100DI-6-40	☆	4.0	3.51	56.0	9.5	3	DIN 2184-1
		.374					.157	.138	2.205	.374		
UNJF #10-32	32.00	12.50	6.00 x 4.90	3B	T300-SD100DI-10-32	☆	6.0	4.83	70.0	12.5	3	DIN 2184-1
		.492					.236	.190	2.756	.492		
UNJF 1/4-28	28.00	16.00	7.00 x 5.50	3B	T300-SD100DI-1/4	☆	7.0	6.35	80.0	16.0	3	DIN 2184-1
		.630					.276	.250	3.150	.630		
UNJF 5/16-24	24.00	20.00	8.00 x 6.20	3B	T300-SD100DI-5/16	☆	8.0	7.94	90.0	20.0	3	DIN 2184-1
		.787					.315	.313	3.543	.787		
UNJF 3/8-24	24.00	23.00	10.00 x 8.00	3B	T300-SD100DI-3/8	☆	10.0	9.53	100.0	23.0	3	DIN 2184-1
		.906					.394	.375	3.937	.906		

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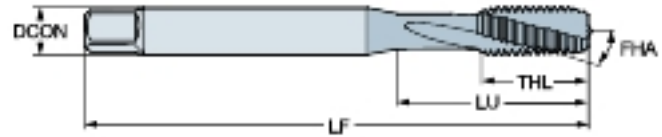
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## CoroTap™ 300 cutting tap with spiral flutes



THCHT C  
 THBTP 1  
 FHA 15°  
 CNCS 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



Thread form: Metric

						s	Dimensions, mm, inch					
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D15	DCON	TD	LF	THL	NOF	BSG
M 2	0.40	8.00	2.80 x 2.10	6HX	T300-SM100DA-M2	☆	2.8	2.00	45.0	8.0	3	DIN 371
		.315					.110	.079	1.772	.315		
M 2.5	0.45	30.00	2.80 x 2.10	6HX	T300-SM100DA-M2.5	☆	2.8	2.50	50.0	9.0	3	DIN 371
		1.181					.110	.098	1.969	.354		
M 3	0.50	10.00	3.50 x 2.70	6HX	T300-SM100DA-M3	☆	3.5	3.00	56.0	10.0	3	DIN 371
		.394					.138	.118	2.205	.394		
M 3.5	0.60	12.00	4.00 x 3.00	6HX	T300-SM100DA-M3.5	☆	4.0	3.50	56.0	12.0	3	DIN 371
		.472					.157	.138	2.205	.472		
M 4	0.70	13.00	4.50 x 3.40	6HX	T300-SM100DA-M4	☆	4.5	4.00	63.0	13.0	3	DIN 371
		.512					.177	.157	2.480	.512		
M 5	0.80	16.00	6.00 x 4.90	6HX	T300-SM100DA-M5	☆	6.0	5.00	70.0	16.0	3	DIN 371
		.630					.236	.197	2.756	.630		
M 6	1.00	23.00	6.00 x 4.90	6HX	T300-SM100DA-M6	☆	6.0	6.00	80.0	15.0	3	DIN 371
		.906					.236	.236	3.150	.591		
M 8	1.25	29.50	8.00 x 6.20	6HX	T300-SM100DA-M8	☆	8.0	8.00	90.0	18.0	3	DIN 371
		1.161					.315	.315	3.543	.709		
M 10	1.50	33.50	10.00 x 8.00	6HX	T300-SM101DA-M10	☆	10.0	10.00	100.0	20.0	3	DIN 371
		1.319					.394	.394	3.937	.787		
M 12	1.75	83.00	9.00 x 7.10	6HX	T300-SM101DA-M12	☆	9.0	12.00	110.0	23.0	4	DIN 376
		3.268					.354	.472	4.331	.906		
M 16	2.00	68.00	12.00 x 9.00	6HX	T300-SM101DA-M16	☆	12.0	16.00	110.0	25.0	4	DIN 376
		2.677					.472	.630	4.331	.984		
M 20	2.50	95.00	16.00 x 12.00	6HX	T300-SM101DA-M20	☆	16.0	20.00	140.0	30.0	4	DIN 376
		3.740					.630	.787	5.512	1.181		



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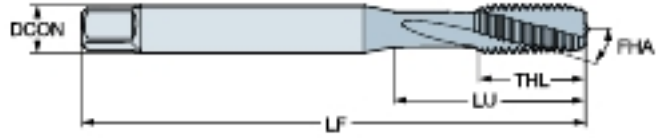


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# CoroTap™ 300 cutting tap with spiral flutes



THCHT C  
 THBTP 1  
 FHA 15°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



Thread form: Metric fine

					s Dimensions, mm, inch							
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	DN15	DCON	TD	LF	THL	NOF	BSG
MF 6x0.75	0.75	23.00	6.00 x 4.90	6HX	T300-SM100DB-M6X075	☆	6.0	6.00	23.0	15.0	3	DIN 371
		.906					.236	.236	.906	.591		
MF 8x0.75	0.75	29.50	8.00 x 6.20	6HX	T300-SM100DB-M8X075	☆	8.0	8.00	29.5	18.0	3	DIN 371
		1.161					.315	.315	1.161	.709		
MF 8x1	1.00	29.50	8.00 x 6.20	6HX	T300-SM100DB-M8X100	☆	8.0	8.00	29.5	18.0	3	DIN 371
		1.161					.315	.315	1.161	.709		
MF 10x1	1.00	33.50	10.00 x 8.00	6HX	T300-SM100DB-M10X100	☆	10.0	10.00	33.5	20.0	3	DIN 371
		1.319					.394	.394	1.319	.787		
MF 12x1	1.00	73.00	9.00 x 7.00	6HX	T300-SM100DB-M12X100	☆	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					.354	.472	3.937	.827		
MF 12x1.5	1.50	73.00	9.00 x 7.00	6HX	T300-SM100DB-M12X150	☆	9.0	12.00	100.0	21.0	4	DIN 374
		2.874					.354	.472	3.937	.827		
MF 14x1.5	1.50	71.00	11.00 x 9.00	6HX	T300-SM100DB-M14X150	☆	11.0	14.00	100.0	21.0	4	DIN 374
		2.795					.433	.551	3.937	.827		



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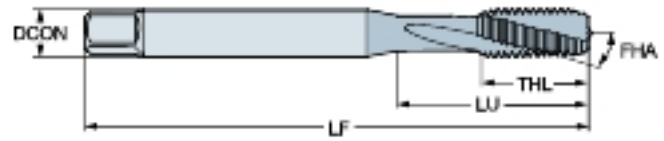


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## CoroTap™ 300 cutting tap with spiral flutes



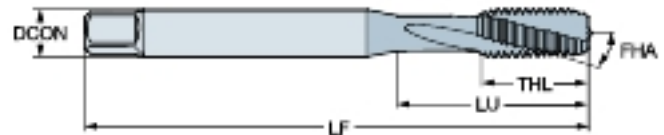
THCHT C  
 THBTP 1  
 FHA 15°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



## Thread form: MJ

						s Dimensions, mm, inch						
TDZ	TP	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D115	DCON	TD	LF	THL	NOF	BSG
MJ4	0.70	13.00	4.50 x 3.40	4H	T300-SM100DC-MJ4	☆	4.5	4.00	63.0	13.0	3	DIN 371
		.512					.177	.157	2.480	.512		
MJ5	0.80	16.00	6.00 x 4.90	4H	T300-SM100DC-MJ5	☆	6.0	5.00	70.0	16.0	3	DIN 371
		.630					.236	.197	2.756	.630		
MJ6	1.00	23.00	6.00 x 4.90	4H	T300-SM100DC-MJ6	☆	6.0	6.00	80.0	15.0	3	DIN 371
		.906					.236	.236	3.150	.591		
MJ8	1.25	29.50	8.00 x 6.20	4H	T300-SM100DC-MJ8	☆	8.0	8.00	100.0	18.0	3	DIN 371
		1.161					.315	.315	3.937	.709		

THCHT C  
 THBTP 1  
 FHA 15°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



## Thread form: UNJF

						s Dimensions, mm, inch						
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR	Ordering code	D115	DCON	TD	LF	THL	NOF	BSG
UNJF #10-32	32.00	16.00	6.00 x 4.90	3B	T300-SM100DI-10-32	☆	6.0	4.83	70.0	16.0	3	DIN 2184-1
		.630					.236	.190	2.756	.630		
UNJF 1/4-28	28.00	25.00	7.00 x 5.50	3B	T300-SM100DI-1/4	☆	7.0	6.35	80.0	15.0	3	DIN 2184-1
		.984					.276	.250	3.150	.591		
UNJF 5/16-24	24.00	29.50	8.00 x 6.20	3B	T300-SM100DI-5/16	☆	8.0	7.94	90.0	18.0	3	DIN 2184-1
		1.161					.315	.313	3.543	.709		
UNJF 3/8-24	24.00	33.50	10.00 x 8.00	3B	T300-SM100DI-3/8	☆	10.0	9.53	100.0	20.0	3	DIN 2184-1
		1.319					.394	.375	3.937	.787		



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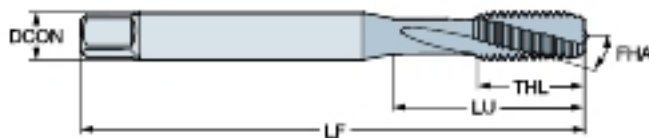
84

# CoroTap™ 300 cutting tap with spiral flutes



Insert Taps

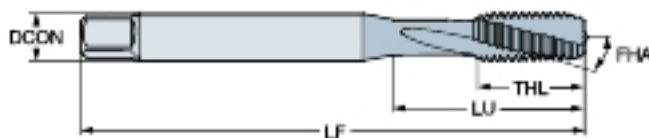
THCHT C  
 THBTP 1  
 FHA 15°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING PVD AlCrN



Thread form: EGUNF

						S	Dimensions, mm, inch					
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR	Ordering code		D15	DCON	TD	LF	THL	NOF
EGUNF #10-32	32.00	16.00	6.00 x 4.90	3B	T300-SM100DS-10-32	☆	6.0	5.94	70.0	16.0	3	DIN 2184-1
		.630					.236	.234	2.756	.630		
EGUNJF 1/4-28	28.00	25.00	7.00 x 5.50	3B	T300-SM100DS-1/4	☆	7.0	7.60	80.0	15.0	3	DIN 2184-1
		.984					.276	.299	3.150	.591		

THCHT C  
 THBTP 1  
 FHA 10°  
 CNSC 0  
 CXSC 0  
 SUBSTRATE HSS-E-PM  
 COATING UNCOAT



Thread form: EGUNJF

						S	Dimensions, mm, inch					
TDZ	TPI	LU	CZC <sub>MS</sub>	TCTR	Ordering code		D15	DCON	TD	LF	THL	NOF
EGUNJF #10-32	32.00	12.50	6.00 x 4.90	3B	T300-SD100DZ-10-32	☆	6.0	5.94	70.0	12.5	3	DIN 2184-1
		.492					.236	.234	2.756	.492		
EGUNJF 1/4-28	28.00	16.00	7.00 x 5.50	3B	T300-SD100DZ-1/4	☆	7.0	7.60	80.0	16.0	3	DIN 2184-1
		.630					.276	.299	3.150	.630		
EGUNJF 3/8-24	24.00	23.00	10.00 x 8.00	3B	T300-SD100DZ-3/8	☆	10.0	10.99	100.0	23.0	3	DIN 2184-1
		.906					.394	.433	3.937	.906		
EGUNJF 5/16-24	24.00	20.00	8.00 x 6.20	3B	T300-SD100DZ-5/16	☆	8.0	9.40	90.0	20.0	3	DIN 2184-1
		.787					.315	.370	3.543	.787		



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## CoroTap™ 200



## Metric values

				T200-SD	
				1.5	2
ISO	MC-Code	Material	HB	Vc (m/min)	
S	S1.0.U.AN	Heat resistant super alloys	200	7	6
	S1.0.U.AG		280	5	4
	S2.0.Z.AN	Nickel based alloys	250	7	6
	S2.0.Z.AG		350	2	2
	S2.0.Z.UT		275	5	4
	S2.0.C.NS		320	5	4
	S3.0.Z.AN	Cobolt based alloys	200	5	4
	S3.0.Z.AG		300	2	2
	S3.0.C.NS		320	5	4

## Inch values

				T200-SD	
				1.5	2
ISO	MC-Code	Material	HB	Vc (feet/min)	
S	S1.0.U.AN	Heat resistant super alloys	200	23	20
	S1.0.U.AG		280	17	14
	S2.0.Z.AN	Nickel based alloys	250	23	20
	S2.0.Z.AG		350	7	7
	S2.0.Z.UT		275	17	14
	S2.0.C.NS		320	17	14
	S3.0.Z.AN	Cobolt based alloys	200	17	14
	S3.0.Z.AG		300	7	7
	S3.0.C.NS		320	17	14

## CoroTap - Optimized for specific materials

## Metric values

				T200-SM	
				1.5	2
ISO	MC-Code	Material	HB	Vc (m/min)	
S	S4.1.Z.UT	Titanium alloys	200	7	6
	S4.2.Z.AN		320	7	6
	S4.3.Z.AN		330	5	4
	S4.3.Z.AG		375	5	4
	S4.4.Z.AN		330	5	4
	S4.4.Z.AG		410	5	4

## Inch version

				T200-SM	
				1.5	2
ISO	MC-Code	Material	HB	ft m/min	
S	S4.1.Z.UT	Titanium alloys	200	23	20
	S4.2.Z.AN		320	23	20
	S4.3.Z.AN		330	17	14
	S4.3.Z.AG		375	17	14
	S4.4.Z.AN		330	17	14
	S4.4.Z.AG		410	17	14



# CoroTap™ 300



## Metric values

				T300-SD	
				1.5	N/A
ISO	MC-Code	Material	HB	Vc (m/min)	
S	S1.0.U.AN	Heat resistant super alloys	200	7	
	S1.0.U.AG		280	5	
	S2.0.Z.AN	Nickel based alloys	250	5	
	S2.0.Z.AG		350	3	
	S2.0.Z.UT		275	5	
	S2.0.C.NS		320	3	

## Inch version

				T300-SD	
				1.5	N/A
ISO	MC-Code	Material	HB	ft m/min	
S	S1.0.U.AN	Heat resistant super alloys	200	23	
	S1.0.U.AG		280	17	
	S2.0.Z.AN	Nickel based alloys	250	17	
	S2.0.Z.AG		350	10	
	S2.0.Z.UT		275	17	
	S2.0.C.NS		320	10	

## CoroTap - Optimized for specific materials

## Metric values

				T300-SM	
				1.5	2
ISO	MC-Code	Material	HB	Vc (m/min)	
S	S4.1.Z.UT	Titanium alloys	200	10	8
	S4.2.Z.AN		320	6	5
	S4.3.Z.AN		330	6	5
	S4.3.Z.AG		375	5	4
	S4.4.Z.AN		330	5	4
	S4.4.Z.AG		410	5	4

## Inch version

				T300-SM	
				1.5	2
ISO	MC-Code	Material	HB	ft m/min	
S	S4.1.Z.UT	Titanium alloys	200	33	27
	S4.2.Z.AN		320	20	17
	S4.3.Z.AN		330	20	17
	S4.3.Z.AG		375	17	14
	S4.4.Z.AN		330	17	14
	S4.4.Z.AG		410	17	14

# Accessories



## G

Cylindrical sleeve with Easy-Fix positioning

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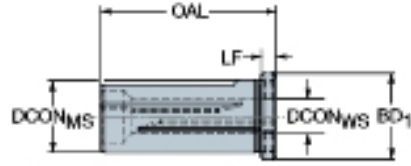
# Cylindrical sleeve with Easy-Fix positioning



ISO 9766

Metallic sealed for high pressure coolant through tool

B



C

## Metric version

				Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	BD <sub>1</sub>	H	LSC	OAL	LF	(BAR)	(KG)
16	5	1	1	EF-16-05	16	5	21	14	30.5	48	5	150	0.130
	6	1	1	EF-16-06	16	6	21	14	31.5	48	5	150	0.110
	8	1	1	EF-16-08	16	8	21	14	43.0	48	5	150	0.100
	10	1	1	EF-16-10	16	10	21	14	43.0	48	5	150	0.080
	12	1	1	EF-16-12	16	12	21	14	43.0	48	5	150	0.065
20	16	1	1	EF-20-16	20	16	25	18	50.0	55	5	150	0.080
25	20	1	1	EF-25-20	25	20	30	23	61.0	61	5	150	0.080
32	25	1	1	EF-32-25	32	25	36	30	60.0	65	5	150	0.120

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# To order your tools..

B Online, printed or digital - there are many ways to find the complete assortment and to order your tools.

## www.sandvik.coromant.com

C Find the latest assortment on our website

## Publications

D The digital library is available both online and offline at [www.sandvik.coromant.com/publications](http://www.sandvik.coromant.com/publications)

## Printed catalogues

E Use Sandvik Coromant's catalogues and supplements

## Applications

F Whether it's finding the right insert, calculating your start values or optimizing settings to maximize the performance of all of your applications; we have an app for that.

G

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## To make life easier, a new standard has been developed

**ISO 13399 is an international standard that strives to simplify the exchange of data for cutting tools. You will notice a slight difference through the new parameters and descriptions of each tool.**

For the first time ever, there is a standardized way of describing product data regarding cutting tools. When all tools in the industry share the same parameters and definitions, communicating tool information becomes very straightforward.

### What does this mean to you?

Basically, it means that your systems can talk to ours, as they all speak the same language. Download product data from our web site and use it directly in your CAD/CAM software to assemble tools that you use in production. No need to look for information in catalogues and interpret data from one system to another. Imagine how much time this will save you!

Short name	Preferred Name
ADJLN	Minimum adjustment limit
ADJLX	Maximum adjustment limit
ADJRG	Adjustment range
ALP	Clearance angle axial
AN	Clearance angle major
ANN	Clearance angle minor
APMX	Depth of cut maximum
APMX_EFW	Depth of cut maximum - end feed
APMX_FFW	Depth of cut maximum - side feed
AZ	Maximum plunge depth
B	Shank width
BAWS	Body angle workpiece side
BAMS	Body angle machine side
BBD	Balanced by design
BBR	Balanced by rotational test
BCH	Corner chamfer length
BD	Body diameter
BHTA	Body half taper angle
BN	Face land width
BS	Wiper edge length
BSG	Basic standard group
BSR	Wiper edge radius
CDX	Cutting depth maximum
CEMR	Cutting edge major radius
CF	Spot chamfer
CHBA	Chamfer body angle
CHBL	Chamfer body length
CHW	Corner chamfer width
CICT	Cutting item count
CICT <sub>E</sub>	Cutting item count - end position
CICT <sub>P</sub>	Cutting item count - peripheral position
CICT <sub>S</sub>	Cutting item count - side position
CICT <sub>T</sub>	Cutting item count - total
CND	Coolant entry diameter
CNSC	Coolant entry style code
CNT	Coolant entry thread size
COATING	Coating
CP	Max coolant pressure
CRKS	Connection retention knob thread size
CRNT	Coolant radial entry thread size
CTPT	Operation type
CUTDIA	Work piece parting diameter maximum
CW	Cutting width
CWN	Minimum cutting width
CWTOLL	Cutting width lower tolerance
CWTOLU	Cutting width upper tolerance
CWX	Cutting width maximum
CXSC	Coolant exit style code
CZC	Connection size code
CZC <sub>MS</sub>	Connection size code machine side
CZC <sub>WS</sub>	Connection size code workpiece side
D1	Fixing hole diameter
DAH	Diameter access hole
DAXIN	Axial groove inside diameter minimum



DAXN	Minimum axial groove outside diameter
DAXX	Axial groove outside diameter maximum
DBC	Diameter bolt circle
DC	Cutting diameter
DCB	Connection bore diameter
DCBN	Connection bore diameter minimum
DCBX	Connection bore diameter maximum
DCF	Cutting diameter face contact
DCIN	Cutting diameter internal
DCN	Cutting diameter minimum
DCON	Connection diameter
DCON <sub>MS</sub>	Connection diameter machine side
DCON <sub>WS</sub>	Connection diameter workpiece side
DCPS	Data chip provision size
DCSF <sub>MS</sub>	Contact surface diameter machine side
DCSF <sub>WS</sub>	Contact surface diameter workpiece side
DCX	Cutting diameter maximum
DHUB	Hub diameter
DIX	Tool changer interference diameter maximum
DMIN	Minimum bore diameter
DMM	Shank diameter
DN	Neck diameter
DRVCT	Drive count
DSGN	Design
EPSR	Insert included angle
FHA	Flute helix angle
FLGT	Flange thickness
FTDZ	For thread diameter size
H	Shank height
HA	Thread height theoretical
HB	Thread height difference
HBH	Head bottom offset height
HC	Thread height actual
HF	Functional height
HRY	Lowest point from reference plain
HTB	Body height
HTH	Height
IC	Inscribed circle diameter
INSL	Insert length
INSUC	Insert usage code
IZC	Insert size code
KAPR	Tool cutting edge angle
KAPR_EFW	Tool cutting edge angle - end feed
KCH	Corner chamfer
KRINS	Major cutting edge angle
KWW	Keyway width
L	Cutting edge length
LAMS	Inclination angle
LB	Body length
LCF	Length chip flute
LCOX	Cut off length maximum
LE	Cutting edge effective length
LF	Functional length
LFN	Minimum functional length
LH	Head length
LPR	Protruding length
LS	Shank length
LSC	Clamping length
LSCN	Clamping length minimum
LSCS	Distance to clamping start
LSCX	Clamping length maximum
LSD	Dead shank length
LU	Usable length (max. recommended)
LU_BFW	Usable length - back facing
LUX	Usable length maximum
MHD	Mounting hole distance
MIID	Master insert identification
MIID <sub>E</sub>	Master insert identification - end position
MIID <sub>S</sub>	Master insert identification - side position
MIID <sub>C</sub>	Master insert identification - central position
MIID <sub>P</sub>	Master insert identification - peripheral position
MIID <sub>I</sub>	Master insert identification - intermediate position
MMCC	Code for preset torque
MMCX	Max. cutting torque
NOF	Flute count
NT	Tooth count
OAH	Overall height
OAL	Overall length
OAW	Overall width
OH	Overhang recommended



OHN	Overhang minimum
OHX	Overhang maximum
ORDCODE	Ordercode
PCL	Peripheral cylindrical length
PDX	Profile distance ex
PDY	Profile distance ey
PHD	Premachined hole diameter
PHDX	Maximum premachined hole diameter
PL	Point length
PNA	Profile included angle
PRFRAD	Profile radius
PRSPC	Profile specification
PSIR	Tool lead angle
PSIRL	Cutting edge angle major left hand
PSIRR	Cutting edge angle major right hand
PSW	Premachined slot width
RADH	Radial body height
RADW	Radial body width
RAR	Right hand relief angle
RE	Corner radius
REEQ	Theoretical radius value required for programming purpose
REL	Corner radius left
RER	Corner radius right
RETOLL	Corner radius lower tolerance
RETOLU	Corner radius upper tolerance
RGL	Regrind length
RMPX	Maximum ramping angle
RPMX	Rotational speed maximum
S	Insert thickness
SDL	Step diameter length
SIG	Point angle
SPTL	Splitline
SSC	Insert seat size code
SSC <sub>E</sub>	Insert seat size code - end position
SSC <sub>P</sub>	Insert seat size code - peripheral position
SSC <sub>S</sub>	Insert seat size code - side position
STA	Step included angle
SUBSTRATE	Substrate
TCDC	Tolerance class cutting diameter
TCDCON	Connection diameter tolerance
TCDMM	Shank diameter tolerance
TCHA	Achievable hole tolerance
TCHAL	Achievable hole tolerance lower
TCHAU	Achievable hole tolerance upper
TCT	Tolerance class tool
TCTR	Thread tolerance class
TD	Thread diameter
TDZ	Thread diameter size
TFLA	Tap floating length ahead
TFLB	Tap floating length behind
TG	Taper gradient
THBTP	Thread back taper property
THCA	Thread helix correction angle
THCHT	Threading chamfer type
THFT	Form type
THFTS	Thread form standard series
THL	Thread length
THUB	Hub thickness
TP	Thread pitch
TPI	Threads per inch
TPIN	Threads per inch minimum
TPIX	Threads per inch maximum
TPN	Thread pitch minimum
TPT	Thread profile type
TPX	Maximum thread pitch
TRMAX	Tap range max
TQ	Torque
TSYC	Tool style code
TTP	Thread type
ULDR	Usable length diameter ratio
VCX	Maximum cutting speed
W1	Insert width
WB	Body width
WF	Functional width
WFCIRP	Width to cutting item reference point
WSC	Clamping width
WT	Weight of item
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count (ZEFP)
ZWX	Maximum number of Wiper inserts





# Safety information

## Safety information in connection with grinding of cemented carbide

### Material composition

#### Tool holders

Tool holders mainly contain iron (FE), and low alloy elements such as chromium, nickel, manganese, molybdenum and silicon.

#### Indexable inserts/cutting tools/round tools

Substances in cemented carbide products contain mostly wolfram carbide and cobalt. They may also contain carbides and carbonitrides of the following elements: titanium, tantalum, niobium, chromium, molybdenum and vanadium.

### Routes of exposure

Grinding or heating of hard metal blanks or hard metal products will produce products that give off dangerous dust and fumes. Avoiding ingestion and contact with skin or eyes is very important.

### Acute toxicity

Intake of the aforementioned substances is toxic. Inhalation may cause irritation and inflammation of the airways. Significantly higher acute inhalation toxicity has been reported during simultaneous inhalation of cobalt and tungsten carbide compared to inhalation of cobalt alone.

Skin contact can cause irritation and rash. Sensitive individuals may even experience an allergic reaction.

### Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction of the airways. Prolonged exposure to increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers previously exposed to high concentrations of tungsten carbide/cobalt carried an increased risk of developing lung cancer.

Cobalt and nickel are potent skin sensitizers. Repeated or prolonged contact can cause irritation and sensitization.

### Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation

Toxic when inhaled

Limited evidence of a carcinogenic effect.

May cause sensitization by inhalation and skin contact

### Preventive measures

Avoid formation and inhalation of dust. Use adequate local exhaust ventilation to keep personal exposure well below nationally authorised limits.

If ventilation is not available or adequate, use respirators appropriately approved for the purpose.

Use safety goggles or glasses with side shields when necessary.

Avoid repeated skin contact. Wear suitable gloves. Wash skin thoroughly after handling.

Use suitable protective clothing. Launder clothing if needed.

Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.





# For the sake of the environment

## Get into the Sandvik Coromant Recycling Concept (CRC) now!

The Sandvik Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts and solid carbide tools offered by Sandvik Coromant to all its customers. In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers. Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way. All used carbide inserts are collected in the collection box at the workplace. When the collection box is sufficiently full, its contents are transferred to the transport box. The full transport box is then sent to the nearest Sandvik Coromant office or to your Sandvik Coromant dealer who can also give you more information.



### The benefits of the CRC speak for themselves

- A worldwide ISO and OHAS certified recycling system.
- Open to all Sandvik Coromant customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.

Order collection boxes for each lathe, milling machine, drill or for your machining centre. We recommend one collection box for inserts and one separate box for solid carbide tools for each cutting workplace.

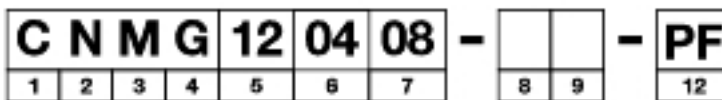
For detailed instructions on how to sell your used cemented carbide, please visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com) and select your market.

Collection box:	Order numbers
Transport box for solid carbide tools (plywood):	91617
Transport box inserts (plywood):	92994
	92995

# General turning inserts



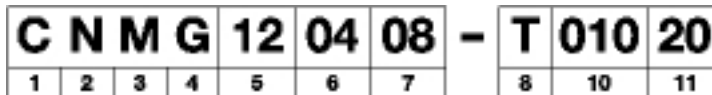
Inserts, metric



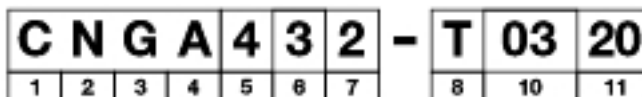
Inserts, inch



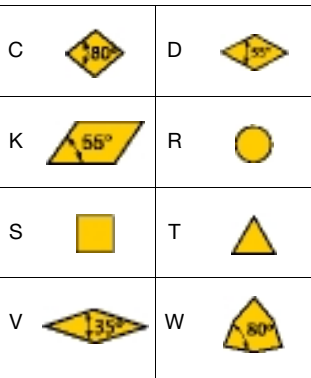
Inserts, advanced cutting materials, metric



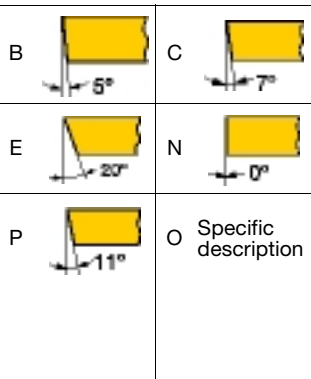
Inserts, advanced cutting materials, inch



### 1 Insert shape



### 2 Insert clearance angle



### 3 Tolerances, metric

Class	S	iC / W1
G	±0.13	±0.025
M	±0.13	±0.05 – ±0.15 <sup>1)</sup>
U	±0.13	±0.08 – ±0.25 <sup>1)</sup>
E	±0.025	±0.025

<sup>1)</sup>Varies depending on the size of iC. See below.

Inscribed circle iC mm	Tolerance class	
	M	U
3.97		
5.0		
5.56		
6.0	±0.05	±0.08
6.35		
8.0		
9.525		
10.0		
12.0	±0.08	±0.13
12.7		
15.875	±0.10	±0.18
16.0		
19.05		
20.0		
25.0		
25.4	±0.13	±0.25
31.75		
32.0		

For positive inserts iC is valid for a sharp corner. See cutting edge condition F. (Picture 8).

### 3 Tolerances, inch



A: Theoretical diameter of the insert inscribed circle.

T: Thickness of the insert.

B: See figures.

#### Tolerances in inch

Class	B:	A:	T:
A	±.0002	±.001	±.001
B	.0002	.001	.005
C	.0005	.001	.001
D	.0005	.001	.005
E	.001	.001	.001
F	.0002	.0005	.001
G	.001	.001	.005
H	.0005	.0005	.001
J	.0002	.002-.005	.001
K	.0005	.002-.005	.001
L	.001	.002-.005	.001
M	.002-.005	.002-.005	.005
U	.005-.012	.005-.010	.005
N	.002-.010	.002-.004	.001





**CNSC**

**Coolant entry style code**

Code	Description	Image
0	Without coolant	
1	Axial concentric entry	
2	Radial entry	
3	Axial concentric and radial entry	
4	Axial concentric entry on circle	
5	Radial entry before adaptor	
6	Decentral over flange	
7	Decentral over flange and axial	
8	Decentral over slots on the shank	

**CXSC**

**Coolant exit style code**

Code	Description	Image
0	No coolant exit	
1	Axial concentric exit	
2	Radial exit	
3	Axial inclined exit	
4	Axial concentric on circle	
5	Axial inclined exit with nozzle, adjustable	
6	Decentral exit with nozzle, adjustable	
7	Decentral over slots on the shank	
8	Axial or decentral with nozzle, adjustable	



A



ENG

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